Summer 1995 Issue #2

The LUDLOW Quarterly

A Newsletter For Ludlow Typograph Operators And Enthusiasts

Typemetal Masters

United American Metals Corporation, located in Chicago, may hold solutions to problems that many Ludlow operators have with their typemetal. This company is one of the oldest alloyers of typemetal in the country. Started in 1895, they for decades served the typemetal needs of many large newspapers.

UAM still manufactures typemetal for Linotypes and Ludlows to a proven formula of 4.25% Tin, with 11.75% Antimony, and the balance (84%) lead. They can also formulate special alloys for monotype machines and stereotype casting. They sell new typemetal in 10 lb notched bars or 20 lb chain feeder pigs in any quantity. The current price per lb for various quantities is:

under 50 lbs - $1.05	100 lbs - 90¢
250 lbs - 85¢	500 lbs - 80¢
1000 lbs - 70¢	2000 lbs - 65¢

They pay the shipping costs on orders over 2000 lbs.

More importantly, and useful to every Ludlow operator, is the metal analysis service they offer. UAM will analyze a sample of typemetal for only $20.00! Just send at least 8 ounces of metal to them and with spectrographic analysis they will determine the percentages of Tin, Antimony, Lead, and contaminating Copper. Results generally take 2 or 3 days. If you want, they will advise you on how much of what type toner metals to add to properly recondition your metal.

They produce "Hytin Ludlow Metal" toner metal containing 6% Tin (11.75% Antimony / 82.25% Lead) which sells for 10 cents more per lb than the rate for regular typemetal. It is designed to replace, ounce for ounce, skimmed dross, so that your metal remains at optimum condition.

UAM compounds "UNAMET" flux and dross reducer, and produces Elrod borders, leads and slug material in various sizes.

For more information contact: Mr. Bill Renotti, Sales Manager, United American Metals Corp., 2246 West Hubbard St., Chicago, IL 60612. Phone number is (312) 733-6700, and the FAX is (312) 733-6710.

SOMETHING NEW!

Dave Seat, of Dave Seat Hot Metal Services in Tennessee, has come up with yet another product for the Ludlow in his continuing attempt to produce all repair parts and service items for the Ludlow typecaster.

He is currently manufacturing new and improved mouthpiece wipers. They are a bit lighter in color and more fluffy, but work every bit as well as the old style while lasting up to three times as long. A box of 25 is $67.50, that's $2.70

each. Since a box could be good for more than 20,000 slugs, he also sells quantities of 1 to 24 wipers for $3.00 ea.

Dave's phone is (800) 542-2508, the fax number is (800) 468-6382.

STAMPMAKERS TIP!

Katie Mulry is the owner of Pelican Engravers and Rubber Stamps in El Cajon, California. Pelican is a "category killer" stamp maker and can provide any kind of stamp and marking device you can think of, most with one day service. This is a tip she sent in:

"Here is something that I found to work really well using Ludlow type. I am making pre-inked stamps with the foam system that is offered by e-z Marking Products and Stewart-Superior. I set the type on the Ludlow and then make my matrix board the same way I would to make a rubber stamp. I then use the powder and foam to make the die. No more waiting two weeks for a pre-inked stamp! I can have one done in a few hours and am now selling this stamp as "self-inking" when my customer wants one. The price is higher than the regular self-inking, but the profit is too! Because of the great quality of the Ludlow type, the lettering comes out nearly print quality. You can also make the stamps multi-color by cutting the dies before placing them in the ink. This is not available except for Xstamper. No special ink is required. They use the regular stamp pad ink so there are lots of colors to choose from."

Questions? Pelican Engravers, 550 Fesler St. - Ste. F,El Cajon, CA. 92020-1903, (619) 444-2066.

Questions and Answers

Q - Isn't it easier to set type by hand than with Ludlow mats? J.H. (AR)

A - No! It is faster than hand-set for several reasons, the chief one being the technique of gathering. Gathering is rapidly picking up a whole word in Ludlow mats with two fingers before setting them in the stick. Once set, repeat castings from one stick allow for printing several-up, and there is no chance that slugs will pi or work-up. Expect a major article pertaining to Ludlow speed-setting in an upcoming issue of the LQ.

Q - What is that "L" shaped blank slug block used for, and do I need one?
R.B. (MA)

A - That is part number A957, "Height Gauge". It is basically a blank slug block with a tailhook on it, and is meant to be used for setting lockup adjustments like the upper limit of the main slide travel. The extended hook on it forces you to put the machine into a safe condition because it only fits into the casting position if the safety connecting rod (a small linkage) has been removed. You must set the lockup dimensions with the machine hot, and cycling the machine, even by hand just to check things, would drop the plunger and dangerously squirt typemetal everywhere.

You can use a blank slug block to set the lockup but make sure that it's thickness is right at .711 inches, and that you disconnect the safety connecting rod.

Jim Parrish Relocates!

Jim Parrish, the well known author of the "Ludlow Troubleshooting Guide" and a series of other Ludlow service and typeface books, has moved to Arizona and established a base of operations in the town of Maricopa, just South of Phoenix.

Phoenix. Deja Vu? - Oui! Mr. Parrish has returned to sunny Arizona after experiencing a year of humidity, rain, snow, sleet, hail and every other form of precipitation on the East coast.

Mr. Parrish was originally a sales and service representative for the Ludlow Typograph Company and installed new Elrod and Ludlow machines in shops across the country. He still keeps busy by regularly servicing hundreds of Ludlow machines across the country in tours that might last a month and cover fifteen states before he returns to his home base.

Jim Parrish can be reached at P.O. Box 1108, Maracopa, Arizona 85239. Phone is (520) 568-3367.

FREE Matrix Identification!

For those of you who do not have the new generation Ludlow mat gauge, which uses the lines on the back of the mats to identify the Ludlow fonts and point size, we are providing a free mat identification service. Just send 1 mat of each font you want identified to the LUDLOW QUARTERLY address, with sufficient postage for return. Make sure the samples you pick exactly match the lines on the back of the mats in the font. The sample mat can be any letter, even a period. Think thin and light, (like '/-), and you might even be able to tape them onto a letter!

BUSINESS PROFILE

The Indian Hill Press is a partnership enterprise of Dan Waters and Hal Garneau located on the island of Martha's Vinyard. It is also a success story, combining state of the art Power Macs in their graphic design studio with a Linotype/Ludlow letterpress operation.

Started about three years ago with a Colt's Armory platen press, early experience with handset type made them realize the need to produce type. In short order they had a #31 Linotype, Ludlow "L", Vandercook SP15, and a new 18' by 32' building to contain everything. The Ludlow came from a prison's print shop. It was plugged in, worked perfectly, and is a breeze to maintain.

The partners emphasize fine typography and print invitations and limited edition poetry, broadsides, and collectibles. Waters mostly uses the "book faces" of Garamond, #11 (Goudy), Eusebius, Bodoni, and True Cut Caslon, and states that Ludlow's Garamond is superior to that of other companies.

Future plans include publishing large broadsides, booklets, and their own line of greeting cards. Another 18' by 32' building is coming soon and will hold a large format cylinder press and a recently acquired Thompson caster. They seek some 60 and 72 point Ludlow Garamond and Garamond Italic mats, and a series of Delphian Open Title.

The Indian Hill Press, P. O. Box 595, West Tisbury, MA 02575 - 0595. Ph (508) 693-1551, Fax (508) 696-8070.

1995 Calendar

August 13-15: The American Amateur Press Association 1995 Convention. In Eugene, Oregon. For information call Dan Rea at: (503) 683-5921.

September 16-17: Small Press Center book fair. - NY, NY, (212) 764-7021.

P☆I☆P☆E DONATIONS

Many thanks to these contributors to the Postage - Ink - Paper - Equipment fund: Hugh Woodruff, Clyde Barbee, Dave Seat, Don K. Black, Edward Barron, and K. Rowin.

Lawyer: "O.J., I've got some good news and some bad news."

O.J.: "What's the bad news?"

Lawyer: "They found your blood all over the crime scene."

O.J.: "Then what's the good news?"

Lawyer: "Your cholesterol is 120!"

CLASSIFIED ADS

Ad cost is only 15 cents per word!
You must be a subscriber to advertise.

To help preserve letterpress equipment, ads offering free items will be run without charge.

FREE

Free: Several Linotype magazine racks, you pick up. Cabinet base for small proof press, (602) 581-1748. (AZ)

WANTED

Wanted: Ludlow mats. Smaller sizes, ornaments, and script faces. I have some Linotype mats and various letterpress equipment to trade, but I will also buy entire font collections. B. Simon, 3115 West Cavedale Drive, Phx., AZ 85027, (602) 581-1748.

Wanted: Information to locate Miller or any other brand of 29" x 41" cylinder letterpress (1 or 2 color) and sized for the above press: an imposing stone, furniture, turtle. Also Vandercook plate mounting system parts; block leveler, makeup gauge, Lite-base casting box or mold only, plate thickness gauge, plate mounting press. Please call John Finch, (303)460-9598. (CO)

Wanted: Five left-hand-pull cases, will buy or trade for right-hand-pull cases. John Rote, 1015 West Moffatt Rd., New Castle, PA 16101, (412) 654-2525.

Wanted: Ludlow mats wanted. 24pt., 36pt., and 48pt. Zephyr. Please call David Laurenzi, (602) 439-3010. (AZ)

Wanted. Cheltenham Lite mats. Call Victor at (212) 740-9388. (NY)

Wanted: Looking for Ludlow mats for Bookman and Bookman Italic, in any size. Also looking for Ludlow border mats. Contact Rev. Jan L. Beaderstadt at P.O. Box 137, Sterling, MI 48659, or call (517) 654-2291, Fax (517) 654-3099.

Wanted: (for museum in England) Parts for a model "K" Elrod; sealing valve, mold housing cover, etc. The LUDLOW Quarterly, (602) 581-1748. (AZ)

Wanted: "Radiant" Ludlow mats. Alan Wagner, (503) 345-4226.

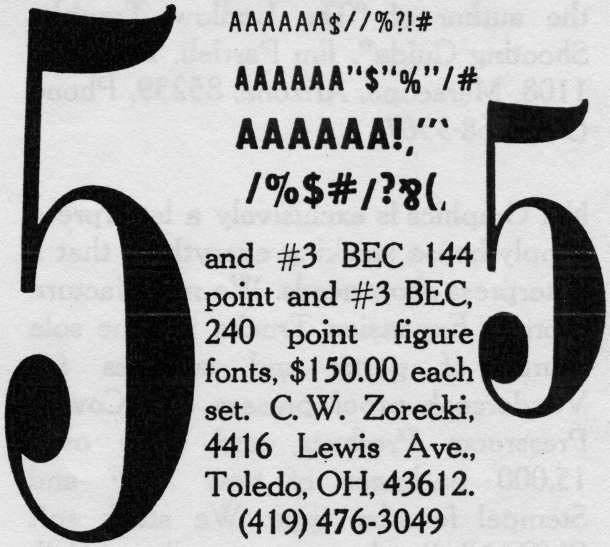
Wanted: Parts for 10" x 15" C&P old style press. The ink disk and support bracket, ratchet lever assembly parts, and base and fork of feed table. - (907) 247-1713. Don Walker, 4979 CR 250, Durango, CO 81301.

FOR SALE

Attention:
Ludlow experience for sale. Last of a dying breed. 40 years of job shop experience. Looking for a shop to display my talents. Write: Ted Zabski, 810 West Army Trail Rd. - Suite 163, Carol Stream, IL 60188.

For Sale: Two gas Ludlow machines, hundreds of fonts, and air and manual Kensol foil machines. Info: (618) 539-3377. Package deal available. (IL)

For Sale: Nearly new deep engraved mats, 10, 12, and 14 point Modern Gothic Medium, $350.00 each set,



and #3 BEC 144 point and #3 BEC, 240 point figure fonts, $150.00 each set. C. W. Zorecki, 4416 Lewis Ave., Toledo, OH, 43612. (419) 476-3049

For Sale: Old English Ludlow Mats. 12-14-18-24-36pt., all in type drawers, with centering stick. All for $1,100. Contact Paul Morneau, 8222 E. Monterosa St., Scottsdale, AZ 85251, or phone (602) 990-1655.

For Sale: Hebrew mats. Call Victor at (212) 740-9388. (NY)

For Sale: Surplus Ludlow mats, sticks, "M" Ludlow, surfacer, and more. Call Sandy for complete list, (360) 532-8791.

For Sale: Linotype metal in ingots, with analysis. Offset presses, bindery items, and letterpress equipment, including two Miehle V50's. Very large selection of numbering machines, including MICR numbers. Printing Equipment Locators. Pager (602) 229-9709 (will return call), Office is (602) 352-1663. (AZ)

For Sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide". Jim Parrish, P.O. Box 1108, Maracopa, Arizona, 85239. Phone (520) 568-3367.

NA Graphics is exclusively a letterpress supply house stocking everything that a letterpress shop needs. We manufacture Morgan Expansion Trucks, are the sole source of parts and supplies for Vandercook proof presses and Cowan Pressroom Products, and have over 15,000 packages of new ATF and Stempel foundry type. We stock soft PVC / Nitrile letterpress rollers. Call, write, or FAX for our 12 page price list and type inventory. N A Graphics, P .O. Box 43038, Cincinnati, OH, 45243-0038. Phone (513) 561-5503. Our FAX number is (513) 561-5536.

For Sale: Two left-hand-pull drawers and four right-hand-pull filler pieces, used where drawers are missing from cabinet. Pump and rebuilding parts, soluble oil. Call John Finch, (303)460-9598. (CO)

For Sale: More than 7,000 Ludlow fonts. 1,411 different fonts in 188 different styles. List, proofs, and prices on request. Thousands of Linotype fonts. Parts and accessories for both machines. Don Black, 120 Midwest Road - Unit 5, Scarborough, Ontario, M1P 3B2, Canada. Ph (416) 751-5944 Fax (416) 751-5413.

For Sale: Linotype molds, liners, and matrices. Quoins, iron furniture, perfect binding machine, small paper cutters, gold foil stampers, typecases, galley cabinets. Sell or trade for Ludlow mats. Bill Simon, (602) 1748. (AZ)

TRADE SERVICES

Expert Ludlow Repairs and Rebuilding. Jim Parrish, P.O. Box 1108, Maracopa, AZ 85239, or call (520) 568-3367.

Ludlow, Linotype, and Intertype service and parts. Call Paul Baker, (903) 596-6390. 24 hour phone. (TX)

EXPERT LUDLOW REPAIRS - Books, sticks, parts, etc. Machinery appraisals and equipment moving. Complete machine package deals available. P.J. BURNS, Mercersburg, PA. Telephone (717) 328-3092.

The LUDLOW Quarterly

Bill Simon - Editor/Publisher, 3115 W. Cavedale Drive, Phoenix AZ. 85027-7637. Phone (602) 581-1748. $6.00 per 4 issues U.S., $8.00 for Canada, $12.00 other countries. 15 cents per word for classified ads. Copy deadline for issue #3 is September 15th, provided that space is still available. Previous issues (U.S.) cost $2.50, pp. We welcome letters to the editor, questions, tips, suggestions, experiences, and articles.

Copyright © 1995
by William Simon, all rights reserved.

This issue was letterpressed on a Vandercook Universal I proof press, typeset entirely with Ludlow mats. Ludlow Black and Bodoni Bold in masthead, 12pt. and 14pt. Cheltenham Wide for text, Cheltenham Bold Condensed headers.

Fall 1995 Issue #3

The LUDLOW Quarterly

A Newsletter For Ludlow Typograph Operators And Enthusiasts

Metal Management

Strong response to our last issue's article on typemetal analysis prompts this short exploration of the subject.

The Ludlow machine was designed to work with a narrowly defined alloy of lead, antimony and tin. The idea is to optimize the melting point, fluidity, cooling characteristics, hardness, etc. An ideal mix is very close to 4.5% tin, 11.5% antimony and 84% lead. The lead provides cheap bulk, the antimony and tin work in combination to provide fluidity, hardness, and control shrinkage. It is interesting to note that antimony in its pure state actually expands as it cools and solidifies, like water becoming ice.

These three metals work in combination, and characteristics such as fluidity, perfect mold filling, and hardness change if their balance is upset. Ludlow machines can work well with from 4% to 6% tin content, but above 6% casting problems generally occur. Controlling tin is most important because the dross that is skimmed from the pot contains more tin than it should. Eventually, the tin content declines.

A really good practice is to use your metal in as large a batch as possible. This tends to dilute out the effect of any small lot's contamination. Don't continually remelt the last job back into the crucible. Save slugs until you get a full furnace full, ideally several hundred pounds, and then properly remelt.

If you don't have a remelt furnace get one, borrow one, or make one. Fancy isn't necessary. The cheapest I have seen was the bottom third of a metal drum, set on bricks, heated with the burner from a gas barbecue. Discarded kitchen pots were used to pour metal into ingot molds.

Know the weight of the slugs and melt everything to 650°F for 30 minutes, adding fluxes, stirring frequently, and skimming off and weighing the dross. Ideally you could stop at this point, pour a sample, get it analyzed, and compute how much toner metal is needed. United American Metals of Chicago, (312)-733-6700, may help you with this computation and sell you the proper quantity of toner metal.

If you don't stop for an analysis - weigh the dross skimmed off the remelt furnace and the dross

mskimmed off the pot since the last remelt, and add to the batch that weight of toner metal. Six percent tin content toner metal is formulated to replace, ounce for ounce, the discarded dross and restore your metal to optimum. Therefore, you need to know the weight of the dross to be discarded.

With the metal at 650°F, add the right amount of toner metal and stir continuously for 10 minutes, then cool to 525°-550°F and pour ingots. Use a thermometer.

With good typemetal getting scarce, it makes sense to protect what you have.

Harmful Impurities

Zinc and/or **aluminum**, in very tiny amounts, increase surface tension and the metal doesn't flow well into mats, leaving voids. Contamination generally stems from the cutting of zinc engravings on the lead saw and remelting the waste. Aluminum sometimes finds its way in via hot stamping foils that contaminate slugs which are then remelted. (A tactic in some strikes was to drop foil gum wrappers into the lino pots - squirts everywhere and the metal was ruined.) Most metallic inks contain large amounts of aluminum, copper, or zinc. If you use such inks, clean the slugs off very well or let them dry and use the supersurfacer to cut the printing face off - then throw those shavings away.

Copper forms needle sharp crystals with tin and antimony. The suspended crystals don't melt at low Ludlow crucible temperatures but are carried with the typemetal and build up to clog the mouthpiece. This buildup is very difficult to remove and causes poor faces and hollow slugs. Copper content of .01% will work, but .03% is essentially fatal to typemetal. This level is easily achieved by accidentally melting a few pieces of old handset type (1%-5% Cu) into the remelt furnace. Copper also comes from the brass mats wearing down with use, especially corroded mats. Brass is actually a copper/zinc/tin alloy. **Nickel**, from plated engravings, acts similarly.

Important Tips

NEVER melt handset type into the typemetal.

NEVER remelt saw and super-surfacer cuttings, throw them away.

DO NOT use flux in the Ludlow machine's crucible - the temperature is too low. The organic stearate and waxes that bind the chemicals leave a carbon buildup in the throat and mouthpiece.

USE a thermometer. It really is necessary, especially to keep from overheating the metal to the point where hazardous lead oxides are formed.

WATERMELONS

Green Buddhas
On the fruit stand
We eat the smile
and spit out the teeth
C. Simic

What's New!

The toll free 800 number of the defunct Ludlow Typograph Co. of Chicago is working again! It is answered, however, by Dave Seat Hot Metal Services which picked up the number after a long period of inactivity. Dave's inventory of parts and supplies is more extensive now than that of the Chicago Company in its last years. The revived number is 1-800-621-6024.

Operating Tip

Self centering sticks are so nice that some operators use them for all their typesetting needs. Do not use one for multiple castings with the machine set to automatically repeat. The mats get much hotter than normal, expand more than normal, and the expansion force all bears on one or two teeth of the tiny pinion gear. When the tooth breaks the stick is broken, and a new gear is $40.00. If multiple centered lines are necessary, you might reduce the risk of gear breakage by relieving and reapplying the thumbscrew pressure after each of the first four or five casts.

Stinking Typemetal!

••••

A subscriber called to say that he bought a number of real clean looking typemetal ingots from a shop going out of business. When they started to use one in the Ludlow it emitted a strong acrid odor, like sulfuric acid, which drove everyone from the shop. They even called the fire department's toxic spill materials unit!

I had never heard of this, no one I checked with had either, so I called Bill Mattes of United American Metals of Chicago. Mr. Mattes has alloyed thousands of tons of typemetal over 25 years and it was new to him! He did say that they use chemicals, including sulphur, in cleaning secondary metals but that eight hours of injecting water/steam into the 16,000 lb batches of alloying metal washes everything out.

So - was a contaminant added in the last melt? Was there an unseen contaminant coating the outside of the ingot? If anyone out there has a clue, or has ever had this problem, please let me know. I am trying to get a sample for analysis, and will let our readers know if something turns up.

This points out the need to closely follow the fluxing regimen described in this issue's main article!

Business Profile

For this issue the Business Profile is history! Hugh Woodruff, a semi-retired letterpress printer in Phoenix, who worked four years for the AVERY LABEL company, wrote that two Ludlow machines were important pillars of the company in its early years.

Stan Avery started with a patent on laminating stock and a handful of employees in Pasadena, California. Hugh worked for them in the early 60's when they had 10 presses, 12 men, and two Ludlows in the back of the shop. They had no Linotypes.

A few labels were printed with zinc cuts, but most used lines of type from the Ludlows. Avery's compositors took full advantage of the Ludlow's ability to cast many copies of each line. Dropping clear acetate prints of multiple image dies over the forms, they were able to space the type lines exactly to the dies before going to press. Many jobs were price labels requiring frequent form changes which were easily done with the Ludlow slugs.

Labels were printed and kiss diecut 3-on to 10-on across a web of laminated label stock on presses that used intermittent paper travel. This was before laminated sheet fed stock was invented,and two webs of paper were glued just before the press with the die cutting process actually mashing the label onto the backing paper.

Certainly the Avery Label company, now grown into the giant Avery-Dennison company, owes much of its early success to the dependability of their Ludlow machines.

Mat Identification - Free!

No Ludlow mat gauge? Just send 1 mat of each font you want identified to the LUDLOW QUARTERLY address, with sufficient postage for return. Make sure the samples you pick exactly match the lines on the back of the mats in the font. The sample mats can be any letter, even a period. Think thin and light, perhaps a period or comma, and you might even be able to tape them onto a letter!

Calendar

Oct. 5 — Nov. 30.

Member's Exhibition - "Hand Bookbinders of California". San Francisco Public Library, Civic Center. Call Andrea Grimes, special collections, at (415) 557-4560.

Nov. 18 & 19

Pyramid Atlantic Washington Art Book Fair. Corcoran Gallery of Art, Washington DC., (301) 459-7154.

P-I-P-E Donations

Many thanks to these contributors to the Postage-Ink-Paper-Equipment fund:

Clyde Barbee, Merle Langley, Ray Ballash, Marlan Bielke, Mike Phillips

---

"Never eat more than you can lift."

Miss Piggy

Classified Ads

Ad cost is only 15 cents per word! You must be a subscriber to advertise.

FREE

To help preserve Ludlow and letterpress equipment, ads offering free items will be run without charge.

WANTED

Wanted: Parts for 10"x15" C&P old style press. The ink disk and support bracket, ratchet lever assembly parts, drive gear, and base and fork of feed table. - (970) 247-1713. Don Walker, 4979 CR 250, Durango, CO. 81301.

Wanted: Ludlow mats. Smaller sizes, ornaments, and script faces. Can trade or buy. Seeking a Ludlow "Shell-High Slug Shear" slug stripper. Would like to know of any molds that produce slugs of odd widths or lengths. B. Simon, 3115 W. Cavedale Dr., Phx., AZ 85027, (602) 581-1748.

FOR SALE

For Sale: Ludlow and 400 fonts, Hillendale Press, 312 Centre Ave., Towson, MD. 21286

For Sale: Electric Ludlow. Also; two cabinets, thirty fonts, self-centering and other sticks, 6 and 12 point molds, cleaning kit, and Misc. Ocala, Florida, 813-920-5668.

Attention:
Ludlow experience for sale. Last of a dying breed. 40 years of job shop experience. Looking for a shop to display my talents. Write: Ted Zabski, 810 West Army trail Rd. - Suite 163, Carol Stream, IL 60188

For Sale: More than 7,000 Ludlow fonts, in 188 different styles with 1,411 different fonts. List, proofs and prices on request. Thousands of Linotype fonts. Parts and accessories for both machines. Don Black, 120 Midwest Road - Unit 5, Scarborough, Ontario M1P 3B2, Canada. Our number is (416)751-5944, or Fax (416) 751-5413.

For sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide".Jim Parrish, P.O. Box 1108, Maracopa, AZ 85239, (520)568-3367.

For Sale: Ludlow Mats, 3 Cabinets, and Ludlow supersurfacer. Retired typographer offering last chance closeout of 71 fonts of beautiful Ludlow mats. 70 Linotype fonts, some new, all excellent. Everything with money back guarantee. Publishers typographic, 4812 Andrews, Amarillo, TX 79106, (806) 353-1370.

NA Graphics is exclusively a letterpress supply house stocking everything a letterpress shop needs. We manufacture Morgan Expansion Trucks, are the sole source of parts and supplies for Vandercook Presses and Cowan Pressroom Products, and have over 15,000 packages of new ATF and Stempel foundry type. We stock soft PVC/Nitrile letterpress rollers. Call, write, or FAX for our 12 page price list and type inventory. NA Graphics, P.O. Box 43038, Cincinnati, OH, 45243-0038. Phone 513-561-5503. Our FAX number is 513-561-5536.

For Sale: Ludlow Mats! So far in our Ludlow Mat Sell-Out, we have sold 400 fonts.We are sorry to upset the price structure others get for their fonts, but I'd rather have your money than this beautiful collection of brass. The price still holds at $35.00 per font, plus handling. We still have hundreds of fine fonts available. This is an opportunity to fill in missing faces and to buy fonts you couldn't afford before. Send for list. I doubt if prices will ever get this low again. Michael Carbone, Inc., Federal Street, Camden, NJ 08105. (609) 946-4112 or Fax (609) 963-8860.

TRADE SERVICES

Expert Ludlow Repairs and Rebuilding

Self-centering stick repairs also. Service tours nationwide. Jim Parrish, P.O. Box 1108, Maracopa, AZ 85239, or call (520) 568-3367.

MARLBORO MATS INC.

Serving hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype, and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to; P.O. Box 188, Coolin, ID 83821.

EXPERT LUDLOW REPAIRS

Books, sticks, parts, etc. Machinery appraisals and equipment moving. Complete machine package deals available. P.J.BURNS, Mercersburg, PA, telephone (717) 328-3092.

DAVE SEAT'S HOT METAL SERVICES

The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Most orders shipped same day. In plant machine service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382.

THE LUDLOW QUARTERLY

Bill Simon,-Editor/Publisher at 3115 W. Cavedale Dr., Phoenix, Arizona 85027-7637. Phone (602) 581-1748. $ 6.00 per 4 issues US, $8.00 Canada, $12.00 other countries. Back issues of the Ludlow Quarterly are available at $2.50 each. 15 cents per word for classified ads. Copy deadline for issue #4 is December 15th, provided that space is still available. Only subscribers may advertise. We welcome letters to the editor, questions, tips suggestions, experiences, and articles.

Copyright © 1995 by William Simon, all rights reserved.

Winter 1995 Issue #4

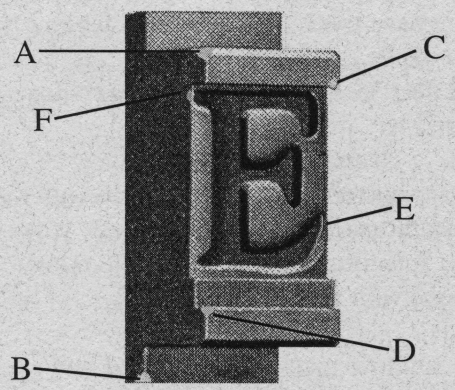
The LUDLOW Quarterly™

A Newsletter For Ludlow Typograph Operators and Enthusiasts

The Best Dressed Mats

Thousands of Ludlow fonts in display sizes get used only once a year and one can fiddle with particular mats to get a line right, but any font can be tuned up for optimum performance. The procedure is called "dressing" the mats.

The Spring issue of the LQ will deal with fast typesetting of Ludlow mats in text work. Speedsetting works, however, only with mats that are in great shape. This does not mean new mats, but clean mats that do not leave hairlines between letters and that have been made to slide easily against each other. The hour or two per font that mat dressing requires is most efficient for fonts used daily or for text work, but troublesome mats of display sizes can be "repaired" using the same techniques.



Dressing removes accumulated fingerprints, dirt, and typemetal on the mats. High spots, "dings", at the corners of the mats (A and B) caused by dropping onto a hard surface are removed and the character's sidewalls are repaired as necessary.

Before getting into procedures, let me caution that buffing wheels kill mats. Never use a buffer to polish mats as it unevenly removes too much material and rounds off the very thin and critical sidewalls (see F and E) between letters. The really shiny mats will then leave great big hairlines.

Step 1 (the tops)

To see the letters and gauge lines on the top of the mats, clamp them into a stick and run only the tops against a very fine wire wheel. Better yet, use a handbrush of fine wire or hand rub them with steel wool. For very corroded or dirty mats use a very coarse grade, like #3 or #4, (with gloves) but for average mats try #0 grade and just polish them up slightly.

Caution! Wear a mask and have good airflow when dressing or wire brushing mats. Brass is an alloy of copper, and its dust and corrosion products, oxides and sulfates, are relatively hazardous. You don't need this stuff in your lungs. They are harmful in typemetal too, so clean the mats very well of dust before casting them again.

There are chemical treatments, such as acids and liquid polishing products like BRASSO that make brass shine like new. Don't use them! They can pit the brass, making it rough on a microscopic level, and any that gets onto the casting surfaces can cause typemetal to adhere to the faces of the mats. You may never get a good cast again.

Step 2 (the sidewalls)

The sidewalls (see E and F) of the casting faces separate the letters so they don't run together when printed. They are sometimes only a few thousandths of an inch thick and with mishandling they crush inwards, leaving a space that metal fills, which leaves raised lead "hairlines" in the printing. The caved-in walls (see F) can be "picked out" by

holding the mat in one hand and using small picks to pull them back to near normal position. This is a difficult and time consuming step and should only be done on the few mats in a font that are leaving hairlines. If the mat works well, leave it alone.

Step 3 (the sides)
Ludlow made mat dressing tools, which are quite rare today. One is a cast iron jig that holds a mill file at exactly 90° to the table. The idea here is to run the side of a mat against the file, just once or twice, while keeping the base of the mat firm against the table. The result is that dinged corners and dirty fingerprints are planed off and the mats fit closer together. There is also a special stick that tightly holds a group of mats so that a very fine file held in a jig can file off dings on the inside corners (see C and D) of the casting well. Examine the sides of your slug where it pulled out of the mats. A shiny streak at the edge of letters indicates an overhang that the slug must pull past, causing resistance. If severe, the pinching effect of the dings can pull the type off the slug as the mold drops, leaving the mats filled with metal, or break safety keys. Use a very fine file very carefully to take off the pinch points only as needed. Don't just file away routinely.

My tool for dressing the sides is a dead flat 8", 1500 grit, diamond wheel made for lapidary work. I lay the dry disk flat on a bench, lay a mat on its side on the disk, and with very light pressure carefully "sand" the sides by making one or two small, 3", circles. Do not sand until the whole side is "bright" brass or you will have removed too much material, ruining the character spacing and especially the sidewalls of the letters. Just work it gently until the dirt, fingerprints, and typemetal are gone and the corrosion has turned a lighter shade. If there was a ding at a corner, that spot will now be bright brass. Now "polish" the sides for a few seconds by rubbing the mat in circles on a sheet of paper taped onto a sheet of glass.

Assuming you don't have a diamond disk, you should use a sheet of wet/dry sandpaper, the black emery stuff, of about 1200 to 1500 grit. These grits are easy to find at an automotive paint store, and almost nowhere else. Tape it down to a sheet of glass to keep everything dead flat. The fine paper quickly loads with material but rinse it out with a brush under a stream of water and keep using it.

Properly dressed mats will slide one at a time from a stack in the case with a very light finger touch. If two mats are lifted when you try to pull one, their sides are not clean or smooth enough. Typos and the dropping of mats increase, and speed decreases. Polish the sides of the offending mats with a circle or two on some paper taped to a sheet of glass. This should take less than two seconds. A full mat dressing procedure probably only needs be done once in the life of a font.

Step 4 (casting faces)
Only work on the letter faces if the mat does not cast well enough to use. This is rare unless the mats were stored upside down on galleys for years. Even then, repeated casting can often eventually clear things out. Try detergents with a toothbrush. On truly corroded mats that are difficult to break apart from one another, you have nothing to loose. Try a toothbrush or toothpicks with toothpaste or fine polishing compound, try BRASSO with a brush. I have tried low power sandblasting with walnut shells (sand would destroy the mats) to some effect. Generally, leave the faces alone.

Step 5 (cleaning)
Clean any dust or residues off the mats with water, acetone, brushes, compressed air, - whatever works. It is important not to contaminate the typemetal with any copper products.

When Ludlow mats are optimized and proper setting techniques are used, you can set circles around those who compose hand-set type. See the Spring 1996 issue for details.

Remember, it is generally better to do less than more. If you are in doubt as to the amount of dressing that needs to be done, send a few of the worst corroded and dinged up mats you have to the Ludlow Quarterly address, with return postage, and I will dress them and return them as samples.

Business Profile

The PRINTER is a monthly newspaper that everyone with a Ludlow should know about. The paper is dedicated to all phases of letterpress and has a strong focus on hot lead casting machines and operations.

They have been in operation for ten years using the traditions they support. Their typesetting is almost entirely Intertype and Ludlow, composed on a dozen 12"x18" galleys, with some small paste-ins of ads and proofs of rare fonts. In the beginning they printed the paper themselves on a Miehle vertical, but with over 1000 subscribers the economy of scale came into play and they now have it printed offset on a daily newspaper's web press in 15 minutes.

The paper is $25.00 per year for 12 issues, with 25 cents per word classified ads. Michael and Sally Phillips do a great job with the paper and promoting letterpress. People requesting a copy often get his "Letterpress Kit" which includes flyers of suppliers and other publications that might be useful. Copies of the LQ are sometimes included. An amazing amount of useful information can be found in every issue and I highly recommend the paper.

The PRINTER, 337 Wilson Street, Findlay. Ohio, 45840. Phone 419-422-4958, Fax 419-423-2472.

What's NEW!

Dave Seat, of Dave Seat Hot Metal Services, has moved hot lead onto the information highway. He now has an E-Mail address to be more accessible for customers. You can get questions answered or send orders to him at:

70254.1575@compuserve.com

For the benefit of his international customers Dave has a page on the World Wide Web. The address for that is:

http://machinerynet.com/printers marketplace/hotmetalservices

New Grease!

The crucible cam roller needle bearings are one of the toughest things on a Ludlow to keep lubricated. The pot heat simply melts out the grease in a few weeks and they run dry because there is no zirk. Dave Seat of DSHMS now has a grease that will stay. Experiments he performed have shown that bearings repacked with this grease are still lubricated months later. It costs a few bucks for a jar that will pack the bearings several times.

P•I•P•E Donations

Our Thanks to these contributors to the Postage-Ink-Paper-Equipment fund: Hugh Woodruff- Phoenix, AZ., and The Front Rubber Stamp Co. of Boston,Mass.

Tip

If you have a Ludlow with the traditional belt driven pump, do not switch to antifreeze and water cooling solution. The pump requires the oil/water mixture to lubricate the packing. It will fail very fast without the oil. The best thing to do with the oil/water coolant is to keep it clean and change it at least twice a year. Old oil oxidizes and precipitates out, clogging the mold and the tank filter. Make sure that you use a half pint of soluble oil per 5 gallons. You can, however, save some money. Many machine shops still buy soluble oil in drums, and might sell you a gallon of it for the same price as you normally pay for the regular pint can.

Humor

I regret to report there was nothing funny this quarter, and now eggnog season is over.

Health Note

If you see any yellow powder in the crucible, get your machine serviced. The powder is a water soluble, and very hazardous lead compound. It forms only when the pot heater is running wild and the pot stays much hotter than the 550 degrees. It may mean that some helpful person turned the heat way up to compensate for mouthpiece heaters or throat heaters that are burned out.

Congratulations!

Mr. Ralph Staples, longtime sales and service representative for the Ludlow Typograph Company, announced his retirement just recently. He Started with Ludlow in 1954, and for the last 15 years independently did service work and sold rebuilt machines in six Northeastern States and parts of Canada. He also ran a print shop and now intends to keep his hand in, doing letterpress invitations, cards, and rubber stamps on a part-time basis.

Stuff

You probably have our stuff in the back of your shop, but we don't know about it yet. Subscription renewals get a bonus of 15 words of classified advertising, so let us know about your stuff when you renew!

New Schematics

If you ever lookinto the manual and noticed that your wiring doesn't look anything like what is in the book, you are not alone. There were more wiring schemes than manuals. Dave Seat is compiling all the possible variants and will soon be able to fax a correct copy to those having trouble. The schematics are being drawn to assist those of you who need to change the old style relay with the silver points to the modern style. The new style is very much cheaper, and much quieter.

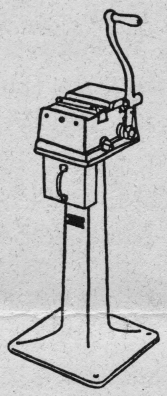
Classified Ads

Still only 15 cents per word. You must subscribe to advertise. Deadline for next issue is March 15th.

Free

To help preserve letterpress equipment, ads offering free items will be run without charge.

Wanted



Wanted: A Ludlow Slug nipper. It takes the tops off of slugs and looks like this picture. B. Simon, 3115 W. Cavedale Dr., Phx, AZ, 85027, or 602-581-1748.

Wanted: Left and right single saddle shafts for the lower ink roller on an 8" x 12" C&P new series press. C&P part number is #40 L, #40 R. Also looking for one or two type cabinets made of oak. Prefer a double cabinet with oak top and standard California cases but will consider others. Don Walker, 4979 CR 250, Durango, CO 81301., or call 970-247-1713.

Wanted: Ludlow mats. A series of 10, 12, 14 point of a roman serif face font. Something for book and text work, like Eusebius, True cut Caslon, etc. Call Gene at 501-474-5134. (AR)

Wanted: Ludlow mats. Smaller sizes suitable for text work, ornaments, and script faces. I have Linotype mats, Ludlow mats, and some letterpress equipment to trade, but will also buy entire font collections. Don't be concerned with the difficulty of packing things up, I send shipping crates to you. B. Simon, 3115 W. Cavedale Dr., Phx., AZ 85027, (602) 581-1748.

For Sale

For Sale: More than 7,000 Ludlow fonts, in 188 different styles with 1,411 different fonts. List, proofs and prices on request. Thousands of Linotype fonts. Parts and accessories for both machines. Don Black, 120 Midwest Road - Unit 5, Scarborough, Ontario M1P 3B2, Canada. Our phone number is (416)751-5944, or Fax (416)751-5413.

For Sale: Quoins, furniture, automated perfect binding machine, gold foil stampers, new ATF type, galley cabinets, or any in trade for Ludlow mats. Bill Simon, (602) 581-1748.

For Sale: Typemetal in 20 lb ingots, two Miehle V50's in nice condition, and a beautiful side-arm tabletop 10" x 12" letterpress. Printing Equipment Locators, pager number is 602-229-9709, will return your call. Phoenix, AZ.

For Sale: Two Ludlows, one is a model M, 20 cabinets of mats, centering sticks, etc. Call, fax, or write for listing. The Front Rubber Stamp Co., Inc. 960 Massachusetts Avenue, Boston, MA 02118. Phone 1-800-666-7600, Fax 1-800-666-7605.

For Sale: More than 7,000 Ludlow fonts, in 188 different styles with 1,411 different fonts. List, proofs and prices on request. Thousands of Linotype fonts. Parts and accessories for both machines. Don Black, 120 Midwest Road - Unit 5, Scarborough, Ontario M1P 3B2, Canada. Our phone number is (416)751-5944, or Fax (416)751-5413.

For Sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide". Jim Parrish, P.O. Box 1108, Maracopa, AZ 85239, (520)568-3367.

For Sale: Ludlow Mats! So far in our Ludlow Mat Sell-Out, we have sold 400 fonts.We are sorry to upset the price structure others get for their fonts, but I'd rather have your money than this beautiful collection of brass. The price still holds at $35.00 per font, plus handling. We still have hundreds of fine fonts available. This is an opportunity to fill in missing faces and to buy fonts you couldn't afford before. Send for list. I doubt if prices will ever get this low again. Michael Carbone, Inc., 2041 Federal Street, Camden, NJ 08105. (609) 964-4112 or Fax (609) 963-8860.

Trade Services

LUDLOW REPAIRS and Machine Rebuilding. Frequent service tours throughout the country. Jim Parrish, P.O. Box 1108, Maracopa, AZ 85239, or call (520) 568-3367.

DAVE SEAT - HOT METAL SERVICES The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Most orders shipped same day. In plant machine service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382. E-Mail:70254.1575@compuserve.com

EXPERT LUDLOW REPAIRS - Books, sticks, parts, etc. Machinery appraisals and equipment moving. Complete machine package deals available. P.J. BURNS, Mercersburg. PA, telephone (717) 328-3092.

MARLBORO MATS INC. has served hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to; P.O. Box 188, Coolin, ID 83821.

THE LUDLOW QUARTERLY

Bill Simon,Editor/Publisher at 3115 W. Cavedale Dr, Phoenix, AZ. 85027-7637. Phone (602) 581-1748. $ 6.00 per 4 issues US, $8.00 Canada, $12.00 other countries. 15 cents per word for classified advertising. Copy deadline for issue #5 is March15th,1996, provided that space is still available. Only subscribers may advertise. We welcome letters to the editor, questions, tips suggestions, experiences, and articles. Reprints of past issues of the Ludlow Quarterly are available at $2.50 each.

Copyright © 1996 by William Simon, all rights reserved.

Spring 1996 Issue #5

The LUDLOW Quarterly™

A Newsletter For Ludlow Typograph Operators and Enthusiasts

Ludlow Speed-setting

The Ludlow machine was designed to be a companion piece to the linotype machine. It did a beautiful job of setting display size type while the Linotype unceasingly cranked out body text.

Times change, however, and today the Linotype is too large for most places and much too complicated to operate and maintain. The Ludlow has been the machine of choice for most modern letterpress typesetting. Its size and ease of use and service have kept it busy producing small amounts of type for ribbon printing, stamps, invitations and checks. Today the cost and scarcity of good handset type has expanded the use of the Ludlow for body text.

Shops that produce custom or miniature books are setting page after page of type. Although it produces type slower than a Linotype, Ludlow typesetting is very much faster than setting foundry type by hand. This is especially true if some special techniques are used.

Lots of things affect speed-setting of Ludlow slugs. For the sake of this article, we will assume you are right handed and setting mats from regular wooden cases. There will be a number of useful tips described in this article. Any single one should increase speed, but combining several together can halve typesetting time and take the drudgery out of using the Ludlow for body text.

The biggest help to speed-setting type on the Ludlow is a technique called Gathering. This is a process in which you reach to a case and pick up, in proper order, enough mats to make from one word to half a line, and then transfer all mats to the composing stick at once. Gathering is an easy technique to learn. In minutes you can pick one mat per second, with very little practice - two or more per second.

The mats must be well dressed. Every single mat must slide easily against others, no sticking at all. If you try to lightly drag a mat up off the stack of a letter and get two or three - you simply cannot gather mats rapidly. Read the article on dressing mats in LQ issue #4. Don't dress every font, just the ones you use for body text.

One thumb, two fingers

Go to a case, make sure that no mats are lying flat in their sections and that the heads of all letters are to the left. In one motion, with no pauses, slide one mat up with your first finger, catch it against your thumb, and continue upwards to a point about 2" off the stack. Leave your forearm rather motionless at a low angle over the case, using wrist motion to get the mat up. Your fingers should be lightly "pinching" only the top 1/4 of the mat. Now touch it to the stack of the next letter just behind the first mat of that stack, and just as it touches, dip your second finger

down, slide a second mat up and against the first, and continue the motion without pause to 2" above the stack. Now you should have two mats, sandwiched between thumb and second finger, with the first finger resting lightly on the top of the two mats, or just above them. This is gathering!

Now take the pinch of two mats, a "pack," set it just behind first mat of the next stack and dip the second finger down to drag up another mat. The thumb and first finger should lightly stabilize the pack to prevent ir from falling over. Again, use a fluid motion up and out.

A few more picks and you will have a pack of mats 1/2" to 3/4" wide, spelling the word you want, but getting a little disorderly. Go for another mat, but instead of a touch and go, set the pack on the stack more deliberately, with a slight tap. If you are correctly using a light pinch, the mats will settle themselves into a more uniform pack which is easier to carry to the next letter. As the pack increases in size you will find you must hold it a bit lower and more firmly. If the number of mats in the stack of a letter is too small to provide an adequate landing space to tap/settle the pack, put some six pica quad blocks behind them.

Some people can gather and set very fast without any quad blocks. They just angle the pack down, setting the end onto the mats of the next letter without ever really releasing their pinch. They drag a mat onto the pack with their second finger, then as the pack leaves they bring their first finger over the mat in mid-air and pinch, which releases the second finger to drag another mat.

Gathering can actually be accomplished using only thumb and one finger. Just set the pack on the stack, leaned against the thumb, use a finger to drag up a new mat, and pinch again. It is, however, very slow.

The motion for the first few mats should be like a bouncing ball, very fluid and non-stop. When you have a larger pack, the motion is like a rabbit landing, pausing a split second, then jumping off again. Pause as you get to a section, not as you leave. Always pull the new mat up to the pack and lift everything away with one motion.

Your jumps should ideally be directly to the section with the next letter, not to a hover looking for the right bin. Knowing the case well will pay off.

Spacing the words

Some printers fill an empty section with the one size of spaces that they want to use and set them in after each word, gathering them up like regular mats. This works well with centered or left-aligned text.

Full width justification is slower, but generally works best if you don't set any spaces in until all words are in the stick. Six words means 5 spaces, so grab 5 equal spaces that make about the right size and try them in the end of the line. If they fit, put them between the words, if they don't, try 5 of a smaller size. Repeat until using single thin spaces to tighten the line.

After casting the mats, unlock the stick, grab half the mats at a word break and drizzle them one by one back into their proper places.

(Continued in the next issue)

Business Profile

Many subscribers of the **LUDLOW Quarterly** have a strong interest in letterpress in general, so this profile is about the best letterpress newsletter in America, the **TYPE & PRESS**.

T&P is a quarterly journal now in its 22nd year of publication. Its longevity is due to its editorial quality and a large enthusiastic following that contributes stories, research, and advice. Editorial subjects are thoroughly researched at rare book rooms and several university libraries. The first time I saw an issue I subscribed and ordered a copy of every back issue. It's that good.

It was started by Fred Williams in 1974, after he retired from 40 years of working at the printing trade. This was a time when large amounts of letterpress type, casters, mats and presses were being scrapped. Trade journals, heavily subsidized with ad revenues from offset-related industries, limited their editorial content to duplicating and electronic publishing. Mr. Williams thought something was needed to keep lines of communication open between letterpressmen. The **T&P** journal allowed them to buy, sell, and trade equipment, and share techniques, supply sources, and news.

Originally hand-set and dip-fed on an 8x12" treadle press, issues were distributed free through the Amalgamated Printers bundle and sent free to those requesting it. It is still produced by letterpress with eight pages per issue on vellum, but type is now set on a linotype and printed on a 12" x 18" Little Giant cylinder press. There are lots of cuts. Mr. Williams and his wife Betty Jean still produce every issue.

Subscribe! The subscription rate is only $5.00 per year U.S., $5.50 Canada, $7.50 overseas, in U.S. funds. Classified advertising rate is 5 cents per word. **Type & Press**, Fred Williams, 24667 Heather Ct., Hayward, CA 94545.

FREE Matrix ID!

For those of you who do not have the new generation Ludlow mat gauge, which uses the lines on the back of the mats to identify the font and point size, we provide free ID service. Just send one mat of each font you want identified to the LUDLOW Quarterly address, with sufficient postage for return.The sample can be any letter, even a period. Think thin and light and you might even be able to tape them onto a letter!

P•I•P•E Donations

Many Thanks to these contributors to the **Postage-Ink-Paper-Equipment** fund: Clyde Barbee - Southern Printing Co., Elmer Broste, Dave Seat - Hot Metal Services, Ed Barron, and Susan Smith.

Tip

You can easily make some strange and non-linear effects with the Ludlow. Make a frame of some iron furniture on a steel surface. Place some type in the hole at odd angles, or even slugs bent into a curve. Pour a little metal from the crucible around the base of the type to freeze it in place, then pour another layer or two until the block is near type high. The resulting rectangle is an instant cut! It takes only seconds to make and locks easily into forms.

New Scraper!

Dave Seat, of Dave Seat Hot Metal Services is now manufacturing an adjustable, three bladed, well cleaning tool. It looks very similar to the old linotype well scrapers and has a cranking handle on the top. It works faster than the normal Ludlow reamer, is adjustable for fit and wear, and does not require long preheating. It was developed because in some machines the normal reamer spins easily in the well but the piston still drags. Call 1-(800)-542-2508.

(Editors note - There is a theory that one can spread the end of the normal Ludlow reamer a few thousandths of an inch with wedges to get it to "cut" better. I have talked to many people who tried to do this and instantly broke the reamer. If anyone has had success with this technique, I would like to hear about it.)

Cyberspace Dingbats

Matt Jalbert took a liking to Ludlow dingbats and has developed a font of six dingbats, each in four rotations of regular form or black box reversed. There are 72 images per font, all are leaf motifs, and they were crafted by scanning into Fontographer 4.0. Available in TrueType or postscript versions, they print well in any size and can be combined for seamless borders. You can try them for free and use them for a $5.00 shareware fee.

Contact Matt Jalbert, P.O. Box 6386, Albany, CA 94706, or try AOL: mjalbert@aol.com, or internet: mjalbert@uclink2.berkeley.edu .

If you cannot download the font, send the LQ a disk, with return postage.

Travel News

Jim Parrish, the renowned Ludlow service technician, has moved from Arizona to Arkansas for a while to help out in family matters. He plans to continue his service tours throughout the West, and will service more customers on the East coast. He can be reached at (501) 734-4035.

Classified Ads

Still only 15 cents per word. You must subscribe to advertise. Deadline for next issue is March 15th.

Free

To help preserve letterpress equipment, ads offering free items will be run without charge.

Wanted

Wanted: Two oak type cabinets wanted, one single-wide, one double-wide, for use in print shop. Must be in restorable condition, priced reasonably, and in the Southwest. I am also interested in type. Don Walker, 4979 C.R. 250, Durango, CO. 81301. Phone 970-247-1713.

Wanted: Ludlow mats. Coronet Bold 14, Times Bold 10, 12, and a series of Times New Roman. Write to the Ludlow Quarterly.

Wanted: Will pay for information on how to make photo-engraved cuts. 1-800-887-0306, Fax 1-800-325-1666

Wanted: Ludlow Mats. Caslon light 12, 14, 18, 30, and Cheltenham Oldstyle 12, 14, 18. Bookbinders Deluxe, Call Victor, at 212-740-9388

For Sale

For Sale: Chase for 12" x 18" Golding. Only $35.00 PPd. John Powers, Box 304 Shore Acres Road, South Harpswell, ME 04079. Phone (207)833-6701.

For Sale: Largest selection of Ludlow fonts in North America. Over 10,000 total fonts - over 1500 different. For complete list phone, fax or write DON BLACK, 120 Midwest Road, Unit 5, Scarborough, Ont. Canada M1P 3B2. Phone 416-751-5944, Fax 416-751-5413. Also have a large list of special sale fonts $30.00 each. Have all related supplies for Ludlow, also thousands of Lino fonts and accessories.

For Sale: LUDLOW MATS. We have hundreds of fine fonts still available at $35.00 per font plus handling, send for list. MICHAEL CARBONE INC., 2041 Federal St., Camden, N.J. 08105. (609) 964-4112, FAX (609) 963-8860.

For Sale: Ludlow Type $1.00 per line. Send $5.00 for laminated Type specimen sheets. Top Notch Press, 28 Wardwell Rd, Canton, MA 02021. (617) 828-4088

For Sale: Two Ludlows, one is a model M, 20 cabinets of mats, centering sticks, etc. Call, fax, or write for listing. The Front Rubber Stamp Co., Inc. 960 Massachusetts Avenue, Boston MA 02118. Phone 1-800-666-7600, Fax 1-800-666-7605.

For Sale: Ludlow fonts, reasonably priced. Henry Weiland, 8946 West Grantosa Drive, Milwaukee, WI 53225. Phone (414) 463-4681.

For Sale: Typemetal, any quantity, in 20 lb ingots with analysis. Excellent side-arm tabletop letterpress. Printing Equipment Locators, pager number is 602-229-9709, will return your call. Phoenix, AZ.

For Sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide". Jim Parrish, P.O. Box 230, Brinkley, AR. 72021-0230, or call (501) 734-4035

For Sale: Kelsey hand press, 5" x 8" Excelsior model in excellent condition with new rollers. $185.00 FOB Durango. Don Walker, 4979 C.R. 250, Durango CO 81301. Phone (970) 247-1713

For Sale or Trade: Over 70 fonts, much variety, but including; Bodoni Bold 12-14-18-24-36-48, Coronet 14-18, Coronet Bold 30-36, Bodoni Campanile 42-48-60, Garamond 30-48, Umbra 24-36-48-72, and many Tempos, Karnaks, Lining Plates and MICR #'s. Some good deals on Linotype fonts. Bill Simon, 3115 W. Cavedale Dr. Phoenix, AZ, 85027, (602)581-1748.

For Sale: Complete Ludlow/foil stamping shop for sale. Use what you need, sell off the rest, will deliver. 618-539-3377 (IL)

Trade Services

LUDLOW REPAIRS and Machine Rebuilding. Frequent service tours throughout the country. Expert composing stick and mold repairs. Jim Parrish, P.O. Box 230, Brinkley, AR. 72021-0230, or call (501) 734-4035.

DAVE SEAT - HOT METAL SERVICES The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Most orders shipped same day. In plant machine service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382. E-Mail:70254.1575@compuserve.com. WWW page at; http://machinerynet.com/printersmarketplace/hotmetalservices.

LUDLOW - LINOTYPE - INTERTYPE Repairs and rebuilding. P.J. Burns, Mercersburg, PA. (717) 328-3092

MARLBORO MATS INC. has served hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to; Marlboro Mats, P.O. Box 188, Coolin, ID 83821.

THE LUDLOW QUARTERLY

Bill Simon,Editor/Publisher at 3115 W. Cavedale Dr, Phoenix, AZ. 85027-7637. Phone (602) 581-1748. $ 6.00 per 4 issues US, $8.00 Canada, $12.00 other countries. 15 cents per word for classified advertising. Copy deadline for issue #6 is June 15th,1996, provided that space is still available. Only subscribers may advertise. We welcome letters to the editor, questions, tips suggestions, experiences, and articles. Reprints of past issues of the Ludlow Quarterly are available at $2.50 each.

Copyright © 1996 by William Simon, all rights reserved.

Summer 1996 Issue #6

The LUDLOW Quarterly™

A Newsletter For Ludlow Typograph Operators and Enthusiasts

Ludlow Speed-setting

Part II - The Perfect Copy

Most text is set from copy. If you can make ideal copy you can set mats faster. I write on a computer and then output to a printer, using a column width that matches the specific Ludlow font and width I am setting. The column width of the printout should be adjusted to match the text length, not the physical length, of the Ludlow column.

For example, if you are setting a 21 pica column (3.5") on the Ludlow the stick might hold 10 e's, 10 a's, 5 m's. 5 n's, and 3 r's. Type those letters into the computer and set the column margin just after the last letter. Depending on the typeface used, the computer's columns will likely not be 3.5". Set a line and add letters until tight, then use that exact text string to set the computer margins. Final adjust by trial and error.

You want the computer printout to mirror exactly what the Ludlow font produces. Sophisticated programs, like PageMaker or Quark Express, will let you stretch text or change spacing in minute increments and exactly duplicate the Ludlow font, but they are not necessary.

If the printout copy is justified flush left, even when you are fully justifying the Ludlow mats, the amount of space at the end of the line gives a big clue to what size Ludlow spacing material you reach for. If using hyphenation, print out the copy exactly as you want it to appear when set. Print out the copy in double or triple spacing if you find that easier to set, and run the spelling checker!

Machine Placement

Good placement of the machine and mat cabinet can make text setting work much faster and easier. It makes no sense to walk twelve feet for every cast.

I use a right-hand-pull Ludlow cabinet (when looking at the open case of mats the drawer pull is on the right) set parallel to the front edge of the Ludlow machine and about 34 inches away. Leave empty the third or forth case slot from the top of the cabinet. Whatever font being currently used for speedsetting text goes into that space. The center of the drawer when fully extended should be directly across from the stick slot in the Ludlow tabletop.

The height of the case center and the height of the tabletop should be almost equal. Now for the best tip - sit on a swiveling stool between the cabinet and machine, adjusted to a height that makes arm motions most comfortable.

Gather mats and spaces into the stick, spin around to the machine, set the stick on the tabletop, tap mats flat, and lock the stick. Insert it into the machine, throw the handle, and trip the lever. While the machine cycles, you can take

the last slug ejected from the machine and with a scraper of some sort clean up any feathered lead at the sides of the face or top edge of the slug. This takes only a few seconds. As soon as the locking handle pops open you can grab the stick, swivel back around, and be distributing the mats into the case in about two seconds.

A Case for Speed

Wooden Ludlow cases are too deep. The dividers of each section are higher than the mats and interfere with setting because the pack of gathered mats (see issue #5 re: gathering) has no flat area on which to momentarily land and stabilize. The solution is to raise the mats.

You need to raise the mats about 10 points. The easiest way is to use a paper cutter to cut 1/8" board stock and line every section. Just raise the mat tops equal to or slightly above the wood dividers. The bottom edge of the case is even higher, and those sections needs about 5/16" buildup.

Now put some surplus quad blocks or large spaces into each section and then load the mats. You want about 1 inch of quad spaces behind every stack of mats, but reduce the amount of spaces to ensure 3/4" open space at the top of each section for easy mat picking. The idea is to build a "landing zone" for gathered mats to rest on as each new letter is gathered onto the pack. Only prepare one or two cases to use for serious text setting. Shift fonts into and out of these special speed cases as needed.

Speedsetting makes setting text on the Ludlow downright enjoyable, and very much faster than handsetting type. There are probably a few more techniques that improve on what is described here. Don't forget about multiple casting and printing x-number-up! Experiment, and if you find any helpful ideas, share them with us!



LudlowQrt@aol.com

For the convenience of our subscribers, we have established an internet account for **The Ludlow Quarterly**. Everyone should find it easier and cheaper to contact us on-line, especially our many overseas subscribers. The address is listed above. You are invited to use it to submit articles, suggestions, and tips!



Why does Hawaii have an interstate highway?



Safety Keys? - Give us a break!

My goodness, there is a hot Ludlow rumor! It goes something to the effect that safety keys, the little breakable things in the cap at the end of the main shaft, are in short supply and they aren't making them any more. The real story is that all the Ludlow equipment suppliers have thousands in stock. The fellow who has made them for years sold the equipment to a different company, but you need never worry about a good supply. It should be noted here that a machine only breaks keys when there is something wrong with it, generally dirt, loose parts, or adjustments.

• • •

If a cow laughed really hard,
would milk come out her nose?

Do you need a silencer if you are going to shoot a mime?

Service Tip

Lubraclean fluid is a very special chemical formulation and on heavy cleaning jobs requires time and temperature to work its best. Try smearing Lubraclean all over the hot piston or mouthpiece, brush it with a wire brush, then wait a while before wiping things clean. Think of it as a detergent and allow the chemicals time to work.

Health Tip

If you notice a yellow powder floating on your metal in the crucible, check the pot temperature. This forms only at temperatures way above normal, and I understand that it is a very soluble lead compound, and therefore much more dangerous than the white lead oxides and normal dross.

Why isn't "phonetic" spelled the way it sounds?

In response to inquiries about Lining Plate fonts, we did a search of several Ludlow typeface books to make this chart of all possible Ludlow Lining Plate faces. Hopefully, it is correct. If anyone has any contrary information, please contact the Editor.

All Possible Lining Plate Fonts

Fonts	Point sizes and numbers
Commerce Goth. Light	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
Commerce Goth. Light Cond.	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
Commerce Goth. Medium	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
Commerce Goth. Med. Cond.	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
Lining Litho Light	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
Lining Litho Bold	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
L.P.Gothic Light	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2) 24pt(1-2)
L.P.Gothic Light Condensed	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
L.P.Gothic Light Extended	6pt(1-2-3-4) 12pt(1-2-3-4)
L.P.Gothic Heavy	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2) 24pt(1-2)
L.P.Gothic Heavy Condensed	6pt(1-2-3-4) 12pt(1-2-3-4) 18pt(1-2)
L.P.Gothic Heavy Extended	6pt(1-2-3-4) 12pt(1-2-3-4)
L.P.Gothic Bold	6pt(2-3-4) 12pt(1-2-3-4) 18pt(1-2?) 24pt(1)
Engravers Bold	6pt(2-3-4-5) 12pt(1-2-3) 18pt(1-2) 24pt(1)
Victoria Italic	6pt(2-3-4) 12pt(1-2-3-4)

Service Tip

The main magnetic relay that controls crucible heating makes a loud buzzing sound in many machines. Of course, it cycles on and off. When it fails, or drives you crazy with all that buzzing, don't try to find an exact replacement at a high cost and which will eventually give you the same noise. W. W. Graingers has a relay for about $20.00. Check the voltages for your machine, but most 220 volt machines will take the 5x848e relay. 110 volt machines should take the 5x847. These are DPDT magnetic relays with self-wiping silver contacts, and they are quiet! (see LQ issue # 1 for solid state crucible control devices)

1996 Calendar

August 25-27: American Amateur Press Convention. Rapid city, SD. Info; Jack Swenson, Box 488, Custer, SD 57730. Call 605-673-3718

September 26-29: American Typecasting Fellowship Convention. Holiday Inn (Airport) Charllotte, NC. Info; Pat Taylor, 52 Fairway Ridge, Lake Wylie, SC 29710.

P•I•P•E Donations

The **Postage-Ink-Paper-Equipment** fund had no contributors this quarter. We are still trying to preserve all sorts of Ludlow items, including promotional materials, manuals, and books. We can sometimes pay the shipping costs. The price of brass is hitting new lows, so have a heart and consider sending sorts and broken fonts of mats to us instead of melting them. Once they are gone they are gone forever.

Classified Ads

Still only 15 cents per word. You must subscribe to advertise. Deadline for the Fall issue is September 15th.

Free

Three new(?) crucible heating elements for Intertype machines. Contact Editor, **LUDLOW Quarterly**.

Wanted

Wanted: Old fashioned composing stone, preferably marble, for a permanent printing museum exhibit in the Phoenix Public Library. Hugh Woodruf, 7300 N. 51st Ave. - #A276,Glendale, AZ 85301, or call 602-937-4791.

Wanted: Two oak type cabinets wanted, one single-wide, one double-wide, for use in print shop. Must be in restorable condition, priced reasonably, and in the Southwest. I am also interested in foundry type. Don Walker, 4979 C.R. 250, Durango, CO 81301. Phone (970) 247-1713.

Wanted: Carbide blade for G-100 Trim-O-Saw, J. Moran, 3011 Country Club Dr., Muskegon, MI 49441.

Wanted: Ludlow and Linotype mats for non-latin faces, Monotype display mats, Curle saw. Phillip Driscoll, 135 East Church Street, Clinton, Michigan 49236.

Wanted: Eusebius 8 and 10 point Ludlow mats. Buy or trade for other mats. Dale Stedman, 4422 Dodge Ave., Fort Wayne, IN 46815. Phone (219) 483-7841.

Wanted: Ludlow mats. Eusebius and Eusebius Italic in 10 - 12 - 14 point. Cedar Creek Press, P.O. Box 59, Mason City, IA 50401, or JHenry@willowtree.com.



If nothing sticks to teflon, how do they get the teflon to stick to the pan?



For Sale

For Sale: 1.5" x 20.5" Ludlow stick, (five column)and one font 36pt Karnak. Phone/fax 64-6-876-4865, Hastings Rubber Stamps, Box 269, Hastings, New Zealand.

For Sale: Largest selection of Ludlow fonts in North America. Over 10,000 total fonts - over 1500 different. For complete list phone, fax or write DON BLACK, 120 Midwest Road, Unit 5, Scarborough, Ont. Canada M1P 3B2. Phone 416-751-5944, Fax 416-751-5413. Also have a large list of special sale fonts $30.00 each. Have all related supplies for Ludlow, also thousands of Lino fonts and accessories.

For Sale or For Trade: Foundry Type in original factory packages. Keith Watkins, 330 East Center, Providence, Utah 84332.

For Sale: New! "Ludlow Field Service Notes" and Ludlow mat gauges with reference charts are now available from the author of "The Ludlow Trouble-Shooting Guide". Jim Parrish, P.O. Box 230, Brinkley, AR 72021-0230, or call (501) 734-4035.

For Sale: Wood type. 1"- 4", seven fonts, regular, bold, extended faces. Ludlow mats for sale or trade. Ludlow wanted, NE area. (508) 587-8850. (MA)

For Sale: Ludlow Type $1.00 per line. Send $5.00 for laminated Type specimen sheets. Top Notch Press, 28 Wardwell Rd, Canton, MA 02021. (617) 828-4088.

For Sale: Ludlow mats - Several fonts of Umbra - Garamond - Coronet mats. Real good deal or trade for other fonts. B. Simon, 3115 W. Cavedale Dr. Phs, AZ.85027- 602-581-1748. (or LudlowQrt@aol.com)

For Sale: Two Ludlows, one is a model M, 20 cabinets of mats, centering sticks, etc. Call, fax, or write for listing. The Front Rubber Stamp Co., Inc. 960 Massachusetts Avenue, Boston MA 02118. Phone 1-800-666-7600, Fax 1-800-666-7605.

For Sale: Ludlow, 30 fonts, left and right hand cabinets, tools, extra plunger, spare parts. 1924 Intertype, 3 mags and side mag. 1888 Pearle platten press, excellent condition, good rollers, hand crank full page proof press, lots of rules, borders, leads and slugs, some handset type. Call 412-658-1493. $1800 takes everything. Located in New Castle, PA.

For Sale: Model L Ludlows, mats, cabinets, hand-set type, Lino mats, proof presses (6), Washington/Hoe presses, remelt furnace, stones, Linotypes: Model #5, Electron, lots more! LINOMARL, Box 356, Amador City, CA 95601. Tel.:(209) 267-5470. CAN BE DELIVERED!

For Sale: Kelsey hand press, 5" x 8" Excelsior model in excellent condition with new rollers. $165.00 FOB Durango. Don Walker, 4979 C.R. 250, Durango CO 81301. Phone (970) 247-1713.

For Sale: Ludlow Typograph Machine, model L, uses natural gas or propane, new motor belt and new mouthpiece. Stored in temperature controlled building. Excellent condition. Clean and ready to run. $1500. Two Supersurfacers, $100.00 each OBO. Ph. 210-650-5473, ask for Rick. (TX)

For Sale: Complete Ludlow outfit, with machine, mats, tools, and spare parts. Installed and guaranteed. Call P.J. Burns, Mercersburg, PA. (717) 328-3092.

Trade Services

LUDLOW REPAIRS and Machine Rebuilding in your shop. Service tours throughout the country. Now scheduling the Northeast area. Expert composing stick and mold repairs. Jim Parrish, author of "The Ludlow Trouble Shooting Guide" Write Jim Parrish, P.O. Box 230, Brinkley, AR 72021-0230, or call (501) 734-4035.

DAVE SEAT - HOT METAL SERVICES The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Most orders shipped same day. In plant machine service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382. E-Mail:70254.1575@compuserve.com. WWW page at: http://machinerynet.com/printersmarketplace/hotmetalservices.

C.A.M. AWARDS - Custom Ribbons. Quality workmanship. Customer satisfaction is our specialty. Call (509) 292-2310. (WA)

LUDLOW - LINOTYPE - INTERTYPE Repairs and rebuilding. P.J. Burns, Mercersburg, PA. (717) 328-3092.

MARLBORO MATS INC. has served hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to: Marlboro Mats, P.O. Box 188, Coolin, ID 83821.

THE LUDLOW QUARTERLY

Bill Simon,Editor/Publisher at 3115 W. Cavedale Dr, Phoenix, AZ. 85027-7637. Phone (602) 581-1748. E-mail: LudlowQrt@aol.com. $ 6.00 per 4 issues US, $8.00 Canada, $12.00 other countries. 15 cents per word for classified advertising. Deadline for issue #7 is September 15th,1996, provided that space is still available. Only subscribers may advertise. We welcome letters to the editor, questions, tips, suggestions, experiences, and articles. Reprints of some past issues of the Ludlow Quarterly are available at $2.50 each.

Copyright © 1996 by William Simon, all rights reserved.

Fall 1996 Issue #7

The LUDLOW Quarterly™

A Newsletter For Ludlow Typograph Operators and Enthusiasts

Basic Ludlow Maintenance

The Ludlow Typograph is probably the least finicky and most bulletproof typecasting machine ever made. I know of people who spent three years getting a Monotype machine to work just once, others who spent three months before they got a single slug out of their Linotype machine, and amateur hobby printers who spent less than three hours getting great slugs from a Ludlow that had been in storage ten years.

I get called frequently by subscribers whose Ludlow machine is "suddenly" not working right. Occasionally the solution is simple, like a heating element burns out, or a fuse blows. Sometimes diagnosing a problem in a machine 2000 miles away is complicated by the fact that it doesn't have a problem, it has several problems - each contributing friction or mis-adjustment to the failure of the machine to put out a decent slug. Most of the problems are purely mechanical, and are a direct result of improper maintenance. Read this as " almost no maintenance." Even a Mercedes requires a little service!

The following article describes what you have to do, occasionally, if you want to head off service problems and consistently produce beautiful slugs.

JUST - DO IT!

Mouthpiece cleaning - Clean the mouthpiece every day if used heavily, and a minimum of every two days if your machine is constantly hot. If you cast infrequently, clean it about every 200 slugs, and as indicated by visual inspection.

First, raise the top of the machine to vertical or beyond. Just push it up! With the machine hot and motor off, release the mouthpiece wiper holder and pull back out of the way. Apply "Lubriclean" across the mouthpiece and down into the slot. Let it sit there and chemically work on the buildup for perhaps two minutes. Wire brush the surface of the mouthpiece, especially perpendicular to the slot, until it is clean and shiny when rubbed dry with a rag. A new or perfect mouthpiece is supposed to be dark brown or black like a blued rifle barrel so never use any sandpaper or metal scrapers on it. Carefully check to see that the "teeth" of the mouthpiece are cleaned of carbon buildup, for air has to escape from the mold through these teeth. Most slots are only .019" wide, so a few thousandths of an inch scale buildup really hinders injection. Use the slot scraper, that thin blade with wavy edges and a curved tip, to clean the slot with vertical motions. Keep the

tip curved and sharp (you can recurve and resharpen it) so the correct cleaning action, that of repeatedly plunging it vertically into the slot, planes any buildup off one side. The curve forces the sharp edge against the wall. Reverse the tool and plane the other side. Do not drag this blade up and out the ends of the slot like a hacksaw or the channel you cut will eventually ruin the mouthpiece. Wipe everything clean and cast 5 or 6 slugs with the blank slug block to purge the slot of excess Lubriclean and save your mats from contamination.

Mouthpiece wiper - Check this when examining or cleaning the mouthpiece. If the edges are hard and shiny, scrape them until they are soft and unfrayed, or replace it.

Oil the machine - Some parts of your machine need oil every day, some parts every month. The oil cups for the main camshaft bearings should be oiled every day. Get to all oil cups and oil holes at least once a week, and trivial parts less often. Give each oil cup a shot of 30 weight oil, use non-detergent if you can find it. DO NOT use Lubriclean to lubricate. There are 14 easily found oil cups under the table top, a fifteenth can be found in the back of the machine on the crucible swivel plate. There are at least 10 oil holes, four on the table top (even though there are over 20 sliding or rotational areas here), four at the crucible hinge pins, and a couple on the delivery slide. Give each a drop or two, but don't stop there. Every week or month put a drop or two where ever parts rotate or slide on each other. Occasionally put a drop into the safety clutch and on the plunger cam lever roll. Parts with larger relative motions or stresses require more frequent oiling, but oil every friction point on the machine at least once in a while. NOTE - Any cup that never needs oil has a blocked line. Do what you need to to get it unblocked, including taking parts off and drilling out oil lines. This is especially true for the crucible cam lever roller which stays pretty hot. Generously oil the main slide and the bottom trim slide every day and put a few drops on the cam rollers. Breaking safety keys is a good indication that you have too much friction in the drive train. Remember that oil doesn't just lubricate, it allows dirt to work out of a joint and decreases wear.

Clean the machine - Bits of metal on slides and cams can wipe out machine adjustments that would normally be rock solid. Blow, wipe, or brush the dirt out. Wipe down the cams where rollers ride and clean out frozen squirts. A thin layer of oil almost everywhere on the inside of the machine prevents further metal squirts from sticking. Do not use grease on the cams, as grease will keep dirt and metal flakes from falling off.

Skim off the dross - This is fun and prevents plunger problems. Keep the metal level high, within a half inch of spilling over.

Coolant level - Check this once a

week, keeping it as high as practical. Watch coolant volume coming back to the tank to assure that enough is going through the mold. Feel the thin side of the mold (toward the crucible) once in a while after repeat casts and if it is very hot, clean out the mold or increase coolant volume. There is a screw-in filter submerged in the tank at the outflow that must be kept clean. Drain the tank every few months just to check sediments. The tank bottom should have no significant layer of sediment.

Plunger and well cleaning - Clean the well and plunger about twice a week. If the machine is hot, it is forming oxides in the well whether or not it is producing slugs. First, put the safety shield onto the mouthpiece. It draws heat from the mouthpiece and freezes a plug of metal in it, preventing splashes of metal when manipulating the plunger. The table top should, of course, be vertical or beyond. Pull out the plunger pins with a pliers, raise the lever, attach the handle and remove the plunger. Liberally coat the outside and bottom of the plunger with Lubriclean and let it sit on a board for a few minutes so the chemicals can work while you clean the well. Skim the pot clean and PREHEAT the well cleaning tool by laying it sideways in the crucible until metal no longer freezes to it. DO NOT insert it into the well until it is completely hot.

While waiting for the tool to heat, clean the plunger with a wire brush and rags, the bottom end too, until shiny. Make sure the linking bar moves freely from side to side inside the plunger, using Lubriclean on the joint if necessary. Turn the plunger upside down and tap with the wood block to knock out dross and dirt. Put just under a tablespoon of Lubriclean on the metal above the well and insert the tool through this pool. Rotate the tool slowly side to side, like steering left and right on a bike, down to the bottom and start to clean the well sides by gradually raising the tool as you more rapidly turn it and spin it completely around. Work the tool up the well and out of the metal then skim off the pool of oxide laden Lubriclean. A rag works well for this.

Repeat cleaning until the tool spins easily. Lay the plunger on the metal until hot before you re-insert it. The specification for "clean" is that when re-inserted, the plunger must float up, not stick down in the well at all. If it sticks down even a little bit, go back and clean the well better. Cleaning the well may have forced bits of oxides or Lubriclean into the throat, so cast a number of blank slugs until they cast cleanly.

Every six months - Remove the mold, fill with cider vinegar, and let it stand overnight. This dissolves rust and oxidized oil. Drain it out, rinse, and reinstall. Clean the metal bits from under the mold.

Once a year - All the above plus remove the mouthpiece (hot), impacting the screws once with a flat ended straight punch and light hammer before turning them out or

they will break off. Clean the bottom of the mouthpiece for better heat transfer. Scrape out the throat with appropriate scrapers. Re-install the mouthpiece with brand new screws. Constant heat greatly weakens older screws and makes them very brittle, causing them to break off at inconvenient times. **NOTE** - mark the mouthpiece so you do not reverse it when re-installing.

95% - Do most of the above maintenance chores and 95 % of the repair problems on Ludlows can be avoided. Done regularly they don't even take very long because you get better at it and there is less to do.

That's All, Good Luck!



Deal of the Decade!

The following is a list of duplicate Ludlow fonts that the Editor, striving to preserve Ludlow equipment, has collected over the years. Some are very common, some are quite rare. They are all for sale, at very reasonable prices, or for trade for fonts still needed in particular series. Not listed are many incomplete fonts that can be used as sorts to fill out your short fonts. If you are interested in anything listed, or need a different font, please contact Bill Simon, who is very easy to deal with. Phone (602)581-1748, Fax (602)587-1603, or write to the LUDLOW Quarterly.

Bodoni Bold	12-14-18-24-36
Bodoni Light Italic	36
Bodoni Modern Italic	18-24-36
Bodoni Truface Italic	24
Caslon Bold Condensed	30
Caslon Light	6-36
Caslon Light Italic	18-24-30-36-42-48
Century Expanded	24-30
Cheltenham Bold	12-24-30
Cheltenham Oldstyle	36
Condensed Gothic	6-10-14-18-36-48
Cond. Gothic Outline	36
Coronet	18
Coronet Bold	30-36
Delphian Open Title	18-24-36-48-60
Eden Light	10-48
Eusebius Light	12-14
Eusebius Light Italic	12-14
Eusebius Open	18-24-36
Florentine Cursive	18
Formal Script	18
Franklin Gothic	42-72
Franklin Gothic Ext. Condensed	24-48
Garamond	14-18-24-30-36-42-48
Garamond Bold	24
Garamond Italic	14-18-24-30-36-42-48
Hauser Script	24-36
Helvetica Medium	18-24-30
Karnak Black Condensed	24
L. P. Gothic Heavy	6 (#4)
L. P. Gothic Light	12 (#1-#2-#4)
Mayfair Cursive	14
Medium Cond. Gothic	24-36-42-48-60-72
MICR #'s	10
Number 11 Bold	12-14
Number 11 Light	10
Number 11 Light Italic	36
Old English	14
Old English	36
Parkway Script	18
Radiant Bold Cond.	14
Radiant Bold Ext. Cond.	24-30-36-42-48
Radiant Heavy	36-42-48
Record Gothic	6-8-10-12-14
Record Goth. Bold Ext.	18
Rec. Goth. Bld Med. Ext	30
Record Gothic Cond.	12
Rec. Gothic Ext. Cond.	12-14-18
Stellar	18-4-36
Stellar Bold	14-18-24-30-36
Stellar Bold Italic	18-24
Tempo Alternate Medium	8-10-12-14-18
Tempo Bold	18-24-36-48
Tempo Bold Italic	36-48
Tempo Heavy Condened	48-60
Tempo Light	30-36-48-72
Tempo Medium	24
Tempo Medium Condensed	60-72
True Cut Caslon	18-24-30-36-48-60-72
True Cut Caslon Italic	18-24-30-36-48
Ultra Modern Bold	18-24-36-48-60-72
Umbra	24-36-48-72

Store Fonts, rule-font mats, leaders, rules, fractions, etc.
Sets of Spaces, 7/8" - 1 1/4" in regular or high-space
Many partial fonts for sorts to fill out short fonts
Also for sale - Self-centering stick

LudlowQrt@aol.com

This is the e-mail address for the Ludlow Quarterly. Use it to use it to submit articles, suggestions, questions, and tips!

WHAT"S NEW!

Congratulations and Best Wishes to Fritz Klinke of Silverton, Colorado. Mr. Klinke recently purchased the NA Graphics Company and has moved the operation from Ohio to Silverton. Now the largest letterpress supply business in the United States, it will continue to be a great source for Morgan expansion trucks, Vandercook press parts and supplies, ATF type, Photopolymer supplies, furniture, composing sticks and generally anything associated with the letterpress industry. The company is the category killer of letterpress supplies. The new address is NA Graphics, Box 486, Silverton CO. 81433. Phone is (970) 3887-0212, Fax (970)387-0127.

Travel News

The **Pioneer Arizona Living History Museum**, a few miles north of Phoenix, has added many new exhibits in their 1840-1912 era print shop, which houses a working Washington press. Call (602) 993-0212 for information.

P•I•P•E Donations

We would like to thank the following subscriber who have contributed this to the **Postage-Ink-Paper-Equipment** fund this recent quarter: Ms. Katie Mulry of Pelican Stamp and Engraving, El Cajon, CA.,- Ray Ballash, Cerritos, CA., and Dave Seat, Dave Seat Hot metal Services, Mt. Juliet, TN.

FREE Matrix ID!

For those subscribers who do not have the new generation Ludlow mat gauge, which uses the lines on the back of the mats to identify the font and point size, we provide free ID service. Just send one mat of each font you want identified to the LUDLOW Quarterly address, with sufficient postage for return.The sample can be any letter, even a period. Think thin and light and you might even be able to tape them onto a letter!

Classified Ads

Still only 15 cents per word. You must subscribe to advertise. Deadline for the Winter issue is December 15th.

Free

To preserve letterpress equipment, ads offering free items will be run without charge.

Wanted

Wanted: Two oak type cabinets wanted, one single-wide, one double-wide, for use in print shop. Must be in restorable condition, priced reasonably, and in the Southwest. I am also interested in foundry type. Don Walker, 4979 C.R. 250, Durango, CO 81301. Phone (970) 247-1713.

Wanted: A museum needs any information about, and especially any table parts, for an antique, cast iron pedestal, leather belt driven lead saw. It is a Miller (Pittsburg), model U5711, manufactured about 1909. Please contact the Ludlow Quarterly.

For Sale: Largest selection of Ludlow fonts in North America. Over 10,000 total fonts - over 1500 different. For complete list phone, fax or write DON BLACK, 120 Midwest Road, Unit 5, Scarborough, Ont. Canada M1P 3B2. Phone 416-751-5944, Fax 416-751-5413. Also have a large list of special sale fonts $30.00 each. Have all related supplies for Ludlow, also thousands of Lino fonts and accessories.

For Sale: Ludlow mats. 14 pt.Tempo Bold (fine cond.) $100.00, 8 pt. Times New Roman (excellent cond.) $150.00, 10 pt. Times New Roman (excellent cond.) $150.00. Plus reasonable UPS charges. Regis Graden, 416 N. Maclay Ave., San Fernando, CA 91340.

Subscribe to **THE PRINTER**, the only monthly publication for letterpress printers, a must for equipment wants and sales. For information: **THE PRINTER**, 337 Wilson Sreet, Findlay, Ohio. Phone (419)422-4958, fax(419) 423-2472.

For Sale: Ludlow model L, gas or propane, new motor belt and mouthpiece.Stored in temperature controlled building. Clean, ready to run, $1500.00. Also a model M Gas, a model M electric, and a model L gas machine. An assortment of fonts and handset type, call for prices and styles. Phone (210) 650-5473, ask for Rick. (TX)

Trade Services

LUDLOW REPAIRS and Machine Rebuilding in your shop. Service tours throughout the country. Expert composing stick and mold repairs. Jim Parrish, author of "The Ludlow Trouble Shooting Guide" Write Jim Parrish, P.O. Box 230, Brinkley, AR 72021-0230, or call (501) 734-4035.

DAVE SEAT - HOT METAL SERVICES The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382. E-Mail:70254.1575@compuserve.com. WWW page at: http://machinerynet.com/printersmarketplace/hotmetalservices.

LUDLOW - LINOTYPE - INTERTYPE Repairs and rebuilding. P.J. Burns, Mercersburg, PA. (717) 328-3092.

MARLBORO MATS INC. has served hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to: Marlboro Mats, P.O. Box 188, Coolin, ID 83821.

THE LUDLOW QUARTERLY

Bill Simon,Editor/Publisher at 3115 W. Cavedale Dr, Phoenix, AZ. 85027-7637. Phone (602) 581-1748. E-mail: LudlowQrt@aol.com. $ 6.00 per 4 issues US, $8.00 Canada, $12.00 other countries. 15 cents per word for classified advertising. Deadline for issue #8 is December 1st, 1996, provided that space is still available. Only subscribers may advertise. We welcome letters to the Editor, questions, tips, suggestions, experiences, and articles. Reprints of some past issues of the Ludlow Quarterly are available at $2.50 each.

Copyright © 1996 by William Simon, all rights reserved.

Winter 1996 Issue #8

The LUDLOW Quarterly™

A Newsletter For Ludlow Typograph Operators and Enthusiasts

Final Edition

This is last issue of the LUDLOW Quarterly. After two years producing this newsletter, I regretfully find I have developed too many other pressing demands on my time and energy and must devote all my attention to those activities.

Many subscribers may not know my profession is that of piano rebuilding and piano tuning. My enthusiasm for Ludlow typography remains undiminished, and complements a hobby of letterpress printing. This newsletter has ended, but the enthusiasm continues and, as in the past, I will continue to assist in any way I can those who are interested in or working with the Ludlow typograph.

I sincerely thank all subscribers for their support and the many very nice people who helped with technical advice and equipment. I especially thank Jim Parrish, Ludlow service technician and author of "The Ludlow Troubleshooting Guide" and many other Ludlow publications. Without his help and encouragement the newsletter would not have been possible.

If your subscription to the LUDLOW Quarterly does not end with this issue, enclosed you will find a check for the balance of your subscription. Advertisers will also find refund checks for their prepaid advertising. If there is an error in your refund, please contact me and I will make it right.

I hope you found issues of the newsletter to contain useful information, and that it was a help in your use of the Ludlow.

Thank you,

Bill Simon

DE-PARTING LUDLOWS

Most things, for good reasons, eventually get scrapped. You could crush every single Chevrolet made after 1960 and improve our society, but we suffer a loss when a Ludlow machine goes. There are only a limited number of these great machines left.

Let's suppose you scrap a Ludlow. Perhaps you had an idiot move it, it fell off the truck, the frame cracked, the top broke off, and it is now dead. Scrap prices will generally return less than $25.00, but before you have the idiot haul it away, there are parts that can be saved that may save you hundreds of dollars and days of time when repairs are needed on another machine.

Here are some items you should try to save when scrapping a machine, listed under three levels of increasing salvaging effort.

Level 1 - The quick, easy and obvious. The mold, its screws, and the close water connections. The bottom trim knife, every fuse in the box, plunger, motor belt, pump belt, safety key cap. The better the condition of the mouthpiece, the more important that you try to save it. If the machine will melt out, take the mouthpiece and plunger, then disconnect power and quickly pull the crucible heaters and sensing bulb.

Level 2 - More work, but generally worth doing because some of these parts can be real expensive to buy. You should already have the level one parts. If the machine won't melt-out, use a torch on the typemetal (it takes a while) and crucible around the mouthpiece, which must be removed hot. Avoid directing the torch flame onto the mouthpiece, pot elements, or temperature sensing bulb stem. Severe damage can result to the parts you want to save. Get the motor and pulley, crucible cam roller assembly, heater solenoid, the entire rheostat control box for the throat and mouthpiece heaters. It is fragile, so handle gently and preserve the wires to the panel box. Get the on-off switch, mouthpiece and throat heaters, water pump, mouthpiece wiper assembly, delivery slide assembly, ejector blade, thermostat assembly, table latch operating stud, stick stop, wood handle, plunger cam lever roller and stud, and every spring you can find.

Level 3 - "Go for it, you never know! "Level 1 and 2 parts and virtually everything you can remove that you could ever conceivably use. The entire crucible assembly, entire electrical box, clutch mechanism, table parts, screws, rollers, cam followers, etc. From oil caps to screws. Safety guards. Most of these parts you will never use.

Generally not worth saving, - the water tank, guards, gears, the main camshaft, table top and most table parts.

A Case for Speed

Gathering mats works much better if the case dividers don't get in the way. In standard wooden cases just line each section with 6 point leads or reglet, so that the height of the mats match the dividers. On the lowest row of sections, try 24 point material so mats are even with the frame. Then add 24 or 36 point quad blocks behind the mats to provide a big landing area on which to tap the pack. Everyone should have one of these speed cases, holding the body text of the day.

Operating Tip

Put some sort of rug or rubber mat in the area of mat setting. Matrices inevitably will be dropped, and if they hit a concrete floor the corners get dinged up, which causes hairlines.

Merle Langley, of **Marlboro Mats**, travels all over the country buying mats and whole shops. He recently discovered someLudlow Company literature about training Ludlow operators and sent it in. Excerpts from the article follow.

From **"Ludlow Training Program"**

"A good rule for a Ludlow production craftsman is a slug a minute. The operator should be able to determine size and faces, gather mats, proofread, and cast within one minute."

"Place a cabinet on each side of your Ludlow. Reduce walking time to increase production. No one can produce while walking, distance increases errors."

"Make the Ludlow area well lighted and equipped with all necessary apparatus to complete any job handled. An operator should never have to leave the area to perform any work."

"Proofread and correct as type and slug are set and cast. Read mats as gathered, placed into the stick, and redistributed."

"Assemble slugs as you cast, setting lines exactly as they appear on the copy. The finished job should be complete and ready to proof."

(Editors note - Gee, Lighten up guys!)

P•I•P•E Donations

Thanks go to Ray Ballash, Cerritos, CA., for contributing to the **Postage-Ink-Paper-Equipment** fund this last quarter.

Deal of the Decade continues

The **GREAT FONT CLEARANCE** continues a bit longer as there are still some fonts left. Notice there are no prices listed. Make an offer! Fax a list of your spare fonts and perhaps we can make a trade, for I am seeking many fonts to fill in incomplete series. If you are interested please contact Bill Simon, (602)581-1748, Fax (602)587-1603.

LUDLOW MATS FOR SALE OR TRADE

Bodoni Bold	14-24-24-36-48
Bodoni Light Italic	36
Bodoni Truface It.	24
Caslon Bold Cond.	30
Caslon Light Italic	18-24-30-36-42-48
Caslon , True Cut	36-60-72
Century Bold Italic	48-48
Century Expanded	24-30
Cheltenham Bold	24-30
Cheltenham Oldstyle	36
Cond. Gothic	6-10-14-18-36-36-48
Coronet	14-18-24-30-48-72
Coronet Bold	24-30-36-48
Eden Light	10-48
Eusebius Bold	8-18
Eusebius Bold Italic	14
Eusebius Light (Jensen)	14
Formal Script	18
FranklinGothExtCond.	24
Garamond	30-48
Garamond Italic	30-36-48
Gothic Cond. Reverse	36
Karnac Black Cond.	24
Karnac Light	24-30-36-42-72
Karnac Medium	42
L.P. Gothic Heavy	6 (2-3-4) 12 (1-2-3-4)
L.P. Goth. Heavy Sorts	6 (1-4) 12 (4)
L.P. Gothic Light	6 (1-2) 12 (1-2-3-4)
L.P. Gothic Light Sorts	12 (2-3)
Mayfair Cursive	14-24-36
Med Cond. Gothic	24-36-36-42-48-48-48-60-72
#11 Bold (Goudy)	10-12-14-24
#11 Bold Italic	48
#11 Light Italic	36
Ornaments	
Radiant Bold Cond.	14
Radiant Bold ExtCond	24-30-36-42-48
Radiant Heavy	36-42-48
Record Gothic	6-8-10-12-14
Record Goth Bold Ext.	18
RecordGothBldMedExt	30
Record Gothic Cond.	12
RecordGothExtCond.	12-12-14-14
Rules	various
Stellar Bold	30
Store Fonts	various
Tempo Black	48
Tempo Black Cond.	72
Tempo Bold	14-36-48-48-48
Tempo Bold Cond.	14-24-24
Tempo Bold Italic	36
Tempo Heavy Cond.	18-30-48-48-48-60
Tempo Heavy Italic	36
Tempo Light	30-36-48-72
Tempo Medium	24-48
Ultra Modern Bold	18-24-36-48-60-72
Umbra	24-24-36-36-48-48-72-72
Underwood Bold	12
Vertical Rules Sets	

Classified Ads

Wanted: Single and double oak type cabinets. Restorable, reasonably priced, in the Southwest. Looking for foundry type. Don Walker, 4979 C.R. 250, Durango, CO 81301. Phone (970) 247-1713.

For Sale: Largest selection of Ludlow fonts in North America. Over 10,000 total fonts - over 1500 different. Also have a large list of special sale fonts $30.00 each. Have all related supplies for Ludlow, also thousands of Lino fonts and accessories. For complete list phone, fax or write DON BLACK, 120 Midwest Road, Unit 5, Scarborough, Ont. Canada M1P 3B2. Phone 416-751-5944, Fax 416-751-5413.

For Sale: Ludlow mats. 14 pt.Tempo Bold (fine cond.) $100.00, 8 pt. Times New Roman (excellent cond.) $150.00, 10 pt. Times New Roman (excellent cond.) $150.00. Plus reasonable UPS charges. Regis Graden, 416 N. Maclay Ave., San Fernando, CA 91340.

Subscribe to **THE PRINTER**, the only monthly publication for letterpress printers, a must for equipment wants and sales. For information: **THE PRINTER**, 337 Wilson Sreet, Findlay, Ohio. Phone (419)422-4958, fax(419) 423-2472.

Trade Services

LUDLOW REPAIRS and Machine Rebuilding in your shop. Service tours throughout the country. Expert composing stick and mold repairs. Jim Parrish, author of "The Ludlow Trouble Shooting Guide" Write Jim Parrish, P.O. Box 230, Brinkley, AR 72021-0230, or call (501) 734-4035.

DAVE SEAT - HOT METAL SERVICES The USA's most complete source for Ludlow, Linotype, and Intertype parts and supplies. Service and maintenance in 50 states and Canada. Rebuilt Ludlow machines. Large selection of new and used mats. 206 Whitnel Drive, P.O. Box 1160, Mt. Juliet, TN 37122. Phone (800) 542-2508, or 24 hour FAX is (800) 468-6382. E-Mail:70254.1575@compuserve.com. WWW page at: http://machinerynet.com/printersmarketplace/hotmetalservices.

MARLBORO MATS INC. has served hot metal typesetters with mats, supplies, and parts for 65 years! 13,000 fonts of Ludlow, Linotype and Intertype mats in stock. Free lists. Phone (208) 443-2715, Fax (208) 443-3060, or write to: Marlboro Mats, P.O. Box 188, Coolin, ID 83821.

THE LUDLOW QUARTERLY

Was published by Bill Simon, 3115 W. Cavedale Dr, Phoenix, AZ. 85027-7637. (602)581-1748. E-mail: BSimon1234@aol.com. Reprints of some past issues of the Ludlow Quarterly are available at $2.50 each.

Copyright © 1996 by William Simon, all rights reserved.