

C. W. BROCKUNIER.
 Manufacture of Glassware.

No. 162,216.

Patented April 20, 1875.

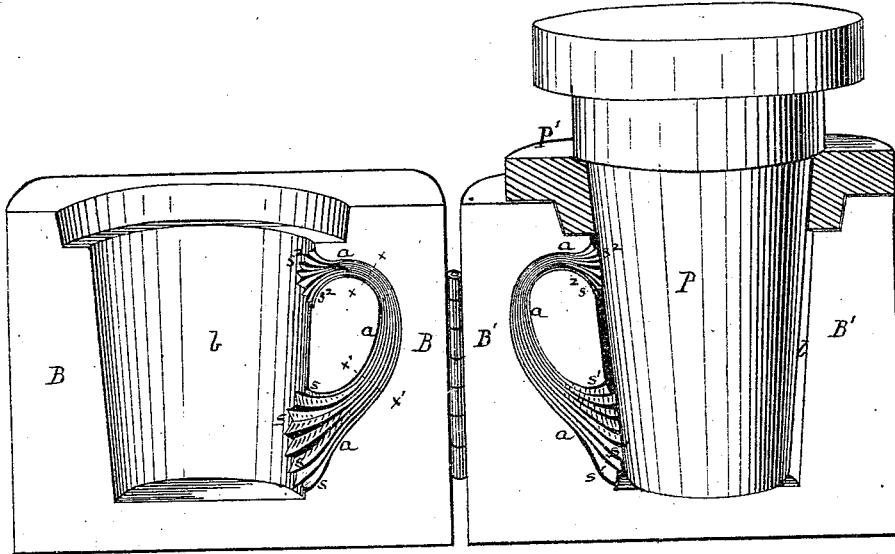


Fig. 1.

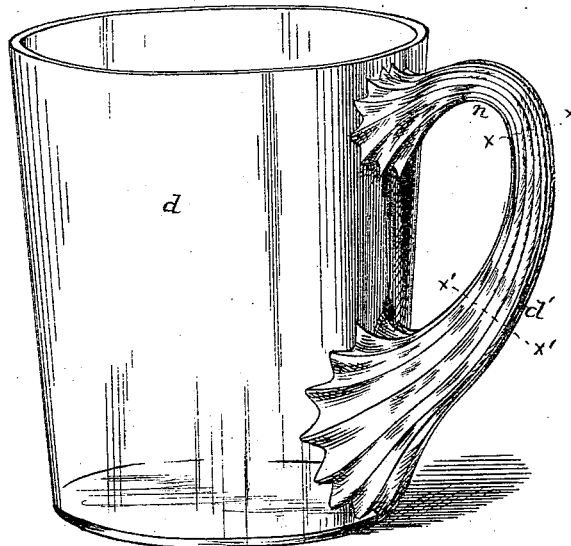


Fig. 2.



Fig. 3.

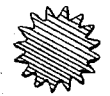


Fig. 4.

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UNITED STATES PATENT OFFICE.

CHARLES W. BROCKUNIER, OF BRIDGEPORT, OHIO.

IMPROVEMENT IN THE MANUFACTURE OF GLASSWARE.

Specification forming part of Letters Patent No. **162,216**, dated April 20, 1875; application filed March 27, 1875.

To all whom it may concern:

Be it known that I, CHARLES W. BROCKUNIER, of Bridgeport, county of Belmont, State of Ohio, have invented or discovered a new and useful Improvement in Manufacture of Glassware; and I do hereby declare the following to be a full, clear, concise, and exact description thereof, reference being had to the accompanying drawing, making a part of this specification, in which—like letters indicating like parts—

Figure 1 is a view in elevation of the inside of a two-part or jointed mold with the plunger and ring in position, such as I use in carrying out my invention, and as a part thereof. Fig. 2 is a perspective view of a lemonade-glass as produced in such mold, and Figs. 3 and 4 are transverse sectional views of the handle in the lines $x x$ and $x' x'$.

My improvement relates to the manufacture of pressed articles of domestic or table glassware having a bowl and ribbed or corrugated handle, both pressed at the same time and in the same jointed or divided mold.

Such a mold is shown in the drawing, where B B' represent the two halves of the mold in jointed form, each half or part having a cavity, $b b$, of suitable form for giving the desired exterior shape to the bowl d to be pressed therein. Each half-mold also contains one-half of a handle-cavity, a , the faces of such cavities being made with ribs or corrugations $s s'$, extending lengthwise of the cavities, from the lower plane or point of junction with the bowl-cavity to or toward the upper end. These ribs or corrugations are preferably made each angular in cross-section, and are so disposed at the base or lower end as to give in the product the imitation of a shell, leaf, or star, or other like figure. From the base end they gradually taper, both in width and depth, toward the upper end, so that the finished product, while retaining the corrugated appearance, shall have a comparatively smooth surface to take

hold of; but such corrugations may run out entirely at or about the curve n of the handle, though with a less satisfactory result. As shown in the drawing, the corrugations $s s'$ extend the entire length of the cavities a , and as they approach the plane or point of junction with the bowl-cavities $b b$ at their upper ends, they increase in size somewhat, as at s^2 , so as to secure the same result at the upper as at the lower end of the handle. The line of division or joint of the handle-cavities is preferably made along the apex of one of the ribs s , so that the fin shall be practically not noticeable, and the fin on the bowl may be concealed in like manner, or, if made on a plain body, may be removed by fire-polishing, in the usual way.

By this means I produce an article having a pressed bowl, d , of any desired form, and a pressed ribbed handle, d' , having the imitation appearance described. The pressing is done in the ordinary way, by a plunger, P, working through the ring P'.

Such ribbed handle-cavities may be combined with bowl-cavities of other forms, and, when desired, may be duplicated on the opposite sides of the bowl-cavities.

What I claim as my invention, and desire to secure by Letters Patent, is—

1. A jointed or divided mold for pressing glassware, having, in combination with the bowl-cavities, longitudinally-ribbed handle-cavities $a a$, substantially as set forth.

2. A pressed bowl and pressed longitudinally-ribbed handle, the ribs tapering from either end or both ends of the handle to or toward the bow or curve, substantially as set forth.

In testimony whereof I have hereunto set my hand.

CHARLES W. BROCKUNIER.

Witnesses:

W. J. W. COWDEN,
GEORGE H. CHRISTY.