



US 20110005533A1

(19) **United States**

(12) **Patent Application Publication**
Evans

(10) **Pub. No.: US 2011/0005533 A1**

(43) **Pub. Date: Jan. 13, 2011**

(54) **MOLD FOR A SMOKING DEVICE**

(52) **U.S. Cl. 131/191**

(76) **Inventor: Douglas J. Evans, Boulder, CO (US)**

(57) **ABSTRACT**

Correspondence Address:
THE WEBB LAW FIRM, P.C.
700 KOPPERS BUILDING, 436 SEVENTH AVENUE
PITTSBURGH, PA 15219 (US)

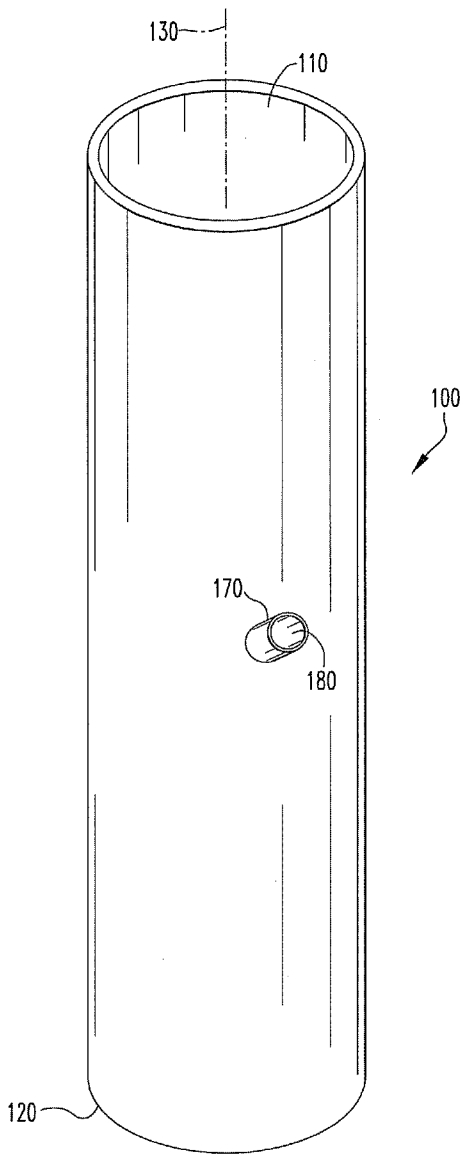
A mold for a smoking device comprises an insertable member removably connected to a body portion. The body portion generally comprises an elongated, preferably cylindrical tube having an open end and a closed end wherein a central axis extends along the axial length of the tube. The insertable member comprises an elongated member having a first end opposite a second end disposed along an axis and a cap portion extending radially outward around the first end. The body portion is filled with a liquid molding medium, such as water, and the insertable member is securely fastened to the body portion. The mold is exposed to a temperature change such that the molding medium changes phase from a liquid state to a solid state. The molded smoking product is removed from the mold and can be used for the user's benefit.

(21) **Appl. No.: 12/498,631**

(22) **Filed: Jul. 7, 2009**

Publication Classification

(51) **Int. Cl. A24F 1/28 (2006.01)**



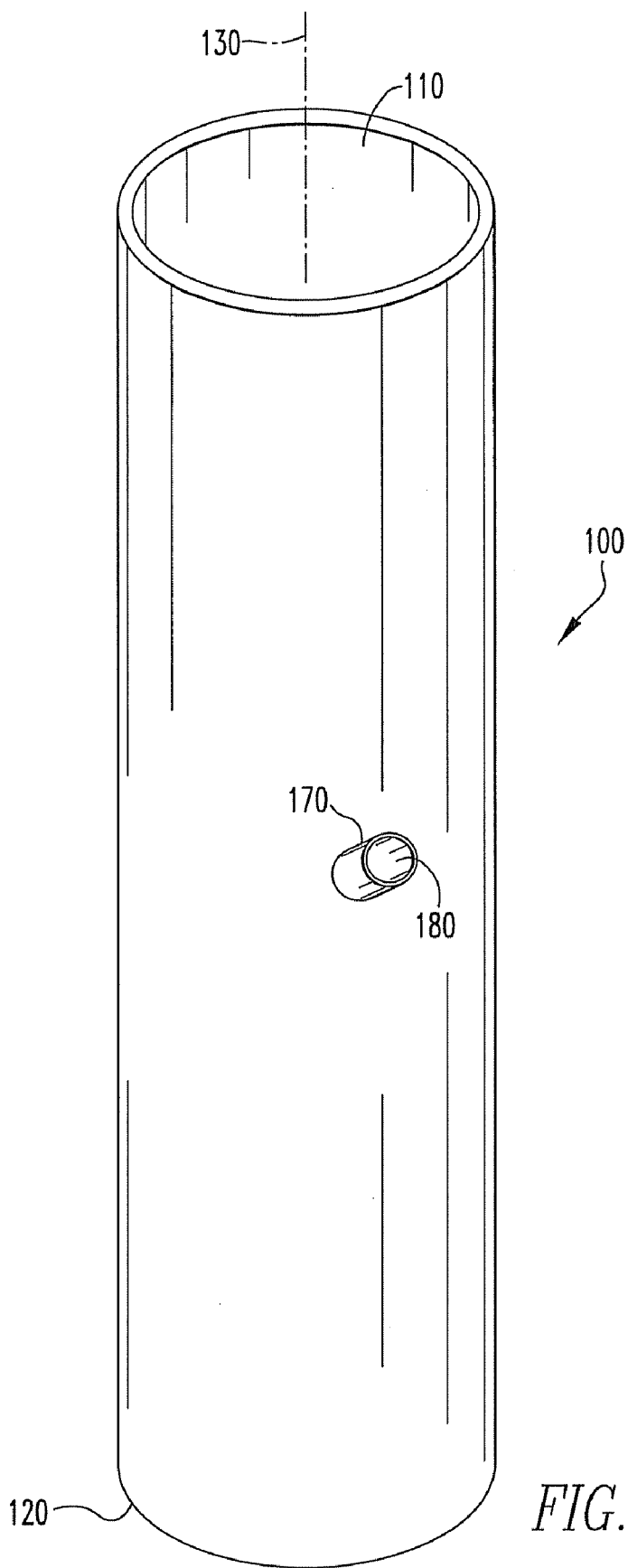


FIG. 1

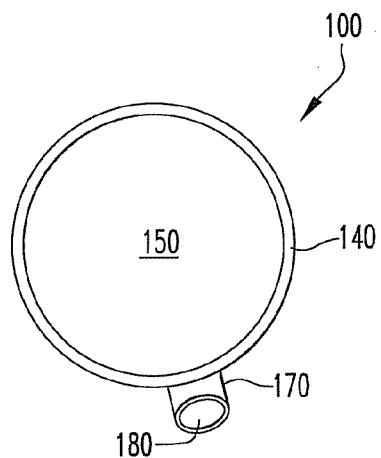


FIG. 2

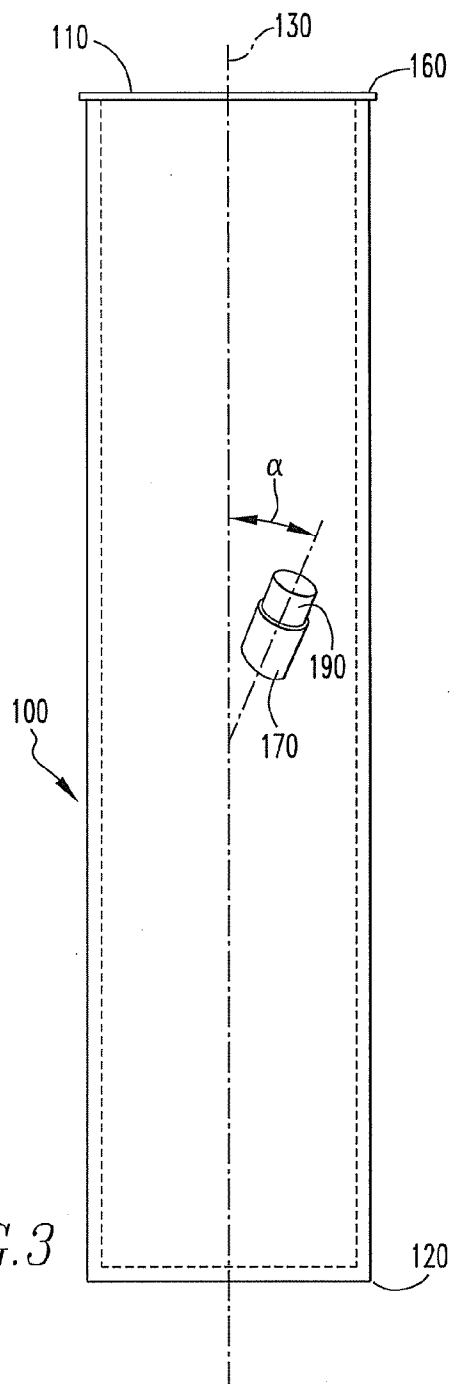


FIG. 3

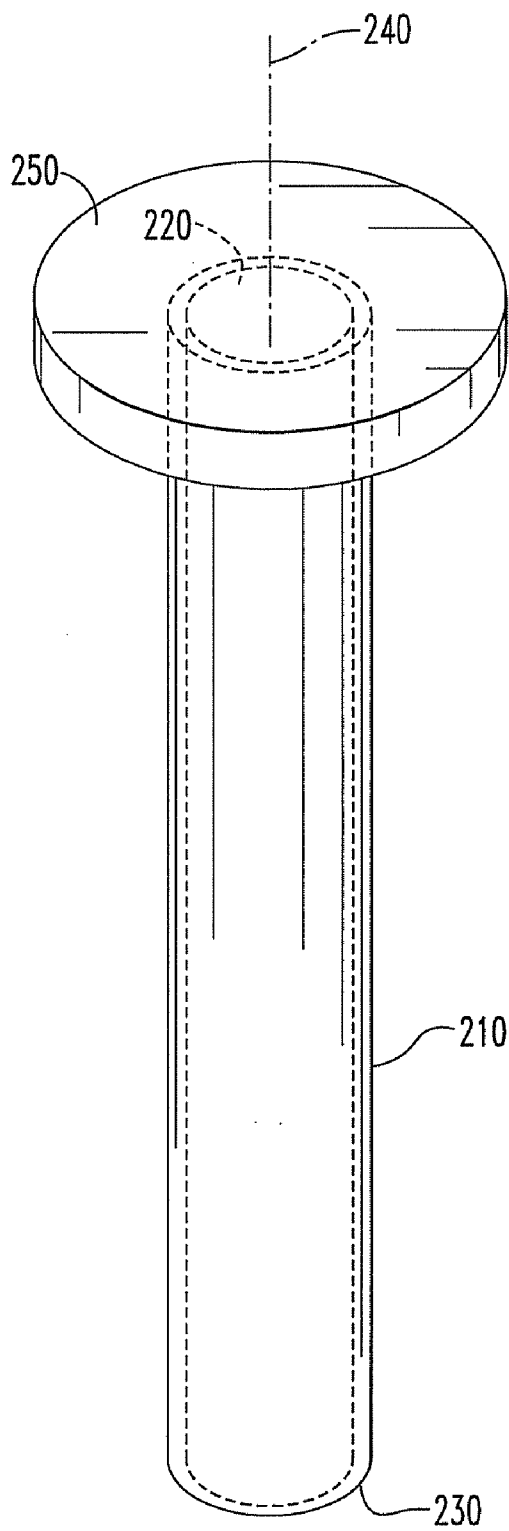
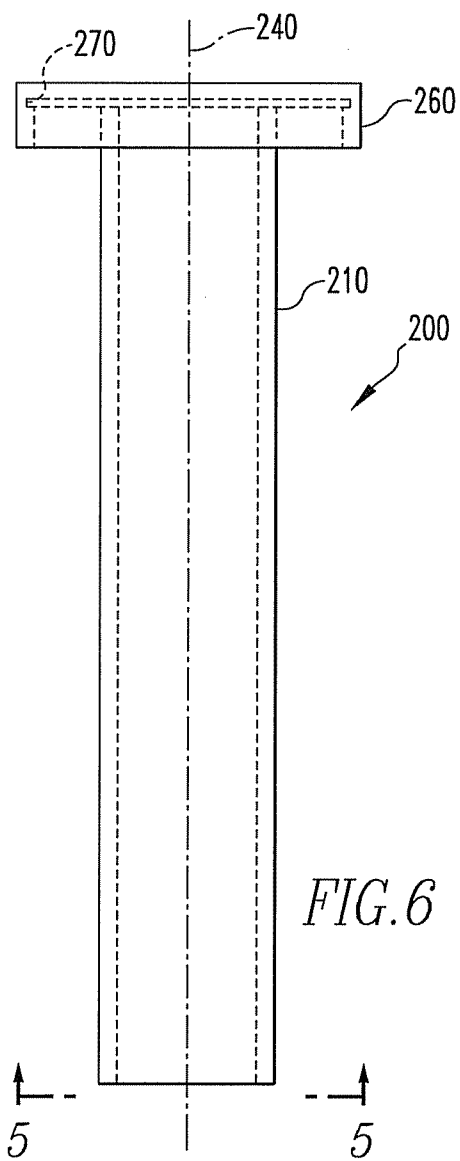
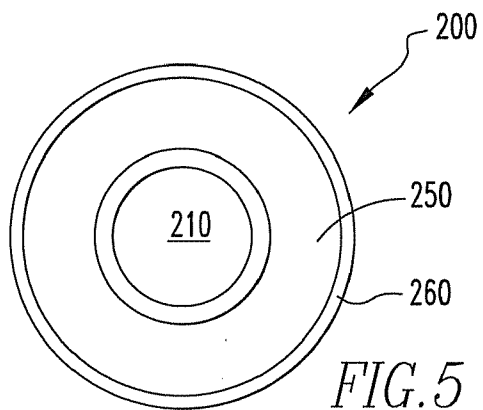


FIG. 4



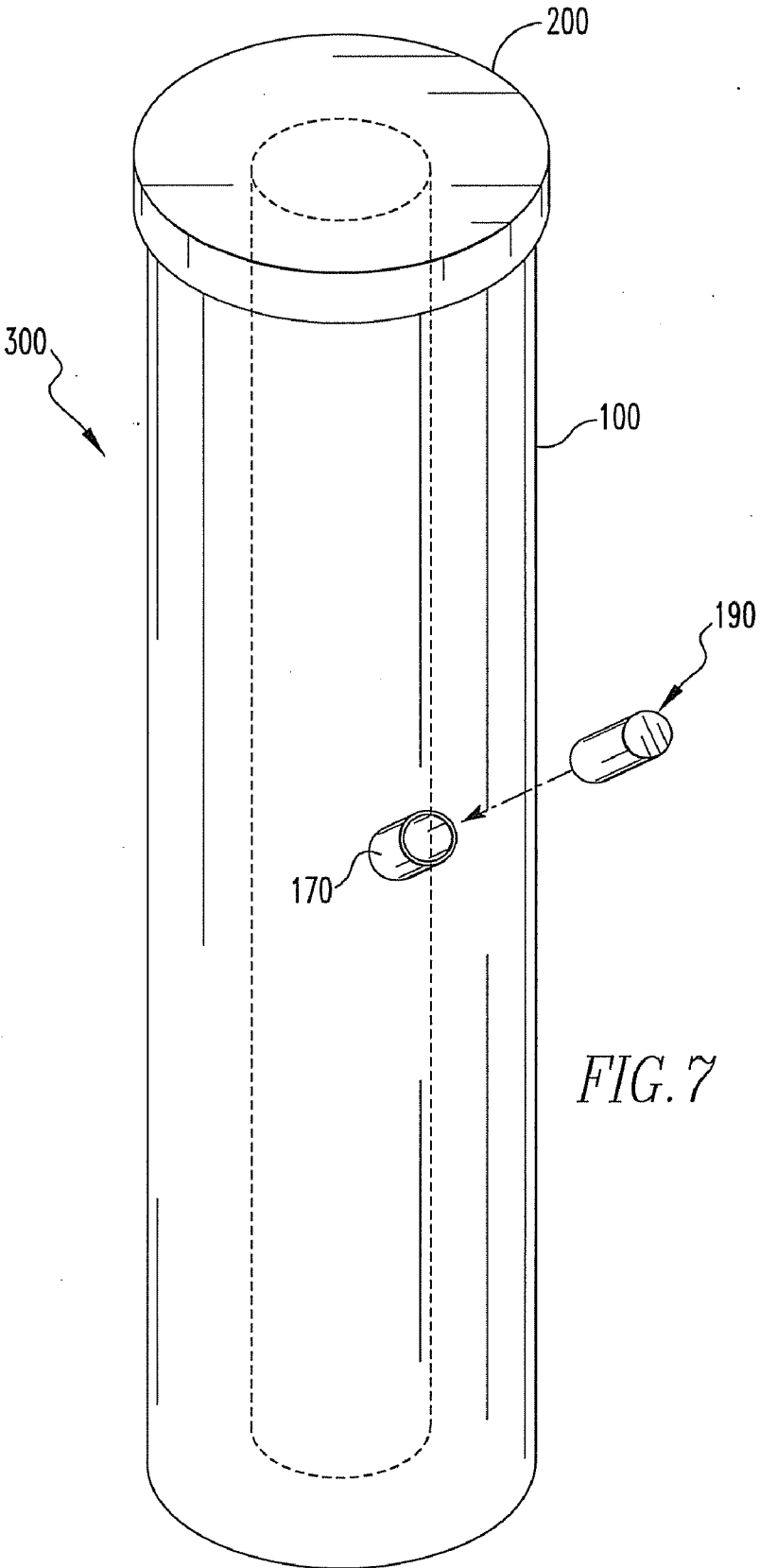


FIG. 7

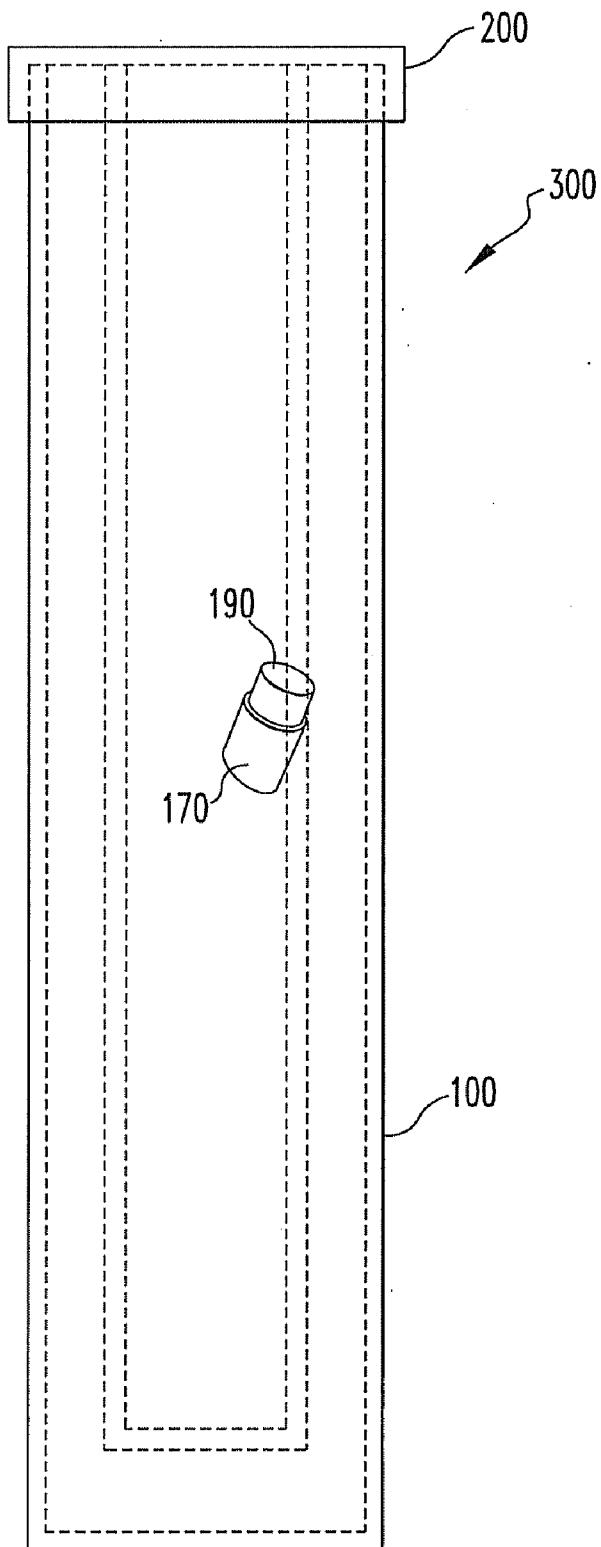


FIG. 8

MOLD FOR A SMOKING DEVICE

BACKGROUND OF THE INVENTION

[0001] 1. Field of the Invention

[0002] The present invention relates, in general, to a mold for a smoking device and, more particularly, to a mold for a smoking device that utilizes a liquid-phase cooling agent to cool the smoke, remove ash, and other contaminate matter before the smoke is inhaled by the user.

[0003] 2. Description of Related Art

[0004] Various forms of smoking paraphernalia are known in the art. Generally, such devices are used to aid in smoking tobacco or tobacco-like substances, including medicinal herbs, and other organic material. Over time, numerous variations of pipes, hookahs, and narghiles have evolved. The use of a cooling agent, such as water or another suitable substance in a liquid state, in connection with smoking paraphernalia has been particularly popular because of the inherent benefits associated with passing the smoke through water before being inhaled by the user. The use of water in smoking paraphernalia is particularly desirable to both cool the smoke and remove ash and other particulate matter from the smoke.

[0005] In general, a conventional smoking apparatus comprises a containment vessel partially filled with water. The containment vessel comprises at least a first orifice for smoke intake and at least a second orifice for smoke discharge. A consumable smoking substance, such as tobacco or other smoking material, is placed inside a bowl comprised on the exterior portion of the containment vessel, wherein the bowl is in fluid connection with the first orifice. Generally, the amount of consumable smoking substance placed inside the bowl is only sufficient to fill the containment vessel with smoke. The containment vessel is filled with water. The user's mouth covers the second orifice, and by taking a deep breath, the air inside the containment vessel is displaced and smoke drawn through the first orifice permeates through the water and fills the containment vessel. The user then inhales the smoke through a series of puffs until all of the smoke inside the containment vessel is used. Optionally, a plurality of tubes may be connected to the first and second orifices for a more convenient use. Additionally, atmospheric air may be introduced into the containment vessel through an auxiliary orifice to dilute the smoke before inhalation. An additional benefit of the auxiliary orifice is to allow the user to control the velocity of the smoke and air mixture being inhaled.

[0006] Water pipes are ordinarily similar in construction to the above-described smoking apparatus, with the exception of a mouthpiece communicating with the second orifice. Using the mouthpiece, the user draws the smoke from the burning bowl through the water in the containment vessel. As the smoke bubbles through the water, it fills the containment vessel and is selectively inhaled by the user through the mouthpiece.

[0007] Despite the popularity of conventional smoking paraphernalia, there exist several disadvantages associated with such designs. Conventional containment vessels are often of unitary construction and may be difficult to maintain in a sanitary condition. This is particularly evident with containment vessels having complex geometric shapes whereby the physical form of the vessel prohibits cleaning out the sediment that may accumulate within the containment vessel. Furthermore, mouthpieces allow for accumulation of moisture and saliva which further compounds the unsanitary condition.

[0008] A further drawback of conventional water pipes is that the cooling medium becomes quickly contaminated with ash and other particulate matter and must be changed frequently. This problem can be alleviated by having multiple water pipes; however, due to their often intricate designs, such a solution may be cost prohibitive to many users. The prior art, therefore, lacks inexpensive and disposable smoking devices adapted for a single use.

[0009] An additional drawback of existing water pipes is that the smoke is not sufficiently cooled prior to being inhaled by the user. While the water cools the hot smoke to an extent, the cooling action may not be as thorough as many smokers desire. Water contained within the containment vessel is often at ambient temperature, and its cooling effect may not be substantial enough to produce a dense charge of smoke within the containment vessel. There exists a need in the art for a novel and improved smoking device wherein the smoking device retains the benefits of conventional smoking paraphernalia and further improves on its shortcomings.

[0010] The present invention overcomes the foregoing and other deficiencies in the prior art by providing a novel and improved mold for a smoking device. The mold generally comprises a cylindrical body portion having an axial bore in a removable connection with an insertable member. The body portion is filled with a molding medium, such as water or an equally-suitable substance, and the mold is exposed to a temperature change such that the molding medium changes its state from liquid to solid. Once solidified, the molded smoking device is removed from the mold and is used in a conventional manner to aid in smoking tobacco or tobacco-like substances.

SUMMARY OF THE INVENTION

[0011] According to one aspect of the present invention, there is provided a mold for a smoking device where the molded product is a smoking device. The molding medium is preferably water; however, wine, fruit juice, or other liquid substances having similar thermal properties to water could be alternately used. Alternately, the molding medium may comprise a material capable of changing phase from liquid to solid once exposed to a temperature change, such as freezing or heating. As a further alternative, the molding medium may comprise one or more liquid-phase constituents that solidify when combined. The molding medium is introduced into the mold which is subsequently exposed to a temperature change such that the molding medium transitions from a liquid state to a solid state. The molded smoking device is intended to be used as a water pipe to aid in smoking tobacco or tobacco-like substances. The molded smoking device preferably utilizes a liquid-phase cooling agent to cool the smoke and remove ash and other contaminate matter before the smoke is inhaled by the user.

[0012] The primary object of the present invention is to provide a novel mold for a smoking device used for smoking tobacco or tobacco-like substances, including medicinal herbs, and other organic material. The mold for a smoking device generally comprises a substantially cylindrical body portion having an axial bore in a removable connection with an insertable member. The body portion and the insertable member can be coupled to create a watertight connection such that all of the molding medium is contained within the mold once the body portion and the insertable member are connected together.

[0013] According to a further aspect of the present invention, the mold for a smoking device enables for molding a smoking device that is economical to manufacture and easy to dispose. Because the molding medium is preferably water, the molded smoking device can be conveniently disposed of after use.

[0014] According to another aspect of the present invention, the mold for a smoking device enables for a smoking device that overcomes the sanitary shortcomings of conventional smoking paraphernalia. The molded smoking device is intended to be used for as long as it retains a solid composition in a given ambient temperature. The molded smoking device may be utilized indefinitely at ambient temperatures below the solidification point of the molding medium. Rather than cleaning the molded smoking device, the user may simply introduce the molded smoking device into an environment having a temperature higher than the melting point of the molding medium. The molded smoking device can thereby be disposed of in a safe and practical manner.

[0015] According to another aspect of the present invention, the smoke cooling and purification benefits of a water pipe are realized in the creation of a molded smoking device adapted to dispense measured quantities of cool, dense smoke for the user's benefit. The cooling benefits are increased because the molded smoking device itself further cools the liquid cooling medium. Being comprised of a frozen molding medium, the molded smoking device effectively removes heat from the liquid cooling medium and enables the user to benefit from a cooler and denser smoke charge.

[0016] These and other features and characteristics of the present invention, as well as the methods of operation and functions of the related elements of structures and the combination of parts and economies of manufacture, will become more apparent upon consideration of the following description with reference to the accompanying drawings, all of which form a part of this specification wherein like reference numerals designate corresponding parts in the various figures. It is to be expressly understood, however, that the drawings are for the purpose of illustration and description only and are not intended as a definition of the limits of the invention.

BRIEF DESCRIPTION OF THE DRAWINGS

[0017] FIG. 1 shows an isometric perspective view of the body portion according to a preferred embodiment of the present invention;

[0018] FIG. 2 shows a top view of the body portion shown in FIG. 1;

[0019] FIG. 3 shows a side, cross-sectional view of the body portion shown in FIG. 1 along line A-A;

[0020] FIG. 4 shows an isometric perspective view of an insertable member according to a preferred embodiment of the present invention;

[0021] FIG. 5 shows a bottom view of the insertable member shown in FIG. 4;

[0022] FIG. 6 shows a side, cross-sectional view of the insertable member shown in FIG. 4 along line B-B;

[0023] FIG. 7 shows an isometric perspective view of the mold for a smoking device according to a preferred embodiment of the present invention; and

[0024] FIG. 8 shows a side, cross-sectional view of the mold for a smoking device shown in FIG. 7.

DESCRIPTION OF THE PREFERRED EMBODIMENTS

[0025] For purposes of the description hereinafter, spatial or directional terms shall relate to the present invention as it is oriented in the drawing figures. However, it is to be understood that the present invention may assume various alternative variations, except where expressly specified to the contrary. It is also to be understood that the specific components illustrated in the attached drawings, and described in the following specification, are simply exemplary embodiments of the present invention. Hence, specific dimensions and other physical characteristics related to the embodiments disclosed herein are not to be considered as limiting.

[0026] As shown in FIGS. 1 and 7, a preferred embodiment of a smoking device mold **300** generally comprises an insertable member **200** removably connected to a body portion **100**. The body portion **100** generally comprises an elongated, preferably cylindrical tube having an open end **110** and a closed end **120** wherein a central axis **130** extends along the axial length of the tube between the open and closed ends. For the sake of a detailed illustration of a single preferred embodiment, the specification describes a cylindrical body portion; however, one of ordinary skill in the art will appreciate that the teachings of the instant invention are not limited to the specific shape described herein and that the same teachings could be applied to various other sizes and shapes. For example, the body portion **100** may have a polygonal or irregularly-shaped prismatic cross section.

[0027] A sidewall **140** extends along the axial length of the body portion **100** from the open end **110** to the closed end **120** and defines an interior volume **150**. The sidewall **140** is preferably smooth to facilitate removal of the molded smoking device (not shown) from the body portion. Alternately, the sidewall **140** may comprise a textured surface or a surface having a defined pattern thereon (not shown).

[0028] As shown in FIG. 3, the closed end **120** is preferably in a perpendicular orientation to the central axis **130** of the body portion **100** such that the body portion **100** may be self-supporting when the closed end **120** is placed on a level surface. The open end **110** is illustrated in FIG. 1 as being parallel to the closed end **120**; however, the shape of the open end **110** and its orientation with respect to the central axis **130** of the body portion **100** need not correspond to that of the closed end **120**. For example, the open end **110** may be angled with respect to the central axis **130** of the body portion **100** or may be shaped to comfortably accommodate the facial contours of the user. The open end **110** of the molded smoking device thereby facilitates in creating suction upon the contents of the interior volume **150** in a manner and for a purpose later described.

[0029] The body portion **100** may optionally have a base (not shown) extending in a radial direction around the body portion. The base may be integrally coupled to the body portion **100**, bonded, or otherwise sealably secured to the body portion. The purpose of the base is to increase the stability of the body portion **100** when it is vertically oriented in order to prevent undesirable tipping.

[0030] The body portion **100** may further comprise a plurality of indicia (not shown) disposed on the interior and/or exterior of the body portion **100**. For example, the body portion **100** may comprise at least one maximum fill line to

indicate the maximum amount of a liquid molding medium which may be poured into the body portion. The maximum fill line is positioned such that once the body portion **100** is filled with a molding medium and the insertable member **200** is inserted therein, a sufficient gap between the waterline and the insertable member **200** exists as to accommodate for expansion of the molding medium as it changes state from liquid to solid. The maximum fill line thereby enables for expansion of the molding medium without the risk of bulging of the body portion **100** due to molding medium expansion. Alternately, the body portion **100** may allow for molding medium expansion without undesirable bulging.

[0031] The smoking device mold **300** is preferably manufactured from a resilient material having stable properties of thermal expansion. Because the smoking device mold **300** will be subjected to large temperature differences, it must not be prone to breaking or cracking at temperatures below the freezing point of water. The mold **300** may be manufactured from metal, such as stainless steel or aluminum. Alternately, the mold **300** may be manufactured from a rigid or flexible plastic material, a rubber material, or a foam material. As a further alternative, the mold **300** may be manufactured using any combination of metal, plastic, and/or rubber materials. Additionally, the material may be translucent or opaque. It is contemplated that the selection of a suitable material for the mold **300** is within the expertise of one of ordinary skill in the art. The present disclosure is not intended to limit the mold material to a specific type described herein but is rather used for describing a single preferred embodiment.

[0032] The smoking device mold **300**, or at least the portions coming into contact with the molding medium, has a low coefficient of friction such that the molded smoking device may be easily removed therefrom. Alternately, the portions of the mold **300** that come into contact with the molding medium may be coated with a material having a low coefficient of friction, such as polytetrafluoroethylene, commonly known under the trademark TEFLON®. Furthermore, it is desired that the body portion **100** and the insertable member **200** are manufactured from a material meeting the necessary health and safety specifications required for human use and contact.

[0033] As best shown in FIG. 3, the perimeter of the open end **110** of the body portion **100** further comprises a fillet **160** extending around the entire perimeter of the open end. The fillet **160** interlocks a corresponding structure later described on the insertable member **200** to create a watertight seal. While a fillet **160** is herein described as the preferred means of removably coupling the insertable member **200** to the body portion **100**, one of ordinary skill in the art will appreciate that a plurality of different mechanical connections may be utilized to accomplish the same result. For example, the insertable member **200** may be removably coupled to the body portion **100** using a threaded connection, an interference-fit connection, a lock, a clip, or a similar mechanical means.

[0034] As shown in FIGS. 1 and 3, the body portion **100** further comprises a hollow stopper extension **170** extending outward from the exterior of the body portion **100** at an angle α compared to the central axis **130** of the body portion. The stopper extension **170** comprises a bore **180** extending through the sidewall **140**. The angular orientation of the stopper extension **170** is such that the axis of the bore **180** is oriented toward the closed end **120**. Preferably, the stopper extension is set at 70° with respect to the open end **110** of the body portion **100**. A stopper **190** is inserted into the stopper extension **170** such that it extends through the bore **180** and

abuts against the insertable member **200** once the insertable member **200** is inserted into the interior volume **150** of the body portion **100**. The term “abuts” means that at least one point or edge on the stopper **190** either directly contacts or is immediately adjacent to the insertable member **200**. The stopper **190** may extend into the insertable member **200**. The purpose of the stopper **190** is to create an orifice in the sidewall of the molded smoking product such that a tubular member, such as a hose or a slide, may be inserted therethrough. The body portion **100** may comprise more than one stopper extension **170** and stopper **190**. Optionally, the body portion **100** may comprise at least one orifice extending through the sidewall **140** of the body portion **100**. The purpose of such orifice is to allow the user to control the velocity and air to smoke ratio of the smoke charge being inhaled.

[0035] The stopper **190** may be manufactured from a rubber, plastic, or metal material. Alternately, the stopper **190** may be manufactured using any combination of rubber, plastic, and/or metal materials. It is intended that the selection of a suitable material for the stopper **190** is within the competence of one of ordinary skill in the art. The stopper **190** may be secured inside the bore **180** via an interference-fit connection. Alternately, the stopper **190** may be secured inside the bore **180** via a threaded connection or a similar mechanical connection.

[0036] In an alternate embodiment of the present invention, the stopper extension **170** may be excluded from the body portion **100**. In such an embodiment, the user may drill an orifice through the sidewall **140** such that a tubular member, such as a hose or a slide, may be inserted through the orifice.

[0037] In an alternate embodiment of the present invention, the body portion **100** may be comprised of two or more members joined together rather than from a single prismatic member. In an embodiment wherein the body portion **100** comprises a plurality of connected members, it is not necessary that the cross-sectional shape of the body portion **100** be prismatic. Rather, the interior volume **150** may assume any geometric shape capable of being enclosed by the plurality of members comprising the body portion **100**. The plurality of members creates a watertight seal once joined together and are removably connected together to facilitate removal of the molded smoking device. Additionally, the closed end **120** may be removably connected to the plurality of members comprising the body portion **100**. In the alternative, the closed end **120** may be integrally comprised on at least one of the plurality of members comprising the body portion **100**. The members may be individually comprised or joined together via a hinge or a similar mechanical means.

[0038] As shown in FIGS. 4-6, the insertable member **200** generally comprises an elongated member **210** having a first end **220** opposite a second end **230** disposed along an axis **240**. The elongated member **210** may be solid or tubular. In the embodiment where the elongated member **210** is tubular, the first end **220** and the second end **230** seal the interior of the elongated member **210**. A cap portion **250** extends radially outward around the first end **220**. The cap portion **250** further comprises a sidewall member **260** extending along the outer circumference of the cap and projecting vertically downward toward the second end **230** in a direction substantially parallel to the axis **240**.

[0039] The cap portion **250** is dimensioned such that the interior of the sidewall member **260** fits around the exterior of the body portion **100**. The cap portion **250** defines a notch **270** extending along the inner perimeter of the sidewall member

260. The fillet **160** surrounding the open end **110** of the body portion **100** locks inside the notch **270**, thereby creating a watertight connection. While the fillet **160** and the notch **270** utilize an interference-fit connection to create a watertight seal, a gasket (not shown) may be utilized to further improve the water-sealing properties. For example, a gasket may be disposed inside the notch **270** on the section of the cap portion **250** abutting the open end **110** of the body portion **100**, or on the sidewall member **260** abutting the side of the body portion **100**. One of ordinary skill in the art will appreciate that a plurality of different materials, including rubber and silicone, may be used to create a gasket enabling for a watertight connection between the body portion **100** and the insertable member **200**.

[0040] The elongated member **210** is dimensioned such that it may be receivably engaged within the interior volume **150** of the body portion **100** without any interference. Furthermore, the elongated member **210** is of such length that once the insertable member **200** is inserted inside the body portion **100** and the fillet **160** is securely fastened inside the notch **270**, the elongated member **210** does not abut against the closed end **120**. The void created between the closed end **120** of the body portion **100** and the second end **230** of the insertable member **200** defines the bottom sidewall of the molded smoking device. The void between the sidewall **140** of the body portion **100** and the elongated member **210** of the insertable member **200** defines the side structure of the molded smoking device.

[0041] In use, the interior volume **150** of the body portion is filled with a liquid-molding medium. While liquid water is defined as the preferred molding medium, one of ordinary skill in the art will appreciate that wine, fruit juice, or other equally acceptable liquid-molding medium may be utilized. Alternately, the molding medium may comprise a material capable of changing phase from liquid to solid once exposed to a temperature change, such as freezing or heating. As a further alternative, the molding medium may comprise one or more liquid-phase constituents that solidify when combined. As yet another alternative, the molding medium may comprise a substance capable of changing phase from liquid to solid after undergoing a chemical reaction. The chemical reaction may be assisted by a catalyst or induced by a temperature change. One of ordinary skill in the art will appreciate that a plurality of different molding media may be utilized with the mold **300** without changing the scope of the present invention.

[0042] Before the interior of the body portion **100** is filled with a molding medium, the stopper **190** is securely fastened to the body portion **100**. The stopper **190** is inserted into the bore **180** of the stopper extension **170** such that the stopper **190** extends into the interior volume **150** of the body portion **100** and abuts the elongated member **210** of the insertable member **200**. Thereafter, the interior of the body portion **100** is filled with a molding medium and the insertable member **200** is fastened to the body portion **100** such that the stopper **190** and the insertable member **200** create a watertight connection with the body portion **100**. Alternately, the insertable member **200** may be first secured to the body portion **100**, and the molding medium is poured into the interior volume **150** through the bore **180** of the stopper extension **170**. Thereafter, the stopper **190** may be secured inside the stopper extension **170**. As a further alternative, the body portion **100** may comprise a sealable opening (not shown) through which the molding medium can be introduced into the internal volume **150**.

Once the stopper **190** and the insertable member **200** are securely fastened to the body portion **100**, the molding medium is contained within the mold **300**, regardless of its orientation. It is preferred that the mold **300** be kept in an upright position during the molding process such that any air pockets remaining in the mold **300** preferably form at the top portion rather than on the bottom or side portions of the body portion **100**. The mold is placed in a low-temperature environment, such as a conventional refrigerator, to allow the molding medium to change phase from liquid to solid. Any potential expansion of the molding medium is preferably alleviated by filling the body portion **100** up to the maximum fill line. Alternately, the material of the body portion **100** can accommodate for expansion of the molding medium.

[0043] Once the molding medium has congealed, the mold **300** may be removed from the low-temperature environment. The stopper **190** is first removed from the body portion **100**, followed by removal of the insertable member **200**. It may be desirable to leave the mold **300** at ambient temperature for a short period of time in order to facilitate removal of the molded smoking device from the mold **300**. Alternately, the mold **300** may be exposed to a temperature change, such as by heating the mold or submerging it in ambient temperature water, in order to facilitate removal of the molded smoking device. The molded smoking device may then be removed from the body portion **100** and utilized for the user's benefit of smoking tobacco or tobacco-like substances.

[0044] In an alternate use embodiment, the molded smoking device need not be removed from the body portion **100**. Rather, after the liquid molding medium has congealed inside the mold **300**, the stopper is first removed from the body portion **100**, followed by the removal of the insertable member **200**. The molded smoking device remains in the body portion **100** and can be utilized for the user's benefit of smoking tobacco or tobacco-like substances. In the instance where the molded smoking device is created by freezing a liquid molding medium, the molded smoking device can retain its shape for a longer period of time if left inside the body portion **100**. Direct contact with the user's hands causes the molded smoking device to absorb a substantial amount of heat that causes the smoking device to melt. When the molded smoking device is left inside the body portion **100**, the user can realize the benefits of smoking a water pipe even after the molded smoking device melts.

[0045] While specific embodiments of the present invention have been described in detail, it will be appreciated by those skilled in the art that various modifications and alternatives to those details could be developed in light of the overall teachings of the disclosure. The presently preferred embodiments described herein are meant to be illustrative only and not limiting as to the scope of the invention which is to be given the full breadth of the appended claims and any and all equivalents thereof.

[0046] Having thus described my invention with the detail and particularity required by the Patent Laws, what is desired protected by Letters Patent is set forth in the following claims.

The invention claimed is:

1. A mold for a smoking device that utilizes a liquid phase cooling agent to cool the smoke, said mold comprising:
 - an elongated body portion having a sidewall defining an interior volume extending from an open end to a closed end along a central axis; and

an insertable member having an elongated member with a first end opposite a second end and a cap portion extending radially outward from said first end, wherein said insertable member may be removably connected to said body portion to create a watertight interior volume.

2. A mold for a smoking device as defined in claim 1, further comprising:

at least one stopper extension extending outward from said body portion, said stopper extension having a bore extending through said sidewall of said body portion; and

at least one stopper capable of being removably inserted into said stopper extension such that said stopper extends through said bore and abuts against said insertable member when said insertable member is inserted into said interior volume of said body portion.

3. A mold for a smoking device as defined in claim 2, further comprising:

a sidewall member extending along the outer circumference of said cap portion,

wherein said sidewall member projects toward said second end in a direction substantially parallel to said axis and wherein said sidewall member is dimensioned to fit around the exterior of said body portion.

4. A mold for a smoking device as defined in claim 3, further comprising:

a fillet extending around the outer perimeter of said open end of said body portion; and
a notch extending along the inner perimeter of said sidewall member of said insertable member, wherein said fillet interlocks with said notch to create a removable connection between said body portion and said insertable member.

5. A mold for a smoking device as defined in claim 4, wherein said closed end is perpendicular to said central axis such that said body portion may be self-supporting when placed on a level surface.

6. A mold for a smoking device as defined in claim 4, further comprising a base extending around said body portion in a radial direction, wherein said base increases the stability of said body portion when it is vertically oriented.

7. A mold for a smoking device as defined in claim 4, further comprising one or more indicia on said body portion, wherein said indicia comprises at least one fill line to indicate the maximum amount of a liquid molding medium that may be poured into said mold.

8. A mold for a smoking device as defined in claim 4, wherein said mold is manufactured from a material not prone to breaking when subjected to large temperature differences.

9. A mold for a smoking device as defined in claim 8, wherein said mold is coated with a material having a low coefficient of friction such that the molded smoking device may be easily removed from said mold.

* * * * *