<page>115v</page>

<image>http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f236.image</image>

<div>  
<id>p115v\_1</id>  
<head>Cast of <m>tin</m></head>

<ab>If the plant or flower that you want to cast <del>in tin</del> is delicate &amp; fine, it is necessary that the <m>tin</m> exceeds <m>lead</m> in the mixture &amp; on the contrary, if it is thick, it is necessary that <m>lead</m> exceed. Therefore for the <del>mixture</del> fine thing, put in some <m>fine tin</m>, not all the <ms>quarter part</ms> of <m>lead</m>. And make sure that your <tl>mold</tl> is <ms>hottish, such that you can hold it in your <tl><bp>hand</bp></tl></ms>, when you want to cast. As for the <m>alloyed tin</m>, the same as mentioned, it is necessary that it is very hot &amp; almost red for casting, so that it penetrates. Otherwise, having <add><fr>a</fr></add> to run the length of the fine branches of the plant, it will get cold before arriving there. And do not forget to mix in it a little <m>looking-glass tin</m>, which makes it run better &amp; firms it up.</ab>

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<margin>left-top</margin>  
In the <m>lead alloyed with tin</m>, or <m>tin alloyed with lead</m>, you can put a little bit of <m><fr>metalline</fr></m> &amp; it will seem <m>silver</m>. But do not put too much, for this hardens the substance &amp; sours it also, so that for a delicate thing like legs &amp; similar things, it would not be appropriate.</ab>

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<div>  
<id>p115v\_2</id>  
<head>For giving vent to the <tl>mold</tl></head>

<ab>In addition to your vents, if your <del><fr>es</fr></del> plant is very fine, you can pass a <tl>thread</tl> through the <add><m>clay</m></add> circle, rather than casting with a <tl>needle</tl>, &amp; make sure it passes through the plant. And with <tl>thread</tl>, burning like the plant, a hole will remain, which will give air &amp; venting, to help clean.</ab>

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<id>p115v\_3</id>  
<head>Reheating the <tl><fr>noyau</fr> molds</tl></head>

<ab>After your <tl>molds</tl> have their gate, vents &amp; <tl>clamps</tl>, as mentioned, make at the end of the <tl>forge</tl> <del><fr>en</fr></del>, or in some clean place, a surrounding of <m>bricks</m>, and fill it with large half lit charcoal. And place your <tl>molds</tl> on top, and leave the charcoals thusly to light by themselves for a <ms><tmp>half hour</tmp></ms>, so that they heat little by little and not all at once. Finally as they begin to become white, beat <del><fr>peu a peu</fr></del> the thusly half-lit large charcoals on top &amp; blow with your <tl>little bellows</tl>, until they are warmed. And thusly, little <add>by little</add>, invigorate the fire, without haste, until you <tl>mold</tl>s are well red on the outside &amp; the inside. If it is for casting some plant or some animal which does not release well &amp; in this case, one needs to burn <add>it</add> in the <tl>mold</tl> &amp; when you look through the gate &amp; through it you see the <tl>molds</tl> are very red &amp; inflamed inside, this will be your signal that they are reheated enough. But if you do not see this signal, increase &amp;continue the fire until it is the case. If there is nothing in the <tl>mold</tl> that needs burning, it will be enough that they are dried well on the same fire, if it is for casting <m>tin</m>, they reheat better in a <tl>reverberatory furnace</tl>.</ab>

<ab>  
<margin>left-middle</margin>figure/>  
Do not pull out your <tl>reheated molds</tl> from the fire, before they have cooled themselves &amp; take care that neither the <env>wind or the cold</env> hits them while very hot, for this would make them burst. One must not reheat them before they are dry and firmed up for they would cast in a different way, and it is necessary beforehand to make gates &amp; vents &amp; place <tl>clamps</tl>.</ab>

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<figure>

<id>fig\_p115v\_1</id>

<link><https://drive.google.com/open?id=0B9-oNrvWdlO5dHVja3NnV0dmMlk></link>

</figure>  
Take care not to heat the fire in one go, for fear <del><fr>f</fr></del> that your <tl>molds</tl> crack inside.</ab>

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They are reheated enough when the entire hole of the gate is red. When it is black, it is not enough.</ab>

<ab>  
<margin>left-bottom</margin>  
For casting in <m>silver</m>, one must not reheat two times <del>&amp;</del>, if there is nothing in the <tl>mold</tl> that needs <del><fr>despouiller</fr></del> burning, simply because it does not release well. All the <tl>molds of <pro>farriers</pro></tl> are reheated two times, first for <figure/></ab>

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