<page>127v</page>

<image><http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f260.image></image>

<div>  
<id>p127v\_1</id>  
<head><m><pro>Founders</pro>’ earth</m></head>

<ab>It is <m><fr>terre bolbene</fr></m> mixed with <m>dung</m> or <m>cloth waste</m>, which withstand fire, which you need to always have provision of, to lute your <tl>molds</tl> which <del><fr>ont b</fr></del> must be used to cast <m>silver</m> &amp; that you need to reheat. Those, where one needs to burn some flower or animal, should not be luted, until they have been reheated once and they have been cleaned from <m>bones</m> &amp; <m>ashes</m> remaining inside, and having removed the <tl>clamps</tl>, you have opened the two halves to see if they have any cracks. For there is some <m>plaster </m>that is not so hard in the fire, the one as much as the other. Moreover, there is some which makes crusty the things which stay burning inside. And these are imperfections that one needs to avoid, either <del>by</del> by bathing well with <m>eau-de-vie</m> the animal before casting in the wet sand, or mixing in more or less <m>brick</m>, or <m>alum</m>, or reheating the <m>brick</m> more, or in place of the <m>brick</m>, mixing in <m><tl>crucible</tl> bottoms</m> &amp; similar things which resist well in the fire. Having therefore reheated your <tl>mold</tl> to burn it inside, leave to cool well. And if it is neat &amp; not cracked, reput the <tl>clamps</tl> &amp; lute with this <m>above mentioned <pro>founders</pro>’ earth</m> &amp; sprinkle a little <m>sifted ash</m> &amp; let dry a little. But keep yourself from luting <del>that they are not</del> until the <tl>molds</tl> are cold. Those for casting <m>silver</m>, where there is nothing to burn inside, only need, except when the gate &amp; vents are made, luting &amp; reheating once. Do not lute the end of the <tl>mold</tl> where you want to make your gate, rather leave it uncovered &amp; the exit of the vent as well. </ab>

<ab><add>If</add> <rub>the <tl>molds</tl></rub> <del>that</del> were <del>do</del> <add>to</add> crack, it is <del>make thus</del> at the first reheating, for at the second, they no longer crack.</ab>

<ab><rub>The smallest</rub> <tl>molds</tl> are reheated more quickly. Take <del>the</del> therefore the first ones reheated when you cast, for you can put several of them to reheat.</ab>

<ab>Light the charcoals, firstly in the <tl>forge</tl>, or in some other place nearby, &amp; having placed your <tl>molds</tl> on a layer of good embers, not burning too much, to have a slow fire at the beginning, put there &amp; adjust a little the half-lit charcoals in the <tl>forge</tl>.</ab>

<ab>  
<margin>left-top</margin>  
The <m>earth that <pro>founders</pro> use to braze or solder</m>, which is <m>sandy clay earth</m>, or else <m>clay mixed with sand</m>, after having dried &amp; <tl>sieved</tl> &amp; then composed it, is good for luting your <tl>molds</tl>, because this <m>earth</m> melts rather than cracks. And any <m>earth</m> that melts <del>is</del> cannot be lacking in this.</ab>

<ab>  
<margin>left-top</margin>  
<add><tl><m>Iron wire</m></tl> to give it bond.</add></ab>

<figure>

<id>fig\_p127v\_1</id>

<margin>left-top</margin>

<link><https://drive.google.com/open?id=0B9-oNrvWdlO5S2VzRmhYUWpfbmc></link>

</figure>

<ab>  
<margin>left-middle</margin>  
<add>Lute thickly your <tl>molds</tl>, &amp; if they are small, you can reheat them immediately in a good fire, especially those of <m><la>crocum</la></m>.</add></ab>

<ab>  
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If the <m>earth</m> is good, &amp; <del><fr>l</fr></del> does not crack while reheating, &amp; does not separate from the <tl>mold</tl>, the <tl>molds</tl> will also not crack &amp; will not make flaws at the casting. Reheat with slow ease in a closed fire &amp; do not expose them hot to the air.</ab>

<ab>  
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Lute rather thickly in two or three layers, especially right in the joints, in order that the <m>silver</m> does not come out of the <tl>mold</tl>. </ab>

<ab>  
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Reheat in a <tl><fr>four de reverberation</fr></tl>.</ab>

<ab>  
<margin>left-bottom</margin>  
To test if your <m>earth</m> is good, before putting it on your <tl>mold</tl>, lute <add>at</add> the place of the <del>fo</del> wall of the <tl>forge</tl> which is around the <tl><fr>tuelle</fr></tl> &amp; barrel of the <tl>bellow</tl>, &amp; light the fire and if it withstands this without cracking, it will be good.</ab>

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