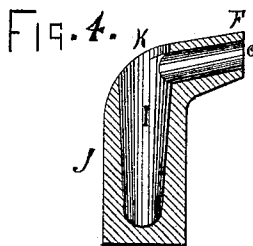
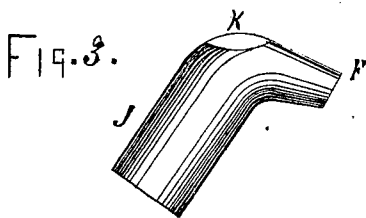
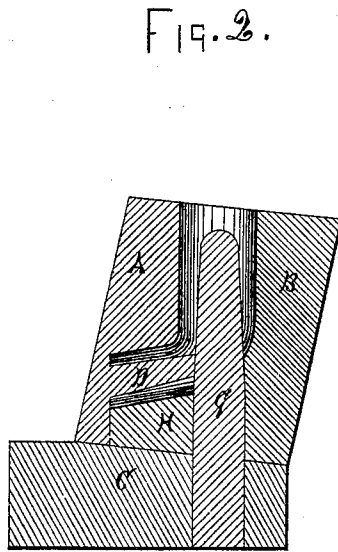
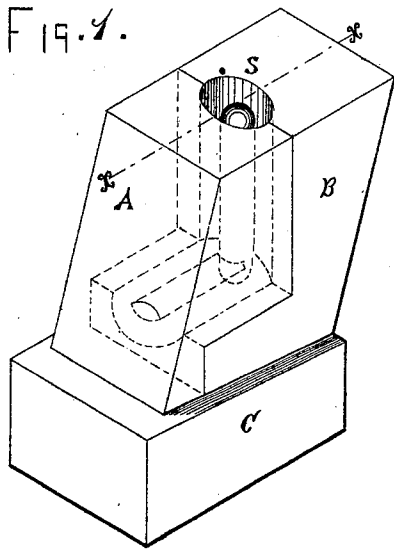


EDWARD CLATOR.

Improvement in Molds for Casting Whistles.

No. 127,956.

Patented June 18, 1872.



WITNESSES.

Stanton W. Howard
William Erskine

INVENTOR.

Edward Clator
By J. Bone McLeese
Attorney.

UNITED STATES PATENT OFFICE.

EDWARD CLATOR, OF WHEELING, WEST VIRGINIA, ASSIGNOR OF ONE-HALF HIS RIGHT TO J. BOONE McLURE, OF SAME PLACE.

IMPROVEMENT IN MOLDS FOR CASTING WHISTLES.

Specification forming part of Letters Patent No. 127,956, dated June 18, 1872; antedated June 4, 1872.

To all whom it may concern:

Be it known that I, EDWARD CLATOR, of the city of Wheeling, in the county of Ohio and State of West Virginia, have made the inventions hereinafter described relating to Cast Whistles and their Manufacture, of which the following is a specification, reference being had to the accompanying drawing and the letters of reference thereon.

My inventions consist, first, of a mold in which whistles of a mouth-piece and a body or bowl—the one being to the other at such an angle that the air, or a sufficient quantity thereof, when blown through the mouth-piece will strike against the inside of the part bordering the air-discharge aperture therein at the place of the intersection of the mouth-piece and the bowl—are cast from sugar, plaster of Paris, and other suitable materials upon two cores, so arranged in the mold that the air-passage in the mouth-piece will be formed by one core, and the air-chamber in and throughout the bowl or body and the air-discharge aperture will be entirely formed by the other; and, second, of the whistle constructed and produced, as above described, as an improved article of manufacture.

Figure 1 is an elevation of the molds set up for use. Fig. 2 is a vertical half-section of the same, the section being taken on the line *x x*, Fig. 1, and showing the construction of the mold and the arrangement of the cores therein to produce the whistle. Fig. 3 is an elevation of a complete whistle made according to my improvement. Fig. 4 is a half-section of the same taken lengthwise of the whistle, and showing its acoustic construction.

Like letters of reference indicate like parts.

A and B are two parts, which together have the form of the exterior of the whistle. C is another and the base part. The part A is provided with a core, D, to form the air-passage E in the mouth-piece F of the whistle. The part C is also provided with a core, G, which passes up through a close-fitting aperture, H,

in part B, to form the air-chamber I throughout the body J of the whistle, and also to form the air-discharge aperture K. When the mold is set up for use the end of core D partly embraces core G at the place of their intersection, thereby completing the air-passage through the mouth-piece, and bringing it in communication with the air-chamber and discharge-aperture.

The casting is effected by pouring the material out of which the whistle is to be made into the mold through the opening S in the top of the mold, and when it has sufficiently hardened therein it is removed therefrom by taking off part A, so as to withdraw core D from out of the mouth-piece, when the whistle is lifted from off the core G by the lifting of part B; or the same can be done by withdrawing core G with part C from out of the body of the whistle. It is evident that core G may be directly attached to part B instead of to part C, as above described, and in which case the whistle would be merely lifted from off core G and out of part B, in which case the part C might or might not be used, as desired; but this would be only a modification of the mold before described, and of the way of relieving the whistle from the mold and cores, because the principle is the same, and I only prefer the former in order that the whistle need not be on its exterior of only such a form that would admit of its being delivered by the latter, but instead thereof of any desired exterior. The acoustic principle of this whistle is that familiarly illustrated by blowing into a key or a bottle so as to produce a whistle.

Having described my invention, I claim as new and desire to secure by Letters Patent—

The whistle-mold, provided with cores D and G, all constructed and operated substantially as herein set forth.

EDWARD CLATOR.

Witnesses:

J. B. McLURE,
STANTON M. HOWARD.