<page>137v</page>

<image><http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f280.image></image>

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<id>p137v\_1</id>  
<head>Tempering <m>sand</m> for molds of flat medals</head>

<ab>Flat medals, of <m>wax</m> or <m>metal</m>, are oiled very lightly &amp; then are touched with a <fr>pinceau</fr> of eau-de-vie. And in order that the mold, wet with water, takes without refusing the oiled thing, one heats the water well for wetting the sand, for with cold water it would refuse. Medals are oiled because they are not malleable &amp; thusly, could break the mold. And animals, which are malleable, do not want to be oiled. Hot water should be of such heat that you cannot hold your finger there, without feeling strong heat. Wet your sand thicker for flat medals &amp; solids than for lizards &amp; fine things. Your sand, having set, clean &amp; scrape your mold on one side &amp; the other &amp; make a notch at the foot &amp; the border of the medal on the side of the gate, in order that you can take it away better. Lower also the mold, scraping the surround of the medal, in order that, from all sides, you can take it away without it corrupting the mold. Next, make your scorings around <del>d’un</del> the first cast mold <del>mes</del>, in order that the second cast joins with it without varying, &amp; especially make a notch at the bottom of the mold where the head of the molded thing is. Make some also at the sides of the gate. This done, dip the reverse of the first mold in water, oil it, &amp; thusly it will not be imbibed. Rub the reverse of the medal with eau-de-vie &amp; secondly cast, wetting in hot water. If you have molded a medal <fr>en noyau</fr>, having made the first cast &amp; this one having set, outline, with the point of a knife, the surround of the medal, in order that it is raised on the cast &amp; and not buried in it. Then having made the second cast, &amp; having opened your mold, <del>have</del> take away the medal, in one go, with <del>one</del> two knife points <del>q</del>, and that one takes it from the side of the gate &amp; the other from the side of the head, which is opposite.</ab>

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Take care not to oil your medal too much, for if the oil seeps out, it diverts the sand from becoming smooth &amp; amassing &amp; makes it wavy &amp; lumpy. One should only touch the middle of the medal <del>d’un p</del> with the point of an oiled <fr>pinceau</fr>, &amp; then spread the oil everywhere.</ab>

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Make especially sure that the gate be the widest you can <del>p</del> towards the medal &amp; embraces it well, that the entrance of the gate is ample, always narrowing towards the medal. Do not forget also to notch the entrance of the gate.</ab>

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