

Electricaster

Hand Book

Simple and Practical Stereotyping Methods

Second Edition

1926



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Electricaster Hand Book

WHAT ELECTRICASTER IS

The Electricaster is a stereotype casting box in which the heating of the box, previous to casting, is accomplished by attaching a cord to an ordinary light socket, the current within a few minutes insuring a temperature which results in a perfect cast the first time, IF INSTRUCTIONS ARE FOLLOWED CAREFULLY.

The box takes a mat three 13-em columns wide by 10½ inches deep, or smaller.

Electricaster is the first equipment offered to newspapers and job plants which, in a practical way, covers the whole problem of light stereotyping.

With our casting box and instruction book, together with our especially prepared flongs, you are enabled to make as good mats and casts as with a large, expensive plant.

CAREFUL STUDY OF OUR INSTRUCTIONS IS VERY NECESSARY, HOWEVER.

Remember that if you have never attempted stereotyping you could not go into a \$50,000 plant and get good results, WITHOUT EXPERIENCE.

If you DO study our instruction book, you get the benefit of years of stereotyping experience and training.

ELECTRICASTER STANDARD EQUIPMENT

The following articles are packed with Electricaster in the shipping box, and constitute standard equipment.

- 1 wrench, for use in locking box in mat-making.
- 1 set of floor casters for packing case.
- 1 set of steel type-high bars.
- 1 set of 9-point shell bars.
- 1 small dipping ladle.
- 2 asbestos-lined felt pads or mitts.
- 5 sheets of backing paper.
- 10 strips of backing felt.
- 1 piece of candle.
- 1 envelope of sample mounting nails.
- 1 envelope of sample corrugated strips.
- 1 Electricaster Hand Book.
- 2 sample mats for casting.
- 3 pieces sample mounting lumber.

INSTALLING THE EQUIPMENT

Arrange a compact department in your office for your stereotyping outfit.

Electricaster comes to you packed in a strong box, especially designed to act as a permanent base for the machine. Four screws hold the lid on the box. First remove these, and lift out the machine. Notice that there is a red paint mark on one leg of the tripod base and a like red mark on one end of the box. Place the machine base on this end so that the red marks come together, and each leg is over the hole drilled for the screw. Use the screws which fastened the lid on the box.

Slip the box lid between the cleats prepared for it inside the box, thus forming a shelf upon which to keep the tools and extra bars. Floor casters are also in the box, and metal-lined holes will be found at each corner of the box to receive them.

The casting box on its base should be placed convenient to the composing stones. Or better still, a steel-topped table, if one is available. The solid surfaces of the stones or steel table will be found necessary upon which to handle hot casts, mounting and finishing. If you have a power saw it should be close by.

Keep all tools used with the outfit or in finishing mounted work, as near as possible AT ARM'S LENGTH. These include chisels, tack hammer, mounting nails (cigar box tacks), punch for setting galleys, hand saw if you have no power saw, etc. Keep the asbestos lined pads with the tools. **KEEP ALL THESE ACCESSORIES TOGETHER WITH THE OUTFIT AT ALL TIMES.**

When you want stereotyping tools, you want them NOW.

Most of the dissatisfaction and poor results with stereotyping in the small office are attributable to carelessness. Scattered equipment cannot result in good work.

A properly installed small stereotyping outfit can shorten your work immeasurably.

YOU MAY USE LINOTYPE MELTING POT

Electricaster is designed to be used in connection with the linotype melting pot, which is always ready for a cast. There is no waiting for the metal to heat.

A special ladle which fits easily into the linotype pot beside the shell, is supplied with each machine. Electricaster is the only casting box so designed that this method is efficient. By reason of the electric heating of the box, any number of pourings from the ladle may be made until a point is found, either in shell or in solid casts, when the box is heated to proper temperature.

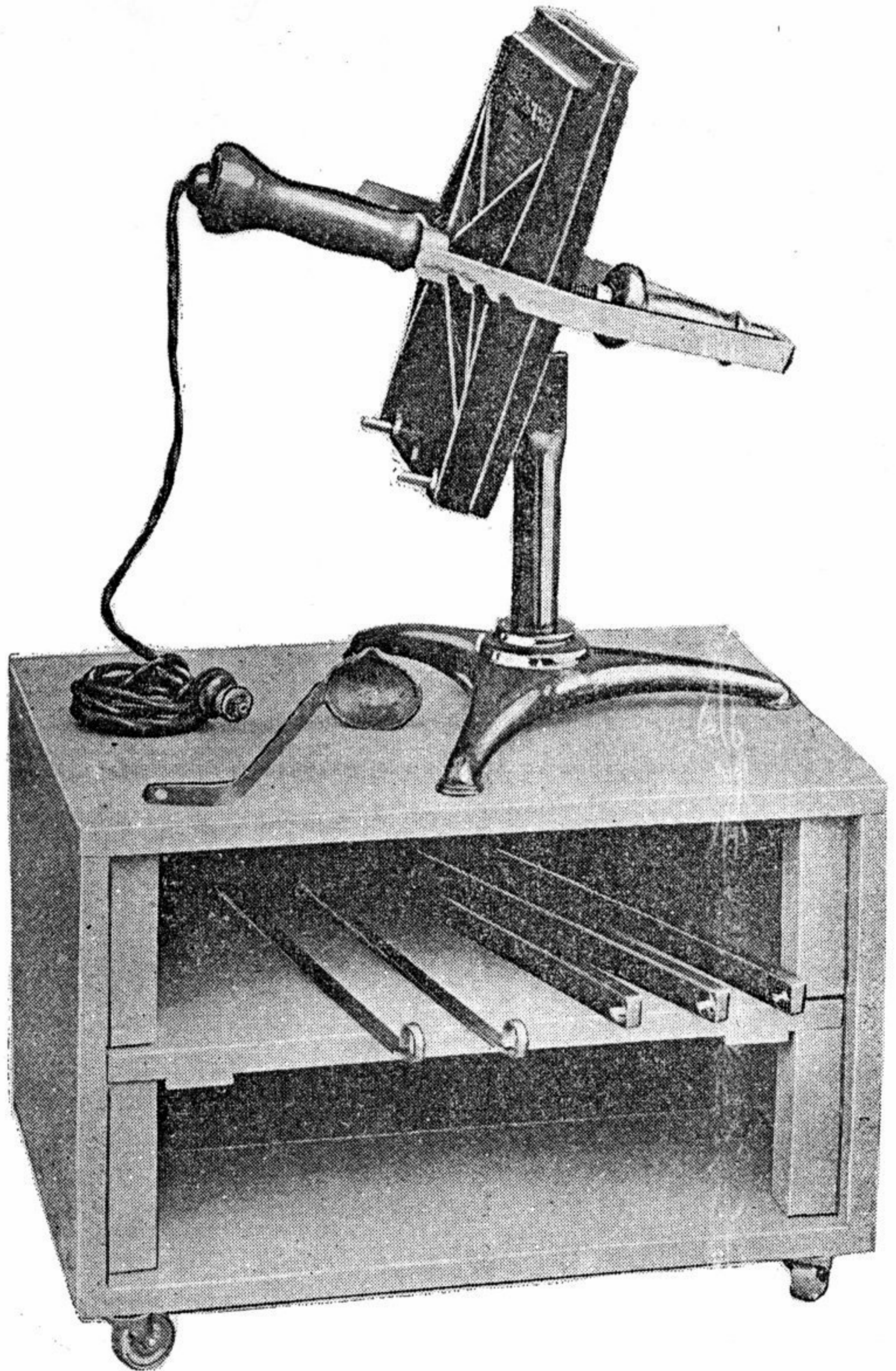


Fig. 1
Electricaster and Accessories.

The use of the linotype pot in no way interferes with the operation of the linotype, as it requires less than a pig of metal to cast an entire quarter page in light plate. Just slip another pig in the pot as

you finish your cast, as the linotype operator does at intervals. While your cast is cooling, the pig will have melted and you are ready for another pouring.

This method disposes of the most troublesome detail in the casting operation in the country office. Last minute casts can be made, finished and in the form before the average metal pot could be heated up. It has the added advantage that the temperature of the metal does not require so much attention. Metal that is right for the linotype is about 100 degrees cooler than that required for an ordinary casting box. If the temperature of the linotype metal is lower than 550 degrees, heat Electricaster about 10 minutes longer. Use only linotype metal in Electricaster, as it is especially designed for this formula.

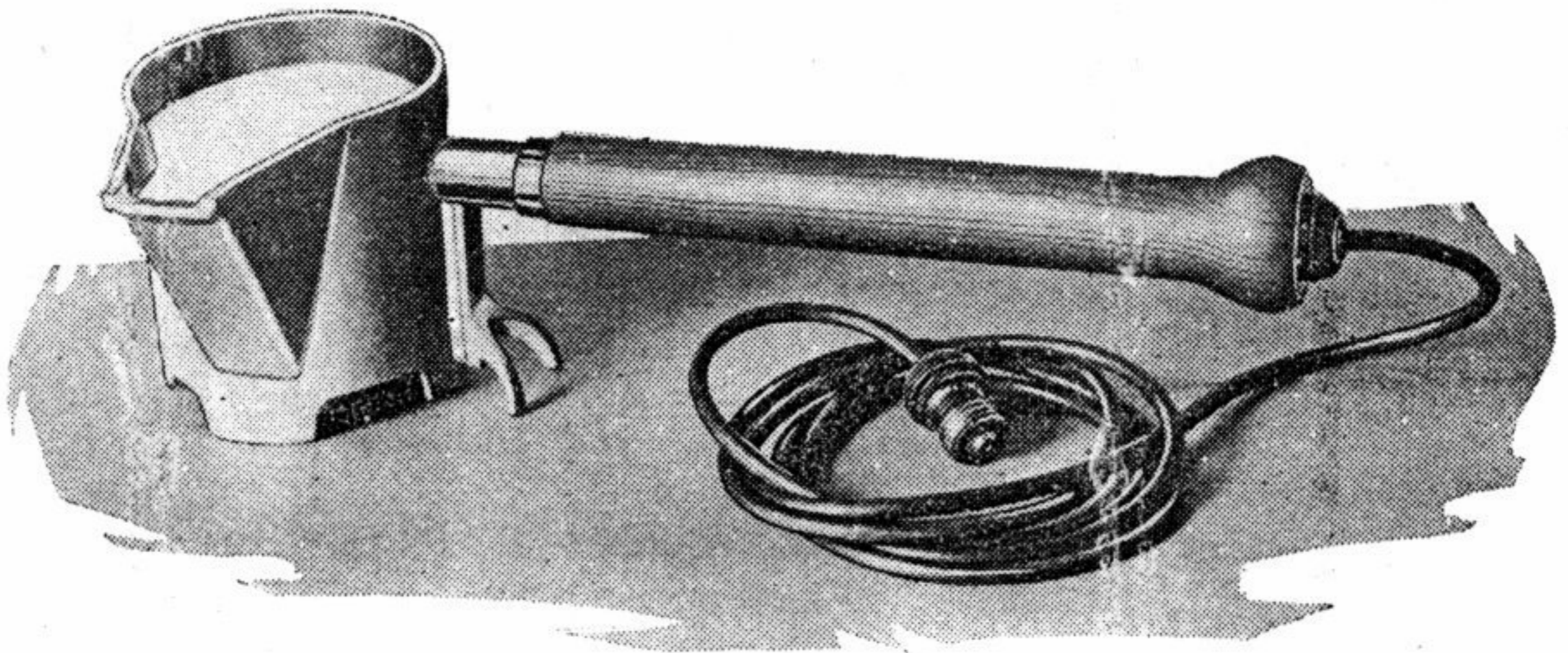


Fig. 2
Electriladle

ELECTRILADLE

As a companion to Electricaster, Electriladle makes our equipment 100 per cent electric. Electriladle is made of cast aluminum, with hardwood handle long enough to be a comfortable two-hand ladle, and holds 15 pounds of metal. One filling is sufficient for several complete shell casts.

Electriladle operates off the electric light line in the same way as Electricaster. The two machines should never be connected up to the same light socket, however, as this would result in a burned-out socket.

Electric heating of metal IN A LADLE SEPARATE FROM THE CASTER adds immeasurably to the convenience and speed of our equipment. Just set the ladle on the stone, fill with linotype slugs, and turn on the current. Forty minutes is the average time required to heat metal to the casting temperature. This time varies with the intensity of the current on your wires.

When you have poured one cast, slip a handful of slugs into the

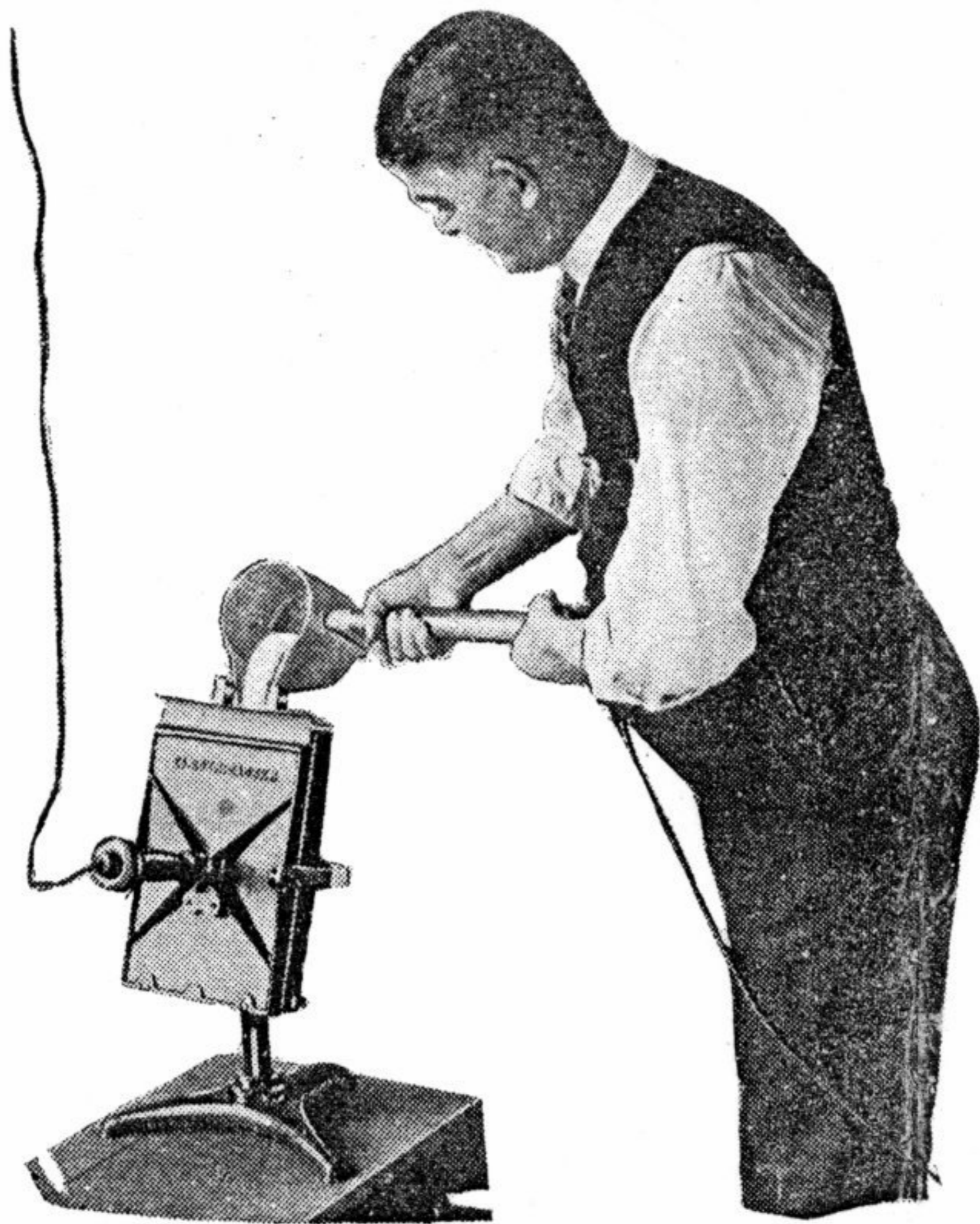


Fig. 3

Pouring cast with Electrilladle.

molten metal, and by the time you have placed the next mat in the caster, the ladle is ready to pour again.

The price of Electrilladle is \$20, F. O. B. Philadelphia. Shipped by express or parcel post. Weight packed for shipment, 8 pounds.

CASTING WITH ELECTRICASTER

STEREOTYPING TERMS

FLONG—The dried stiff, board-like material which you moisten and beat into the form. The raw material for a mat.

PLATEN—One of the two halves of the casting box.

BARs—(Side and end—shell and type-high)—The thin and type-high pieces of steel with which you surround the mat IN THE CASTING BOX.

When the Electricaster and the Electrilladle are used in combination, they **MUST NOT BE ATTACHED TO SAME LIGHT SOCKET**. If it is done, the light socket will burn out. Each may be put on a different socket without harm provided the line is not already loaded with lights. If but one socket is available, use a double-plug adapter and plug in **AFTER** the key socket is turned on.

Heating the Box

Electricaster is built for current of both 110 and 220 volts. In ordering the caster your current voltage **MUST** be specified.

Place the two halves of the Electricaster together and switch on the current. Let them stand this way about 40 minutes. Open up and test the heat with a piece of candle or paraffine. If the smoke from the candle follows up the hot face of the platen and is quite thick, the heat is right. If any of the melted candle runs down the face of the platen and does not burn off immediately with a thick smoke, the caster is not hot enough.

Now place the side irons and the bottom iron between the two halves and let them get good and hot. This prevents your cast from getting chilled along the edges.

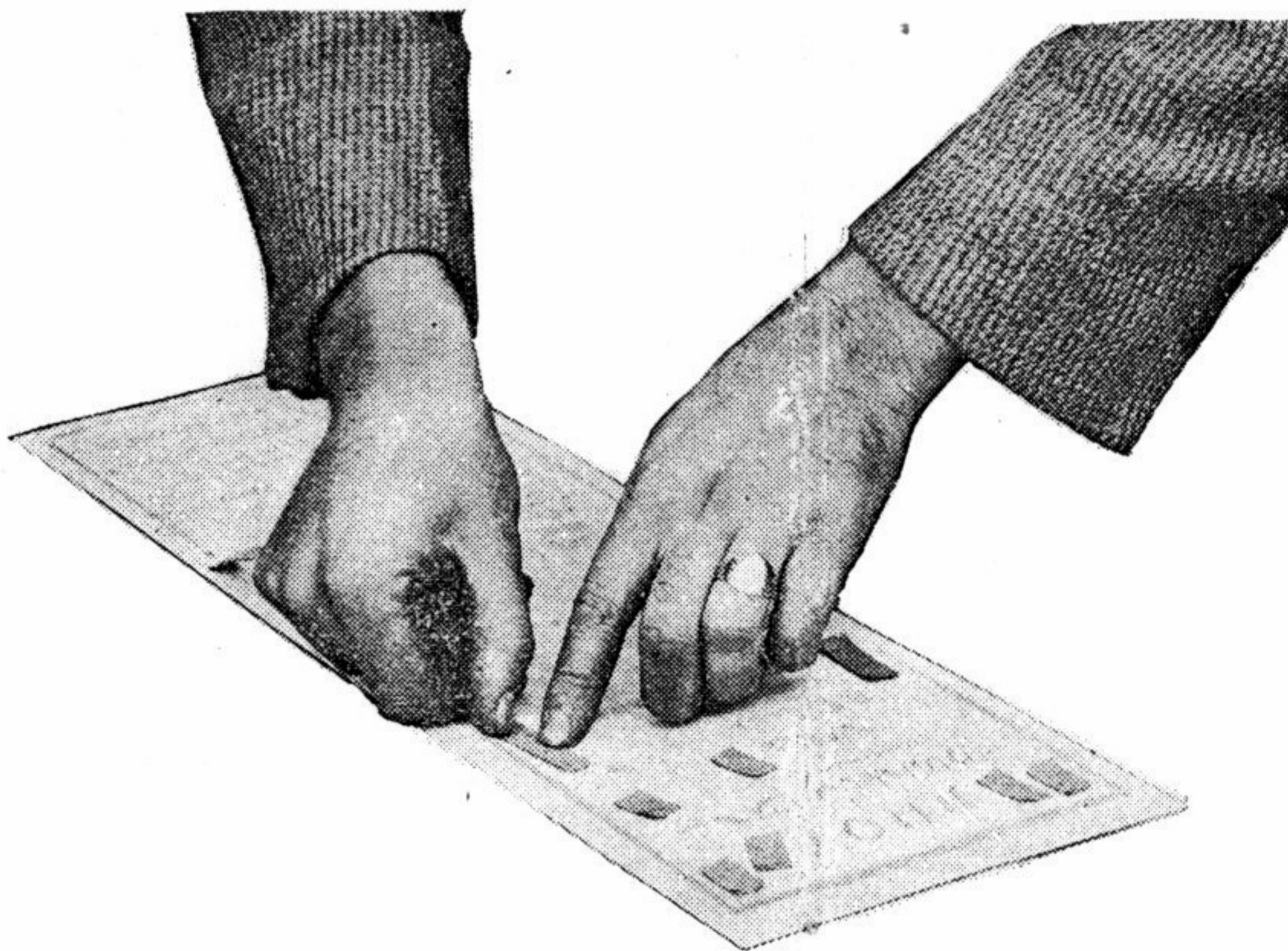


Fig. 4

Filling open spaces with backing felt to prevent high spots in the completed plate.

Backing the Mat

First back up all open spaces in the mat with backing strips. This material is obtainable in convenient narrow 12-inch lengths from the supply department of Electricaster Service. Strawboard will do, gummed on one side, if you do not have the backing material. Use glue—or thick paste. (See Fig. 4, page 6.)

Backing up the open spaces supports the mat against the weight of the metal when casting, and avoids high spots in the resulting plate, which otherwise would have to be routed or chiseled out.

Drying the Mat

Do not confuse the terms "dry" and "wet" mat. They refer to the method of making, which is treated under another heading. Whether the mat you are about to cast is a "wet" or "dry" one, it **MUST BE DRIED OUT** before placing in box for casting. There is always some moisture in it, if only from the atmosphere. So after the mat is properly backed, and some 30 minutes after turning the current on the box, place the mat face up on hot machine and allow it to dry out.



Fig. 5

Fig. 5 shows mat with "leader" attached. Be sure that you attach leader on the face of the mat, so that the metal will run over the mat instead of under it.

Attaching Leader

In order that the metal when poured finds its way down the face of the mat only, **AND NOT BETWEEN THE BACK OF THE**

MAT AND THE PLATEN, it is necessary to attach a "leader" to the upper margin of the mat. (See Fig. 5, page 7.)

Use some sort of tough, hard paper for the "leader," such as wrapping paper. Of the same material, cut a backing strip the width of the box, and several inches longer. (See Fig. 6, page 8.)

This strip of backing material is to lie between the metal and the iron of the lid of the box, and forms the smooth bottom of the cast you take from the box. This sheet must be large enough to go well past the inside edge of the side and bottom irons, otherwise the plate would be too thin to the extent of the thickness of the paper.

Backing paper of the exact size required in Electricaster may be had from our supply department, in packages of 50 sheets.

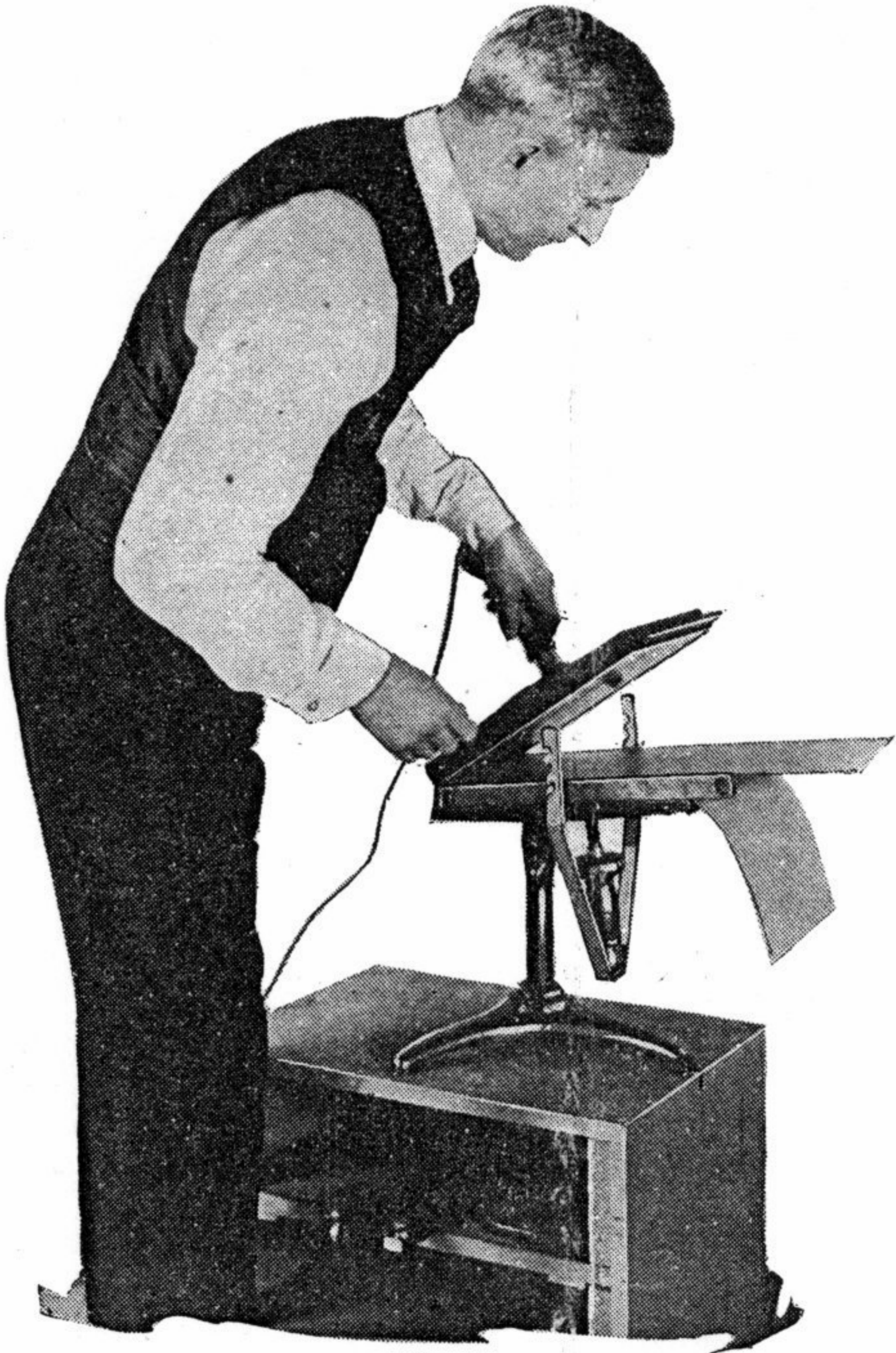


Fig. 6

Closing the box after placing the mat in position.

Locking Box for Cast

Electricaster is equipped to cast "shells" (9-point casts, for mounting on wood 790 thousandths), or type-high metal casts. WITH THE BOX ARE SUPPLIED END AND SIDE BARS FOR 9-POINT SHELL CASTS, AND A SET OF ACCURATELY MACHINED TYPE-HIGH BARS. THESE PROVIDE FOR EITHER 9-POINT SHELL CAST; CAST ON WOOD MOUNT TYPE HIGH; OR SOLID TYPE-HIGH METAL CAST. After deciding which you will make, select the proper side and end bars. Place the mat in position on the platen. (See Fig. 10, page 13.)

Now place end and side bars on margin of the mat, snugly up to the line of the matter on the surface of the mat, the width you want

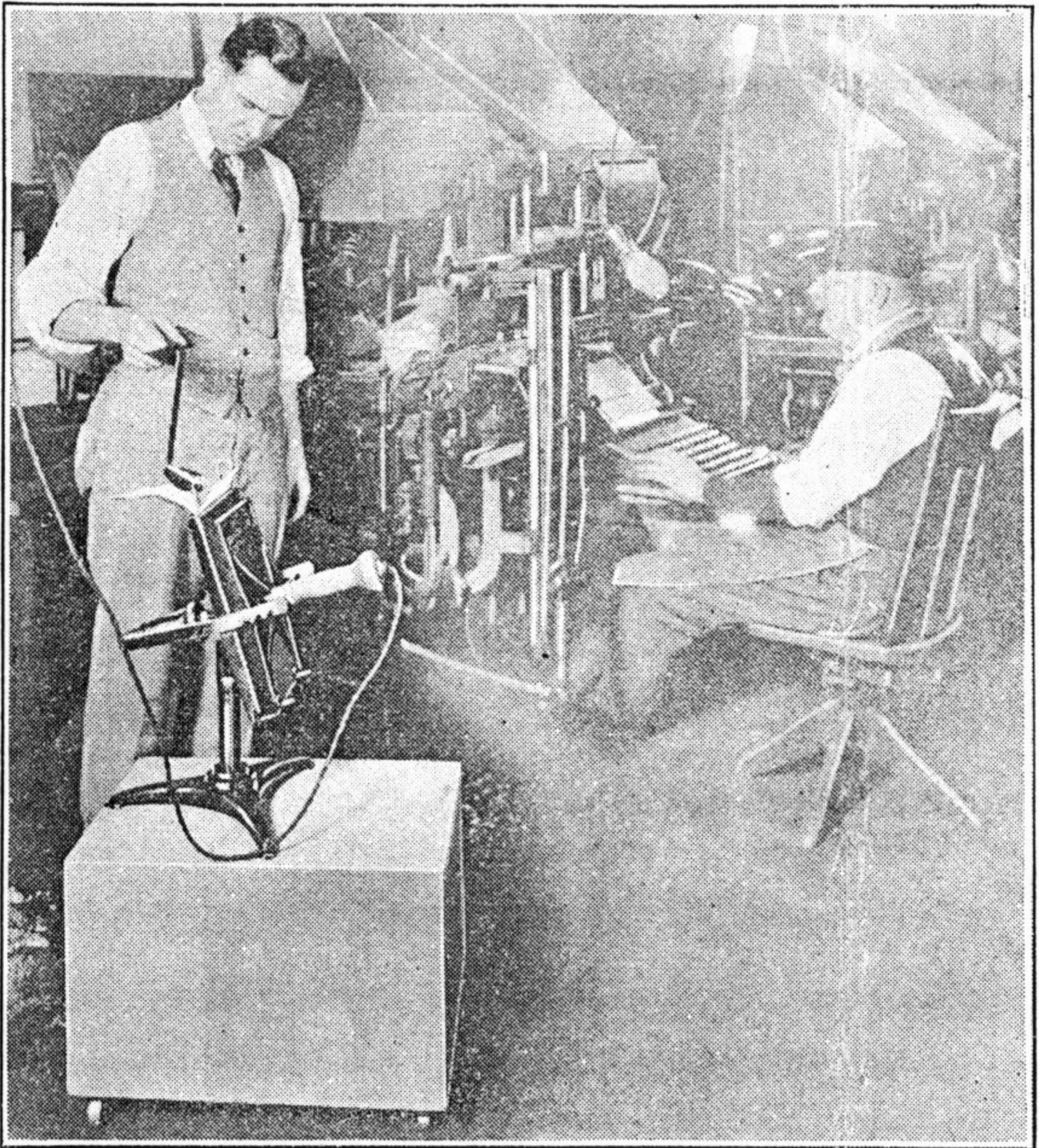


Fig. 7

Hot metal always at hand for a cast. Electricaster's dipping ladle fits easily into the linotype pot, and extracts at one dip sufficient metal for the average small cast.

the cast to be. Next lay the backing strip over the side bars, well down over the end bar, and replace the lid of the box. In doing this, gently engage the notches at the foot of the lid with the tops of the pins in the platen, and slide down the pins until the lid rests on the bars. In preparing for either shell or type-high cast, be sure that side bars rest squarely against the bottom bar before tightening box. Then engage the locking lugs on the side pins and screw up tight.

Then tilt up the box into casting position, spreading the "leader" and the "backing strip" apart. (See Fig. 7, page 9.)

Now pour the metal into the box, between the two sheets of protruding paper, moving the spout of the ladle back and forth across the mouth of the box, to avoid burning through the leader. Allow enough metal to flow to come up to the top of the box (if a full cast), and **TURN OFF ELECTRIC SWITCH.**

When pouring a cast from the Linotype pot, **WHERE SEVERAL LADLEFULS ARE Poured**, keep the switch on for the entire time, cutting off the current with the last pour.

For last minute casting, where the cut is a line drawing, you can get good results with caster cooler than where half-tones are contained in the mat. Caster must be good and hot for half-tones.

Making Shell Casts on Wood

Much time and cost can be saved by making the shell casts **DIRECTLY ON THE WOOD MOUNT.** This method saves much of the time of mounting, and enables you to use and re-use the mounting lumber that is abundant around every office. There are numerous methods of casting on wood, a number of which are practical and more or less successful.

We confine our instructions to the simplest method, and the one which allows the indefinite re-use of the mounting lumber.

THE ONE BIG IMPORTANT THING TO REMEMBER ABOVE ALL IS THAT THE MOUNTING BLOCKS MUST BE PERFECTLY DRY BEFORE THEY ARE PLACED IN THE CASTING BOX.

Whatever moisture there is in the wood will be turned instantly into steam when the metal is poured, and the result is likely to be a blistered mat, and a bad cast. When the blocks are perfectly dry there is no trouble, and the process is very satisfactory.

It is therefore well to demount and keep handy a variety of sizes of blocks thoroughly dried out. These blocks should be 790 one-thousandths in height (thickness). Some sort of metal box on top of the stove or radiator will serve very well as a kiln for drying them. (See Fig. 8, page 11.)

With a mounting block that is thoroughly dry, and nearest the size you wish to cast the cut, proceed as follows:

Drive several mounting nails (See price list, page 25) into the block, one at each of the four corners and two or three distributed over the surface of the block. Drive the tacks down so that only 1-16 inch of the nail is above the surface of the block. (See Fig. 9, page 12.) If you are using old blocks, and have knocked the metal

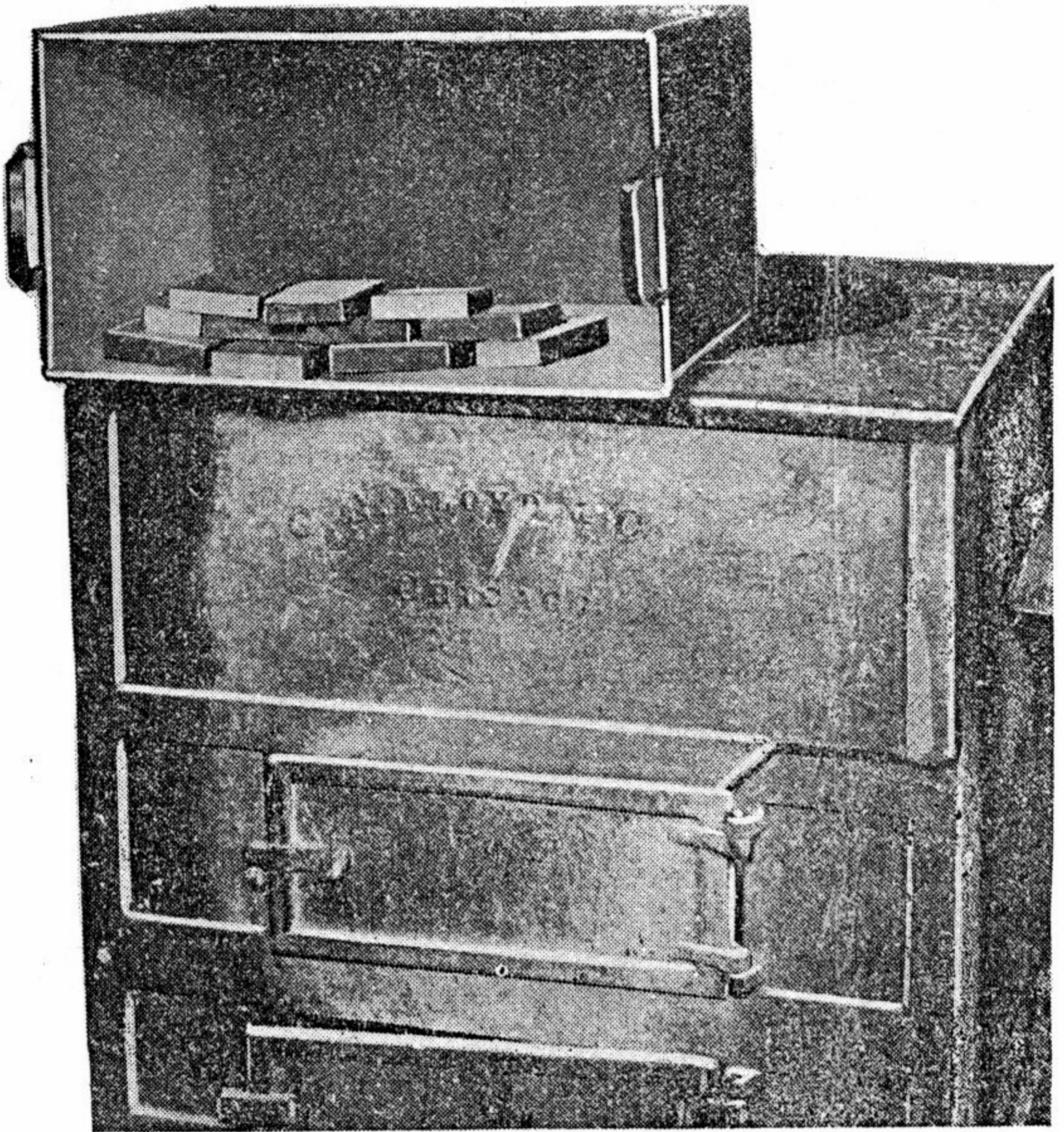


Fig. 8

How new or old mounting blocks may be dried on a stove or radiator.

off by just striking over the edge of the box, the block may have the nails already in.

A Wonderful Outfit

I am taking the liberty of writing you a few lines regarding Electricaster. It's sure a wonderful outfit. It surpasses all my expectations, and the more I use it the more I like it. Troubles or difficulty in casting? I did not meet any of them, yet am using the outfit every day, and had no previous experience in stereotyping.

But this is not all. Electricaster does double duty. For drying mats it is a marvel, and could not be overpraised.

Enthusiastically I can say that Electricaster does not need boosting to any of its users. For dependability, reliability, trouble-proof casting, it is a marvel.

THE AMERICAN CITIZEN,
Alfred C. Pini, Pub.,
Omaha, Neb.

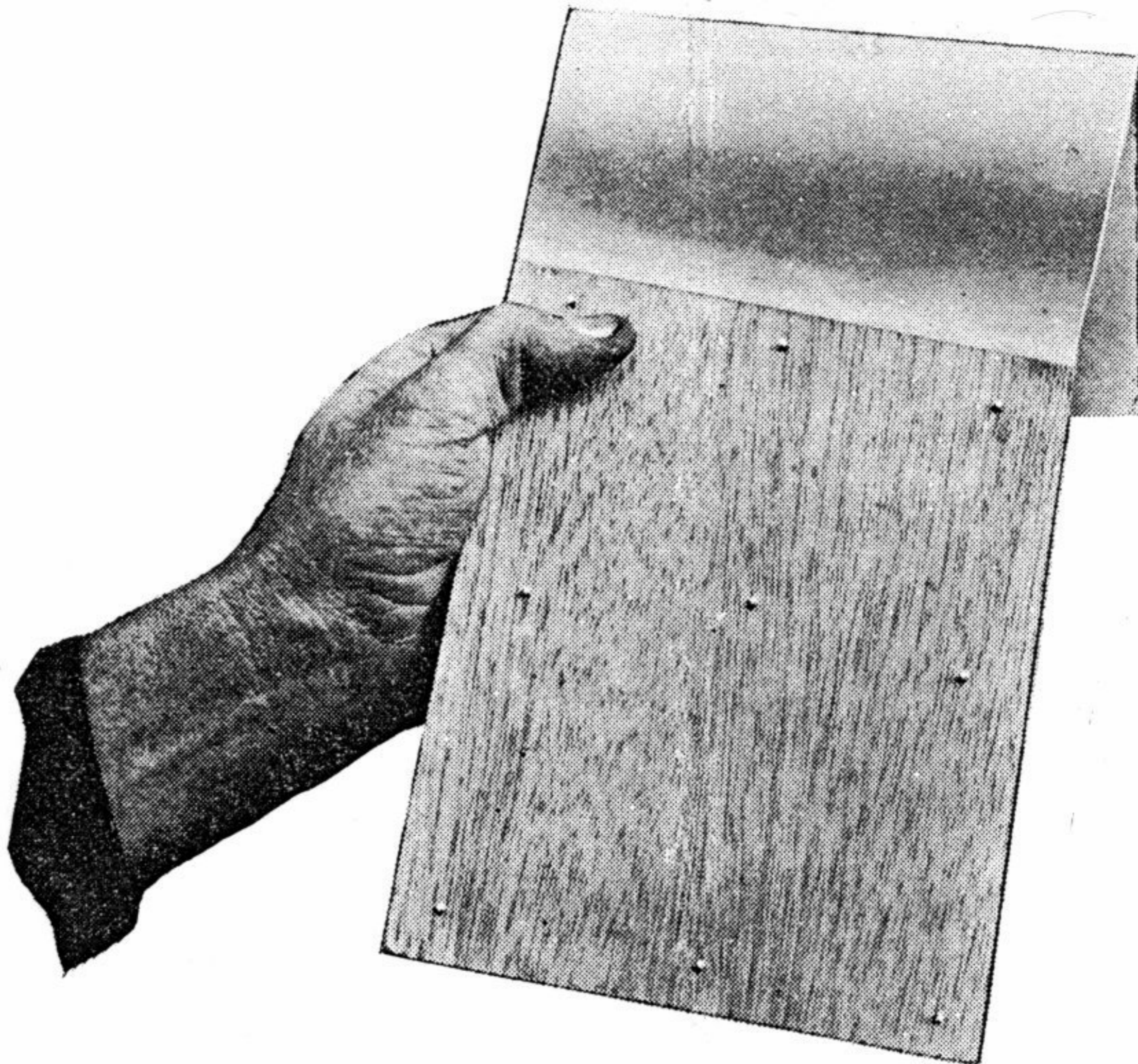


Fig. 9

Mounting block with nails driven in before the cast. Let the nails project up above the surface of the block 1-16 inch.

Paste or glue a leader strip to the edge of the mounting block (See Fig. 9. page 12) just as you would a mat. This directs the metal away from the end of the block, and to the surface and the mat.

You will find an ENVELOPE in the box containing several pieces of corrugated 1-point strips of lead. Lay four of these corrugated strips on the face of the mat, one at each corner. They serve to hold the mounting blocks above type-high until the pressure is applied in closing the box.

“Innocent Bystander” Gets Good Results

Yours of April 3, inquiring as to our success with Electricaster. Considering that no one in the office was more than an innocent by-stander in the art of stereotyping, our results have been very satisfactory. Yes, we spoiled the first three or four casts getting the “hand of it,” but since that time have had no complaint.

We consider it one of the best pieces of equipment we have installed, and often wonder how we got along without it so long. It is admirably suited to the requirements of the average weekly.

Very truly yours,
PINE CONE PRESS,
W. S. Overstreet, Editor,
Carmel-by-the-Sea, Cal.



Fig. 10

Placing the mounting block, in which the nails have been driven, in the caster.

After you have placed mat in box, with the type-high bars along the margins, lay the mounting block over the mat, face down (with the tacks next the face of the mat). See that side bars are as close to the block on each side as possible, then close the box and lock it. This brings the block exactly type-high, as the locking pressure squeezes down the corrugated lead strips, automatically justifying the casting space to type-height.

Pour the cast as usual, allowing the metal to come up a little over the top end of the block. After cutting off the tail, if the work has been carefully done, just a run-around with a pocket knife or a file will be all that is necessary.

Obviously, a large block would require several more of the lead strips along the margin, or in the large open spaces.

MAKING MATS WITH ELECTRICASTER

We have prepared a very practical little outfit for making mats to be cast in Electricaster. The outfit consists of the following articles:

One heavy galley with steel end-lock, to be used in locking forms.

12-pound labor-saving set of metal bearers to surround the form.

One molding blanket and molding block.

Four drying blankets.

Two dozen dried flongs, size 8x12.

One molding planer, with felt face.

This material, or as much of it as is desired, may be had from our supply department. The outfit as listed is priced at \$10. All items are priced individually in our supply list, page 25.

From this department, as needed, we can supply you with a special flong for mat making. This flong comes to you dried, and is prepared for use by moistening.

With this outfit, and your HAND paper cutter clamp, you can make practically as good mats as can be made on a modern mat roller, if proper care is taken.

Experience All that Is Required

We feel that all that is required in bettering our success with Electricaster is experience. And with a little time and your appreciated suggestions, we will get by all right. We like Electricaster, and think it is a fine thing for the average shop.

THE RECORD, Detroit, Minn.

In regard to our Electricaster, we wish to say that the machine is up to standard.

THE BARNESVILLE WHETSTONE,
Barnesville, O.

More Satisfactory than Large Box

Responding to yours of the 2d, inquiring as to our experience with the electric casting box, let me say that I am indeed pleased that you have taken sufficient interest to make such inquiry. I am just as pleased to answer.

The most favorable report I am able to make as yet is that it is more satisfactory than our large casting box, and if properly handled, perfect for small casts.

THE HARLAN REPUBLICAN,
David K. Brown,
Harlan, Iowa.

Gets First-Class Cuts

We have had occasion to use the caster but a half dozen times. So far we have been very fortunate in getting first-class cuts. I attach proof of one, which we consider to be as good as one could wish for.

THE GLOBE,
Wellsville, Kan.



Fig. 11

Laying the moistened flong on the form preparatory to making impression with paper cutter.

Form for Matting

To prepare your form for matting, lock it up in the heavy galley supplied by Electricaster, **IN THE CENTER OF THE GALLEY** at the closed end, surrounded by type-high bearers, at least $\frac{1}{2}$ -inch in width. (See Fig. 11, above.) Much time in "backing up" mat will be saved if you fill open spaces in form with cut-up Linotype slugs.

The bearers are made up in labor-saving lengths for forms the size of Electricaster's platen and smaller. They are carried in 12-pound fonts in our supply department. (See page 25.)

Reverse Platens and Heat Box

In mat-making we reverse the two platens, so that the one containing the heating element is **ON THE BOTTOM**. So that the box will be ready when you have "rolled" your mat, make this change now, and turn the current on with both platens together.

Preparing Mat

Cut a piece of the flong 1 inch larger both ways than the form to be matted, but no wider than the platens of the casting box. With a slow, swinging motion, from left to right and back, dip it in water, until it is thoroughly wet and limp. Place the wet flong flat on the table or stone until the free water has disappeared from the surface.



Fig. 12

Placing molding block over moistened flong before putting form under paper-cutter clamp.

Rolling Mat

Take the galley containing the form to the paper cutter bed. Place the mat, which has been moistened, and allowed to season, tissue side down over the form. Next place molding blanket, and next the block over the back of the mat. (See Fig. 12.)

Push the galley (being very careful not to disturb mat and blanket) back on the cutter bed, under the clamp. The galley must be stopped the first time at a point where the center of the clamp is above one end of the type form. (See Fig. 13, page 17.) Bring the clamp

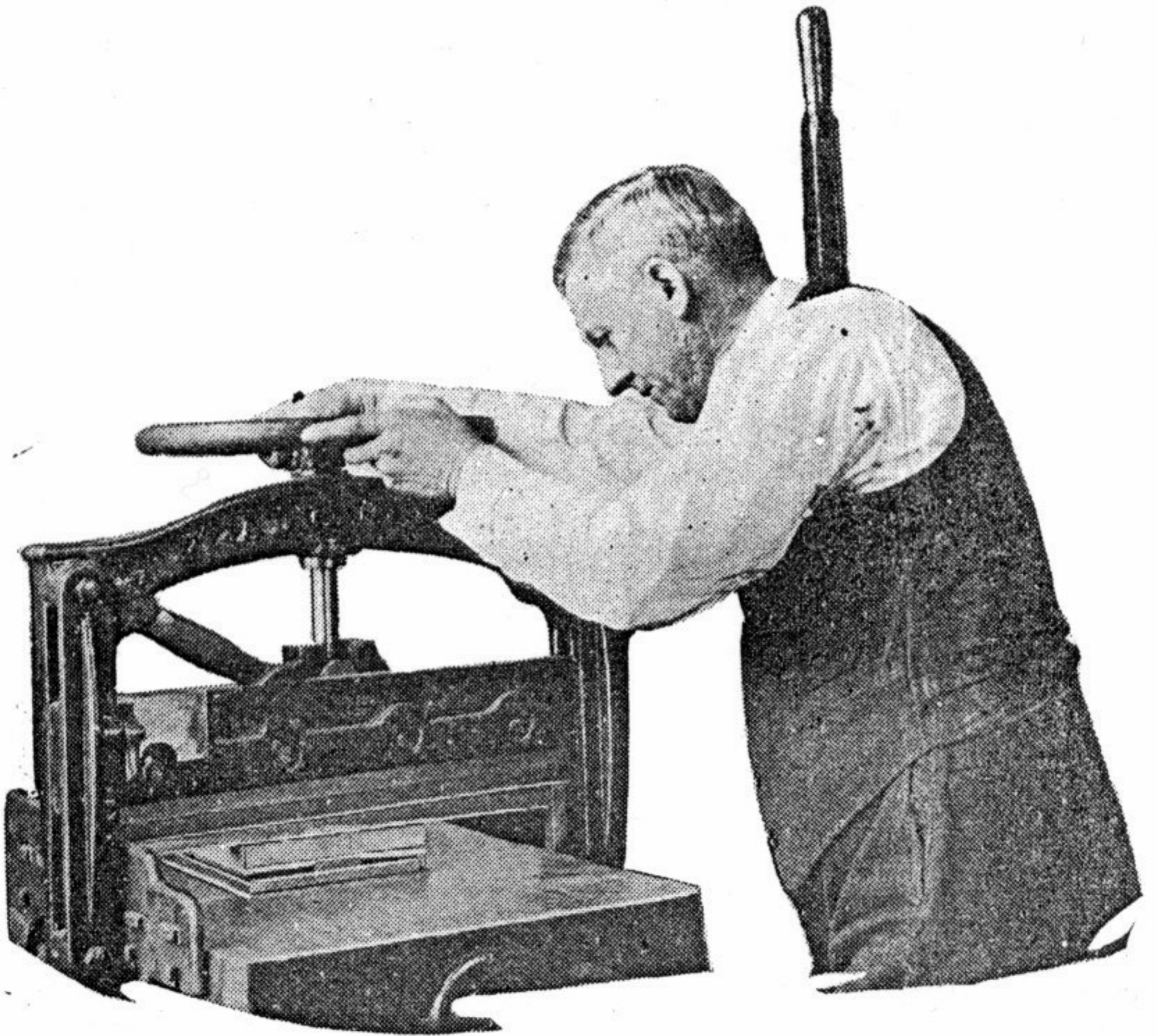


Fig. 13

In making impression with paper cutter, begin at one end of the form for the first "bite."

down on the blanket block as hard as you can, HOLDING IT there a few seconds. Release clamp and pull the galley toward you a little less than the width of the face of the clamp. (See Fig. 14, page 18.) (EXAMPLE: If the face of the clamp is 2 inches wide the movement of the galley is $1\frac{1}{2}$ inches each time.)

Rapid Work

Made seven quarter page casts and seven smaller ad cuts—all separate casts—in one hour and fifteen minutes. Caster works great. Takes a little time to learn how. Like service very much.

NEWS-CHRONICLE,
Wisner, Neb.

It Is Enough!

We like it fine! It is fast, safe, economical, and simple.

FRANKLIN PUBLISHING CO.
Union, Mo.

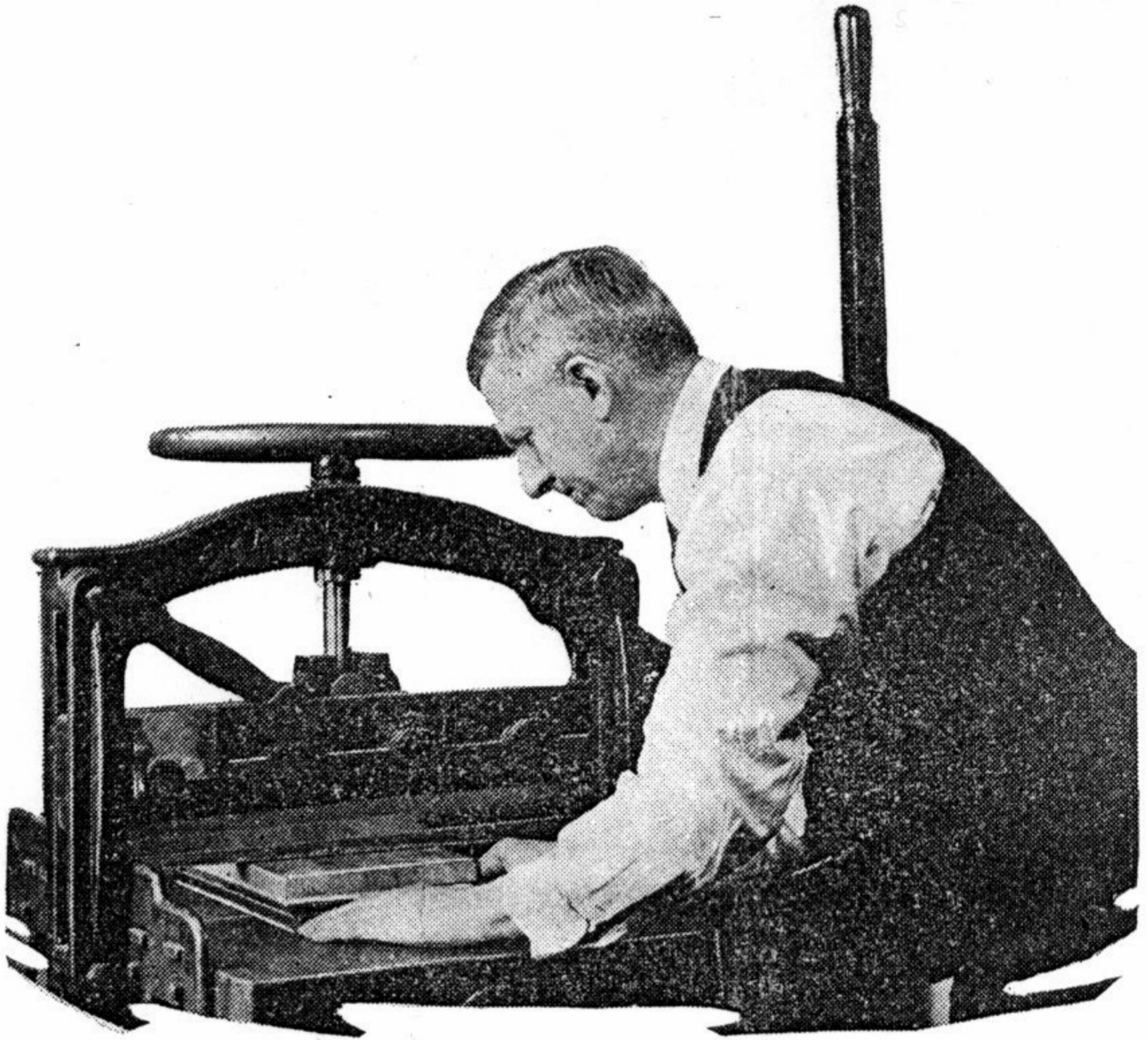


Fig. 14

After each bite, draw the form towards you less than the width of the clamp, clamp it, and proceed thus until the whole form has been covered. In moving the form, be sure that your clamp has been lifted each time high enough so that in moving the form the molding block and flong do not get disturbed on the form.

CONTINUE THIS OPERATION, DWELLING WITH THE CLAMP EACH TIME JUST A FEW SECONDS, UNTIL YOU HAVE PRESSED THE MAT INTO THE FORM ALL THE WAY DOWN.

This method approximates the "rolling in" principle of the most modern mat rollers, by reason of the bending of the block of wood slightly with each clamping. It is an adaptation of the method you use in "pulling" a proof on the stone with proof planer. DO NOT ATTEMPT TO MAKE A MAT ON THE PAPER CUTTER SIMPLY BY PRESSING WITH THE CLAMP TO THE CENTER OF THE FORM. Some inexperienced operators do use this method, but it never results in a perfect, deep mat.

Now remove the galley from the clamp when you have covered the whole form.

Lift the block and molding blanket carefully up from the form, and lay them aside.

Place the galley with the form on this bottom platen of the Electricaster box, **THE MAT UNDISTURBED AS IT WAS PRESSED INTO THE FORM**, and still wet. Place four drying blankets over the back of the mat. (The back of the mat is that part which is up.)

Now place the other platen of casting box over blanketed form and lock as you do for casting.



Fig. 15

After you have locked the caster as tightly as possible with the hands, give it additional tightening with the wrench.

Turn up the handle of the cold platen as tight as you can by hand, and use the hand wrench to give it more pressure. (See Fig. 15, page 19.) This wrench is only needed when drying mats, as the pressure by hand is ample when locking the box for a cast.

AFTER PLACING THE FORM IN THE BOX AND LOCKING IT, TURN THE CURRENT OFF, SO THAT YOU WILL NOT MELT YOUR TYPE.

Leave the form in the hot box for about 20 minutes, if good and hot when you put it in.

Caution!

After drying, be very careful in removing mat from form. First be sure it is perfectly dry. Then grasp it at one end and lift off, gently forcing it if it resists.

BE SURE A FORM LOCKED UP FOR MATTING IS FREE FROM INK. If the type is dirty and is washed with benzine, allow plenty of time for benzine to evaporate before matting. The tissues of the face of the mat are delicate and will not stand foreign substances under heat.

Do not try to make mats with the commercial dry mats by this process. The commercial dry mat requires a very powerful DRY MAT ROLLER for good work. We have developed the Electricaster flongs after many years' experience, and they are adapted to this work.

Making Mats with a Planer

We now include with the mat-making outfit a small felt-faced planer. We have found it a very helpful tool in the rapid preparation of a mat.

Many users of Electricaster prefer this method to that of the paper cutter clamp, as it is quicker, and gets more depth to the mat.

When using the planer method, the flong should be wetter than when using the paper cutter. Wet the dried flong thoroughly, passing it several times through the water, until it is as limp as a rag. Then lay it aside, tissue face upward, until there is no free water on the surface. When it is ready to use, the surface will be dull, without any glistening of water.

Likes It Better than Old One

The only serious trouble we have had with Electricaster is from casting mats which have a warp in them. We get the _____ service, and occasionally their mats have warps, causing light spots in the center or along the edge.

On the whole we like the caster very much, and find it very handy—far more convenient than the machine we used to have.

STAR PUBLISHING CO.,
Hot Springs, S. D.

A Pleasure to Handle It

In answer to yours of April 5th. We have been using your caster for a few days past, and are having excellent results with it. It gives us pleasure to handle castings with it, and we make very satisfactory cuts.

WM. MITCHELL PRINTING CO.,
Greenfield, Ind.

That's That

Not a thing wrong with it—Works fine.

SANFORD MORNING SIGNAL,
Sanford, Fla.



Fig. 16

Making impression with felt-faced planer. Hold the planer firmly on the flong and go over the form repeatedly until every line is perfect. See that the edges of the form are as carefully molded as the middle.

Now place the flong, tissue side down, upon the form. Beginning at the head of the form, with the planer beat it down into the type form, just as you would a wet proof. Use care that the blows of the mallet do not disturb the flong on the type.

After you have been over the form with the felt-faced planer until the proper depth of impression has been obtained, lay a piece of heavy, smooth press board over the flong, and place your regular heavy planer (the one you use on your forms) on it and strike it several sharp blows with the mallet, going over your form thoroughly. The

hard surface of the press board serves to smooth the casting surface of the mat, especially on the solid parts of the form, like heavy letters. (See Fig. 16, page 21.)

Now place the form in Electricaster, with the heated platen on the bottom, as described in the foregoing instructions.

SAVING TIME WITH SMALL MATS

Grouping small mats on one sheet of backing paper saves much time, especially if there are several casts to be made.

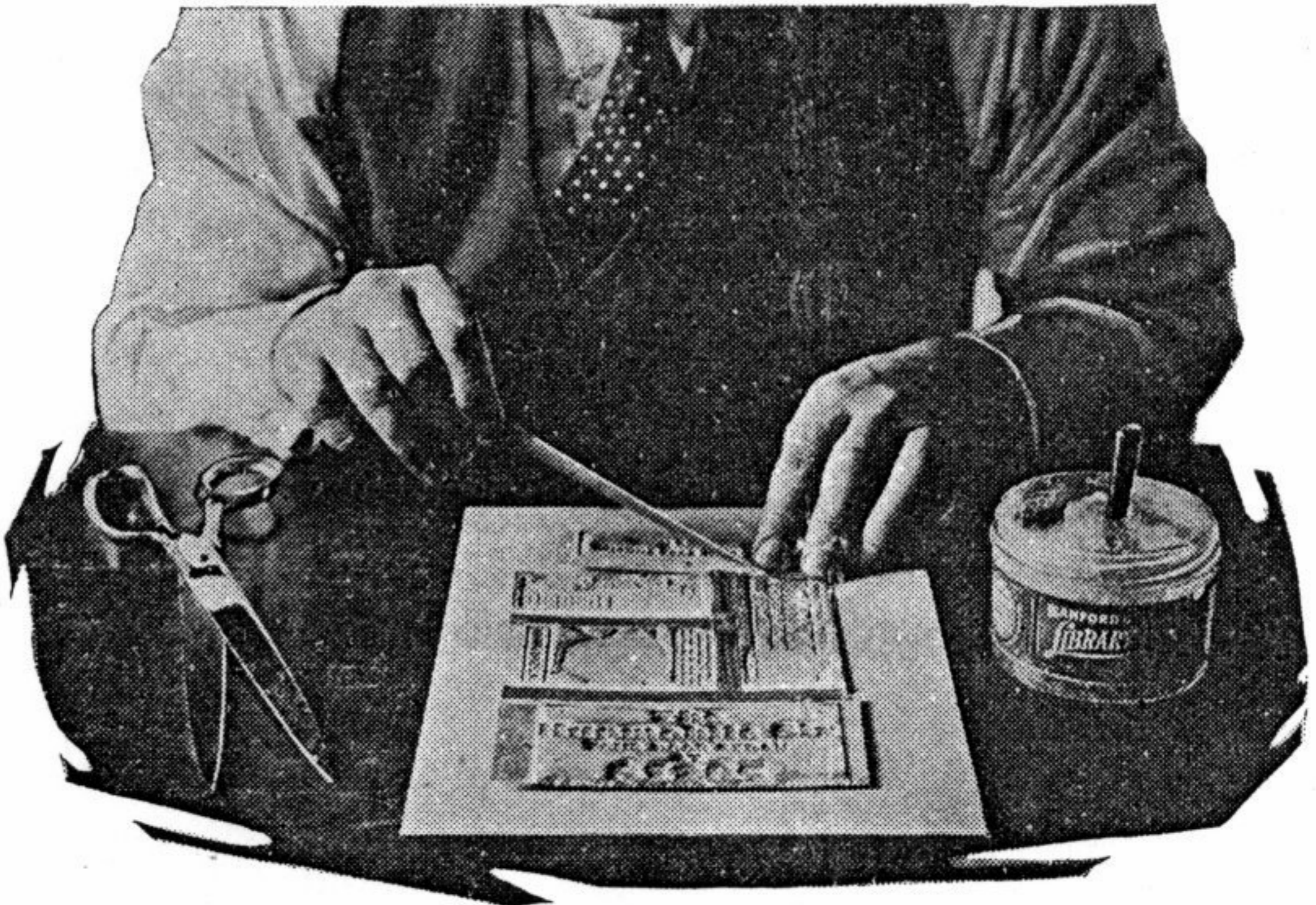


Fig. 17

Preparing several small mats for casting at one time.

This is done by selecting a smooth, unused piece of backing paper, and fastening all the small mats to the one piece, to fit the casting box.

Use $\frac{1}{2}$ -inch gummed strips of paper to fasten the small mats, running the gummed strips along the edges of the mats, and out onto the backing paper. (See Fig. 17, page 22.) This makes the assembled whole mat ready to use at once when it is dry, and the gummed strips prevent the metal from running behind the mats.

“George” Does It

Replying to your letter of April 3d, will say that we have in the office a full page casting box, and an Electricaster. Two-thirds of our cuts are made on the Electricaster, and we have no trouble whatever with it. It is being operated by the colored boy who takes care of the metal, and he is making good cuts with it.

THE KANSAN PRINTING COMPANY,
J. C. Mack, Newton, Kan.

CASTING LARGE MATS IN ELECTRICASTER

When you consider that 95 per cent of your casting can be done in a box the size of Electricaster, with its speed and convenience, it



Fig. 18

A full-sized 8-column newspaper page ad that was cast in Electricaster in sections and mounted on one block the size of the page.

seems hardly worth while to install a large, cumbersome machine, which requires so much time to get into action.

Many publishers are using Electricaster for their large casts, by simply cutting the mats, rather than heating up the big box.

The average page mat is easily cut and cast on this machine.

Even large illustrations usually are so drawn that they may be dissected and assembled without the joint being discernible in the finished ad. Of course the border is sacrificed in some cases, but that is only a few minutes' work in these machine days. The illustration (Fig. 18, page 23) makes clear the method of cutting up large mats for casting.

• TABLOID INSTRUCTIONS

All operations in proper sequence. When you have read the foregoing pages, try to work by this table. You will soon follow them in proper order.

To Make Shell Cast

- 1—Place platens of box together with heating element platen on top.
- 2—Connect plug in light socket and turn on current.
- 3—Heat box for 40 minutes.
- 4—Paste leader on mat.
- 5—Open box and place mat, gages and back sheet in casting position.
- 6—Tighten clamps and allow box to stand for 2 or 3 minutes with heat on, before pouring metal.
- 7—Place dipping ladle in linotype metal pot and allow to remain for 2 minutes.
- 8—Pour cast, with heat still turned on.
- 9—Shut off heat and allow box to stand for 2 minutes before opening.

To Make a Cast on Wood Base

- 1—Place platens of box together, with heating element platen on top.
- 2—Connect plug in light socket and turn on current.
- 3—Heat box for 40 minutes.
- 4—Select block correct size for cast, drive in nails, paste on leader, place on metal pot to heat for 15 minutes. Block must be too hot to hold in bare hand. Block must not be more than 790 one-thousandths inch thick.
- 5—Paste leader on mat.
- 6—Open box. Place mat, gages, short pieces of corrugated 1-point lead, block and backing sheet in position.
- 7—Tighten clamps and allow box to stand, with heat on, for 2 or 3 minutes before pouring metal.
- 8—Put ladle in metal pot and allow to remain for 2 minutes.
- 9—Pour metal with heat still turned on box.
- 10—Shut off heat and allow box to cool for 2 or 3 minutes before opening.

To Make a Mat

- 1—Wet flong as instructed, and allow to season.
- 2—Place box platens together with heated platen on bottom, and form must be in center of galley.
- 3—Lock form in metal galley, using bearers on all sides of form. Form must be in center.
- 4—Force mat into form with paper cutter clamp, or planer.
- 5—Place galley in box. Have heated platen on bottom.
- 6—Place blankets over mat and lock box, using wrench to tighten.
- 8—Mat should be dry in about 30 minutes.

PRICE LIST

OF

ELECTRICASTER SUPPLIES

(Prices subject to changing market conditions.)

SIDE AND END BARS, TYPE-HIGH.—For type-high casting; perfectly machined type-high. Per set of 3 bars.....	\$ 5.0
SIDE AND END BARS, THIN.—For casting shell casts to be mounted on wood. Per set.....	2.5
✓ STEEL MAT-MAKING GALLEY.—Heavy, specially-built galley for locking forms for stereotyping; with removable end-gate. Each.....	1.7
LADLE.—For dipping metal from linotype pot; especially designed for the purpose, and makes quick casting easy. Each.....	1.0
✓ MOLDING BLANKET.—First quality molding felt, with wood block 8x12 inches, ready to use. Each.....	2.1
✓ STEREOTYPE METAL BEARERS.—Accurately finished, ½ inch wide, made up in labor-saving fonts containing 12 pounds; includes single, double and three column sizes, to go around form when making mats. Per font.....	4.5
MOUNTING BLOCKS.—Per font of 12 1-col. 13-em; 9 2-col. 26½-em, and 6 3-col. 40-em; .790 inch thick. Carried on 13-em stock. Per font.....	4.5
ELECTRILADLE.—Electrically heated 15-pound melting ladle for use with Electricaster. Heavy Cast aluminum, 14-inch hardwood handle. (See pages 4 and 5.) Made in 110 and 220 voltage which must be specified in ordering. Price each, complete, F. O. B. Philadelphia (shipping weight 8 pounds.).....	20.0
✓ DRYING BLANKETS.—For drying freshly-made mats in Electricaster; set of four, 8x12. Per set.....	.7
BACKING AND LEADER PAPER.—Cut to fit Electricaster, and of material best suited to this use; makes smooth casts. Package of 50 sheets.....	.7
CORRUGATED LEAD STRIPS.—For use in casting directly on wood mounts, as described in instructions; 1-pound box, cut in 2-inch lengths, ready to use. Per box.....	.8
DRIED FLONGS.—Ready-to-use "wet" mats, prepared by simply moistening with water; well-made, commercial matrix stock; makes a perfect mat by the process described in instruction book. Package of 12 flongs, 8x12 inches.....	1.2
✓ MAT-MAKING PLANER.—Hardwood, faced with molding blanket felt, for beating in flongs. Each.....	1.0
MOUNTING NAILS.—Best quality steel; for mounting shell casts on wood. Per 1-pound package.....	.3
NAIL SET PUNCH.—For setting the mounting nails in plates where it is difficult to drive them with a hammer. Each.....	.2
BACKING FELT.—For backing up mats before casting; supplied in strips ½-inch wide; in packages of approximately 100 ft. Per package..	.3
ENGRAVERS' CHISEL, OR GOUGE.—For hand-routing casts; best grade steel tool. Each.....	1.0
TRIMMING FILE.—Coarse cutting edge; a handy tool for quickly trimming up cuts, where there is no power saw. Each.....	1.5
STEREOTYPERS' MITTS.—Squares of soft felt, asbestos-lined material for handling hot metal (and the machine when hot). Per pair.....	.3
COMBINATION METAL.—For use where it is desired to use only one grade of metal in the office; a good, all-around metal for Linotype, Intertype, Linograph, Monotype, Ludlow, or for stereotyping; prices always in line with the market. Write for quotations.	

Electricaster accessories and specialties are carried in stock only at Omaha. Mail all orders for these goods direct to Western Newspaper Union, 621 S. 15th St., Omaha Nebr. All prices are F. O. B. Omaha, unless otherwise stated, and subject to fluctuations of the market.

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