

X-PP2FO1

COPY

PATHE NEWS.

Extract from letter from the Royal Mint,
London, E.C. 3.

"The Deputy Master of the Mint is therefore prepared to grant facilities for the filming to be carried out, subject to your agreement to the following conditions :

1. That the use of the material taken as a result of the granting of this facility must be restricted to the production in question, and that any further use of the material contemplated must be made the subject of a further application to the Royal Mint.
2. That the Company at its own expense must provide the Royal Mint with a lavender print of all the material taken thus.
3. That the right to use the said print for all official purposes be reserved to H.M. Government,
4. That there must be no interruption to production in the Royal Mint.

For Mr. H. Wynder.

Edwards
covered
Kota
25/2/57

57/24

~~ROYAL MINT~~

ROYAL
MINT

COINAGE OF GOLD

Melting

The melting of the gold alloy is done in gas-fired furnaces; the charge, consisting of fine gold, process scrap and copper, in the correct proportions to give a resulting assay of 916.6 parts per 1,000 (or 22 carats) being placed in a graphite crucible holding 2,000 ozs.

The mixture is melted for approximately 70 minutes until a temperature of 1200°C is reached. The crucibles are then lifted from the furnace by means of a hand-operated, overhead tackle, and the molten gold poured into upright iron moulds giving a cast bar 2ft. long and $1\frac{3}{8}$ " x $\frac{5}{8}$ " cross section.

After assaying for correct composition, the bars pass to the Rolling process.

Rolling

The bars are passed through a series of Rolling Mills which gradually reduce their thickness to that required for the coin blanks. The strips (or "fillets") become elongated during the process and require to be cut into convenient lengths for ease of handling.

As fillets pass through the final rolling mill, test blanks are frequently cut from them and weighed to ensure that the thickness is such as will give coins of the correct weight.

Cutting

Finished fillets are passed through Cutting Presses which punch out blanks, two at a time, at a rate of 300 blanks per minute.

The resulting "Scissel", or webbing, is returned for melting down.

Annealing

The cut blanks are softened by annealing in closed tubes at a temperature of 700°C.

Blank Weighing

The blanks are individually weighed on Automatic Balances, being fed down a tube on to the pan, weighed, and ejected down a chute into one of three containers, determined by whether the blank is of correct weight, light or heavy. The process of weighing each blank occupied about 3 seconds.

After weighing, the blanks are counted by draughting on a hand scale.

Striking

Striking is done in a Coining Press, which impresses both obverse and reverse designs simultaneously, and at the same time forms the graining (or "milling") on the edge. This latter is obtained by having ridges inside the "collar" in which the blank is held during striking; the metal being squeezed into these ridges by the pressure of the blow.

Presses strike at a rate of 120 coins per minute, at a pressure of 75 tons per square inch.

Inspection and Bagging

Finished coins are inspected visually, rung and finally counted into bags containing 1,000 sovereigns.

Royal Mint,
February, 1957.

ROY ~~1957~~ 8261

N.B. Sovereigns are struck occasionally just for practise. Minting gold is a special technique, and as the old craftsmen retire, the new boys have to learn it. It makes no difference to the gold reserves - coin is a very convenient way of storing gold anyway.