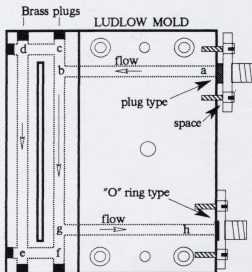


# The LUDLOW Quarterly

A Newsletter For Ludlow Typograph Operators And Enthusiasts

## The Very COOL! Mold

Possible mold cooling problems: the slugs have poor faces and the body may be somewhat hollow, generally accompanied by excessive bottom trim. These problems indicate the typemetal didn't lose heat fast enough and began to drain out before solidifying. Slugs that don't cool fast may not shrink enough to be ejected easily and broken safety keys or slipping belts may result.



The internal water passages of a Ludlow mold reflect some design

compromises that seem to eventually cause trouble for all operators. (See the diagram) Coolant enters the rear of the mold (a-b) and splits into two streams (b-g and b-c-d-e-f-g) which join to exit the mold (g-h). Under ideal conditions the same volume of coolant travels along each side of the slot, cooling both sides equally. Passage b-g is smaller in diameter than the longer kinked passage c-d-e-f so that resistance, and therefore flow, is more equal. Change viscosity, flow rate, or deposit sludge from an oil/water mixture and everything changes. Generally, the long left passage collects a build-up, which decreases flow, which encourages sedimentation, etc, which diverts more and more coolant into b-g, the right side passage, until the left passage is totally blocked and bypasses all coolant through the right side.

This is a double problem! Besides causing bad slugs the greater thermal expansion of the very hot left side is so much more than the right side that the stress can open the seam between them and cause coolant to seep out the crack. The mold might even crack!

Check it out! - After your machine is up to temperature, check to see that there is a good flow of coolant pouring

into the holding tank. At this point the flow reflects pump output through the resistance of the entire system. A cup every 8 seconds should be considered minimum, a cup or more every 4 seconds is great! If circulation is poor, check the coolant level, check the screen filter (yes - there is one!) in the bottom of the reservoir (model L), and pump output by removing the line to the rear water fitting of the mold. If there is good circulation to this point, reattach line and then cast three slugs rapidly. Lift the table top, wait a couple seconds, and carefully feel the mold temperature on either side of the slot with your fingers, while letting the water circulate. If the left side is very hot, but the right side is relatively cool, you probably have a clogged mold. Keep checking to see if and how fast the left side cools off. 100% clogs don't allow the left side to cool very much at all.

In machines using oil/water coolant the blockage is probably a combination of two materials: rust and sludge. Solvents can remove sludge and a weak acid, apple cider vinegar, can dissolve the rust.

To clean out the mold, DO NOT unscrew the big screws on the end in an attempt to take it apart. You will never get it back together right. Stand it on end with the water fittings up, fill it with solvent, let it sit a while, and then pour and/or blow it out. Use a pipe cleaner. Repeat until clear. For solvents I have tried: alcohol, lacquer

thinner, solvent, mineral spirits, TSP solution, detergents, etc. Then let the mold stand overnight filled with cider vinegar, not white vinegar, and most of the rust should go. Vinegar will stain the mold so wipe off spills. Flush the mold well and test it in the machine again.

If the problem isn't fixed now, send it to a repairman. Sometimes the passages need to be drilled out. Jim Parrish cleans and repairs molds, and installs removable plugs so that the operator can easily clean the passages in the future.

Don't think that you can easily drill out the brass plugs, ream the passages out and install new plugs. You can, but not easily. The brass plugs are tapered, and have very non-standard sized threads. A good lathe with a taper attachment should be able to duplicate them. This author spent several hundred dollars having custom taps and dies made to make replacement plugs, so if it is too late and you are already in trouble, call and I might be able to help.

If you feel you MUST remove the water connectors, be very careful not to break the screws. A trick with the tapered plug type is to use broken spacebands as wedges, tapped in evenly under both arms to extract the plug. Grease it well when reinstalling. Always replace the O-rings when reassembling that type.

Good Luck!

## BUSINESS PROFILE

Our focus this issue is on Craftsman Rubber Stamp Co. of Eugene, Oregon. Proprietor Alan Wagner this month celebrates the 2nd anniversary of his rubber stamp business. Formerly a print broker and then letterpress printer, he grew tired of maintaining an early Intertype, eventually buying his 1928 model L Ludlow from a printer in Eugene and switching to rubber stamp production.

His Ludlow with over 80 fonts is the heart of his local business stamp operation, and he has installed a solid-state thermostat to adjust temperature for mold changes. Alan also sells business and art stamps by mail-order across the country. He makes hundreds of copyrighted art design stamps using a computer and photo-polymer intermediate matrix to make pure rubber stamps. He also makes chemical and solvent resistant stamps.

Currently Alan is working out of his residence, but growth is making space tight and he is looking to move into a storefront location. He wants to get a supersurfacers and is seeking a 6-48pt. series of Radiant Medium and more sizes of Old English.

## NEW DEVICES!

There is a new development for the Ludlow!

Dave Seat, of Dave Seat Hot Metal Services in Tennessee, has developed two new solid-state thermostats for the Ludlow machine. One has an adjustable dial control and keeps temperature constant to plus or minus five degrees. The second, and more expensive, unit regulates temperature to plus or minus one degree, and is completely digital.

The new devices completely replace the standard thermostats and their mercury sensing bulbs with a new control box and temperature probe. The new temperature probes are 1/5th the cost of standard probes.

Instructions come with the units and most operators can do the replacement themselves. Dave is happy to lend assistance by phone. The digital style accepts voltages from 90 to 280 volts. The ability to easily make temperature changes for different molds should help to produce better slug faces. Dave's phone is (800) 542 2508.

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## Questions and Answers

Q - How much does a model L Ludlow machine weigh with a full crucible? P. Walters - Iowa

A - 1,300 lbs with full water tank.

## *Congratulations!*

The Ludlow Quarterly congratulates Marlboro Mats on their 65th year of supplying Linotype and Ludlow mats to operators. Sales in 1994 were reported to be better than in 1993, and may 1995 be even better! Phone is (208) 443-2715. (ID)



How many lawyers does it  
take to roof a house?

\* \* \*

It depends on how thin  
you slice them.



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## **P\*I\*P\*E Donations**

Our thanks to these contributors to the Postage - Ink - Paper - Equipment fund: Mike Phillips, Susan Smith, Hubert Jesse.

## **FREE Matrix Identification!**

For those of you who do not have the new generation Ludlow mat gauge, which uses the lines on the back of the mats to identify the Ludlow fonts and point size, we are providing a free mat identification service. Just send one mat of each font you want identified to the LUDLOW QUARTERLY address, with sufficient postage for return. Make sure the samples you pick exactly match the lines on the back of the mats in the font. The sample mat can be any letter, even a period. Think thin and light, (like ., -) and you might even be able to tape them onto a letter!



It is wrong to assume that  
worrying about things doesn't  
help. Most of the things I've  
worried about never happened.



## **CLASSIFIED ADS**

Ad cost is only 15 cents per word.

To help preserve letterpress equipment, ads offering free items will be run without charge.

### **FREE**

Free: Several Linotype magazine racks, you pick up. Cabinet base for small proof press. (602) 581-1748

### **WANTED**

Wanted: Information to locate Miller or any other brand of 29" x 41" cylinder letterpress (1 or 2 color) and sized for the above press: imposing stone, furniture, turtle. Vandercook plate mounting system - block leveler. makeup gauge, Lite-base casting box or mold only, plate thickness gauge, plate mounting press. Please call John Finch, (303) 460-9598. (CO)

Wanted: Looking for Ludlow mats for Bookman and Bookman Italics, any sizes. Also looking for Ludlow border mats. Contact Rev. Jan L. Beaderstadt at P. O. Box 137, Sterling, MI 48659 or call (517) 654-2291, Fax(517) 654-3099.

Wanted: Five left-hand-pull cases, will buy or trade for right-hand-pull cases. John Rote, 1015 West Moffatt Rd., New Castle, PA 16101. (412) 654-2515.

Wanted: Ludlow mats. Smaller sizes, ornaments, and script faces. I have Linotype mats and some letterpress equipment to trade, but will also buy entire collections. Bill Simon, 3115 W. Cavedale Dr., Phx., AZ 85027. (602) 581-1748

### **FOR SALE**

For sale: Two left-hand-pull drawers and four right-hand-pull filler pieces, used where drawers are missing from cabinet. Pump and rebuilding parts, soluble oil. Call John Finch, 303-460-9598. (CO)

For sale: Linotype metal in ingots, with analysis. Offset, bindery, and letterpress equipment, including two Miehle V50's. Large selection of numbering machines, including MICR numbers. Call Printing Equipment Locators, digital pager (602)229-9709 (will return call), Office (602)352-1663 (AZ)

For Sale: Two gas Ludlow machines, mega fonts, air and manual Kensol foil machines. Info: (618) 539-3377 - (IL)

For sale: Vandercook SP 15 proof press in beautiful condition, \$175.00. Kelsey press 9"x13" Excelsior model FA - \$150.00. Wood type - 17 drawers full, the whole lot for \$350.00. Ludlow cabinets, empty, \$60.00. Ludlow fonts, (Send for list) priced at \$55.00 per font. John Gallagher, R. R. #3, Pembroke, Ontario K8A-6W4. Phone (613) 735-7080.

For sale: Retiring Typographer has sold the Ludlows but has three excellent cabinets of beautiful mats (mostly series), 13 extra fonts in cases (total 73 fonts), lots of quads, dividers, 15 sticks ( includes one self centering ), supersurfacers, plunger puller, some Ludlow parts. Could be impossible to assemble this beautiful like new collection of Ludlow mats ever again. Must sell all together, only \$2,500.00. Also have 30 excellent Linotype fonts. Call or write for list. TYPOGRAPHIC, phone (806) 353-1370, 4812 Andrews, Amarillo, Texas 79106.

For sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide". Jim Parrish, 1483 N. Mount. Juliet Rd. #223, Mt. Juliet, TN 37122. (615) 758-8592

For sale: Ludlow mats. 4 pt. to 42 pt. Five Ludlow cabinets with slant tops, \$50.00 each. J. D. Moreaux, 2831 Amberwood Place, Thousand Oaks, CA 91362.

For Sale: Linotype molds, liners, and mats. Quoins, furniture, automated perfect binding machine, small paper cutters, gold foil stampers, new ATF type, type cabinets, galley cabinets. Will also trade above for Ludlow mats. Bill Simon, (602) 581-1748.

For Sale: Old English Ludlow mats. 12-14-18-24-36 pt. and centering stick. All for \$1,300. Contact Paul Morneau, 8222 E. Monterosa St., Scottsdale, AZ 85251 - (602) 990-1655.

## **TRADE SERVICES**

### EXPERT LUDLOW REPAIRS

Books, sticks, etc. Machine packages available. Machinery appraisals and equipment moving. P. J. BURNS, Mercersburg. PA (717) 328-3092

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The LUDLOW Quarterly is launched! There are hundreds of expert Ludlow operators all over the country, and the editor asks for your help to make this newsletter more useful to the rest of our subscribers. We welcome letters to the editor, questions, suggestions, tips, experiences, and articles.

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### The LUDLOW Quarterly

Bill Simon, Editor/Publisher at 3115 W. Cavedale Dr., Phoenix, AZ 85027-7637. Phone (602) 581-1748. \$6.00 per 4 issues U.S., \$8.00 Canada, \$12.00 other countries. 15 cents per word for classified ads. Deadline for issue #2 is June 10th.

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This issue was letterpressed on a Vandercook Universal I proof press and type was set entirely with Ludlow mats. Ludlow Black and Bodoni Bold in masthead, 12pt. and 14pt. Cheltenham Wide for text. Cheltenham Bold Condensed headers, and Coronet Bold.