UNITED STATES PATENT OFFICE.

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JACKET FOR SAND MOLDS.


Fig. 4, is a cross-sectional view through the sand mold and cores as arranged for pouring the metal.

Fig. 5, is a view of a flask, partly in broken section, showing the manner of using a flask as a pattern for the jackets.

As here shown the jacket is an integral rectangular shaped casting, —1, conforming to the shape of a flask. Flanges 2 and —3, are formed on the four sides of the jacket 60 flange —2 serving as a hand hold for raising and lowering the jacket relative to the sand mold, and flange —3 as a base for the jacket, both flanges acting to strengthen the jacket and to keep the sides straight in casting.

The jackets are made in sets, each set conforming in inside length, width and taper to the sand flask in connection with which the jackets are to be used. While any suitable pattern may be used for producing the jackets, the best results are obtained, and with reduced pattern cost, by using the sand flasks as patterns. By adding a bottom extension —4, to a flask —5, as indicated in Fig. 5, of the drawings, to compensate for shrinkage of the metal in casting, the inside dimensions in length, breadth and taper of the flask can be closely approximated in the jacket castings made from it, the height, thickness of the walls and external conformation of the castings being determined by using suitable cores, as indicated in Fig. 4, in preparing the molds.

Having described my invention, I claim:

1. The herein described method of casting jackets for sand molds consisting in adapting a sand flask as the pattern for a jacket, in using the flask so constructed to form the inner part of a sand mold for the jackets, in arranging cores relative the said inner part to complete the mold and in casting a jacket therein.

2. The herein described method of casting jackets for sand molds consisting in adapting a sand flask as the pattern for a jacket, by adding an extension of the flask to the bottom thereof, in using the flask as constructed to form the inner part of a sand mold for the jackets, in arranging cores
relative to said inner part to complete the mold and in casting a jacket therein.

3. The herein described method of casting jackets for sand molds consisting in adapting a common sand flask as the pattern for a jacket, in supporting the flask in raised position relative to the inner sand mold for the jacket to compensate for shrinkage of the metal in casting with respect to the taper of said jacket, in arranging cores externally to complete said mold and in casting a jacket therein.

In testimony whereof I affix my signature.

SAMUEL P. GREENE.