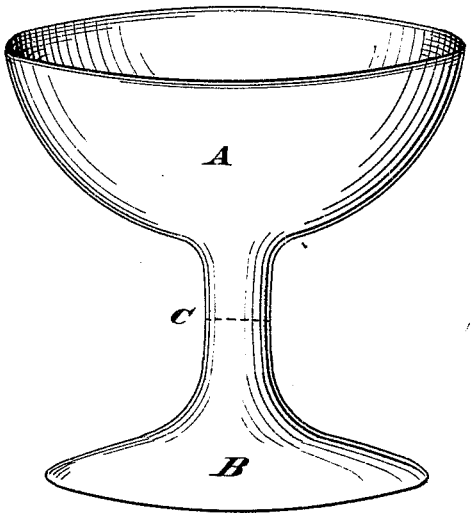
L. WAGNER.

MANUFACTURE OF GLASS-WARE.

No. 180,970. Patented Aug. 8, 1876.



Attest.

James C. Dodge
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Inventor.

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UNITED STATES PATENT OFFICE

LOUIS WAGNER, OF WHEELING, WEST VIRGINIA, ASSIGNOR TO J. H. HOBBS BROCKUNIER & CO., OF SAME PLACE.

IMPROVEMENT IN THE MANUFACTURE OF GLASSWARE.

Specification forming part of Letters Patent No. **180,970**, dated August 8, 1876; application filed July 27, 1874.

To all whom it may concern:

Be it known that I, LOUIS WAGNER, of Wheeling, in the county of Ohio and State of West Virginia, have invented certain Improvements in the Manufacture of Glassware, of which the following is a specification:

My invention relates to stemmed articles of glassware, and consists in forming the article in two pieces—the one being the bowl and a portion of the stem, and the other the foot and a portion of the stem—and uniting the two portions together at a welding-heat or in other appropriate manner, so that the joint lies in the stem between the bowl and the foot, instead of at the top of the stem, as heretofore.

The drawing represents a cup or goblet, in which A is the bowl, B the foot, and C the stem.

In the ordinary method of forming the foot and stem in one piece and joining the bowl to the top of the stem, the article almost invariably breaks by any sudden change of temperature, and very often immediately after finishing. The cause of this breakage is the unequal expansion and contraction of the bowl and stem, and the necessary imperfection of a joint formed between parts so different in shape and construction. I obviate this by forming the bowl and a portion of the stem—say, as far as the dotted line at C—in one piece, and the foot and lower part of th stem as far as the same dotted line C, in an other piece, and then uniting the two, eithe in the ordinary manner by the use of third or a welding piece, or by the method o pressing together in a mold while in a plasti state, as described in J. H. Reighard's re issued Patent 5,924, of June 16, 1874, whic latter I prefer, as it forms a more perfect join The two portions of the stem, being of equa size, shape, and density, will expand and cor tract equally, and consequently there will b no strain from that cause on the joint. Thi location of the joint also permits the differen operations of manufacture to be effected wit greater facility, and, consequently, at a lowe cost than is possible by the ordinary metho and at the same time produces ware of grea er stability.

Having thus described my invention, claim—

A stemmed article of glassware, formed i two pieces, the upper consisting of the bov and a portion of the stem, and the lower i the foot and a portion of the stem, whe joined together at a point in the stem betwee the bowl and foot.

LOUIS WAGNER.

Witnesses:

JAY E. RATCLIFFE,

JAMES COX.