

# Blankmould Flushpin Gauge

## Instructions for use.

Bench:

Preparation.

Ensure bottom of the Blankmould Set is clean & free of damage.

Inspect joint face for damage. Remove any faults.

The Mould should be placed on a surface plate for best results.

Bring both halves of the Mould together. Make sure the faces come together with no gap. Check the seam joint with a feeler Gauge at the top & bottom of the Mould. If the two halves of the mould do not meet investigate why not. It is not possible to Gauge the Dovetail until the faces of the Mould make a good joint.

When the joints are good bring the two halves of the Mould together. Level the top & bottom of the Mould. The inside of the Neckring cut-out faces should be level. If they are not, find out why. The probable cause will be damage to the base of the Mould halves.

Apply a clamp to hold the two halves of the Mould together. When the clamp is applied check the Mould seam joint are together and the top & bottom of the Mould are level.

When the two halves are together on the seam joint & the top of the Mould the Blankmould Flushpin Gauge can be applied.

The Dovetail should be clean.

Depress the Moving Anvil & place the Gauge into the Dovetail at 90° to the Mould Seam.

Gently release the moving Anvil until it makes contact with the Mould Dovetail.

Carefully rock the Gauge until the Moving Anvil has moved out to its full extent.

The end of the moving Anvil should be between the step on the end of the Flushpin Gauge. If the Anvil end is inside the Gauge body, the Dovetail is undersize. If the Dovetail appears to be undersize it is possible the Mould is not level at the top & bottom faces. Check the faces are level & re-check the Dovetail with the Blankmould Dovetail Gauge. If the Anvil end is still inside the Gauge body the Dovetail is undersize.

If the Anvil end protrudes out from the Gauge body step the Dovetail is oversize. If the Dovetail appears to be oversize investigate whether the Mould seam faces are together. If the Two halves of the Mould are not together the Dovetail will appear to be oversize.

A Golden rule is, if the Gauge informs you that the Mould Dovetail is wrong, firstly make sure the Mould faces are in good condition & fit to be Gauged before recommending re-work on the mould.