<page>113v</page>

<image>http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f232.image</image>

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<id>p113r\_1</id>

<ab>such that while reheating the two casts will unjoin. <del><fr>Et pour pl</fr></del> Therefore, for this effect, take several <tl>bowls of different size, which have a lip</tl>, to cast better. In these pour some <m>common <env>fountain</env> water</m>, &amp; mix into it <ms>as much <m>essence of sal ammoniac</m> as can be held in an <m>egg</m></ms>, <add><figure>#</figure></add> composed as mentionned. If you want to cast in <m>lead</m> or <m>tin</m> - because one would need more for casting <m>gold</m> &amp; <m>silver</m> - the <m>essence</m> once in your <tl>bowl</tl>, <del><fr>mesles</fr></del> put <del><fr>y</fr></del> your sand in it &amp; not the <m>essence</m> in the sand &amp; add it <del><fr>a dista dista</fr></del>with such discretion that <del><fr>il</fr></del>, while stirring &amp; mixing it promptly with a <tl><m>wooden</m> spoon</tl>, it does not become thicker than <m><del>clear</del> mustard</m>. And thus throw <del><fr>le</fr></del> first the non-thick part, <del><fr>qui es</fr></del> as is always at the surface, in shakes &amp; <del><fr>da</fr></del> at the top of your <tl>mold</tl>. And doing so, since your animal is nearly covered, blow strongly everywhere in order to dissipate the small and big bubbles that the wet sand makes &amp; continue without delay to put all the rest which is at the bottom, &amp; a little thicker than the top, until everything is filled, up to the mark for thickness that you made.

<figure>

<id>fig\_p113v\_4</id>

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</figure> And do not forget to shake the <tl>mold</tl> <del><fr>affin</fr></del> while throwing, so that the wet sand runs &amp; enters well everywhere. Also tip your <tl>mold</tl> up on the side of the head, which is higher than the body, and thus your <tl>mold</tl> will have the same thickness, &amp; you will spare sand. All of this being done scrupulously <del><fr>fai</fr></del>, let it set, which will take a <ms><tmp>quarter of an hour</tmp></ms>. Then release the <m>clay</m> circle, which can be used another time. And leave it to dry a little bit, &amp; separate your <tl>mold</tl> from the <fr>tourtelle</fr> <m>earth</m>, which also <del><fr>de</fr></del> will be appropriate for molding right away, and pare the excess with a big <tl>knife</tl>, giving to it the long shape of a <mu>mandore</mu>. <del><fr>Rasche</fr></del> Scrape &amp; cut also away the back <add>of the <tl>mold</tl></add>, which is always the weakest, and adapt it cleanly thusly. And do not forget to make notches around, so that the second cast fixes &amp; binds better

<figure>

<id>fig\_p113v\_5</id>

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</figure> without changing.</ab>

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<del>If you can, fill</del> your half <tl>mold</tl> in one go &amp; with <del><fr>la pre</fr></del> one wet batch it is the best.</ab>

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<figure>#</figure>

<ms>or two <m>eggs</m></ms>, because there is no risk if there is more. <del><fr>Et l’<m>eau</m></fr></del>If you cast in two goes, it is enough to put <m>essence of sal ammoniac</m> at the first bowlful. </ab>

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Make it clear like a <m>broth of juices</m>, or like <m>starchy water</m>, that <pro>women</pro> use to make their <m>starch</m>. For there is no risk in it being very clear, because sand always settles in the bottom &amp; <m>water</m> separates &amp; remains on top. The same that one scrapes since it is too weak &amp; soft. And it will not let itself set quickly, for all things calcined dry out promptly from mixed <m>water</m>.</ab>

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<figure>

<id>fig\_p113v\_3</id>

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</figure>

If you don't fill in one go your <tl>mold</tl> <del><fr>destrempe</fr></del> with wet sand, take head to stir your second cast with the <del><fr>e p</fr></del> surface of the first, <del><fr>p</fr></del> by mixing with the <tl>spoon</tl> or a <tl>spatula</tl> with which you wet it.</ab>

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<m>Essence of sal ammoniac</m> is not necessary for small <tl>molds</tl>, which do not require neither a big nor a long fire to be reheated, however, when you put some in it will only be better. <ill/>

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<head><del>Second cast</del></head>

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