<page>137v</page>

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

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

<ab>Flat medals, of <m>wax</m> or <m>metal</m>, are <m>oiled</m> very lightly &amp; then are touched with a <tl><fr>pinceau</fr></tl> of <m>eau-de-vie</m>. And in order that the <tl>mold</tl>, wet with <m>water</m>, takes without refusing the <m>oiled</m> thing, one heats the <m>water</m> well for wetting the sand, for with <m>cold water</m> it would refuse. Medals are <m>oiled</m> because they are not malleable &amp; thusly, could break the <tl>mold</tl>. And animals, which are malleable, do not want to be <m>oiled</m>. <m>Hot water</m> should be <ms><sn>of such heat that you cannot hold your <tl><bp>finger</bp></tl> there, without feeling strong heat</sn></ms>. Wet your sand thicker for flat medals &amp; solids than for <al>lizards</al> &amp; fine things. Your sand, having set, clean &amp; scrape your <tl>mold</tl> 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 <add>the <tl>mold</tl>, scraping</add> the surround of the medal, in order that, from all sides, you can take it away without it corrupting the <tl>mold</tl>. Next, make your scorings around <del>of the</del> the first cast <tl>mold</tl> <del><fr>mes</fr></del>, in order that the second cast joins with it without varying, &amp; <corr>especially</corr> make a notch at the bottom of the <tl>mold</tl> 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 <tl>mold</tl> in <m>water</m>, <m>oil</m> it, &amp; thusly it will not be imbibed. Rub the reverse of the medal with <m>eau-de-vie</m> &amp; secondly cast, wetting in <m>hot water</m>. If you have molded a medal <fr>en noyau</fr>, having made the first cast &amp; this one having set, outline, with the <tl>point of a knife</tl>, 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 <tl>mold</tl>, <del>have</del> take away the medal, in one go, with <del>one</del> two <tl>knife points</tl> <del><fr>q</fr></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 <m>oil</m> your medal too much, for if the <m>oil</m> 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>of the <fr>p</fr></del> with the <tl>point of an <m>oiled</m> <fr>pinceau</fr></tl>, &amp; then spread the <m>oil</m> everywhere.</ab>

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Make especially sure that the gate be the widest you can <del><fr>p</fr></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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