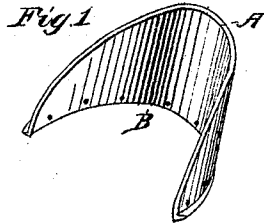


H. WRIGHT.

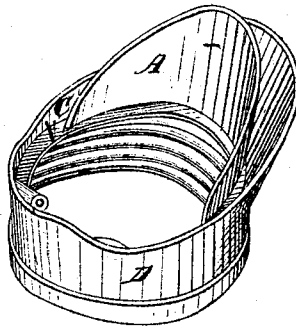
Improvement in Jug-Tops.

No. 129,303.

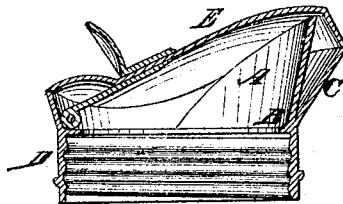
Patented July 16, 1872.



*Fig. 2*



*Fig. 3.*



*Witnesses.*

*B. Christy*  
*C. Hasbrouck*

*Inventor.*

*Horner Wright*

# UNITED STATES PATENT OFFICE.

HOMER WRIGHT, OF PITTSBURG, PENNSYLVANIA, ASSIGNOR OF TWO-THIRDS OF HIS RIGHT TO HENRY H. COLLINS AND BENJAMIN F. COLLINS, OF SAME PLACE.

## IMPROVEMENT IN JUG-TOPS.

Specification forming part of Letters Patent No. 129,303, dated July 16, 1872.

I, HOMER WRIGHT, of Pittsburg, in the county of Allegheny and State of Pennsylvania, have invented a new and useful Improvement in Jug-Tops, of which the following is a specification:

My invention relates to a jug-top, constructed so as to return the drippings or overflow to the jug; and consists in the use of a sheet-metal inner lip, in combination with a cast body and neck, economy of metal and facility of manufacture being the prime objects.

In the accompanying drawing, Figure 1 is a perspective view of my sheet-metal lip. Fig. 2 is a side elevation of a jug-top, showing the sheet-metal lip in place. Fig. 3 is a vertical section through the middle of the lip, body, neck, and lip.

To enable those skilled in the art to make and use my invention, I will proceed to describe it.

With a proper die I cut my lip A from thin sheet metal and form it into the general half-circular shape shown in Fig. 1, with its lower edge at B grooved or perforated for the purpose of giving it a firmer hold in the cast alloy. I provide also a metallic mold, with cores properly shaped, and within which is provided a recess or carp for the purpose of receiving and retaining the lip A in proper position within the mold. In the production of a jug-top I first introduce the lip A into the recess or carp in the mold, permitting the grooved or perforated edge B to project within, and having prepared a quantity of melted alloy, (Britannia, for example,) I pour this into the mold, and thus form body C and neck D, when it immediately unites with or embraces the grooved edge of lip A and forms a permanent joint. It is now ready for the reception of the lid E, when it is turned and finished in the ordinary manner.

It will thus be seen that I can produce a jug-top so constructed as to return the drippings or overflow to the jug, having an inner lip of thin sheet metal, which does not require to be over one-half the thickness of cast metal, (the latter will not flow in the mold at a less

thickness than about one-sixteenth of an inch,) effecting a saving of one and three-quarter pounds of metal per gross, which is no inconsiderable item in view of the fact that several thousand gross of jug-tops are annually made at the factory with which I am connected.

I prefer Britannia sheet metal for the lip, as it unites more readily with the cast metal, while it takes a high polish from the rolls and requires no further finish. In case a sheet metal is used that will not unite with the cast alloy—sheet-tin, for example—I find that the groove or perforations B afford sufficient hold for the cast metal.

A skillful workman with the aid of the blow-pipe may be able to solder an inner lip to a jug-top body, but it would be a tedious and expensive process; while in the above-described mode any one capable of placing the lip within the mold and handling an ounce of metal alloy may produce the body and neck, and attach the lip by the simple act of pouring the metal into the mold.

I am aware that metals of different kinds have been united by casting one upon the other; and that articles denominated "pitcher-tops" have been made of several pieces, and soldered together or cast solid; but they lack the distinguishing features of a jug-top, to which alone I seek to apply my improvement, which is an article of a distinctive form, having a ewer mouth, and is a well-known article of manufacture; and I am not aware that it has ever been provided with an inner sheet-metal lip, attached as described above, previous to my invention.

Having thus described my improvement, what I claim as my invention is—

A jug-top having an inner sheet-metal lip, in combination with a cast body and neck, the body and neck being cast upon the lip substantially in the manner described.

HOMER WRIGHT.

Witnesses:

B. C. CHRISTY,  
C. HASBROUCK.