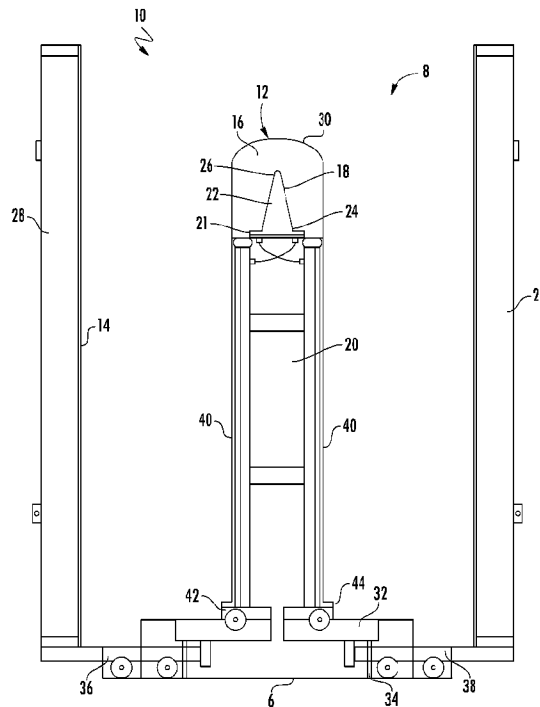




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 (54) Title: ADJUSTABLE MOLD AND METHOD FOR MANUFACTURING DRAINAGE CHANNELS



(57) **Abrégé/Abstract:**

An adjustable mold capable of making castings of various configuration is provided. The adjustable mold has an adjustable die with a core and an adapter, a protrusion, a cavity, and an outer portion with at least two sidewalls, at least two endwalls, and a base therebetween, which outer portion at least partially surrounds the adjustable die to thereby define a mold. During casting, molding material is poured in the mold and allowed to cure to make a casting. The adapter is replaceable to enable castings of multiple configurations to be cast using the adjustable mold.

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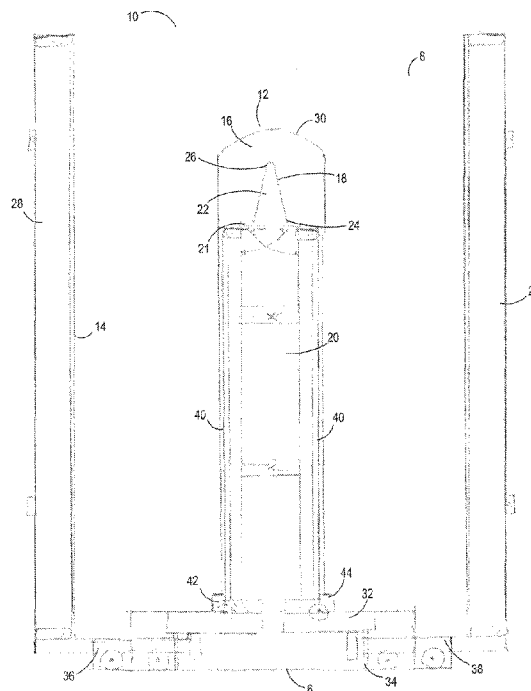


FIG. 1

(57) Abstract: An adjustable mold capable of making castings of various configuration is provided. The adjustable mold has an adjustable die with a core and an adapter, a protrusion, a cavity, and an outer portion with at least two sidewalls, at least two endwalls, and a base therebetween, which outer portion at least partially surrounds the adjustable die to thereby define a mold. During casting, molding material is poured in the mold and allowed to cure to make a casting. The adapter is replaceable to enable castings of multiple configurations to be cast using the adjustable mold.

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ADJUSTABLE MOLD AND METHOD FOR MANUFACTURING DRAINAGE CHANNELS

CROSS-REFERENCE TO RELATED APPLICATION

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FIELD

[0002] This invention relates generally to drainage channels and trench-forming adjustable molds, and to a method and system for using the adjustable molds to create different-sized drainage channel castings with variable slope capabilities and configurations.

BACKGROUND

[0003] Molds are commonly used as a form to cast structural and ornamental elements used in construction and other applications. The molds are filled with cementitious materials, polymer concrete and other formable materials that are allowed to cure. The casting is then removed from the mold.

[0004] In some embodiments, the molds are designed to be reused. This avoids the need to reconstruct the mold repeatedly in order to make multiple castings of the same product. However, there are instances where a casting has multiple possible configurations. Conventionally, reusable molds had to be made and stored for each configuration of the casting, which molds cost significant resources to build and store, especially for larger castings.

[0005] Accordingly, there remains a need for a reusable mold that can be easily adjusted to accommodate variations in a casting so that multiple molds do not have to be constructed and stored for the different configurations.

BRIEF SUMMARY OF THE INVENTION

The present invention provides a reusable mold that can be easily adjusted to accommodate variations in a casting so that multiple molds do not have to be constructed and

stored for the different configurations. In one embodiment, an adjustable mold for making castings of various configurations is provided. The adjustable mold comprises an adjustable die comprising a core having a protrusion, wherein the protrusion has a configuration and a first adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion. The adjustable mold comprises an outer portion at least partially surrounding the adjustable die to thereby define a mold, the outer portion comprising at least two sidewalls, at least two endwalls, and a base therebetween.

[0007] According to one embodiment, the configuration of the protrusion has a transverse width that varies along its axial length so as to have a first width at a first portion of the protrusion and a second width at a second portion of the protrusion that is wider or shorter than the first width. According to another embodiment, the protrusion has a triangular configuration.

[0008] According to one embodiment, the base has at least one base support and at least one base member. According to another embodiment, the core is configured to be removably attached to the base.

[0009] According to yet another embodiment, the mold comprises a second adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion, and wherein the external configuration of the first adapter and the external configuration of the second adapter are different.

[0010] The present invention also provides a method of making castings of various configurations, the method comprising providing an adjustable mold for making castings of various configurations, the adjustable mold comprising an adjustable die comprising a core having a protrusion, wherein the protrusion has a configuration; and a first adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion and an outer portion at least partially surrounding the adjustable die to thereby define a mold, the outer portion comprising at least two sidewalls, at least two endwalls, and a base therebetween. The adjustable mold is used to form a first casting.

[0011] According to one embodiment, the method comprises replacing the first adapter with a second adapter. In one embodiment, replacing the first adapter with the second adapter comprises removing the first adapter from the core and positioning the second adapter on the core.

[0012] According to another embodiment, the adjustable mold is used to form a second casting having a configuration that is different from the first casting.

BRIEF DESCRIPTION OF THE SEVERAL VIEWS OF THE DRAWINGS

[0013] The following detailed description of embodiments refers to the accompanying drawings which illustrate specific embodiments of the disclosure. Other embodiments having different structures and operations do not depart from the scope of the present disclosure. Reference will now be made to the accompanying drawings, which are not necessarily drawn to scale, and wherein:

[0014] Figure 1 is a cross-sectional view of the front of an adjustable mold in an expanded configuration according to one embodiment of the present invention, prior to the introduction of molding material;

[0015] Figure 2 is a perspective view of a portion of an adjustable die in accordance with one embodiment of the invention; and

[0016] Figure 3 is a cross-sectional view of the front of an adjustable mold in an assembled, enclosed configuration in accordance with one embodiment of the invention.

DETAILED DESCRIPTION OF EMBODIMENTS OF THE INVENTION

[0017] Embodiments of the present invention will now be described hereinafter with reference to the accompanying drawings, in which some, but not all, embodiments of the invention are shown. Indeed, the invention may be embodied in many different forms and should not be construed as limited to the embodiments set forth herein; rather, these embodiments are provided so that this disclosure will satisfy applicable legal requirements. Like numbers refer to like elements throughout.

[0018] Referring to the drawings, Figure 1 illustrates a cross-sectional view of an adjustable mold **10** for a mold **8**, such as a drainage channel, in an expanded configuration before the introduction of molding material. The adjustable mold **10** has an adjustable die **12** and an outer portion **14** at least partially surrounding the adjustable die **12** to thereby define the mold **8**. The adjustable die **12** comprises an adapter **16** and a core **20**, wherein the core **20** may further comprise a connector **21**. In one embodiment, the adapter **16** and core **20** of the adjustable die **12** are connected through a female and male connection. In another embodiment, the adapter **16** and core **20** of the adjustable die **12** are connected through a slidable connection. In Figure 1, the

adapter **16** has a cavity **18**, which represents the female portion of the connection, and the connector **21** of the core **20** has a protrusion **22**, which represents the male portion of the connection. The configuration of the cavity **18** and protrusion **22** can vary. In other embodiments, the adapter **16** has the protrusion **22**, while the connector **21** has the cavity **18**. In still other embodiments, the cavity **18** extends through the connector **21** and into the core **20** of the adjustable die **12**.

[0019] In some embodiments, the adapter **16** is removably attached to the connector **21**, and the connector **21** is removably attached to the core **20**. In other embodiments, the protrusion **22** is operatively coupled directly to the core **20** without use of the connector **21**, wherein the core **20** has the protrusion **22** or the cavity **18**. In some embodiments, the connector **21** is interchangeable and disposable, which allows for a uniform attachment of various connectors and protrusions to the core **20** while offering the potential for compatibility with various configurations, e.g., shapes, slopes, sizes, etc. of adapters without requiring that the core **20** and the adjustable mold **10** as a whole be used only for a specific design of mold **8**.

[0020] The protrusion **22** has a transverse width that varies along its axial length so as to have a first width at a first portion **24** of the protrusion **22** and a second width at a second portion **26** of the protrusion **22** that is wider or shorter than the first width. The cavity **18** and protrusion **22** may be of any shape, wherein the cavity **18** is an inverse shape of the protrusion **22** and is configured to detachably receive the protrusion **22**, thereby removably attaching the adapter **16** to the core **20**. In the embodiment illustrated in Figure 1, the protrusion **22** and the cavity **18** are of a triangular shape with at least two planar sides, wherein the protrusion **22** is tapered from bottom to top. In some embodiments, and as illustrated in Figure 1, the tip of the protrusion **22** may be rounded.

[0021] Referring now to Figure 2, which illustrates a perspective view of a portion of the adjustable die **10**, in accordance with one embodiment of the invention, the adapter **16** has the cavity **18** and is removably attached to a connector **21**, which has the protrusion **22**. In this embodiment, the adapter **16** is configured to be removably attached to the connector **21**, which, in turn, is configured to be removably attached to the core **20**, allowing for variations in the channel shape and size of the mold **8** due to the customizable nature of the interchangeable adapter **16** and connector **21** within the adjustable mold **10**. Furthermore, the height of the adapter **16** may vary along the length of the adapter **16**, wherein a proximal end of the adapter **16**

has a height that is different than the height of a distal end of the adapter **16**, thereby allowing for the molding of castings with sloped channels. In other embodiments, such as the embodiment illustrated in Figure 3, the height of the adapter **16** is the same along the length of the adapter **16**.

[0022] Referring now back to Figure 1, the outer portion **14** has at least two sidewalls **28**, at least two endwalls (not shown), and a base **32** therebetween. In some embodiments, the endwalls may be similar in design and function to the sidewalls **28**. The size and shape of the sidewalls **28**, endwalls, and base **32** may vary and/or be adjustable, thereby varying or adjusting the size and shape of the mold **8** to allow for the molding of castings of different configurations, e.g., shapes, slopes, sizes, etc. In other embodiments, such as the embodiment illustrated in Figure 3, the sidewalls **28** and base **32** are planar. The base **32** has at least one base support **34** and at least one base member. The at least one base support **34** is operatively coupled to a bottom surface of the base **32** and supports the base **32** while in contact with the floor **6**. In the embodiment illustrated in Figure 1, the base **32** has two base members **36**, **38**, which are, preferably, removably attached to a bottom portion of the base **32** and/or base support **34**.

[0023] When using the adjustable mold **10** to make a casting, molding material, such as concrete, is poured in the mold **8** until it fills the mold **8** above the height of the adjustable die **12**. After pouring molding material in the mold **8** and allowing it to dry, a casting is formed and removed from the adjustable mold **10**, wherein the adapter **16** and/or connector **21** may be discarded. The external surfaces and shapes of the casting are defined by the internal surfaces and positions of the at least two sidewalls **28** and at least two endwalls. In one embodiment, the internal surfaces of the at least two sidewalls **28** and at least two endwalls are smooth planes, and as such, the external surfaces of the casting are smooth planes, which may reduce the stress concentration in the casting. Alternatively, the internal surfaces of the at least two sidewalls and at least two endwalls can include one or more ribs or other features desired to define the external surfaces of the casting. The positions of the at least two sidewalls and at least two endwalls may also be altered to form castings of different widths, depths, and shapes, as described more fully below.

[0024] A purpose of the adapter **16** is to be easily removed from the core **20** and/or connector **21** and molding material so that the outer portion **14** and the core **20** can be reused with adapters **16** and connectors **21** of various configurations, e.g., shapes, slopes, sizes, etc., to thereby form molds **8** and castings of various configurations, e.g., shapes, slopes, sizes, etc. In

one embodiment, the external surface and shape **30** of the adapter **16** is a half circle-like configuration comprised of three planar sides. This design reduces the stress concentration in a drainage channel casting. Specifically, in such embodiment, stress is reduced in the corners of the internal surface of the casting, such as a drainage channel, as compared to the stress concentration in the corners of a traditional, rectangular casting. Any number of internal surfaces and shapes for the casting can be defined by changing the external surface and shape **30** of the adapter **16**. In this regard, in other embodiments, the external surface and shape **30** of the adapter **16** is a parabolic curve or comprises more than three planar sides.

[0025] The various portions of the adjustable mold **10** according to example embodiments of the invention can be made of any of various materials. The outer portion **14** and core **20** can be made of metal, wood, or plastic, as can the various portions of the outer portion **14**. The adapter **16** and the connector **21** are preferably made of material that is formable or easily-shaped and removable, as explained above. In some embodiments, such material is a formed plastic body. In other embodiments, such material is expanded polystyrene. The cavity and protrusion can include surface treatments to make the connection therebetween sticky, so long as the adapter is removable from the core. In some embodiments, the outer portion **14** and/or adjustable die **12** comprise a surface coating or covering, which can be fixedly adhered to the outer portion **14** and/or adjustable die **12** or reapplied prior to each molding of a casting. The surface coating may be on the side of the outer portion **14** and/or adjustable die **12** in contact with the molding material and structured to have no or limited adherence to the molding material. Such no or limited adherence to the molding material may allow the outer portion **14** and/or adjustable die **12** to be reusable. In some embodiments, the surface coating may be a film having an adhesive backing that will adhere to the outer portion **14** and/or adjustable die **12** with a relatively smooth outer surface that has no or limited adherence to the molding material. In such embodiments, the surface coating can be a film comprising a metal (e.g., aluminum) and/or plastic (e.g., polypropylene or polyester), including metallized plastic. In other embodiments, the surface coating is a sprayed or brushed on coating, such as a polyurea or a styrospray (e.g. styrospray 1000), that has no or limited adherence to the molding material.

[0026] The adjustable die **12** is configured to be removably attached to the base **32** at the core **20**. In the embodiment illustrated in Figure 1, the core **20** is removably attached to a top portion of the base **32**. Alternatively, the core **20** can be removably attached to an aperture in the

base **32** by a mechanism, which, in such embodiment, the aperture's length and width is greater than the length and width of the core **20**. For example, the core **20** can have numerous holes on the exterior surface of the core **20** at different heights, and the inner walls of the aperture in the base **32** can have numerous locking mechanisms, such as indexing plungers, that, when aligned with the holes on the exterior surface of the core **20** at a desired height, lock the position of the core **20** in place at such height. In such embodiment, two base members **36, 38** may be positioned at a distance relative to each other that is greater than the width of the core **20**, and the core **20** may be adjusted and positioned at different heights within the outer portion **14**, which gives the adjustable mold **10** the flexibility to change the overall height of the mold **8**. Moving the position of the core **20** within the outer portion **14** toward the floor **6** increases the overall height of the mold **8**, while moving the position of the core **20** within the outer portion **14** away from the floor **6** decreases the overall height of the mold **8**.

[0027] In other embodiments, the overall height of the mold **8** is adjusted by merely removing the then-existing core **20** from the adjustable mold **10** and replacing it with a core **20** of a desired height. In yet still other embodiments, the overall height of the mold **8** is adjusted by merely removing the then-existing adapter **16** and/or connector **21** from the adjustable mold **10** and replacing it with an adapter **16** and/or connector **21** of a desired height. The shape of the inner portion of the mold **8**, i.e., the internal surface of the casting, can be adjusted by replacing the then-existing adapter **16** and/or connector **21** with an adapter and/or connector of a desired shape, thereby customizing, for example, the channel shape of a drainage channel mold and casting.

[0028] As illustrated in Figure 1, the core **20** of the adjustable mold **10** has at least two core walls **40** that at least partially form the inner channel of the mold **8**. In some embodiments, the core walls **40** are operatively coupled to a top surface of the base **32**. The core walls **40** are positioned around the core **20** and, in some embodiments, may be operatively coupled to the core **20**. In other embodiments, the core walls **40** may not be permanently fixed to the core **20**, allowing the core walls **40** to move away from the core **20** towards the sidewalls **28**, thereby increasing the width of the core **20** and the overall width of the adjustable die **12**. As illustrated in Figure 1, in one embodiment, the core walls **40** are operatively coupled to one or more core wall member **42, 44**, which are, in turn, operatively coupled to the base **32**.

[0029] Different types of mechanisms for allowing two core wall members **42, 44** and/or two core walls **40** to move toward and/or away from each other and for selectively locking two core walls members **42, 44** and/or two core walls **40** relative to each other will be apparent to one of ordinary skill in the art in view of this disclosure. In one embodiment, two core wall members **42, 44** are configured to be removably attached to the base support **34** and/or base **32** by a mechanism, such as one or more track systems, that allows the two core wall members **42, 44**, and therefore the two core walls **40**, to slide toward and/or away from each other. Such a mechanism may include one or more locking mechanisms, such as a bolt and wing nut placed in a track, which allows a user to lock the two core wall members **42, 44** at a position and desired distance away from each other. Moving the core walls **40** farther away or closer to the core **20** at least partially adjusts the overall width of the adjustable die **12** and, thereby, may produce a casting and/or mold **8** of variable internal channel width. Different types of mechanisms for allowing the two (or more) core wall members **42, 44** to move toward and/or away from each other and for selectively locking the two (or more) core wall members **42, 44** relative to each other will be apparent to one of ordinary skill in the art in view of this disclosure.

[0030] In one embodiment of the invention, an adapter **16**, connector **21**, core **20**, two core walls **40**, two core wall members **42, 44**, two sidewalls **28**, two endwalls, base **32**, base support **34**, and/or two base members **36, 38** are not fixed to each other and some or all of these elements of the adjustable mold **10** can move independently of each other. Preferably, the adapter **16**, connector **21**, core **20**, two core walls **40**, two core wall members **42, 44**, two sidewalls **28**, two endwalls, base **32**, base support **34**, and/or two base members **36, 38** are each operatively coupled by mechanisms that allow a user to move some or all of these elements relative to its other respective element. In other embodiments, each pair of elements listed above may be operatively coupled to and fixed relative to the other elements of the adjustable mold **10**.

[0031] The at least two sidewalls **28** and at least two endwalls are configured to be removably attached to at least one of the at least one base member **36, 38** and are able to be positioned at different distances and slopes relative to each other, which gives the adjustable mold **10** the flexibility to change the overall width, depth, and shape of the mold **8** and, thus, the configuration of the casting. The at least two sidewalls **28** and at least two endwalls can be configured to be removably attached to the at least one base support **34** by a mechanism, such as one or more track systems, that allows the at least two sidewalls **28** and at least two endwalls to

slide toward or away from its other respective sidewall or endwall. Such a mechanism may include one or more locking mechanisms, such as a bolt and wing nut placed in a track, which allows a user to lock the at least two sidewalls and/or two endwalls at a position and desired distance away from each other. Alternatively, the sidewalls **28** and/or at least two endwalls can be hingedly connected to the at least one base support **34** through hinges. This hinged configuration may be useful to adjust the slope of the at least two sidewalls and/or at least two endwalls and/or for aiding in the removal of the mold **8** from the adjustable mold **10**. In other embodiments, the sidewalls **28** and/or endwalls may be operatively coupled directly to the base **32** instead of the at least one base member **36, 38**. In some embodiments of the invention, the core walls **40** and the core wall members **42, 44** may be configured in a manner similar to that of the sidewalls **28** and base members **36, 38** as previously described, allowing for the core walls **40** to be positioned at different distances and slopes relative to each other, which gives the adjustable mold **10** the flexibility to change the overall configuration, e.g., width, depth, and shape of at least a portion of the adjustable die **12**, the mold **8**, and, thus, the configuration of the casting, including the configuration of the internal surface of a drainage channel casting.

[0032] Adjusting the slope of the at least two sidewalls **28**, at least two endwalls, and/or at least two core walls **40** adjusts the thickness of the mold **8**, and thus the thickness of the casting. Increasing the thickness of the casting at areas of higher stress concentration minimizes the need to use additional materials to support the casting at such areas of higher stress concentration and, thereby, reduces the cost of the casting. For example, a tapered thickness of walls of the casting can be created by changing the distance between leading ends of the at least two sidewalls **28**, while keeping trailing ends of the at least two sidewalls **28** at the same distance apart.

[0033] In other embodiments, the at least two sidewalls **28** and/or at least two endwalls are of integral unitary construction with the at least one base support **34** but are still capable of being positioned at different distances from each other through adjustment mechanisms in the at least one base member **36, 38**. Moving the position of the at least two sidewalls **28** away from each other increases the overall width of the mold **8**, while moving the position of the at least two sidewalls **28** toward each other decreases the overall width of the mold **8**. Similarly, moving the position of the at least two endwalls away from each other increases the overall depth of the mold **8**, while moving the position of the at least two endwalls toward each other decreases the

overall depth of the mold **8**. Different types of mechanisms for allowing the at least two sidewalls **28** and/or at least two endwalls to move toward and/or away from each other and for selectively locking the at least two sidewalls **28** and/or at least two endwalls relative to its other respective sidewall or endwall will be apparent to one of ordinary skill in the art in view of this disclosure.

[0034] In one embodiment, two base members **36, 38** are not coupled to the base **32** and/or base support **34** but are held in a position relative to each other merely by the weight or shape of the adjustable die **12**. In another embodiment, two base members **36, 38** are configured to be removably attached to the base **32** and/or base support **34** by a mechanism, such as one or more track systems, that allows the two base members **36, 38** to slide toward and away from each other. Such a mechanism may include one or more locking mechanisms, such as a bolt and wing nut placed in a track, which allows a user to lock the two base members **36, 38** at a position and desired distance away from each other. Different types of mechanisms for allowing the two (or more) base members **36, 38** to move toward and/or away from each other and for selectively locking the two (or more) base members **36, 38** relative to each other will be apparent to one of ordinary skill in the art in view of this disclosure.

[0035] In some embodiments, the base **32** or bottom portion of one or both sidewalls **28** have inserts, or other protrusions, extending therefrom into the mold **8**. When the molding material is poured into the mold **8**, the inserts create recesses in upper edges of walls of the casting. In one embodiment, such recesses are used for positioning during installation and/or for securing a cover to the top of the casting. In such embodiment, pins can be inserted into the recesses to secure a cover to the top of the casting. Inserts provide increased flexibility and customization of the mold **8** and casting.

[0036] In some embodiments of the invention, one endwall of the adjustable mold **10** has an extension around its periphery, the extension extending from such endwall into the mold **8**. The extension creates a groove or other recess in one end of the casting formed from the mold **8**, such as a U-shaped groove. In such embodiments, the other endwall of the adjustable mold **10** generally has a recess around its periphery, the recess extending into such endwall, creating a tongue or other extension in the other end of the casting formed from the mold **8**, such as a U-shaped tongue. Such grooves and tongues are sized such that the groove in one end of the

casting can receive the tongue in the other end of the casting to interlock the two sections together in an aligned relationship.

[0037] Referring still to the drawings, Figure 3 illustrates a cross-sectional view of the front of an adjustable mold **10** in an assembled, at least partially surrounded and enclosed configuration, in accordance with one embodiment of the invention. As illustrated in Figure 3, the outer portion **14** of the adjustable mold **10** encloses the adjustable die **12** to form the shape of a mold **8** between the outer portion **14** and the adjustable die **12**. As previously discussed, molding material, such as concrete, is poured in the mold **8** until it fills the mold **8** above the height of the adjustable die **12**. After the molding material is poured into the mold **8**, the molding material is allowed to dry, whereafter the formed casting may be removed from the adjustable mold **10**. In some embodiments, the outer portion **14** of the adjustable mold **10** further comprises a lid or cover **50** which is operatively coupled to the periphery of the top of the enclosed sidewalls **28** and/or endwalls to further define the shape of the casting or mold **8** and to protect the mold **8** while the casting is drying. In one embodiment, the cover **50** is secured in place by the weight of the cover **50** itself. In other embodiments, the cover **50** is secured to the periphery of the top of the outer portion **14** of the adjustable mold **10** by one or more locking mechanisms, such as bolts or clamps, which prevent the cover **50** from moving separately from the outer portion **14** while the mold **8** is drying. Other methods for securing the cover **50** to the outer portion **14** will be apparent to one of ordinary skill in the art in view of this disclosure. The cover **50** may further comprise a handle **52** to assist in lifting and removing the cover **52** from the adjustable mold **10** by machinery or an operator of the adjustable mold **10**.

[0001] Many modifications and other embodiments of the inventions set forth herein will come to mind to one skilled in the art to which these inventions pertain having the benefit of the teachings presented in the foregoing descriptions and the associated drawings. Therefore, it is to be understood that the inventions are not to be limited to the specific embodiments disclosed and that modifications and other embodiments are intended to be included within the scope of the appended claims. It should be understood that “operatively coupled” or “coupled,” when used herein, means that the components may be formed integrally with each other, or may be formed separately and coupled together. Furthermore, “operatively coupled” means that the components may be formed directly to each other, or to each other with one or more components located between the components that are operatively coupled together. Furthermore, “operatively

coupled” may mean that the components are detachable from each other, or that they are permanently coupled together. Although specific terms are employed herein, they are used in a generic and descriptive sense only and not for purposes of limitation. In addition, where possible, any terms expressed in the singular form herein are meant to also include the plural form and/or vice versa. As used herein, “at least one” shall mean “one or more” and these phrases are intended to be interchangeable. Accordingly, the terms “a” and/or “an” shall mean “at least one” or “one or more,” even though the phrase “one or more” or “at least one” is also used herein.

THAT WHICH IS CLAIMED:

1. An adjustable mold for making castings of various configurations, the adjustable mold comprising:

an adjustable die comprising:

a core having a protrusion, wherein the protrusion has a configuration; and

a first adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion; and

an outer portion at least partially surrounding the adjustable die to thereby define a mold, the outer portion comprising at least two sidewalls, at least two endwalls, and a base therebetween.

2. The mold according to Claim 1, wherein the configuration of the protrusion has a transverse width that varies along its axial length so as to have a first width at a first portion of the protrusion and a second width at a second portion of the protrusion that is wider or shorter than the first width.

3. The mold according to Claim 1, wherein the protrusion has a triangular configuration.

4. The mold according to Claim 1, wherein the base has at least one base support and at least one base member.

5. The mold according to Claim 1, wherein the core is configured to be removably attached to the base.

6. A mold according to Claim 1, further comprising a second adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion, and wherein the external configuration of the first adapter and the external configuration of the second adapter are different.

7. A method of making castings of various configurations, the method comprising: providing an adjustable mold for making castings of various configurations, the adjustable mold comprising:
- an adjustable die comprising:
 - a core having a protrusion, wherein the protrusion has a configuration; and
 - a first adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion; and
 - an outer portion at least partially surrounding the adjustable die to thereby define a mold, the outer portion comprising at least two sidewalls, at least two endwalls, and a base therebetween; and
 - using the adjustable mold to form a first casting.
8. The method according to Claim 6, wherein the configuration of the protrusion has a transverse width that varies along its axial length so as to have a first width at a first portion of the protrusion and a second width at a second portion of the protrusion that is wider or shorter than the first width.
9. The method according to Claim 7, wherein the protrusion has a triangular configuration.
10. The method according to Claim 7, wherein the base has at least one base support and at least one base member.
11. The method according to Claim 7, and wherein the core is configured to be removably attached to the base.
12. The method according to Claim 7, further comprising providing a second adapter having an external configuration and having a cavity, wherein the cavity is configured to detachably receive the protrusion.

13. The method according to Claim 12, wherein the external configuration of the first adapter and the external configuration of the second adapter are different.

14. The method according to Claim 12, further comprising replacing the first adapter with the second adapter.

15. The method according to Claim 14, wherein replacing the first adapter with the second adapter comprises:

removing the first adapter from the core; and
positioning the second adapter on the core.

16. The method according to Claim 14, further comprising using the adjustable mold to form a second casting having a configuration that is different from the first casting.

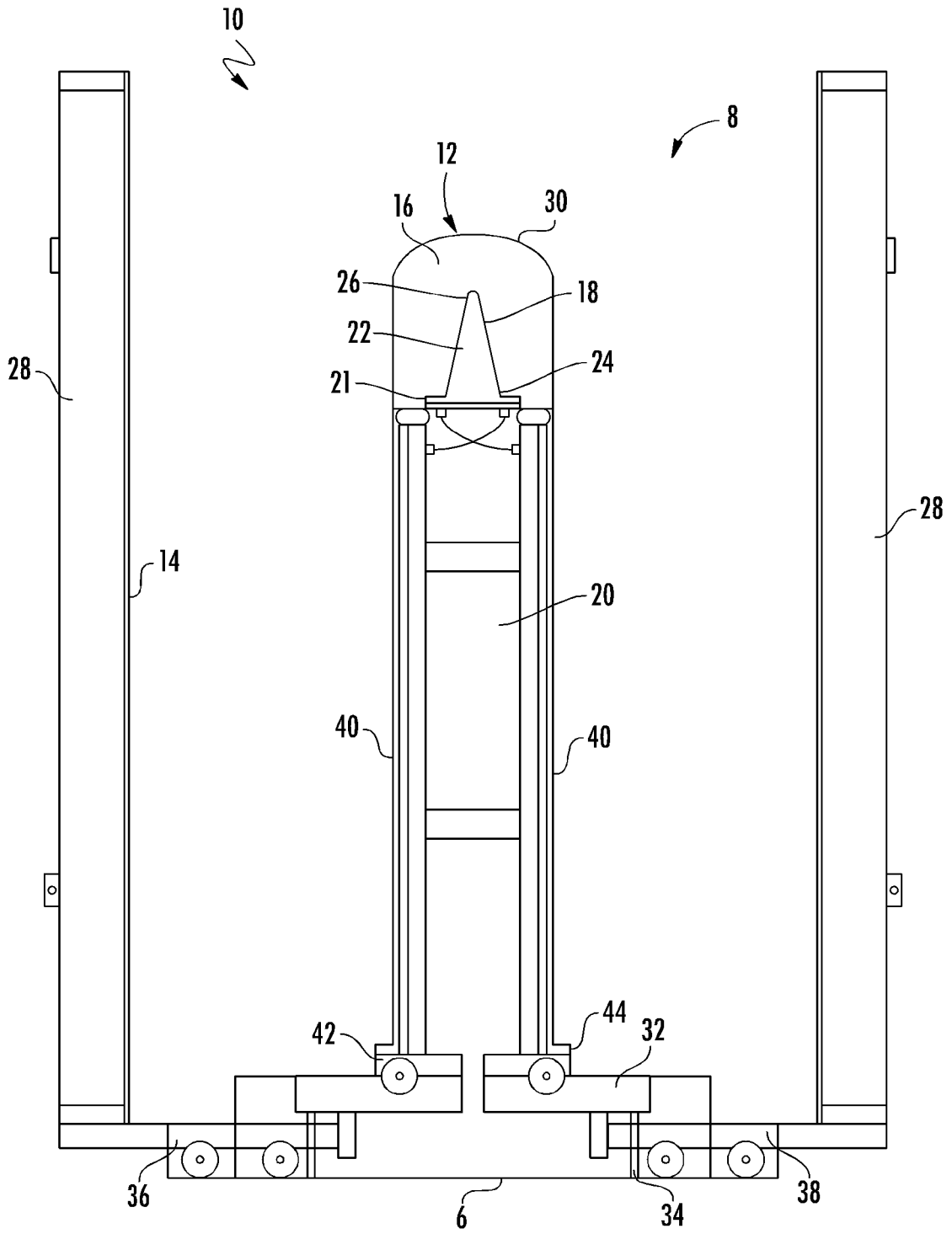


FIG. 1

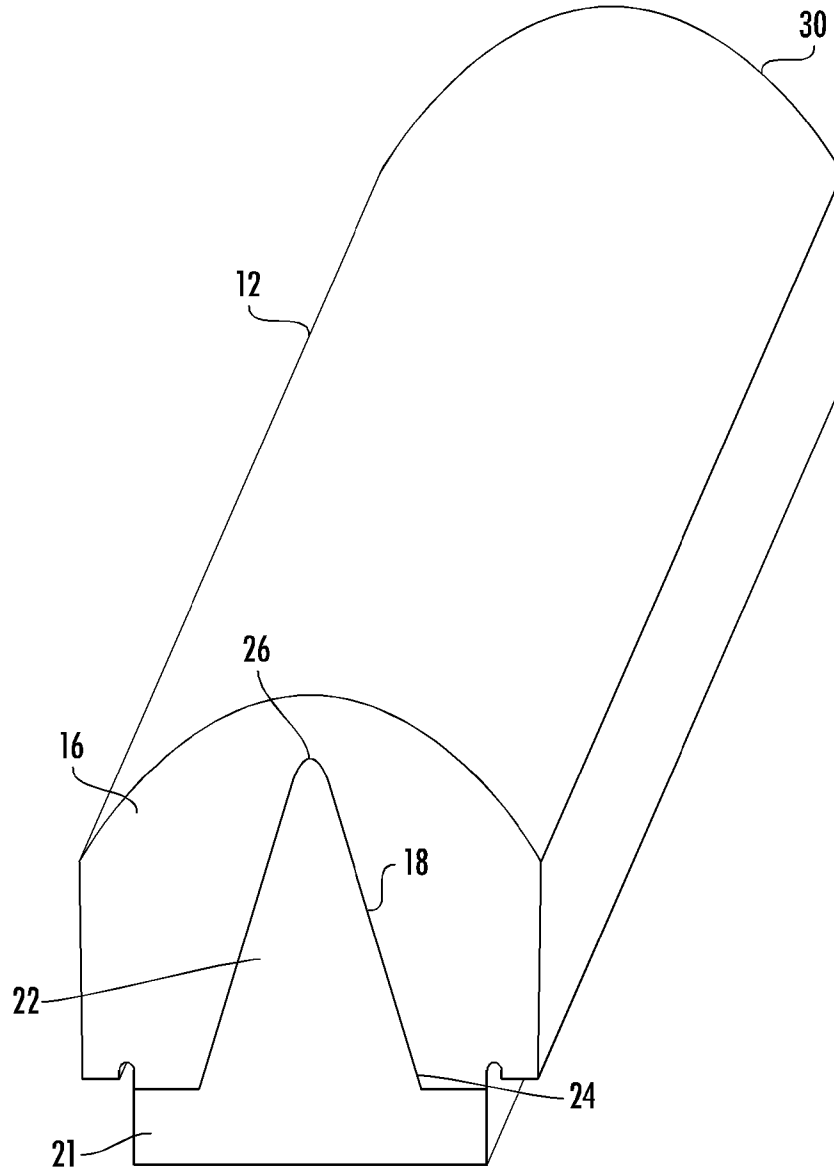


FIG. 2

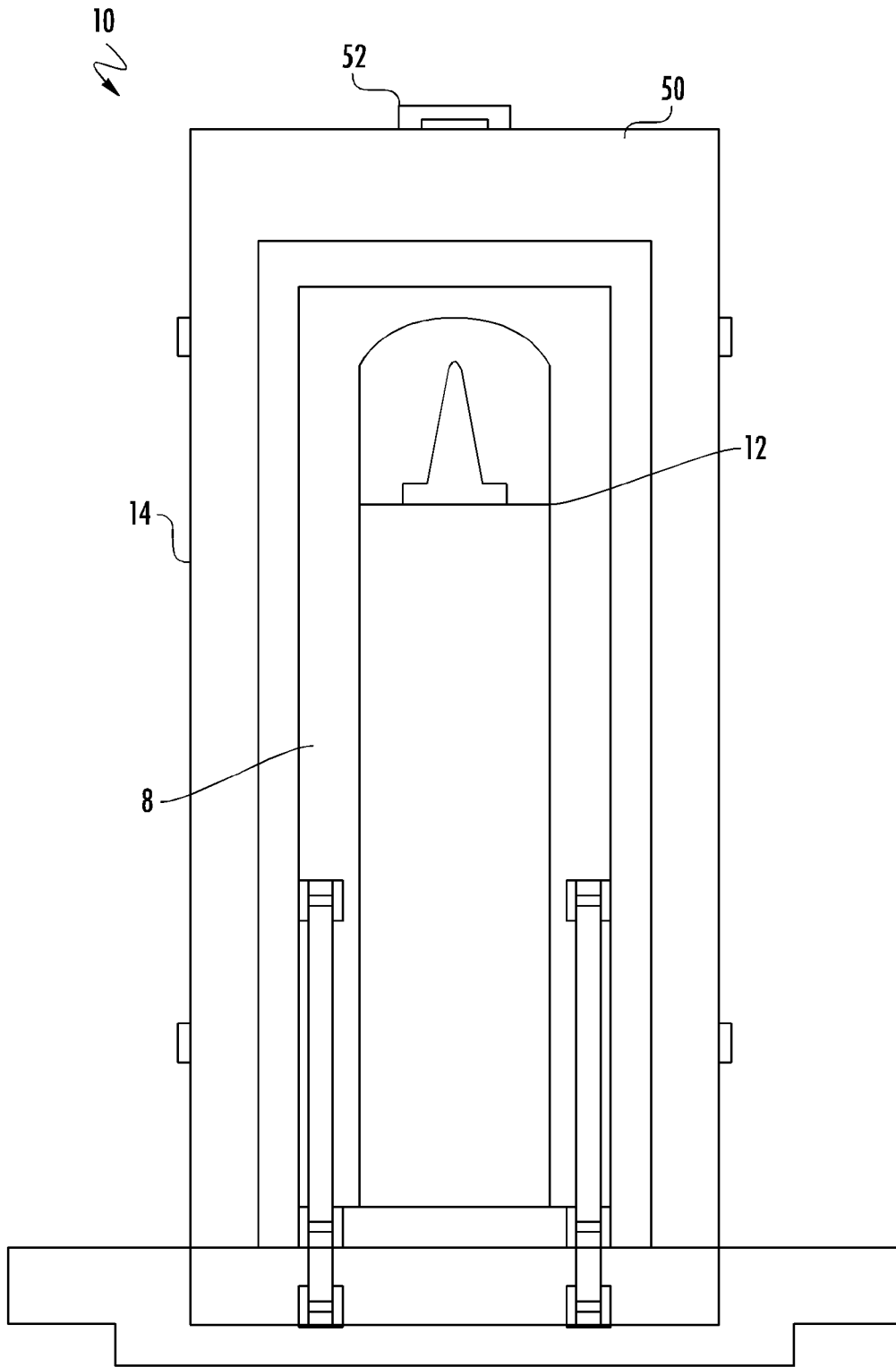


FIG. 3

