

# MILIARIUS

THE BOOK

REUGE



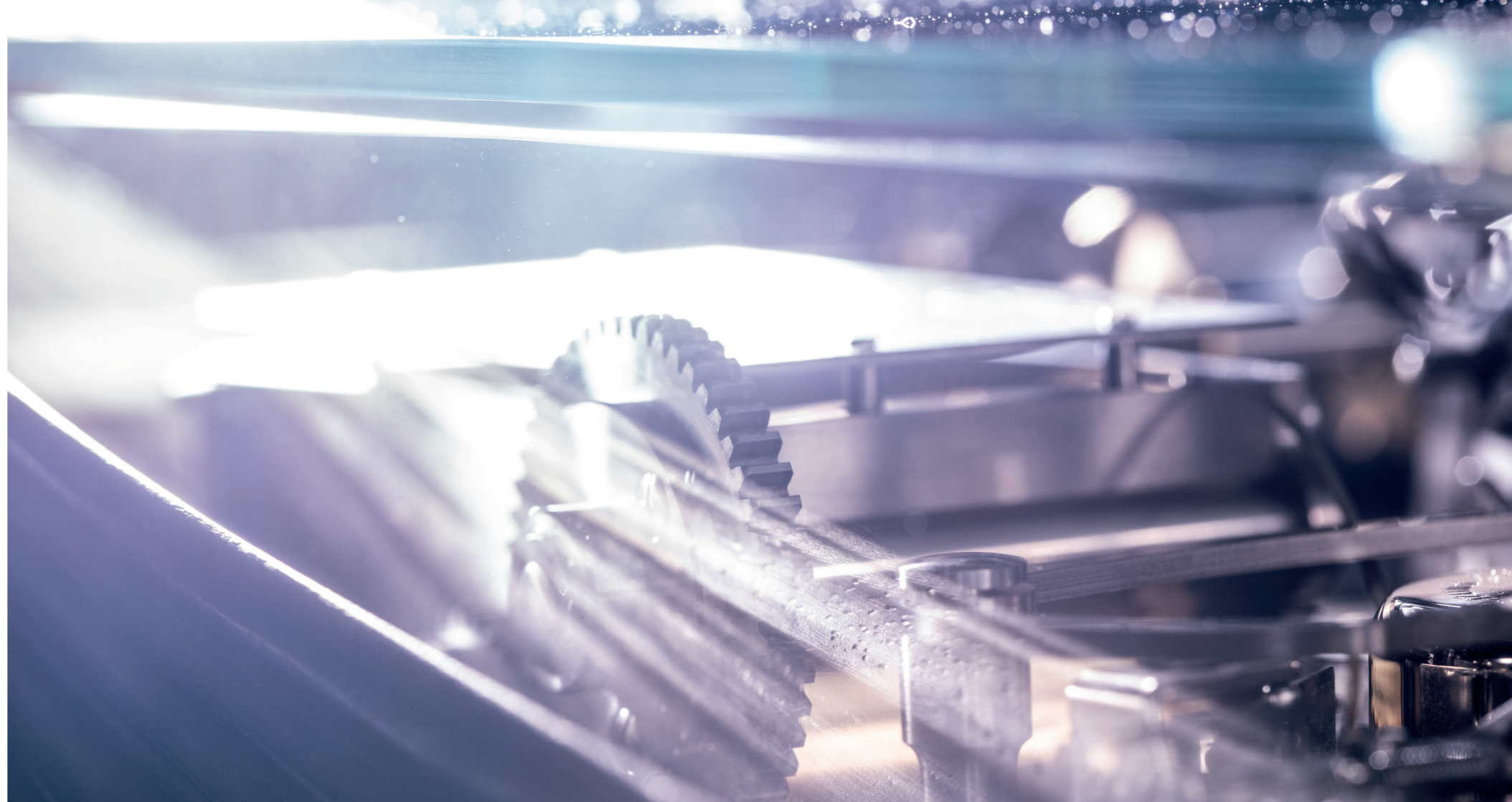




## CREATING MUSIC, MOTION AND EMOTION

Based in Sainte-Croix, Switzerland, with more than 150 years of expertise, REUGE is positioned as the world leading producer of musical automatons, that are technically, acoustically and aesthetically superlative. Forwardthinking and innovation define REUGE just as much as its

respect for traditional craftsmanship. REUGE's ability to transform inanimate metal into emotion continues to enthrall those who seek a genuine piece of craftsmanship, reaching beyond fleeting trends.







# MILIARIUS

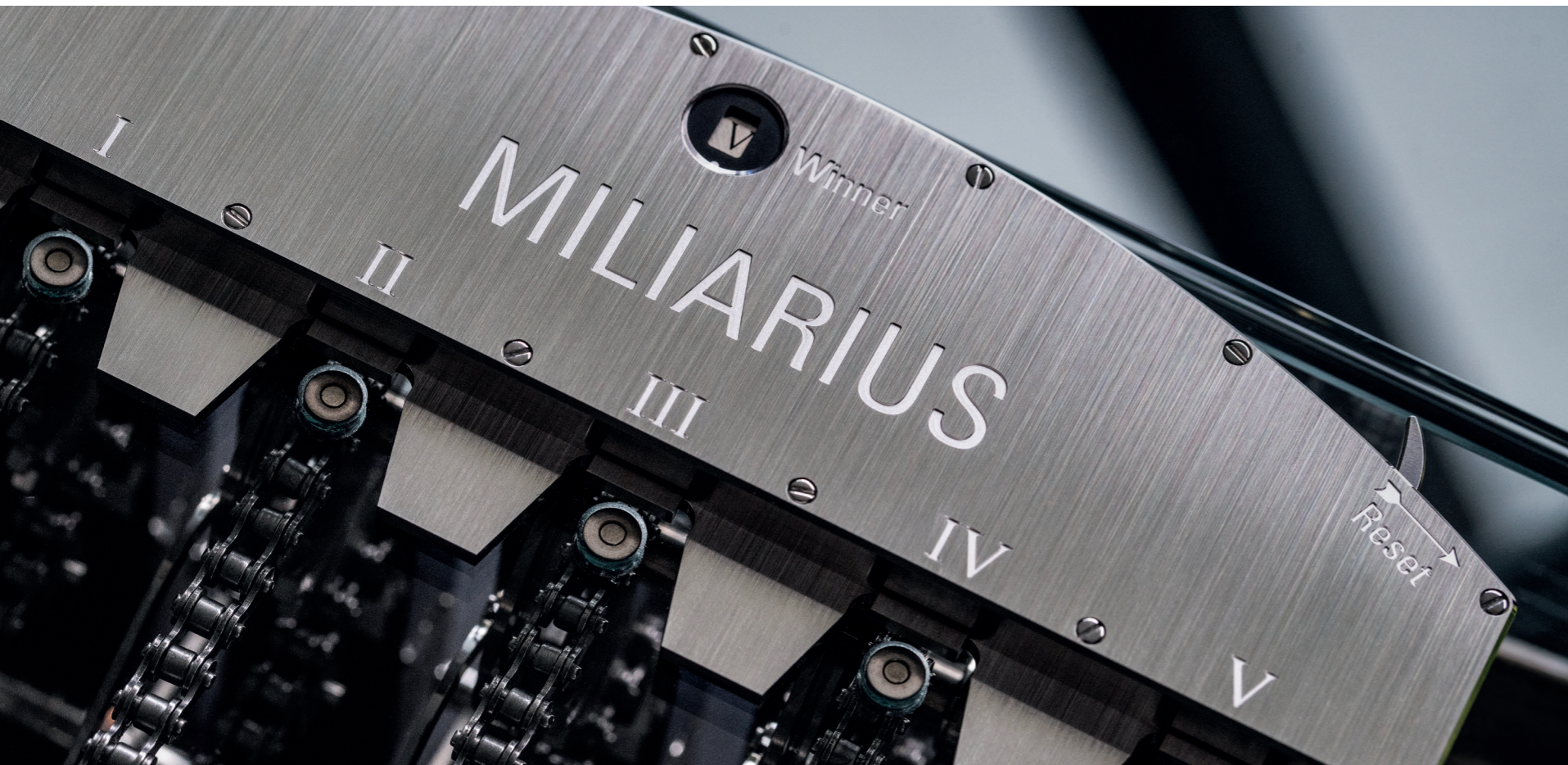
A TRIBUTE TO THE ROMAN EMPIRE

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In the Ancient Roman Empire, legendary chariot races took place in the Circus Maximus Arena applauded by 300,000 spectators including the great emperor Julius Caesar himself. This is where fearless slaves risked their lives in ferocious struggles to seize a victory and gain their freedom. Miliarius was the finest of them all, the charioteer with a thousand victories. He was revered by both the public and the elite for his courage, which inspired REUGE to dedicate his name to a unique mechanical artistry.

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Every single element of the Miliarius, whether technical or decorative, was made entirely by hand by the craftsmen of the REUGE Manufacture in Sainte-Croix with outstanding quality and artisan expertise. Most of the decorative elements involve the process of casting.

« THE MILIARIUS IS UNIQUE »

After designing and conceptualizing, liquid metal is poured into a mould with a hollow cavity of the desired shape. Once it has solidified, the sculptor craftsman carves the last intricate features, right up to the details of the horses' mane or the veins of the foliage on the crown. Finally, the decorative elements are gilded in 18 carat gold and carefully manipulated for a perfect finishing. Hand craftsmanship means that each and every element constituting the Miliarius is unique.



Upon activation of a lever, five chariot fighters pulled by ten horses are set into motion. The race starts and bets are cast among the viewers but no one knows its outcome yet because a different horse wins each time. The mechanism of this automaton took months to conceive and develop within the REUGE atelier of Sainte-Croix.

It encloses more than 2200 components which interact flawlessly together, bringing the automaton to life. The horserace occurs without music so as to enhance the rhythmic sound of a gallop, keeping everyone's eyes on the prize. As the horses breathlessly cross the finish line, the incomparable REUGE musicality rises from the mechanism. The "Victory Parade" melody, used as the

celebratory anthem after all Roman races held in the Circus Maximus Arena, is reproduced with a flair that only REUGE can master.

Miliarius embodies REUGE's creativity and know-how. The automaton brings an epic battle back to life; the music consecrates the scenery. Behind the Brand's mystical quest for an organic sound and a creative motion, lies a desire to transcend an experience.

Music and movement engage senses: when played right, when timed just so, they have the power to take us back in time so that we relive emotions we thought were hidden.







## CHARACTERISTICS

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Roman Chariot Race musical and sound automaton

Limited Edition of 50 pieces

5 chariot fighters, silver

1 victory crown, silver and 18k gold plated finish

2 dolphin winders, silver and 18k gold plated finish

One cylinder playing one melody

More than 2'200 components in the mechanism

In-house movement (SH 3.144) produced and assembled by hand

More than 2'200 pins on the cylinder and 144-note keyboard

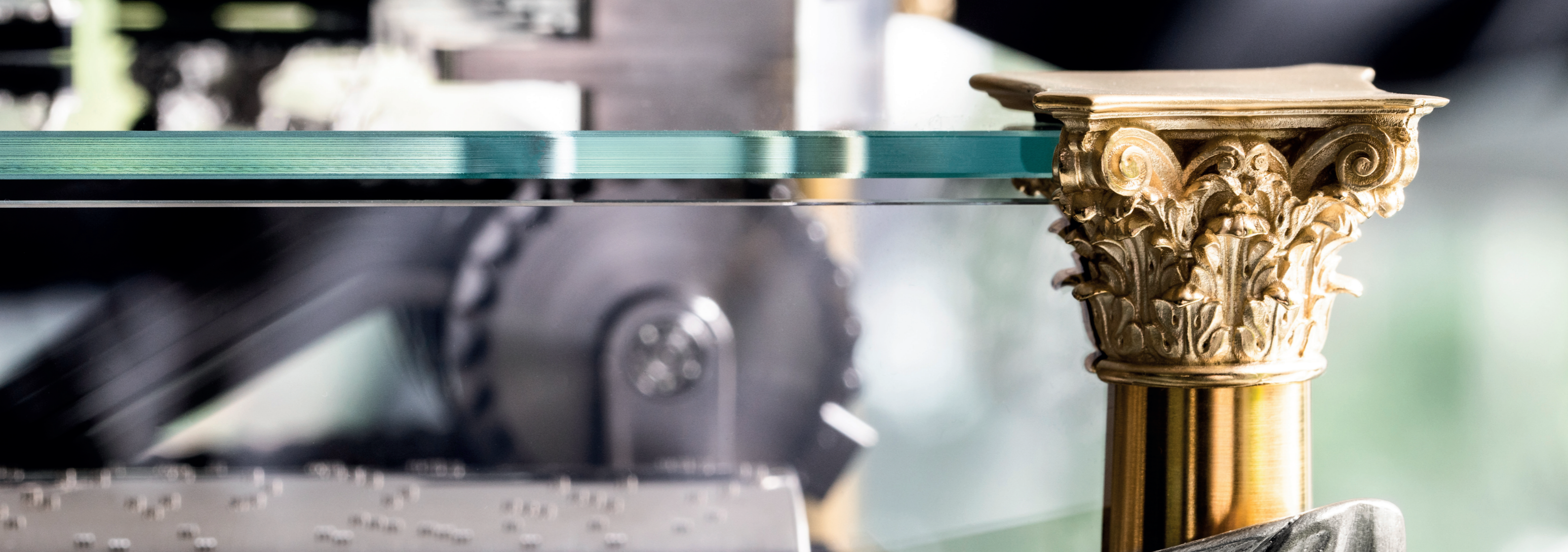
Manual and individual tuning of musical comb, nickel plated finish

About 35 seconds per tune

41 minutes power reserve

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# MANUFACTURING PROCESS



## WOOD AND SCULPTURE DRAPE

It all begins with a drawing traced on a wooden board. Simple and authentic, the artisan's drawing is transformed into a drape approaching its final form. Five elements are selected for work with a carving gouge, an indispensable tool for the artisan who uses it to carve the wood. The resulting wooden molds will be used by the founder to produce the wax molds.

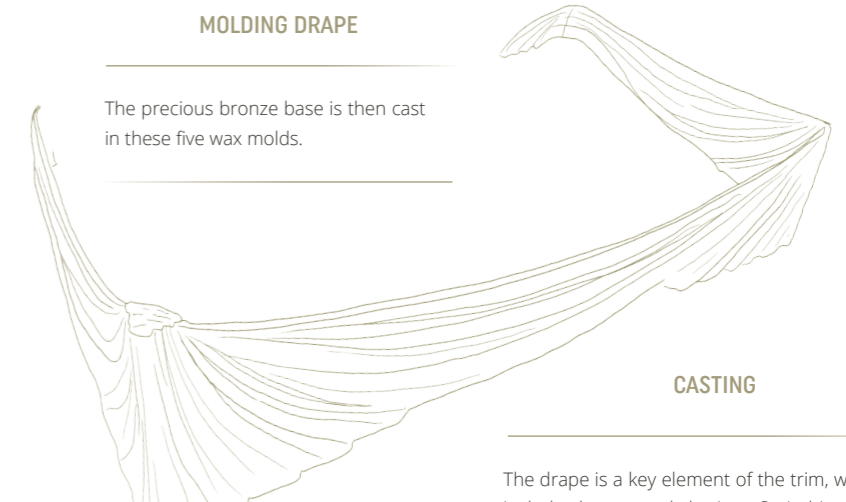


## FOUNDRY DRAPE

The metallurgical industry uses procedures that may be rough, but they are nonetheless carried out meticulously. The more precise the forms of the initial mold, the greater the quality of the finished product. The step in which the bronze fills the wax mold is of utmost importance. The drying process takes 36 to 48 hours so that the piece can be finished under the best possible conditions. Reuge puts painstaking efforts into their wooden and wax molds to eliminate any roughness, allowing the drape to be refined and polished, reducing any defects to the bare minimum. The automaton can then be embellished with its unique, precious trim thanks to the incomparable expertise of our craftsmen.

## MOLDING DRAPE

The precious bronze base is then cast in these five wax molds.



## CASTING

The drape is a key element of the trim, which also includes horses and chariots, Corinthian columns and capitals, dolphin winders, as well as a laurel wreath, the emblem of Miliaris' consecration. Based on a technical drawing and a 3D wax print, Reuge reproduces identical final pieces to assess precision. The setter can thus create his own mechanically produced molds, enabling him to refine them for casting the silver. Once the precious metal has solidified, the characters are delicately polished by the artisan, from the horse's mane, to the veins on the leaves of the wreath, providing contrast and depth. Except for the silver horses, all other components are plated with 18 carat gold.





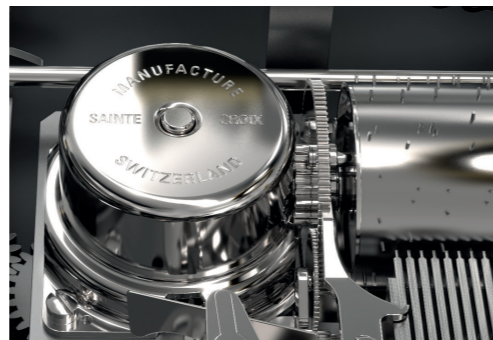
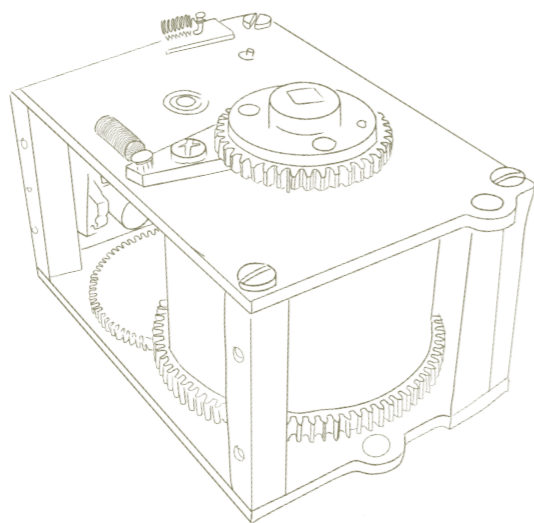
## MUSICAL MOVEMENT AND MECHANISM OF THE AUTOMATON

Milarius stands out with its two manufactured movements. The first activates the chains and gears connected to the automaton's mechanism, which powers the system. This lever raises the barrel like in a watch mechanism. The power reserve takes two full turns. When the handle is turned, the gear activates the chariots, which take off in a frantic race whose results are unpredictable thanks to the ingenious system developed at the Reuge ateliers.

The second movement is the musical automaton and is the heart of the House's know-how. The melody is created by more than 2,200 pins, all carefully positioned along the cylinder. Combined with the 144-note keyboard, the automaton reveals all the originality of its organic sound with the unique emotions that can only be produced by this musical experience.

Special attention has been paid to tuning. In fact, the lead weight placed under the keyboard enables the reproduction of the lowest notes. The walnut sound box is a key component in the musical automaton, reproducing an unequaled sound quality.

A discreet winder button on the front of the case triggers the automaton. Once the chariots have arrived in random order, the prestigious raising of the wreath announces the winner, while playing the victory melody. Precious as gold, Ruthenium covers nearly all the components of the mechanism.



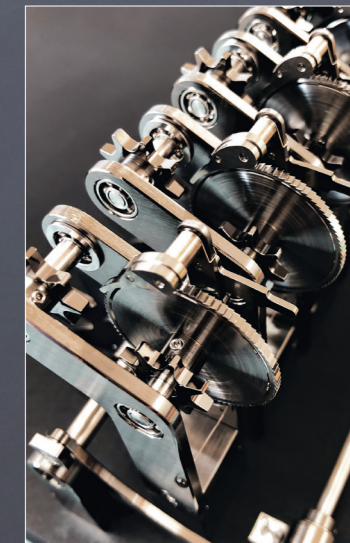
## POLISHING

Polishing is another aspect of the meticulous, indispensable know-how, as it brings out every sublime detail of the product, giving it life and radiance. The polisher-artisans at Reuge spend long hours with their magnifying glasses to bring out the beauty of each piece individually.



## MINIATURE PAINTING

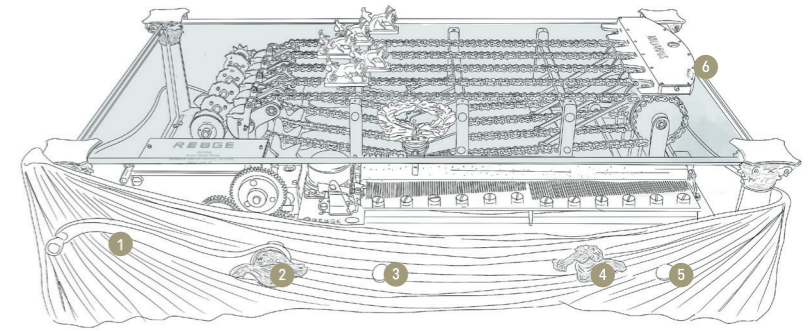
The artisans at Reuge apply their artistic crafts, an ancestral know-how that the House has preserved. This step is divided into four phases. After cleaning the chariots, horses and drivers, the miniaturist uses a process to apply a coating that is resistant to oxidation, water and heat, before undertaking the drying step in a low-temperature kiln, which takes a few hours. The piece is then varnished before the final drying phase, to obtain an inalterable colored finish.



## ASSEMBLY

The artisans at Reuge perform precision assembly work to achieve ultimate excellence. Extensive tests are performed for three days before the final phase, to ensure that each sound resonates harmoniously. It takes another five days to complete the product's assembly.








## HOW TO USE MILIRIUS

1. Winding automaton motor
2. Winding musical movement
3. \* Mechanism selector
4. Reset automaton button
5. Start automaton pusher
6. Reset display button

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Auto  SOUND & MUSIC	On demand  MUSIC ONLY	Mechanism sound only  WITHOUT MUSIC
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**REUGE**

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