

(No Model.)

A. JEWETT.
BULLET MOLD.

No. 354,422.

Patented Dec. 14, 1886.

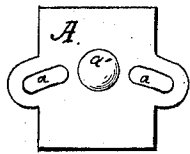


Fig. 1.



Fig. 2.

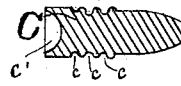


Fig. 3.



Fig. 4.

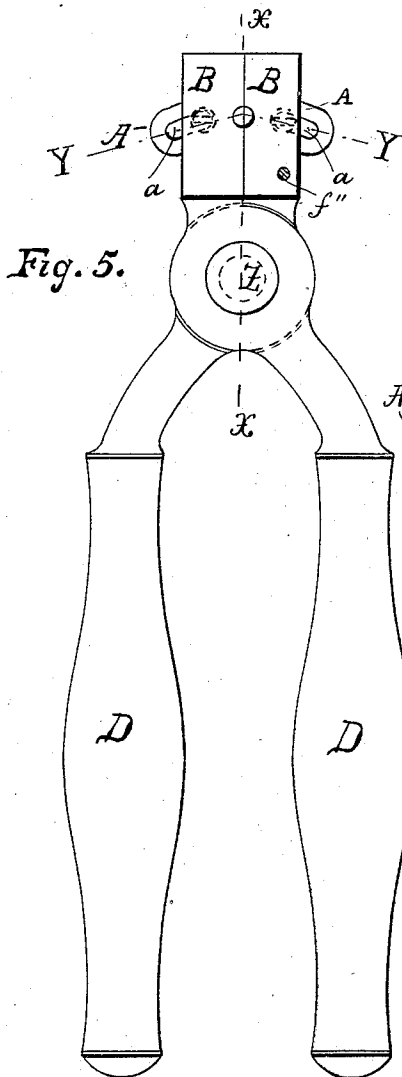


Fig. 5.

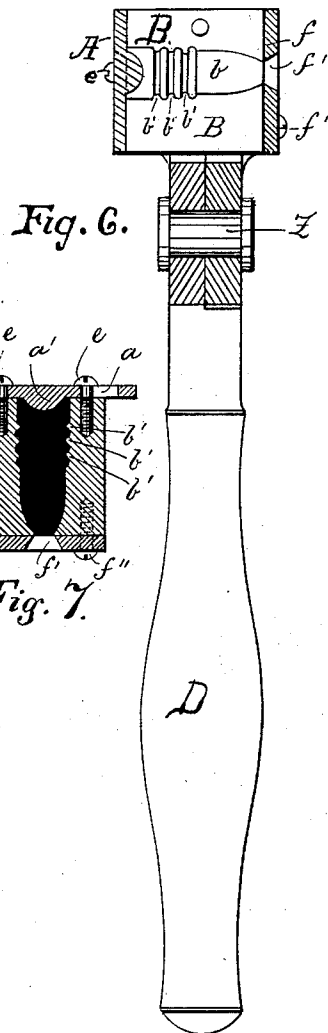


Fig. 6.

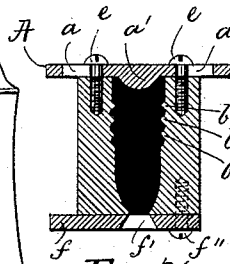


Fig. 7.

Witnesses:
Francis Allen,
Henry Chadbourne.

Inventor.
Amory Jewett.
by *Alban Andrew*
his atty

UNITED STATES PATENT OFFICE.

AMORY JEWETT, OF SOMERVILLE, MASSACHUSETTS.

BULLET-MOLD.

SPECIFICATION forming part of Letters Patent No. 354,422, dated December 14, 1886.

Application filed October 11, 1886. Serial No. 215,831. (No model.)

To all whom it may concern:

Be it known that I, AMORY JEWETT, a citizen of the United States, and a resident of Somerville, in the county of Middlesex and State of Massachusetts, have invented new and useful Improvements in Bullet-Molds, of which the following, taken in connection with the accompanying drawings, is a specification.

This invention relates to improvements in bullet-molds for the purpose of making cast lead bullets having circumferential grooves and central rear or base recess; and the invention is carried out as follows, reference being had to the accompanying drawings, where—
Figure 1 represents an interior view of the self-centering back plate, with its projection for making the rear central recess in the bullet when cast in the molds. Fig. 2 represents a central longitudinal section of said self-centering back plate. Fig. 3 represents a central longitudinal section of the bullet made by my improved molds. Fig. 4 represents a rear view of said bullet. Fig. 5 represents a front elevation of my improved bullet-molds, showing the perforated cutter-plate as removed. Fig. 6 represents a central longitudinal section on the line X X, shown in Fig. 5, and Fig. 7 represents a cross-section on the line Y Y, also shown in Fig. 5.

Similar letters refer to similar parts wherever they occur on the different parts of the drawings.

C in Figs. 3 and 4 represents the form of bullet that I produce by my improved molds, such bullet having the circumferential grooves *c c c* and central rear recess, *c'*, as shown in said Figs. 3 and 4. To cast such a bullet, and at one and the same operation produce on it said circumferential grooves and central rear recess, is the object of my invention, for which purpose I make my improved bullet-molds as follows:

B B are the molds, open from end to end, each one having a cavity, *b*, equal to one-half of the bullet to be cast, and semicircular ribs or projections *b' b' b'*, for producing the circumferential grooves *c c c* on the bullet. The molds B B are pivoted together by means of a bolt or rivet, Z, (shown in Figs. 5 and 6,) and provided with the respective handles D D, as is common in bullet-molds.

A is the self-centering back plate, located at

the rear of the molds B B, and connected to the latter by means of headed screws *e e*, that pass loosely through the curved or inclined slots *a a* in the plate A, and are screwed into screw-threaded perforations in the rear ends of molds B B, as shown in Fig. 7, by which arrangement the molds B B may be expanded or closed without changing the position of the back plate, A. The plate A has on its inside a circular projection or core, *a'*, corresponding in size and shape to the desired recess or cavity, *c'*, to be given to the rear end or base of the bullet C. The curved or inclined slots *a a* are of such a length as to cause the insides of the screws *e e* to bear against the inner termini of said slots when the molds B B are closed, as shown in Fig. 7, by which arrangement the plate A is held in such a position relative to the closed molds B B as to cause the projection or core *a'* to be centrally in a line with the bullet-cavity in the molds B B, and when the molds B B are expanded to their extreme limit the screws *e e* serve as stops against the outer termini of the slots *a a*, to prevent the molds from being opened farther than is necessary for the removal of the cast bullet.

At *f''* on one of the molds B is pivoted to the front end of the latter the shear or cutter plate *f*, as is common in bullet-molds, such cutter-plate having a conoidal perforation, *f'*, (shown in Figs. 6 and 7,) that is placed centrally in a line with the mold-cavity in the molds B B when the bullet is to be cast. The molten metal is then poured into the mold-cavity through the perforation *f'*.

In using my improved molds I proceed as follows: The molds B B are closed, as shown in Fig. 5, causing the core or projection *a'* on plate A to be centered relative to the mold-cavity in molds B B, as described. I then swing the plate *f* around its pivot *f''*, so that its hole *f'* coincides with the forward end of the mold-cavity in molds B B, after which I pour the molten metal through hole *f'* into the mold-cavity in the molds B B, causing the bullet to be shaped with circumferential grooves *c c c* and rear or base cavity, *c'*, as shown in Fig. 3. By swinging the cutter-plate *f* to one side the surplus ingot metal at the forward end of the bullet is sheared off, after which the molds B B are opened as far as the slots *a a* in plate A will allow, and the now finished bullet is

dropped out of the molds and a new one cast in the same manner, and so on.

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

5 1. The expansive molds B B, pivoted together and having connected to their rear ends the plate A, having the core or projection *a'* on its inside for the purpose of forming a cavity or recess in the base of the bullet, as set
10 forth.

2. The expansive bullet-molds B B, having mold-cavities *b b* and semicircular ribs *b' b' b'*,

as described, in combination with the self-centering back plate, A, having core or projection *a'* for the formation of the rear cavity in 15 the base of the bullet, as set forth.

In testimony whereof I have signed my name to this specification, in the presence of two subscribing witnesses, on this 9th day of October, A. D. 1886.

AMORY JEWETT.

Witnesses:

ALBAN ANDRÉN,
HENRY CHADBOURN.