

**THE PATTERN MAKER'S
HANDYBOOK. A
PRACTICAL MANUAL ON
PATTERNS FOR FOUNDERS**

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The pattern maker's handybook. A practical manual on patterns for founders by Paul N. Hasluck

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PAUL N. HASLUCK

**THE PATTERN MAKER'S
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PRACTICAL MANUAL ON
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THE
PATTERN MAKER'S
HANDYBOOK.

A Practical Manual
ON
PATTERNS FOR FOUNDERS:

*EMBRACING INFORMATION ON THE TOOLS, MATERIALS AND
APPLIANCES EMPLOYED IN THEIR CONSTRUCTION.*

BY
PAUL N. HASLUCK, A.I.M.E.
AUTHOR OF "LATHE-WORK," "THE METAL TURNER'S HANDYBOOK," "THE
WOOD TURNER'S HANDYBOOK," ETC.

WITH UPWARDS OF ONE HUNDRED ILLUSTRATIONS.



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PREFACE.



THIS handybook is intended to afford some information on pattern making, and also some insight of the processes to which the patterns are to be subsequently subjected, as a knowledge of these is essential to enable a pattern maker to labour to the best advantage.

The literature of this subject is but scanty ; the cause may be that this intricate art is one that cannot be conveniently brought under well-defined rules. Almost every fresh pattern that is made requires some amount of independent thought from the artificer. This handybook is intended to be especially useful to the beginner. The general information it contains, and the glossary of terms, may make it handy even to practised hands of wide experience.

LONDON,
July, 1887.

P. N. HASLUCK.

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THE
PATTERN MAKER'S HANDYBOOK.

CHAPTER I.

PATTERN MAKING.

THE patterns on which this handbook treats are those used for forming the moulds in which metal castings are made. Any mechanic may find it necessary to make a pattern, some time or other, to replace a broken casting or to carry out his own ideas when pattern makers are not get-at-able for odd jobs in busy times.

Pattern making is of endless variety. In this business a piece of work may be turned out to-day, the like of which was never before seen nor imagined, and which may never be required again. It is an art which takes in all manner of shapes and sizes. A good pattern maker is always learning, and he must think for himself to supply the demands that are constantly being made upon his ingenuity by new forms and fresh devices. To take any pattern, and explain its construction would be of little advantage, because of the dissimilitude of forms which have to be dealt with. However, there are certain operations or processes, not very numerous, which the pattern maker has at command, adapted to the peculiarities of the material in which he works. All patterns are alike in that they are the result of these processes : and, however diversified their forms,