

PATTERN MAKING.

PART I.

PATTERN MAKING dates back to the time when the first article was made from solid metal for the use of man. The pattern must precede the making of the metal counterpart, and is therefore the first subject to be treated in the working of metal.

Qualifications of the Pattern Maker. The pattern maker is essentially a worker in wood, though, where many castings are to be made from the same pattern, the final or working pattern is made of metal. These metal patterns are very serviceable, and leave the sand more easily and cleanly than those made of wood. Metal patterns are always necessary when the work is of a delicate or very light character. In all such cases, however, the first pattern—from which the metal pattern is to be made—is made of wood, allowance being made for double shrinkage, and, where necessary, for double draft. The necessity for this will be clearly explained further on.

The pattern maker should possess a practical knowledge of the properties of metals. First of all, he must understand the shrinkage of metals, that is to say, how much smaller the solid casting will be than the pattern from which it flows into the mould; he should know what the strength of the metal is; he should be familiar with the relative rapidity of casting, so that internal stresses in the body of the completed casting may be avoided as much as possible; he also should know enough about the practical work of the moulder to double upon the generalization of construction of the pattern for any given piece; and he must be sufficiently skilled as a draftsman to lay out, without the assistance of the designer, the drawings of the piece to be made. It is very true, however, that there are many good pattern makers who do not possess all of these qualifications.

The last-mentioned qualification is one of the most important. The drawings furnished the pattern maker are usually on a small scale.

In order to work to the best advantage, he must reproduce in part or all of them at full size, as working drawings. To do this he

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