

J. Ziegler,

Casting Hollow-ware.

N^o 83,751.

Fig. 1.

Patented Nov. 3, 1868.

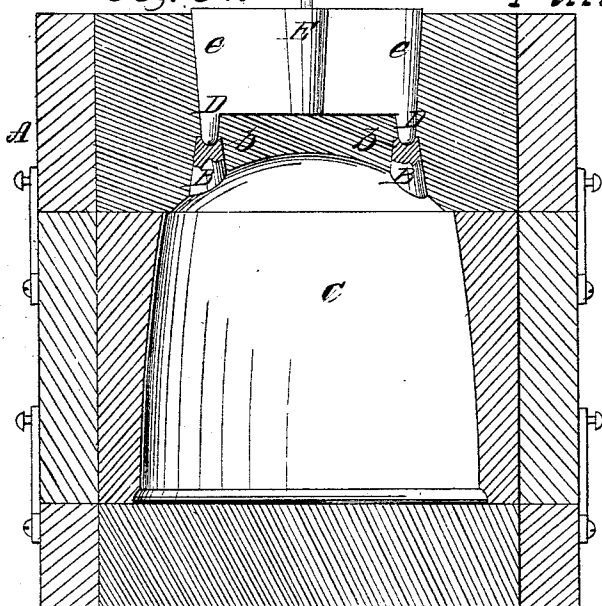
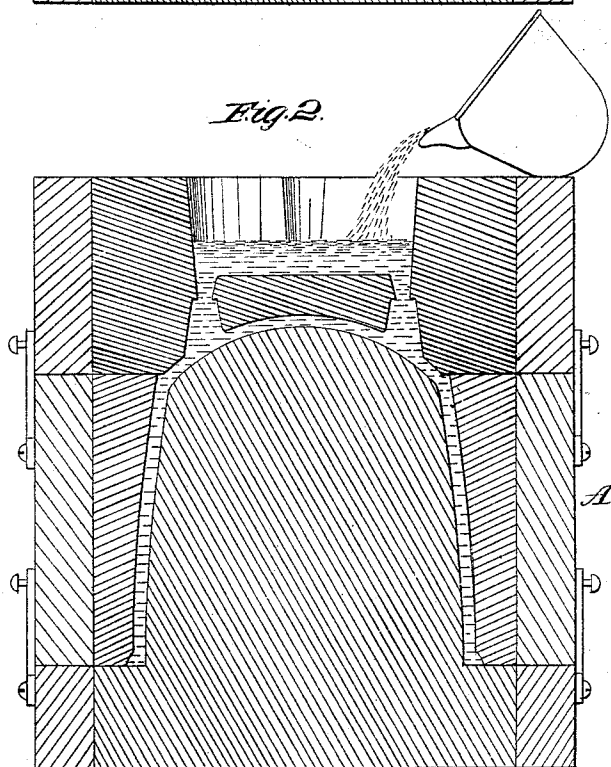
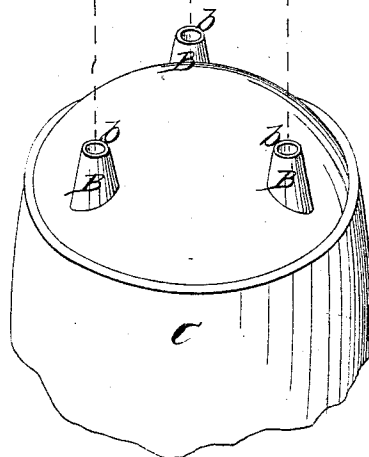
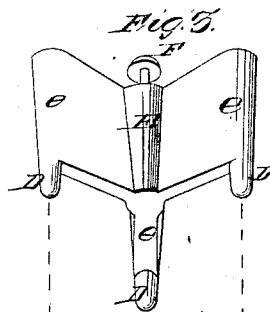


Fig. 2.



Attest:

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United States Patent Office.

JOHN ZIEGLER, OF DAYTON, OHIO.

Letters Patent No. 83,751, dated November 3, 1868.

IMPROVEMENT IN CASTING HOLLOW-WARE.

The Schedule referred to in these Letters Patent and making part of the same.

To whom it may concern:

Be it known that I, JOHN ZIEGLER, of Dayton, Montgomery county, Ohio, have invented a new and useful Mode of Casting Feet Hollow-Ware; and I hereby declare the following to be a full, clear, and exact description thereof, reference being had to the accompanying drawings, making part of this specification.

My invention consists in an improved mode of casting pots, and other articles of hollow-ware having feet, by connecting the sprues or channels for the molten metal to the ends of the feet, thereby avoiding the unsightly burr, stub, or scar always seen on the bottom of such vessels where the gate or sprue has been broken off.

Figure 1 is a vertical section of a flask, with the pot-pattern and gate-stick in position, and the sand rammed up.

Figure 2 represents the same flask, in condition for casting.

Figure 3 is a perspective view of the gate-stick, and of the bottom portion of the pot-pattern.

A may represent a flask, of customary form.

Hollows or cavities *b* in the ends of the feet *B* of pot-pattern *C* receive the extremities of sprues or branches *D* of my gate-stick *E*, which extremities are of less diameter than those of the feet, in order to facilitate the separation of the surplus metal, after

casting, without marring the proper contour of the feet.

Each sprue depends from the lower edge of a wing, *e*, of the gate-stick, which wings are, consequently, as many in number as the feet of the vessel.

The said gate-stick is formed with an upward draught or flare, to enable its ready removal; and, with the same object, may be provided with a handle, *F*.

I am aware that sprue-patterns have before been made with branches, to rest at several different points on the pattern of the casting to be made. This, therefore, I do not claim; but

What I do claim, and desire to secure by Letters Patent, is—

1. The sprue-pattern herein described, constructed with wings *e e e*, and downward projections *D D D*, so arranged as to correspond in position with the feet of the vessel to be cast, as and for the purposes stated.

2. The process of casting hollow-ware, by introducing the metal through the part or parts of the mould which are to form the feet of the vessel, substantially as and for the purposes set forth.

In testimony of which invention, I hereunto set my hand.

JOHN ZIEGLER.

Witnesses:

GEO. H. KNIGHT,
A. O. KITTRIDGE.