<page>108r</page>

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<ab>To hold the cores, some <x>people</x> use <m>wire</m> made of the same <m>metal</m> as that to be cast because it boils down &amp; is made similarly, but when it is melted or pliant the core varies. Other <x>people</x> find it serves them better to use sharpened <m>iron wire</m> about the borders because it holds more firmly, &amp; having fine points it does not rise up any more than the point of a needle and one can apply <m>gold</m> or <m>silver</m> on this rather than putting it in works <x>where</x> one makes a hole in the work with a small chisel.</ab>

<ab><m>Spirits</m> prevent the sand from bubbling &amp; do not make little holes on the borders of the mold if the thing to be molded is very damp, the holes &amp; farts &amp; bubbling does not make it in the place of the mold which is thick but at the borders which are more delicate.</ab>

<ab>One casts ordinary <m>silver</m> of the sort <pro>goldsmiths</pro> coarsely work, which is made with mediocre <m>alloys</m>. And when one casts with <m>solder</m>, it runs even better.</ab>

<ab><m>Spalt</m> is a whitish stone which can be found in Germany, &amp; mainly in Augsburg from which can be made the most excellent <m>sand</m> that can be found for <x>casting</x> <m>lead</m>, <m>tin</m>, <m>copper</m>, <m>silver</m> &amp; <m>gold</m>. And the more it is used, the better it is. It is clean for casting flat things in a frame. For rounded things, it is not as attractive <x>because it</x> does not hold in the fire as the aforementioned <x>things</x> composed of <m>plaster</m>.</ab>

<ab>The snippings of <x>a</x> large <x>piece of</x> greasy <m>leather</m> are good to cast in melted <m>copper</m> and <m>brass</m> because they clean it &amp; take away from it all its <m>filth</m>. </ab>

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<head><m>Spalt</m></head>

<ab><m>Spalt</m> is white like cooked <m>plaster</m> and one can find it in mounds and stones made in long stairs &amp; long veins. It is very soft such that with a fingernail &amp; it makes a powder like that of our <m>chalk</m> from Champagne. And because everything which is provided from the <m>earth</m> is mixed with some other substance, to purify it <x>the spalt</x>, one boils it with somewhat large <m>gemstones</m> then tempers it with <m>essence of sal ammoniac</m>. One puts <x>a lump of it</x> the size of a walnut in a large bottle of <m>water</m> and</ab>

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