W. TAYLOR.

Gate for Pattern.

No. 204,510. Patented June 4, 1878.

Fig: 1.

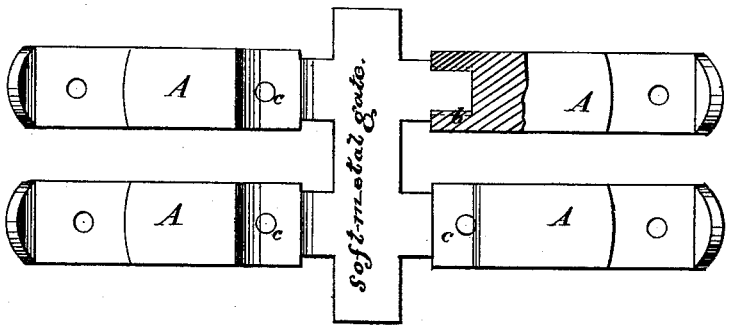


Fig: 2.

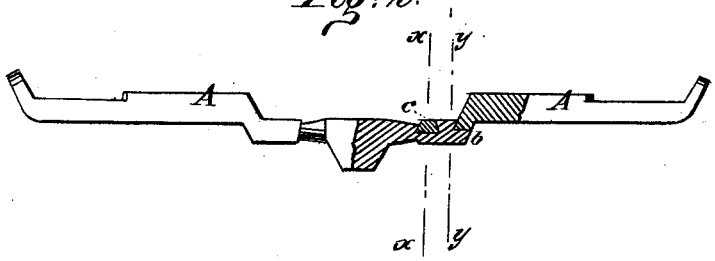


Fig: 3.

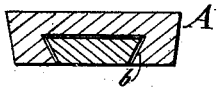
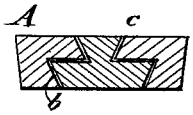


Fig: 4.



WITNESSES:

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UNITED STATES PATENT OFFICE.

WILLIAM TAYLOR, OF PEEKSKILL, NEW YORK, ASSIGNOR TO HIMSELF AND GEORGE W. ROBERTSON, OF SAME PLACE.

IMPROVEMENT IN GATES FOR PATTERNS.

Specification forming part of Letters Patent No. **204,510**, dated June 4, 1878; application filed April 17, 1878.

To all whom it may concern:

Be it known that I, WILLIAM TAYLOR, of Peekskill, in the county of Westchester and State of New York, have invented a new and useful Improvement in Gates for Patterns, of which the following is a specification:

Figure 1 is a plan view, partly in section, illustrating my improvement. Fig. 2 is a side elevation, partly in section. Fig. 3 is a transverse section taken on line *y y* in Fig. 2. Fig. 4 is a transverse section on line *x x* of Fig. 2.

Similar letters of reference indicate corresponding parts.

My invention relates to an improved method of attaching gates to patterns for foundry use.

The invention will first be described in connection with the drawing, and then pointed out in the claim.

Referring to the drawing, A A are patterns, in each of which is formed a dovetail slot, *b*, and a countersunk hole, *c*. The patterns thus slotted and drilled are molded in sand in the usual way, and when the cope is removed the patterns are taken from the sand and cleaned to remove every particle of sand from the dovetail slot and from the countersunk hole. The mold for the gate is then formed in the sand in the usual way, and the patterns are replaced and the flask is closed. An easily-fused alloy is then poured into the mold to fill the molds for the gates, and also the holes and slots in the patterns.

The pattern, after cooling, is fitted by filing and scraping, and is ready for use.

Patterns attached in this manner are not easily broken from the gate in the operation of ramming the mold or rapping the pattern, as is the case with patterns made wholly from cast-iron; and the patterns are attached at a trifling expense compared with the usual method of riveting them to wrought-iron gates, besides giving the gate a better form for molding and for detachment from the casting.

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

The combination of a gate formed of easily-fused metal, interlocked with a pattern having countersunk holes or dovetail slots, or both, substantially as herein shown and described.

WILLIAM TAYLOR.

Witnesses:

FRANKLIN COUCH,

C. I. SOUTHARD.