

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 where 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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Xiang Xie



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Table of Contents Patternmaking 1905 Lost Technology Series

1. Understanding the eBook Patternmaking 1905 Lost Technology Series
 - The Rise of Digital Reading Patternmaking 1905 Lost Technology Series
 - Advantages of eBooks Over Traditional Books
2. Identifying Patternmaking 1905 Lost Technology Series
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Patternmaking 1905 Lost Technology Series
 - User-Friendly Interface
4. Exploring eBook Recommendations from Patternmaking 1905 Lost Technology Series
 - Personalized Recommendations
 - Patternmaking 1905 Lost Technology Series User Reviews and Ratings
 - Patternmaking 1905 Lost Technology Series and Bestseller Lists
5. Accessing Patternmaking 1905 Lost Technology Series Free and Paid eBooks
 - Patternmaking 1905 Lost Technology Series Public Domain eBooks
 - Patternmaking 1905 Lost Technology Series eBook Subscription Services
 - Patternmaking 1905 Lost Technology Series Budget-Friendly Options

6. Navigating Patternmaking 1905 Lost Technology Series eBook Formats
 - ePub, PDF, MOBI, and More
 - Patternmaking 1905 Lost Technology Series Compatibility with Devices
 - Patternmaking 1905 Lost Technology Series Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Patternmaking 1905 Lost Technology Series
 - Highlighting and Note-Taking Patternmaking 1905 Lost Technology Series
 - Interactive Elements Patternmaking 1905 Lost Technology Series
8. Staying Engaged with Patternmaking 1905 Lost Technology Series
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Patternmaking 1905 Lost Technology Series
9. Balancing eBooks and Physical Books Patternmaking 1905 Lost Technology Series
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Patternmaking 1905 Lost Technology Series
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Patternmaking 1905 Lost Technology Series
 - Setting Reading Goals Patternmaking 1905 Lost Technology Series
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Patternmaking 1905 Lost Technology Series
 - Fact-Checking eBook Content of Patternmaking 1905 Lost Technology Series
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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