**NEW LINOTYPE MOLD SEASONING INSTRUCTIONS**

**After a NEW Linotype mold has been in use for a certain length of time, the casting surfaces of the mold body and cap will gradually become coated with a greyish film of oxides. This oxide film, commonly regarded as a detriment, is really of great benefit to the mold because it helps insure easy ejection of the slugs. When the casting surfaces of the mold are new and perfectly clean, the steel has a considerable affinity to type metal. After approx.. 25 to 30 slugs are cast in rapid succession without permitting the mold to cool, ejection becomes difficult because the type metal adheres closely to the highly finished mold surfaces. It is this metal adhesion which must be prevented.**

**There is a systematic procedure which should be followed to “BREAK IN” a NEW mold. The following steps should be taken:**

1. **Place the NEW mold on the mold disk, then as soon as the mold is properly seated and tightened cast “5” token slugs, as soon as the ejection becomes difficult, the mold should be allowed to cool for a few minutes.**
2. **After the mold has cooled, cast “8” to “10” more slugs then let the mold cool again.**
3. **Carry on this process until the casting surfaces of the mold body and cap take on an oxide discoloration. This discoloration should be of a brownish-red color at first and is usually obtained after about “50” or so slugs have been cast by the gradual process described above. As additional slugs are cast, the oxide film becomes greyish in color and extends from the back of the mold to the front.**
4. **Once this film is fully formed it will act as an insulating layer between the mold surfaces and the slugs and ejection should be easier from then on.**

**It is sometimes necessary to polish the casting surfaces with a MOLD POLISH in order to remove small particles of metal which may adhere to the mold body and cap. When mold polish is used it should be applied to the mold surfaces using a flat pine stick. The stick should be moved in circular strokes and the stick should be held flat on the surface being polished. Tilting the stick will tend to round the edges of the mold. After the parts have been cleaned, remove the polish from the casting surfaces with a soft cloth. Most of the oxide film previously formed on the casting surfaces will be removed when the mold polish is used. Consequently, before the mold is placed in use again, it should be subjected to the gradual “break-in” process described above until a new film is formed.**