

(No Model.)

G. BUCHANAN.
CHILL FOR CASTING SASH WEIGHTS.

No. 531,774.

Patented Jan. 1, 1895.

Fig. 1.

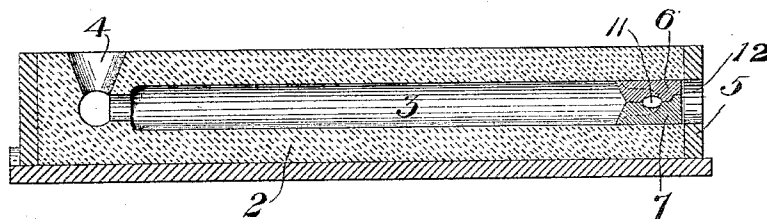


Fig. 2.

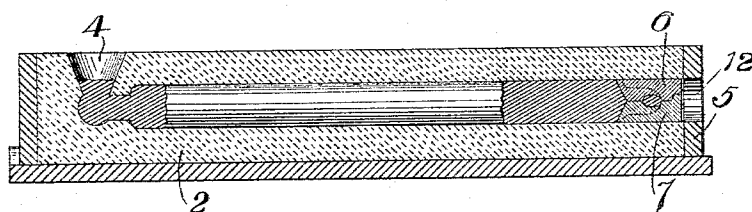


Fig. 3.

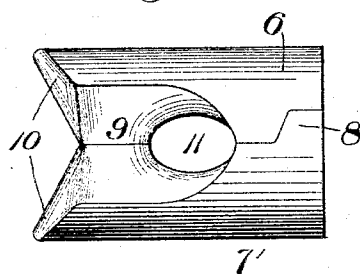
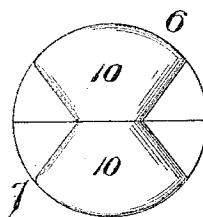


Fig. 4.



WITNESSES

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GEORGE BUCHANAN, OF ALLEGHENY, PENNSYLVANIA.

CHILL FOR CASTING SASH-WEIGHTS.

SPECIFICATION forming part of Letters Patent No. 531,774, dated January 1, 1895.

Application filed August 13, 1894. Serial No. 520,115. (No model.)

To all whom it may concern:

Be it known that I, GEORGE BUCHANAN, of Allegheny city, in the county of Allegheny and State of Pennsylvania, have invented a new and useful Improvement in Chills for Casting Sash-Weights, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is a vertical longitudinal sectional view of a mold provided with my improved chill. Fig. 2 is a similar view after pouring. Fig. 3 is an enlarged side elevation of my divided chill; and Fig. 4 is an end view of the same.

My invention relates to the chills employed in casting sash weights, and is designed to provide a chill which shall be cheaper and lighter than those formerly employed, and which shall occupy less space in the mold and produce an improved article.

In the drawings, 2 represents a mold having the usual matrix cavity 3 and gate 4, and provided with my improved chill, which is of substantially the same size as the matrix cavity, and is pushed in through a hole 12 in the end plate 5 of the mold beyond the inner edge of the plate so that it will fall out with the sand. This chill, as more clearly shown in Figs. 3 and 4, consists of two similar halves 6 and 7, one of which has a projection 8 fitting into a recess in the other to hold them in correct relative position. Each half is cut away on its sides at 9 and is provided with an inclined end face 10, a transverse groove being formed on the inner face of each section, forming the hole 11 for the eye of the weight.

It will be noticed that the end of the weight body proper is formed against the end faces 10, while the eye portion is not inclosed by

the chill, but the sides of the eye portion are formed against the sand of the mold. There is therefore no ring or annular fin formed upon the weight by the inclosing chill, the edges of the eye portion being at the edges of the curved faces 9.

The advantages of my improved chill will be apparent to those skilled in the art, since the chill is small in diameter, takes up little room in the mold, and needs no specially formed aperture therefor, but is pushed into the hole out of which the pattern is drawn. An improved article results, as there is no ring at the upper end, and the side faces of the eye are formed in the sand.

Many variations in the form and arrangement of my improvement may be made by the skilled mechanic without departure from my invention; since

What I claim as new is—

1. A two-part sash weight chill having an eye aperture extending transversely through the same from side to side; substantially as described.

2. A two-part sash weight chill having a transverse eye aperture and open side grooves extending from the ends of the eye aperture to the inner face of the chill; substantially as described.

3. The combination with a sash-weight mold, of a two-part chill having a transverse eye aperture and open grooved sides, said chill being of substantially the same size as the matrix cavity for the weight; substantially as described.

In testimony whereof I have hereunto set my hand.

GEO. BUCHANAN.

Witnesses:

H. M. CORWIN,
F. E. GAITHER.