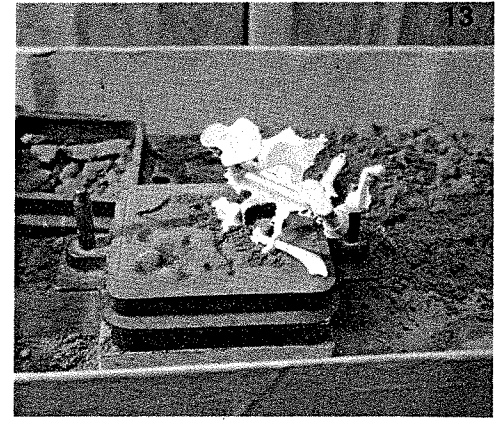


Pouring Cerrobend into mold.

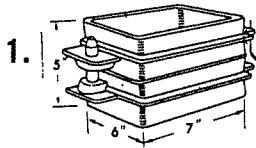


Cope removed from flask showing "gate" of castings.

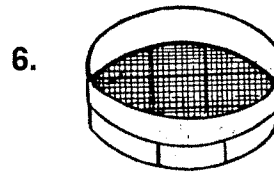


Casting ready to break apart and finish.

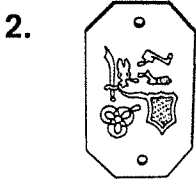
LIST OF PARTS AND THEIR USES



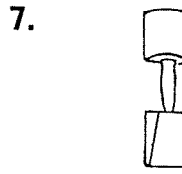
1. CASTING FLASK—2½" cope, 2½" drag x 6" x 7". Fitted with hardened steel bushings and pins. All steel construction, same as in larger standard foundry flasks.



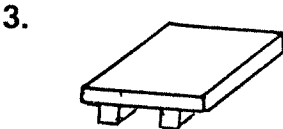
6. RIDDLE. The riddle is a screening device used to remove foreign matter and sand lumps and for depositing a layer of fine sand on the surface of the pattern.



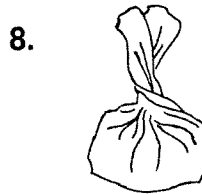
2. MATCH PLATE of ¾" plywood is supplied with small patterns of Cerrobend, permanently mounted. Plastic impregnated surface eliminates need for painting.



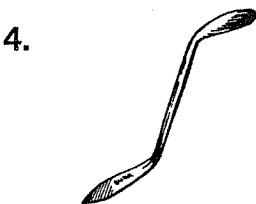
7. BENCH RAMMER. This wooden tool is provided with a wedge shaped part called the peen and a round part called the butt, and is used for packing sand in the flask.



3. BOTTOM BOARDS (2) of cleated pine provide surface for supporting flask during ramming.



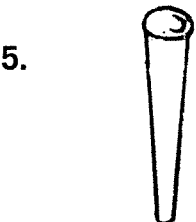
8. DUST BAG. Contains the parting compound which is dusted on the patterns to prevent sand from sticking to them.



4. GATE CUTTER. A double end tool of steel for cutting passageways in mold and for making minor repairs to mold.



9. MOLDING SAND. Sand supplied is ready for use except for additional moisture which may be required for proper tempering. Directions for tempering included with sand.



5. SPRUE CUTTER. This tapered brass tube is used for making a passageway for the metal through the sand in the cope of the mold.



10. CERROBEND ALLOY. Approximately 10 pounds of Cerrobend alloy is included in each kit. Melting temperature 158° F., melts in inner vessel of double boiler. Shows slight expansion on solidification with additional growth in solid phase.