

one hand, while the other hand rubs it down smoothly and evenly as put on. PRACTICE IS REQUIRED IN THIS. After the first tissue is pasted on the blot-sheet, paste it over again and add another tissue. Continue this until five tissue sheets are pasted on the blotting sheet. When you have as many as will do you a week, dampen the back slightly (the blot side) with a brush and water, and put them, one on another, between two stereo blank plates, which you can cast in the casting-box. The paper should lay two days before using.

The majority of failures in the general process of stereotyping are caused by the careless pasting of the blotting and the tissues. A good matrix is necessary to produce first-class workmanship. When it is possible, it is far better to send to the manufacturer for ready-made paper or flong.

LOCKING-UP THE FORMS.—A small imposing surface should be placed as conveniently as possible to the place selected for the work.

1. Take the casting-box and place it over the furnace to warm. (Where a drying press is used, merely light the lamp under it to warm it up. You do not use the casting-box in that case).

2. Take the form that is to be moulded and unlock it on the imposing surface.

3. The forms are to be locked up with guards around them—one on each of the four sides, a nonpariel from the matter. The guards can be cast in the casting-box, and should be type-high, and one-half inch wide, the side next to the type being beveled slightly at the top.

This done, see to the cleanliness of the form, and that there are no slipped letters or brass rules riding. Be careful that the type are thoroughly clean and dry, and evenly planed down, before moulding, and, if satisfactory, lock up the usual way.

4. See that the form will lift with safety; and, if so, slaken the quoins so that they are very little tighter than can be undone by the fingers.

MOULDING.—Slightly oil the face of the form with the brush prepared for that purpose, which is done by pouring a little olive oil into the palm of the left hand, and rubbing the hair of the brush evenly into it. The oil should be hickory nut or olive oil. Then lay on your matrix, tissue side down, and beat it gently with the beating brush. Then have a piece of muslin a little larger than the form; dampen it, and spread

it over the matrix, and beat it gently and evenly all over, turning the form in beating to make sure of it being even. Beat lightly on those parts of the form which are open. You can lift up a corner of the matrix from the type and see how deep it has gone in. When you think it very near deep enough, lift off the muslin and paste a waste printed sheet on the matrix, and put on the muslin again, after dampening it, and beat until you get the required depth; then lift off the muslin and paste another thin sheet on, and beat without the muslin.

Be very careful to exclude all the air that may have got between the papers in laying on; and, should there be any whites or open work in the form, a great saving of time is effected by filling the same with a little softened pipe clay, or by pasting a piece of thin pasteboard, cut so as to keep it a great primer from the type. The pasteboard can be pasted in with the pipe clay. This should be done before the last sheet is put on and beaten-in, after which the form is to be planed and locked up in the usual way.

Lift the lid of the drying and casting-press, (which has been warming over the furnace), and place the form on the centre of the surface between the two upright pillars. (If you have a drying-press you will want it put there). Spread a piece of thick blanket doubled over the form (thirty thicknesses of old newspaper will do), and immediately cover the whole with the lid, and screw it tightly down with the lever, say, a little more than can be done with one hand. Let it remain in the press about ten minutes, then raise the lid (which will allow the confined steam to evaporate), and let it remain about two minutes to allow the matrix to thoroughly dry, after which remove the form back to the imposing surface, and take off the mould by lifting gently at each corner. Cool your form in water, and rub over the face with oil and water, which will prevent the type from sticking.

CASTING.—1. Cover the underside of the lid of the casting-box with strong, smooth manilla paper, pasting it on the side only with strong paste.

2. Cut the superfluous portion of the mould away with a pair of shears, leaving the edges caused by the type-high guards which were placed around the form, and hammer down any projection, should one appear, where the metal was joined at the corners.