

J. E. RUSSELL.

Flasks for Casting Sash-Weights.

No. 153,616.

Patented July 28, 1874.

fig. 1

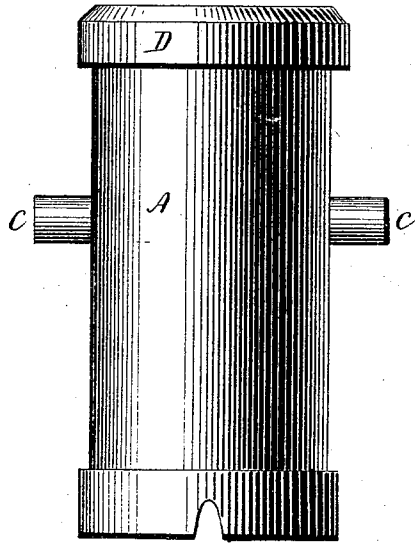


fig. 2

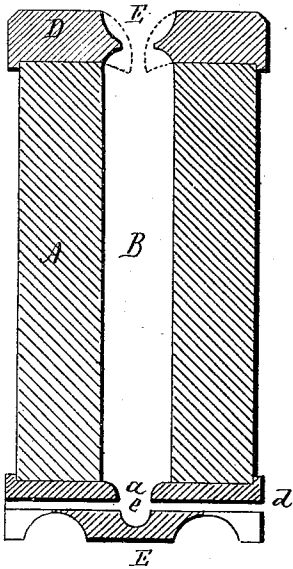


fig. 3

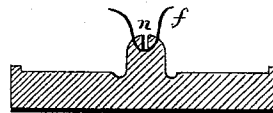
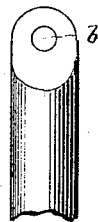


fig. 5



fig. 4



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JAMES E. RUSSELL, OF BRANFORD, CONNECTICUT.

IMPROVEMENT IN FLASKS FOR CASTING SASH-WEIGHTS.

Specification forming part of Letters Patent No. **153,616**, dated July 28, 1874; application filed June 3, 1874.

To all whom it may concern:

Be it known that I, JAMES E. RUSSELL, of Branford, in the county of New Haven and State of Connecticut, have invented a new Improvement in Flask for Casting Sash-Weights; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a side view; Fig. 2, a vertical section; Fig. 3, a modification of the lower head; and in Figs. 4 and 5, the two classes of weights.

This invention relates to an improvement in the method of casting sash and similar weights, the object being to avoid the expense of molding for each weight; and it consists in a metal flask with removable heads, one of which forms the mouth through which to pour the metal, the other formed to shape and finish the upper or top end of the weight, as more fully hereinafter described.

A is the flask, which is made of cast-iron, with a central opening, B, from end to end of the form of the weight to be produced. For convenience the flask is provided with trunnions C. The upper end is fitted with a removable head, D, constructed with a central perforation, E, through which to pour the metal. This perforation is preferably lined

with sand or other substance, as denoted in broken lines, prior to pouring.

Weights are of two classes: First, those which are formed with a perforation to make the eye, as seen in Fig. 4; and, second, those which have the eye formed by the insertion of a piece of wire in the process of casting, as seen in Fig. 5. To cast the first the lower head E is formed with a central recess, *a*, corresponding to the exterior of the neck of the weight, and transversely through the head is a perforation, *d*, through which a core, *e*, is secured in the recess *a* to form the eye *b*, Fig. 4. To form the second class the head is constructed with an upward projection, *f*, with a transverse central slit, *n*, into which the wire *m*, Fig. 5, is laid; then the metal poured into the flask secures the wire. These heads are interchangeable, so that the same flask may be used for both classes.

I claim as my invention—

The herein-described flask for casting weights, consisting of the body A, with the vertical opening B, the upper or pouring head D, and the lower head E, constructed with the recess *a* or projection *f*, substantially as specified.

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Witnesses:

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