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belly and shoulders is feethed as it ought to to be, the legs and thighs, which are not so big, will be burnt and consumed with the fire before the trunk is hot through. And this caution is necessary in all the different pieces of work that can be made, if the workman would perform it with judgment, and prevent such ill accidents as may happen upon the like occasions.

When the mould is finished after the manner before directed, the artificer orders a hole to be dug four-square, large enough to contain the figure; but it must have a wide space of at least a foot or a foot and an half about it, and be deeper than the mould is high; for, at the bottom, it should have a sort of an oven, whose mouth must be on the outside for the putting in of the fire, and above that a strong iron grate, strongly supported by the arch and walls of the oven; which should be made of freestone or brick, as well as the four sides of the hole from bottom to top.

After the grate is placed on the oven at the bottom of the hole, the mould is let down with engines, and the necessary provision made for it; pans are set under the pipes, that serve for casts and vents to receive the wax that runs out of them; then the hole is covered by planks, and, by lighting a moderate fire under the figure, that, and all the place in which it is, is heated with a moderate heat, till the wax melts and runs out of the mould, none remaining behind; for, if there was, it would cause a deformity in the figure, when the metal ran into it.

The mould must not be so hot as to make the wax boil, which might hinder its running out intirely.

When it is thought all the wax is melted, which may be known by the quantity which comes out, for it must be weighed before it is put in; the pans are taken away, and the mouths of the holes at which the wax ran out are covered with earth; all the void spaces between the mould and the walls are filled with pieces of bricks, which are thrown down softly and without ranging in order; and, when that is done to the top, a good wood fire is made under the furnace. The flame, being intermixed with these pieces of brick, cannot ascend with violence or damnify the mould; but communicates a heat only in passing through those pieces of brick, which it heats, so that it grows red, as does also the mould.

After the fire has burnt about twenty-four hours, and it is perceived that the bricks and moulds are lighted from bottom to top, that fire is let out, and the moulds grow cold again; all the bricks being taken away that were about it. When the heat is quite gone, earth is thrown into the hole to fill up the vacancy left by the bricks, and, as the earth is thrown down, it is trod upon and pressed against the mould, which therefore should not

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