H. L. Worden Co. "Make a Lamp" System

C20-10 Spreading Dragonfly T

Rev. 5/10

Cartoon Pattern Packet

Lamp Specifications

No. Glass Pieces: 366
Glass Needed: 7.9 sq. ft.
Diameter: 20″
Height: 8.5″
Aperture: 4″
Design Repeats: 6

Needed to make this lamp

Pattern Packet No. C20-10*
SectionalForm™ No. C20**
Stained Glass
4″ Vase Cap***
Lamp Base or Hanging Hardware to Swag

Additional Items Needed

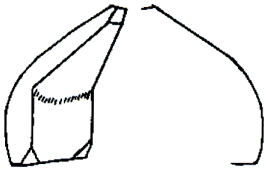
Basic Supplies
Basic Tools

*No. C20-10 Pattern Packet Includes:

1 Paper Pattern (black) Sheet
1 MagicStrip™ (blue) Sheets
1 Instructions
1 Color Key w/Glass Descriptions
6 Sets (24 Wings) Etched Filigree

**No. C20 SectionalForm™

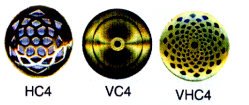
Sectional form embossed and numbered to accept glass placement guides (cartoon)



used to make this 6-repeat design

**** 4″ Vase Cap**

Lamp Color	Key	Description	Glass Type	Sq. Ft.
	UN,LN,UBD	B'gd & Bd.	Amber/Green Opal	6.1
2	W	Wings	Amber, Blue, Purple, Opal	1.5
	B	Head & Body	Dk. Green Opal	.25
	E	Eyes	13mm Jewels	12
			Asst. Round Jewels	36



HC4 VC4 VHC4
Need One 4" (10.2cm) Vase Cap
Sold Separately

Paper Pattern
MagicStrips™
MADE IN USA

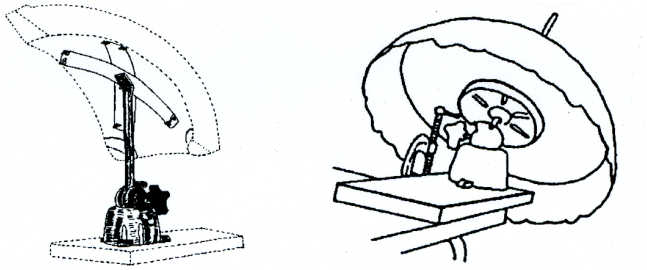
Filigree
MADE IN
TAIWAN

Wings-The wings in this shade are quite large and will not lay flat to the mold. They will protude at the ends of the pieces. Use pins to elevate adjoining pieces to the same level, your pieces will be recessed if you do not elevate them. Place flat headed pins under the glass pieces using additional pins at the edges, to hold the pieces in position until you can tack solder them in position.

Dragonfly Filigree-The wings of the original lamps made by the Tiffany Studios were constructed of flat streaky opal art glass. The filigree was soldered on the outside giving a natural three dimensional look to the dragonflies. Solder is built up to fill the gaps where the wings are above the form. DO NOT cut the small round part on the body end, this represents the wing muscle attached at the top of the Dragonfly body. Tinning and Antiquing- We have found it best to solder the filigree in place after the lamp is completed, cleaned and antiqued. BE SURE AND LEAVE A FLAT SEAM AROUND THE OUTSIDE EDGE OF EACH GLASS PIECE THAT IS TO BE COVERED; SO THE FILIGREE WILL LAY FLAT NEXT TO THE GLASS. Prepare the filigree for antiquing, by tinning it first. To tin: lay it on a flat wooden surface, leave the filigree fastened together, clean by rubbing with steel wool (brass conducts heat; use a heavy glove to hold it in place) brush on a generous amount of flux, use a clean freshly tinned soldering iron set on high heat. Rub the surface with the flat part of the iron tip, use a very small amount of solder, just enough to turn the surface a bright aluminum color, do both sides, rinse and pat dry. Next antique the outside of each filigree part, try not to get the antiquing solution on the edge, rinse and dry, cut apart, and solder it on top of the foil overlap around each glass part, build up a nice rounded seam and carefully antique the edge trying not to stain the glass under the filigree. Use household shears to cut the filigree apart.

Sectional Form Construction Update

New easy time saving techniques that make lamp crafting more fun. To assure that the completed lamp is perfectly round and the form is not melted from solder flow through, follow the steps below. Refer to the manual.
(1) Cover the form with parts - hold with pins.
(2) Pull pins part way out, foil and repin.
(3) Tack solder all parts together.
(4) Flatten the solder tacks out and tin the exposed foil on the outside with a flat seam. - DO NOT FILL OUTSIDE SEAMS ON FORM.
(5) REMOVE the glass sections as they are completed and store.
(6) USE SOLDER LOOPS. The discovery of solder loops to hold the sections until they are fastened together is so easy to do. You can adjust the glass sections by bending the sections slightly if necessary for a perfectly round fit before tack soldering together.
(7) The lamp is now ready to complete. Fill and build all the inside seams, then do the outside. By filling the inside first any solder flow through will be removed when building the outside seams. If you are making several lamps consider using Worden Lamp Positioner to build seams it works great.



WordenSystem™ POSITIONER

Our No. 310 Positioner can be used to position sectional forms as the glass is cut and pinned to the form. It makes designing, building, and soldering your lamp panels much easier.

Use our No. 330 Positioner for working with full forms. The No. 330 is also great for working with partially finished shades whether built on sectional or full forms. Once the vase cap is installed put your lamp on the No. 330 and position the shade to have a level surface for final soldering.