<page>164v</page>

<image>http://gallica.bnf.fr/ark:/12148/btv1b10500001g/f334.item</image>

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<id>p164v\_1</id>

<head>Molds</head>

<ab>

For those <del>qui</del> in which one needs to burn something, and which do not open before being reheated, one does not make any casts before it is reheated. For large molds in which the gate is big and ample, it is necessary that the gate be well notched &amp; scratched, in order that the weight of the metal does not go with much force. They make hardly any fins if they are pressed. But before pressing them, put between them and the press some pieces of thick &amp; <fr>mouflé</fr> felt, which is hardly yet crushed, for it fills the concavities &amp; keeps the mold from breaking. The clamps should be placed before reheating or drying it.</ab>

<ab>

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When the earth, from which you make the earth slab to arrange your animal, is too soft, the points that you put in it come out easily &amp;come undone when you thrown in the sand &amp; thus the mold spoils and the shape comes undone. Therefore when you recognise that your slab is too tender &amp; soft, spread on top some hot ashes &amp; blow with bellows.</ab>

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<id>p164v\_2</id>

<head>Sable</head>

<ab>

If there is not enough good <m><fr>alum de plume</fr></m> or <m>crocum</m>, it will easily break in the fire. But if it is mixed with it, as it should be, it withstands it. One recognizes it as good when, being hot after the cast, it quickly imbibes water when one quenches it in it, &amp; breaks <del>rend</del> easily because the alum &amp; the crocum render it spongy. Contrarily, bad sand, which is only of plaster &amp; brick, &amp; little mixed with alum, breaks easily in the fire &amp; hardens in water. Cast, if possible, all in one go.</ab>

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<id>p164v\_3</id>

<head>Molds</head>

<ab>

Even though you cast in lead, the molds want to be well dried, especially when they are large, and one needs to redden them on the outside &amp; keep them in continuous heat, until they no longer smoke from inside. Do not place them to reheat at different moments, but continue once you have started. And do not place them to cool in the cold, <del>with</del> for they would break, but leave them to become lukewarm near the fire, &amp; like they are when of such a heat that you have noticed before, when putting your finger in the gated hole. And when the mold is large, it needs more time to reheat &amp; dry &amp; one needs to cast hotter.</ab>

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