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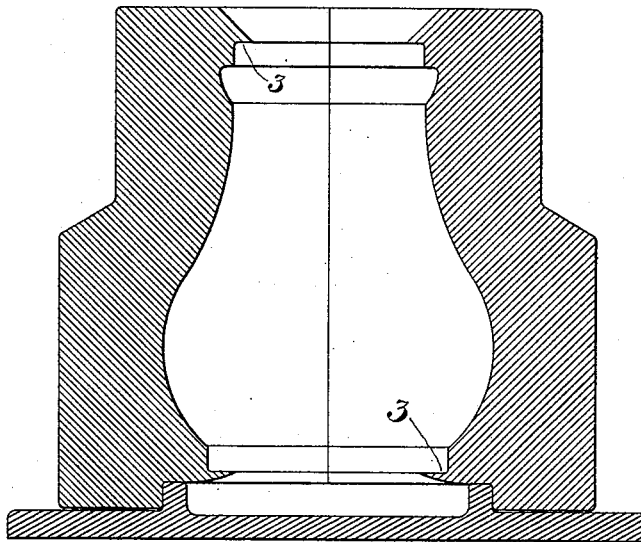
2 Sheets—Sheet 1.

F. W. STEWART.  
MANUFACTURE OF LANTERN GLOBES.

No. 523,133.

Patented July 17, 1894.

*Fig. 1.*



WITNESSES

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*A. L. Gill*

INVENTOR

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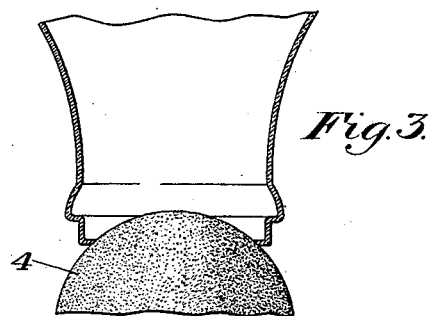
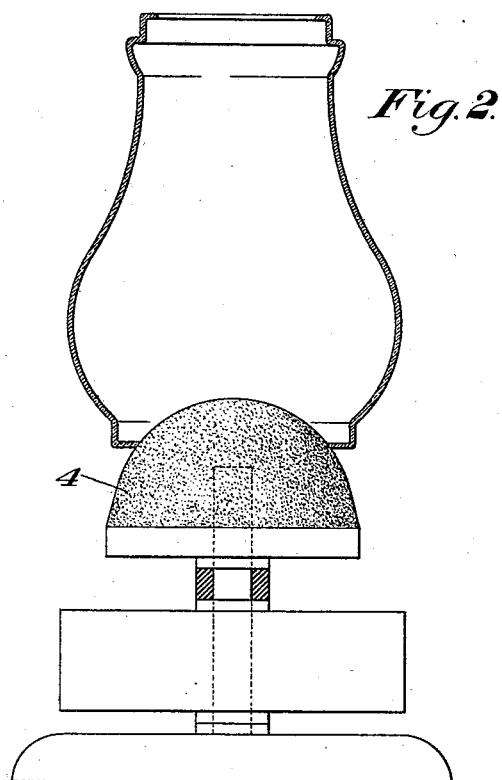
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*H. M. Cram*  
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INVENTOR

*Fred W. Stewart*  
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# UNITED STATES PATENT OFFICE.

FRED W. STEWART, OF BELLAIRE, OHIO, ASSIGNOR OF ONE-HALF TO W. C. BERGUNDTHAL, OF SAME PLACE.

## MANUFACTURE OF LANTERN-GLOBES.

SPECIFICATION forming part of Letters Patent No. 523,133, dated July 17, 1894.

Application filed July 12, 1893. Serial No. 480,247. (No specimens.)

*To all whom it may concern:*

Be it known that I, FRED WILLIAM STEWART, of Bellaire, in the county of Belmont and State of Ohio, have invented a new and useful Improvement in the Manufacture of Lantern-Globes, of which the following is a full, clear, and exact description, reference being had to the accompanying drawings, forming part of this specification, in which—

Figure 1 is a vertical sectional view of my improved mold. Fig. 2 is a side elevation, partly in section of the grinding apparatus I employ, showing the method of grinding the lower end of the globe; and Fig. 3 is a similar view of the upper end of the globe.

My invention relates to the manufacture of lantern globes and similar glass articles, and is designed to produce articles of exactly the same length and with smooth blown upper and lower bearing faces.

Heretofore, in the manufacture of globes and glass articles, one or both of their ends have necessarily been ground off to remove the rough and uneven end faces formed in the manufacture. This grinding is a very difficult operation, and it is impossible to grind them uniformly and produce globes of the same length. I avoid these difficulties by blowing the globe in the mold of Fig. 1, having an annular inwardly projecting offset or shoulder 3 at its upper and lower ends, against which shoulders the upper and lower faces of the globe are formed in blowing. These shoulders are preferably beveled inwardly to produce a thin knife-edge upon their interior, as shown, producing a crack-off or blow-over upon the globe, these blow-overs being formed upon the inner projecting edges of the end flanges. These blow-overs are broken off

when the globe is removed from the mold, and the rough inner edges of the end faces are then ground off by the conical or oval grinding wheel 4 of Fig. 2, which projects within the globe and adjusts itself to the size of the opening.

The advantages of my invention will be apparent to those skilled in the art, since globes are produced which are of exactly the same length and have smooth fired end faces. Moreover no skilled labor is necessary as formerly, when a high degree of skill was essential to the grinding of the end faces, and the method is applicable to any kind of ware which is ground at either the top or bottom.

The inner rough edges may be removed by other means than grinding, and many other variations may be made without departure from my invention, since

What I claim is—

1. The method of manufacturing globes and glass articles, consisting in blowing them in a mold with an end flange, and then removing the rough inner edge of said flange; substantially as described.

2. The method of manufacturing globes and glass articles, consisting in blowing them in a mold with an end flange, and then grinding off the rough inner edge of said flange; substantially as described.

3. As a new article of manufacture, a globe having a lateral end flange with a ground inner edge; substantially as described.

In testimony whereof I have hereunto set my hand.

FRED W. STEWART.

Witnesses:

JOHN PARKS,  
W. C. BERGUNDTHAL.