<page>150v</page>

<image>http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f306.image</image>

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<id>p150v\_1</id>

<head>Molding hollow</head>

<ab>This <tl><m>iron wire</m> point</tl>, which is put thusly <del><fr>bi</fr></del> through the hole, is to better hold the <fr>noyau</fr> &amp; keep it from shifting. All of this being <del><fr>d</fr></del> thusly arranged, lay your <tl>mold</tl> on the <tl>table</tl>, the hole at the top, as it is here marked on the side, &amp; then adapt a <tl>circle of <m>soft clay</m></tl> <del><fr>aultr</fr></del>, two <ms><bp>fingers</bp></ms> high, around the hole, like for other <tl>molds</tl>. And then wet your molding sand, moderately thick, &amp; throw it through the hole until it is well filled, up to the surface of the <tl><m>clay</m> circle</tl>. But take heed to not throw <del><fr>r</fr></del> in through the middle of the hole, but rather from the side, for, because the already made <tl>mold</tl>, drinks and sucks the moisture <del>of the new</del>. The new one that you throw in <del>which dries quickly</del>, on the edge of the <tl>mold</tl>, being quickly dry, <del><fr>s</fr></del> would obstruct the <tl>mold</tl> &amp; it would not finish filling. And when you throw from the side, if you recognize that it is obstructed, you can clear a path. Having thrown in, blow on the <del><fr>f</fr></del> <corr><del>the</del></corr> wet gate, &amp; put, a few times, the <tl><bp>end of your finger</bp></tl> in the hole, <del><fr>po</fr></del> or some <tl>small point</tl>, to unblock it, &amp; make the hollow <m>wax</m> fill up. Throw in, at the end, the sand wetted a little thickly to give strength to the <tl>mold</tl>, for <m>water</m> coming to the surface <del><fr>s</fr></del> <add>of the <tl>mold</tl></add>, always makes it softer. Having set, scrape off the <tl><m>clay</m> circle</tl> &amp; the excess which is on the hole, through which you cast the <fr>noyau</fr> &amp; nothing will be discernable. When your <tl>mold</tl> is thusly prepared, <m>lute</m> it all around with the same sand which served for the <tl>molds</tl>. Next, reheat it in a slow fire, at the beginning, &amp; the mouth of the gate at the bottom, in order that the <m>wax</m> flows out <corr>gently</corr>. For if you were to give it great heat until the <m>wax</m> came out, it would boil inside &amp; leave some blisters &amp; lumpy things, although</ab>

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This <tl>point</tl> is placed in the middle &amp; through the hole of the gate, when the <tl>mold</tl> is in several pieces, like a <al>turtle</al>, and this is done in order that the <fr>noyau</fr> does not shake. But when the mold is only of two pieces, it is not necessary to put <tl>points</tl> in the middle of it.

<figure>

<id>fig\_p150v\_1</id>

<link><https://drive.google.com/open?id=0B9-oNrvWdlO5eVVJSjUwSFhpUzg></link>

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<figure>

<id>fig\_p150v\_2</id>

<link><https://drive.google.com/open?id=0B9-oNrvWdlO5SUk5cUNtNnpqbXc></link>

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Before casting the <fr>noyau</fr>, make some notches all around the hole through which you want to cast, in order to always better secure the <tl>mold</tl>.</ab>

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Mixed <m>tallow</m> is the reason that, when emptying the <m>wax</m>, the hole does not become obstructed. One needs <ms>half</ms> <m>tallow</m> &amp; <ms>half</ms> <m>black wax</m>.</ab>

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All very thick pieces come out better in hollow, because a thick mass of mostly <m>lead</m> remains hot a long time &amp; eats the <tl>mold</tl>.</ab>

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You can, after the cast is done, mold <del>a</del> the part of the shell of the belly where you have made the hole on the natural one<comment>c\_150v\_03</comment>, and reattach it with <m>solder</m>.</ab>

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<figure>X</figure>Note, that after your <fr>noyau</fr> is cast, it is better to put the <tl>mold</tl> in <m>hot water</m> to open it, in order to remove the most <m>wax</m> that you can, always softening <del><fr>a</fr></del> it in <m>hot water</m>. For the less <m>wax</m> that remains in it, the better, in order that, when reboiling a lot in the <tl>mold</tl> when you reheat it, no blisters or lumps are made in it. And then, if there is hardly any <m>wax</m>, you will not need to reheat it as much. When opening the <tl>mold</tl>, the cast will break. But it can easily be repaired, even though you cast<figure>A</figure><comment>c\_150v\_02</comment>

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