<page>164v</page>

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

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<id>p164v\_1</id>

<head><tl>Molds</tl></head>

<ab>

For those <del>which</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 <tl>molds</tl> 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 <m>metal</m> does not go with much force. They make hardly any fins if they are pressed. But before pressing them, put between them and the <tl>press</tl> some <tl>pieces of <m>thick &amp; <fr>mouflé</fr> felt</m></tl>, which is hardly yet crushed, for it fills the concavities &amp; keeps the <tl>mold</tl> from breaking. The <tl>clamps</tl> should be placed before reheating or drying it.</ab>

<ab>

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When the <m>earth</m>, from which you make the <tl><m>earth</m> slab</tl> to arrange your animal, is too soft, the <tl>points</tl> that you put in it come out easily &amp; come undone when you thrown in the sand &amp; thus the <tl>mold</tl> spoils and the shape comes undone. Therefore when you recognise that your <tl>slab</tl> is too tender &amp; soft, spread on top some <m>hot ashes</m> &amp; blow with <tl>bellows</tl>.</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><la>crocum</la></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 <m>water</m> when one quenches <corr>it in it</corr>, &amp; <del>rends</del> breaks easily because the <m>alum</m> &amp; the <m><la>crocum</la></m> render it spongy. Contrarily, bad sand, which is only of <m>plaster</m> &amp; <m>brick</m>, &amp; little mixed with <m>alum</m>, breaks easily in the fire &amp; hardens in <m>water</m>. Cast, if possible, all in one go.</ab>

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<id>p164v\_3</id>

<head><tl>Molds</tl></head>

<ab>

Even though you cast in <m>lead</m>, the <tl>molds</tl> 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 <m>smoke</m> from inside. Do not place them to reheat at <tmp>different moments, but continue once you have started</tmp>. And do not place them to cool <env>in the cold</env>, <del>with</del> for they would break, but leave them to become lukewarm near the fire, &amp; when they are when they are still of such a heat as you have noticed before putting your <tl><bp>finger</bp></tl> in the hole, cast. And when the <tl>mold</tl> is large, it needs more time to reheat &amp; dry &amp; one needs to cast hotter.</ab>

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