Rúleform Composition the economical *Ludlow way*

The Ludlow Ruleform System is a unique method of casting quality rule forms in easy to handle slug form. This system does away with the old-fashioned method of cutting and fitting brass or steel rule, and the patented slug-aligning matrix described below permits much more accurate alignment of the vertical rules than other systems.





rufe mattin in affith

Line of rundaries matrices in Lodier loose-side matrix shick, ready for casting

The slug-aligning matrix

The key to the Ludiew Ruledom Bystem is the patenteel sug-eigning martir. As shown above, this matrix casts a longue projection on the upper side of the slag head and a corresponding recess on the lower side of the slag all below the printing surface. This interlock accurrately aligns the vertical rules and holds the form together as a single sold metal block rather than a group of hose shage.

Intersecting ruleform matrices

Ludlow intersecting ruleform matrices are unique in that they cast the vertical and horizontal rules as a single piece on the slug. Since they are cast as a single piece, the printed Ludlow ruleform will not show breaks where horizontal and vertical rules joh.

These matrices are also unique in construction and manufacture. The conventional one-side construction and the usual methods of manufacture cannot be used, as it is necessary to obtain interactions which will be clear, sharp and accurate. Instead of being driven into the matrix body. In relifs can's call and the matrix body when the the matrix body have the private starts body mitted recess in the matrix body and matel by ministrate mixes. All this work is carefully impacted by microscopes and special micrometers to ensure maximum precision.

ADVANTAGES OF LUDLOW RULEFORM

All-slug make-up

The recognized advantages of all-skg maker-up are evident in very value of areting end handing Ludges Referent Composition. The all-slag form, locked together by the slag-langing matrices, is easy to handle and requires nether painstaking tie-up nor expectivity careful treatment in composing roum of press room. Once proofread and corrected, a Ludgeweid ruletorm strays correct. There is no risk of transposition of telese or flipsna, nor of points or characters at the edds do times failting of the edited down.

Unlimited material

With Ludiow ruleform and typeface matrices at hand and with metal in the crucible, the Ludiow compositor will never run short of cules. He can set as many forms as necessary without hunting for missing type or rules.

Multiple forms

The repeat casting feature of the Ludiow makes it easy to produce any number of slugs from a single line set in Ludiow Ruleform matrices. When the preise bed permits printing a form 2,4,5,16 or more up, the form can be cast easily in multiple, radically reducing costs in both the composing room and the press room. Many printers have discovered that the cost of casting duplicate forms on the Ludlow is generally less expensive than making electrotypes and also avoids delay in getting the forms to the press.

Standing Forms

Since reprints are usually ordered, it is in the printer's interest to keep ruleforms standing; but with single type and rule methods a standing form deprives the composing room of type and rules for other jobs. With the Ladlow Ruleforms standing, however, the printer will have only metal lide up and the composing room will not be affected by any lack of material.

Changes indicated on a reprint order may be expensive and cause delay if the standing form to be changed is an electrotype, but with Ludlow-set referoms changes can easily be set and new slags inserted in the form with a minimum of delay and excense.

Reduced make-ready

With both type and rules on brand new slugines produced on the same machine, and all lines exceedingly accurate in height-to-paper, make-ready time is reduced to the minimum.

Employing all-slug forms, it is impossible for letter characters, rules, spaces or quads to work up while the job is running and this also saves time in the press-room.

SETTING A LUDLOW RULEFORM

A made-up ruleform, produced in its entirety on the Ludlow, is illustrated at right: first with the stug lines separated to show just how it is made up, and second closed up in assembled form, reach to print.

As will be apparent from the illustration of the separate slugs, the ruleform is made up of four kinds of elements. Beginning with the top line of the ruleform (bottom of the illustration), these are:

 A rule-slug produced by inserting a Ludiow rule block in the Ludiow matrix stick and casting a slug.

2 Blank stugs cast on the Ludow machine, with a blank stug block used instead of a line of matrices. These are used as spacing material between ruledom and type stugs, and are of exact height to support overhunging portions of the vertical rule-sections. The Ludow caster may be set to repeat-cast these blank alags sutomatically.



Top portion of a rulehorm, opened up to show the individual stag

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Ramo alogs closed up, by assaudiled forms rapidly to print

3 horizontal and vertical rule-sections cast from lines of Ludiow matrices set separately in the same matrix stock, with the words located in the line as required by copy.

The blank portions of these slugs also are of exact height to support the overhanging portions of the vertical rule-sections when the form is assembled.

4 Ruleform skigs. These slugs are cast from lines consisting of intersecting rule matrices, horizontal rule matrices, and a slug-aligning matrix. The intersecting rule matrices alone would make a line looking like this:

The horizontal rule matrices, in a wide variety of widths to meet all requirements, alone would make a line printing thus:

A slugine cast from these intersecting rule matrices and horizontal rule matrices assembled together in the Ludiow matrix stick prints thus:

In place of a regular horizontal rule matrix, a special Ladow slag-aligning rule matrix is placed in the line next to one of the vertical intersecting rule matrices. On the printing wrates of the skag, one section of the horizontal rule is format from this alig-aligning matrix, which also forms the interlaced in the head of the slag. of the second rule intersection from the right end of the rule/orm slags.

ACME SERVICE STATION

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Dotted Ruleform

To meet the many special requirements of ruleforms, dotted ruleform matrices manufactured to the same precision as the other ruleform matrices are also available. Ludiow dotted ruleforms are set and made up in exactly the same manner as standard ruleform matrices. A sample Ludiow ruleform of dotted horizontal and 1-cont varrical rule is flatartand before.

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ECONOMY AND QUALITY

Efficient and economical composition of ruleforms of high quality is only one of the many advantages alforded the commercial printer by the Ludiow system of hand-set slag-cast composition. The simplicity and ease of the Ludiow system. It is speed in production and the quality and variety of the forms produced have set new standards for this kind of composition.

Many small shops throughout the world have built a portitable buisses specializing in relations and, in handing such work, depend entirely, on the Ludlow for their composition. Other Ludlow equipped plants with typefacematrix equipment have found that the addition of Ludlow relation mantices provides another say to meet the requirements of job, display and utilizen composition in great variety of high usaint a low cost.

Ludlow Ruleform Matrices

Horizontal Rule Matrices

Platine One-point { Nade up in sets of rule matrices of different set widths from 2 points to 21 picas, inclusive

1					22.90.	2-6 pt.	Histainfal Face	Vartical Face	Ossignation
	Ţ	Ţ	1	Ļ	÷	+	Hairline	Hairline	RF 11-21
1	1	1	1	ļ	ł	Ŧ	Hairline	Double Hairline (2 point while spend)	RF 12-21
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1	1	1	1	1	4	+	Hairline	Double Half-point	RF 14-21
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1	1	1	Ι	1	1-			One-point	RF 07-01

Ludlow Dotted Ruleform Matrices

Horizontal Dotted Rule Matrices

Made up in sets of dotted rule matrices of different set widths from 2 point to 18 point, inclusive

Intersection Dotted Rule Matrices

12 pt. 14 pt. 16 pt. 18 pt. 20 pt. 22 pt. 24 pt.	Harizontal Face	Vertical Face	Ossignation
111144	Dotted	Haidine	RF 331-21
	Dotted	Double Hairline (2 point white special	RF 332-21
111111	Dotted	Half-point	RF 333-21
IIIIIII.	Dotted	Double Half-point	RF 334A-21
	Dotted	Double Half-point (2 point shife speed	RF 334-21
111111	Dotted	Ore-point	RF 337-21
1111111	Dotted .	Datted	RF 3333-21
	and in		1
cal Dotted Rule Matrices	6.6		
Standard Sizes	249.50		1.1
12 pt. 14 pt. 16 pt. 18 pt. 20 pt. 22 pt. 24 pt.	1000	Vertical Face	Everynation
TIPPE	100	Datted	RF 033-01
and the second	1000		

Slug-Aligning Dotted Rule Matrices

__ Detted Black Searce SA 00.00

SA 330-91

Standard Point Sizes: 12, 14, 16, 18, 20, 22 and 24 point.

LUDLOW TYPOGRAPH COMPANY

2032 Clybourn Avenue, Chicago, Illinois 60614