

VI. Molds and Liners

UNIVERSAL ADJUSTABLE MOLD

THE universal adjustable mold is adjustable for any measure from 4 to 30 ems pica and from 5 to 14 points in body thickness. The body portion of the mold is screwed firmly to the disk. The mold cap overlying the body is held at each end by upright mold cap guides insuring position adjustment, front and back, of cap and body.

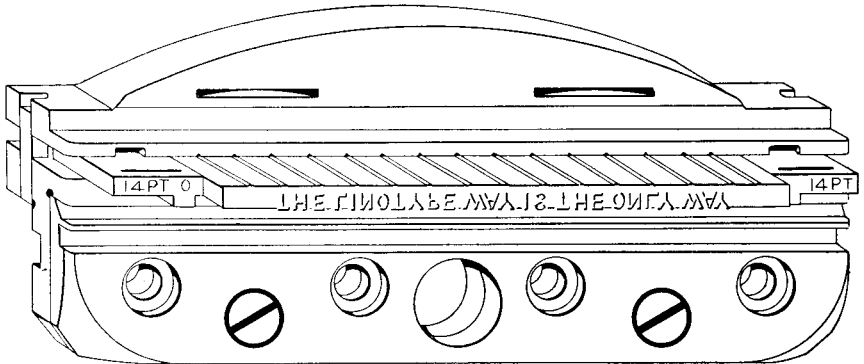


FIG. 129a.—Universal adjustable mold.

The right- and left-hand liners are held firmly between the cap and body by the pressure of the mold cap screws, and at right-angles with the mold slot by keys on bottom of liners, which fit in mold body, insuring rigidity and accuracy in length.

A change of measure and body does not affect the general relation of the mold to the trimming knives. Therefore, the molds and knives, when properly adjusted, will maintain their corresponding position indefinitely, thus insuring slugs of equal height and thickness.

The mold disk opening or pocket is of a curved form on the outer side, with three set screws through the rim from the outside which hold the mold cap liners securely in place.

In order to change the length of the line, it is only necessary to loosen the screws so that the left-hand liner may be withdrawn easily and one of the proper length inserted. The mold cap can be raised by inserting a screwdriver in the slots which will be found in either end of the cap. Never

pry the cap open by inserting screwdriver in the mold slot. This will eventually ruin the mold. Use a piece of brass.

If a change of body is required, the screws are loosened at both ends, and both liners (right-hand and left-hand) withdrawn and the proper ones inserted. When tightening the screws, use only a moderate pressure. There is no need of binding.

Liners can be supplied for all measures in even ems or half ems up to 30 ems pica, and in all bodies from 5 to 14 point, inclusive. It is convenient to have an assortment on hand.

The universal adjustable mold can be changed for any lengths of line or thickness of body in a very short time.

RECESSED MOLD

In order to reduce the quantity of metal in large slugs and to improve the face on large characters—10 to 14 point, inclusive—this mold is provided with a cap having projecting portions that form large cavities, or recesses, in the slug, as shown in the illustration, thus reducing the weight of each Linotype slug about one third.

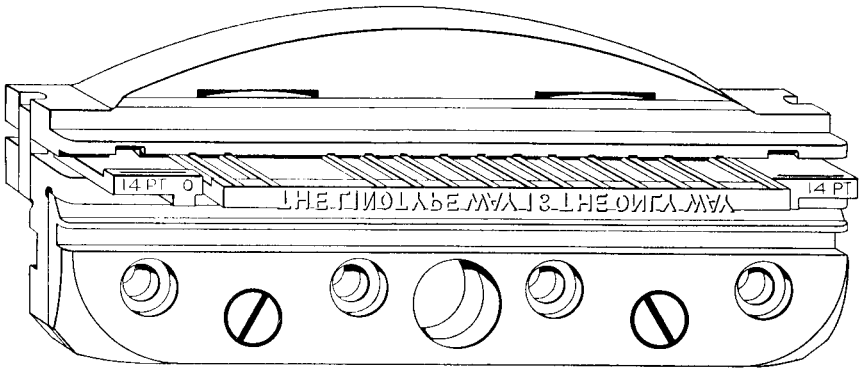


FIG. 129b.—Recessed mold.

The slug has a solid face, as usual, and ribs at the side to sustain the face, so that it stands up solidly under the pressure of stereotyping, electrotyping, or printing from the slugs direct.

The recessed mold is, in general construction, similar to the universal adjustable mold. The right-hand liner is precisely the same as that used in the universal adjustable mold, but the left-hand liner, which is used in changing from one measure to another, is *special, and can be used only in a recessed mold.*

The mold can be applied to any machine having a universal adjustable mold disk, without altering or fitting the parts, and may be used in

connection with the ordinary ejector blades, *but the ejector blade must be five points thinner than the body being cast, on account of the recessed cap.*

The slugs being much lighter than when cast solid, the saving in metal reduces the expense of keeping matter standing. As the air to be displaced from the mold is less than that from the Universal Adjustable mold, more perfect slugs are secured, especially on the larger sizes.

Recessed molds may be specified on all new Linotypes, except Models K and 15, without extra charge.

UNIVERSAL ADJUSTABLE LOW MOLD

This mold is used for casting low slugs without ribs from 5 to 14 points in thickness and any ordinary length of line. Both right- and left-hand liners used in this mold are special. The ordinary matrix slide blocks may be used with this mold but the slide is special, being extra thick in order to make up for the difference between the height of this mold and the ordinary mold. The universal adjustable low mold is only .754" high.

ROGERS TABULAR MOLD

This mold can be used for casting blank slugs on a machine equipped with the Rogers tabular attachment. The mold is .731" high and used only with the tabular attachment. Matrix slides are not made for use with the Rogers tabular mold.

FUDGE MOLD

This mold is used to produce a slug with a taper from top to bottom, so that a number of them when assembled will fit the curved surface of the plate cylinder of a rotary newspaper press. A fudge is a number of these slugs so fastened to the cylinder that, if desired, it may be printed in a different color from the rest of the plate of that particular page, or may be inserted in a stereotype plate.

This mold cannot be used to cast any measure or body except the one for which it is built. To make these, the factory must have the following information:

1. An accurate drawing of the cylinder, showing its total diameter, and the radius from center to the face of the type.
2. Exact length of slug at face of type.
3. State whether the two ends of the slugs are to be brought to an angle, or left flat or square, same as the regular slugs.
4. Height of slug from bottom to the beginning of the angle on the two ends. Also what the angle on ends is to be; whether forty-five degrees, or some other angle.
5. Size of face.
6. Size of body on which the face is to be cast.
7. Show how slugs are to be held in position.

In supplying a Fudge mold there are some extra parts necessary to be applied to the machine, and an order should always state (unless you already have one of our fudge molds and only desire to replace it) that the necessary parts should be supplied.

If you have one fudge mold and desire to put another in the other side of the mold disk, it is only necessary to purchase the mold itself.

Regular ejector blades are used with fudge molds. *The liners, however, are special, and are not adjustable*, for a fudge mold can be used for only one specified body and one measure.

DISPLAY OR HEAD-LETTER MOLD

The display mold, used to cast the larger bodies, is similar to the recessed mold, the recess being proportionately deeper to accommodate the increased size of slug. This style of mold requires a pocket or opening in

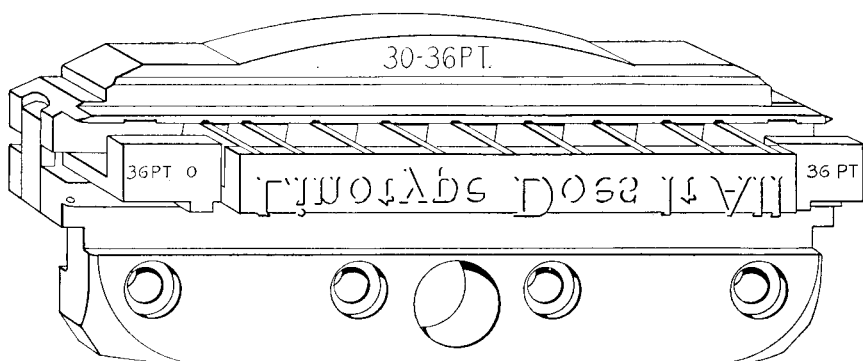


FIG. 129c.—Display or head-letter mold.

the mold disk somewhat larger than that required for other styles of molds. This mold is adjustable for body size as well as length of line and is used in the same general manner as other molds.

ADVERTISING-FIGURE MOLD

This mold is made for the purpose of casting large figures for price figures or other display characters on a slug of smaller size than the face of the type. It permits of casting a character that overhangs the slugs below. There is a wide lip on the cap, against which the overhanging portion of the character is cast, and the ribs are parallel, instead of tapered as usual. This mold will cast overhanging faces up to 24 point in face, and it is adjustable in body from 5 to 12 point.

In special cases this mold will be adapted to accommodate 14- or 15-point liners so that certain 30-point display faces can be cast overhanging. When 14- or 15-point liners are so used, the two-letter attachment must be used to prevent the mold cap lip from striking the first elevator back jaw.

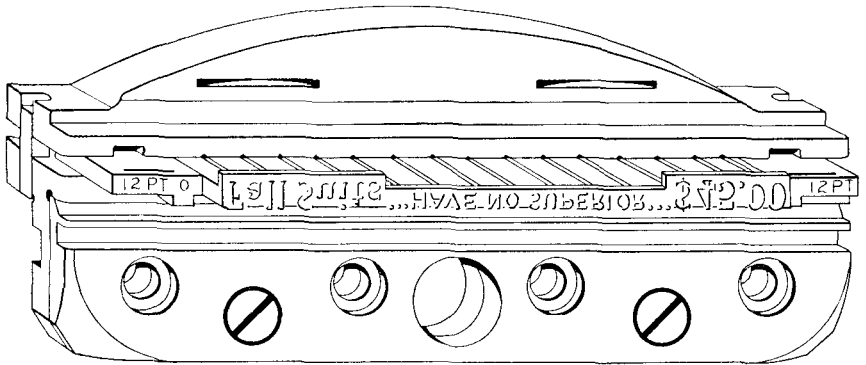


FIG. 129d.—Advertising-figure mold.

Fig. 129d shows the advertising-figure mold with slug bearing overhanging characters. This style of composition is frequently required in newspaper and job work, and is easily and quickly accomplished by the use of this type of mold.

SPECIAL ADVERTISING MOLD

For Use with Matrices in the Auxiliary Position.—This mold is for use with extra large figures and display faces. It is a one-letter mold for use only with matrices punched in the auxiliary position, and will cast large advertising figures up to and including 42 points. Thus, its scope is much larger, due to an extra wide lip on the mold cap to provide for the overhang, than the regular advertising mold. Regular universal adjustable mold liners from 5 to 12 points, inclusive, can be used with this mold. The largest overhang that can be cast against the face of the mold cap is 27 points.

MOLD LINERS

Universal Adjustable Mold Liners.—Universal adjustable mold liners are made in point sizes from 5- to 14-points, inclusive, and, in length, to produce a slug by ems or half ems from 4 to 30 ems, inclusive. When ordering liners the body as well as the length of line to be cast should be stated.

CHANGING MOLD LINERS

To change the liners in a universal adjustable mold from one thickness to another, or from one length to another, lower the vise and revolve the mold disk to a convenient position where the mold will be accessible, as shown in Fig. 60. Loosen the screws in the mold disk above the mold cap, remove the liners, and insert those you desire to use, then tighten the screws. Be sure to change the ejector blade before changing the liners if you have reduced the length or thickness of the slug. The mold must be turned to the ejecting position after the change. Do not remove the keeper from the mold for any reason, except an injury. If it is necessary to remove

it, care must be taken in replacing it to see that there is no dirt on it and that its upper edge is brought up to its proper seat, as this controls the alignment of the matrices. Set the vise jaws by the gauge attached to the vise, close the vise, and set the side trimming knife, the assembler slide and delivery slide, and the first-elevator jaw line stop one eighth of an inch longer than the length of the line after it is justified.

Caution: In order to change the left-hand mold liner in a 36-em mold, it is necessary to take the mold from the mold disk, after which the cap can be removed and the liner taken out. The liner is held in position by the mold cap guide and cannot be changed while the mold is in the mold disk, as the universal adjustable mold liner is changed. Be sure that the mold body and cap are perfectly clean, and that there is no metal adhering to them when changing liners.

Left-hand liners made for 30-em molds cannot be used in 36-em molds, and *vice versa*.