

(No Model.)

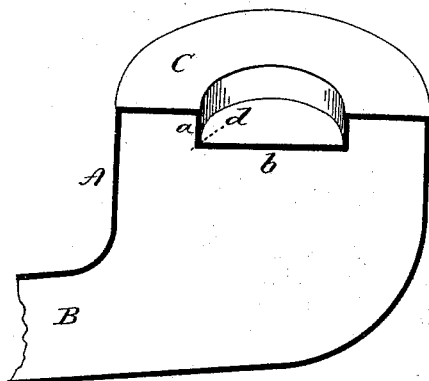
J. A. TALMADGE.

MANUFACTURE OF GLASS WATER CLOSET BOWLS.

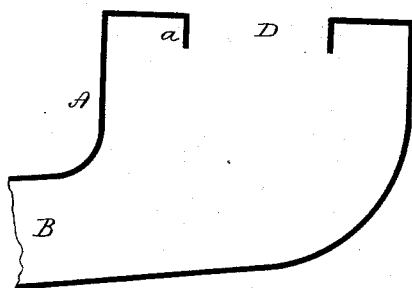
No. 266,918.

Patented Oct. 31, 1882.

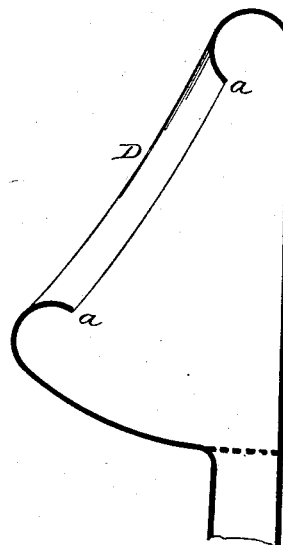
*Fig. 1*



*Fig. 2*



*Fig. 3*



*Witnesses.*

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# UNITED STATES PATENT OFFICE.

JUNIUS A. TALMADGE, OF MERIDEN, CONNECTICUT.

## MANUFACTURE OF GLASS WATER-CLOSET BOWLS.

SPECIFICATION forming part of Letters Patent No. 266,918, dated October 31, 1882.

Application filed July 31, 1882. (No model.)

*To all whom it may concern:*

Be it known that I, JUNIUS A. TALMADGE, of Meriden, in the county of New Haven and State of Connecticut, have invented a new Improvement in the Manufacture of Glass Water-Closet Bowls and Urinals; and I do hereby declare the following, when taken in connection with the accompanying drawings and the letters of reference marked thereon, to be a full, clear, and exact description of the same, and which said drawings constitute part of this specification, and represent, in—

Figure 1, a sectional perspective view of a water-closet bowl as it comes from the mold; Fig. 2, the same as completed; Fig. 3, a vertical section of a urinal.

My invention relates to an improvement in that class of hollow articles which require an opening in the top of less diameter than the top, with special reference to water-closet bowls and urinals, but applicable to other hollow articles, and is an improvement on the invention for which Letters Patent were granted to George E. Hatch, dated June 28, 1881, No. 243,447. In the invention of Hatch the flange around the opening in the top of the bowl is turned upward in order to form an inverted-V shape at the upper edge of the flange, the "blow-over" standing below the apex of the V, and so that grinding off the apex of the V separates the blow-over and finishes the flange; but in practice it is found that the water, in flushing the bowl, will be thrown inward over the opening, there being no protection around the opening against the flow of water.

The object of my invention is to provide a downwardly-projecting flange which shall serve as a stop to prevent the over or inward flow of the water; and my invention consists in hollow articles of glass blown in molds and having a sunken recess in the top corresponding to the opening required to be made, the blow-over or bottom of the recess cut away to leave an inward or downwardly projecting flange around the opening, as more fully hereinafter described.

A represents the top of the bowl, and as one

of that class in which the outlet B is at one side; C, the top; D, the opening through the top; *a*, the downwardly-projecting flange around the opening B.

In the manufacture of this bowl I construct the mold corresponding to the exterior of the bowl with an inward projection corresponding to the opening D. The glass is then introduced and blown into the mold, shaping the bowl accordingly. The blow-over *b* closes the opening, as seen in Fig. 1. After the bowl is removed from the mold a cutter is applied at the lower angle of the recess, as at *d*, to cut away the blow-over and leave the downwardly-projecting flange *a*, as seen in Fig. 2. This flange protects the opening from the flow of water, and serves to turn the water which approaches the opening back into the bowl. I make urinals in the same manner, a recess corresponding to the opening of the urinal extending inward the distance required for the flange. Then the blow-over cut-off will leave the inwardly-projecting flange. This method of making an inwardly-projecting flange may be applied to other hollow articles of glass. I therefore do not wish to limit my invention to the manufacture of water-closet bowls and urinals; but

What I do claim is—

1. The herein-described improvement in hollow articles of blown glass having an opening formed therein, consisting in forming a recess in the article corresponding to the opening to be made and in the process of blowing, the blow-over forming a bottom to said recess, and subsequently cut away, leaving an inwardly-projecting flange around said recess, substantially as described.

2. As a new article of manufacture, the herein-described bowl for water-closets and urinals as made from glass blown in a mold and having the inwardly-projecting flange *a* around the opening, substantially as described.

JUNIUS A. TALMADGE.

Witnesses:

GEO. E. HATCH,  
T. B. CLARK.