

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

CF18-1 Dragonfly T

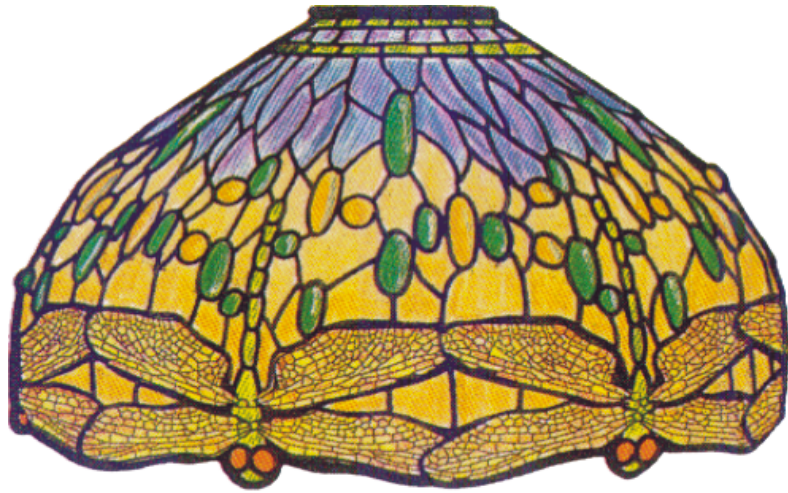
Cartoon Pattern Packet

Lamp Specifications

No. Glass Pieces: 525
Glass Needed: 7.5 sq. ft.
Diameter: 18"
Height: 10"
Aperture: 4"
Design Repeats: 7

Needed to make this lamp

Pattern Packet No. CF18-1*
FullForm™ No. CF18**
Stained Glass
4" Vase Cap***
Lamp Base or Hanging Hardware
to Swag



Additional Items Needed

Basic Supplies
Basic Tools

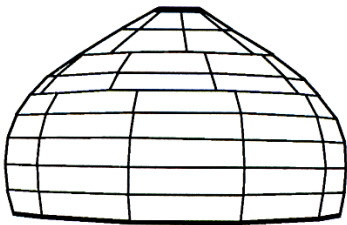
*No. CF18-1 Pattern Packet

Includes:

1 Paper Pattern Sheet
5 MagicStrip™ Sheets
1 Instructions
1 Color Key w/ Glass Descriptions
7 Sets Dragonfly Wings

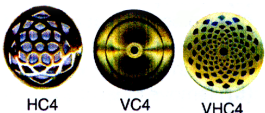
**No. CF18 FullForm™

360° form embossed and
numbered to accept glass








placement guides (cartoon)
One Reusable FullForm™ is used
to make this 7-repeat design

*** 4" Vase Cap



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

Lamp

Color	Key	Description	Glass Type	Sq. Ft.
	U,N	Upper Background	Blue/Purple Opal	2.25
	M,N	Middle Background	Lt. Amber Opal	1.5
	L,N	Lower Background	Dk. Amber Opal	1.5
	W	Wings	Orange Mottle Opal	1.75
	A, R	Borders/Bodies	Green Ripple Opal	5

Paper Pattern
MagicStrips™
MADE IN USA

Wing Filigree
MADE IN TAIWAN

CONSTRUCTION TIPS

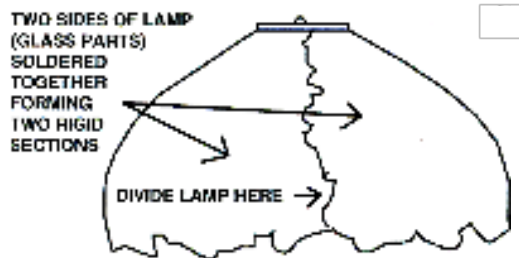
This pattern has been designed for American (Tiffany style) jewels or German jewels (sold by H. L. Worden Co). There are 2 cutting lines on the paper pattern. If using American jewels follow the solid line when cutting the pattern and glass. If using German jewels follow the dotted line when cutting the pattern and glass.

FULL FORM CONSTRUCTION TIPS

Follow the Basic Method detailed in the WordenSystem™ Instruction Manual.

- (1) Select, cut, trim, and pin all stained glass pieces over the MagicStrip™ cartoon on the form. COMPLETELY COVER THE FORM. Use glass headed pins or common pins. Be sure to push the pins all the way in to hold each glass piece securely.
- (2) To ensure the vase cap will be level: If using a positioner; place vase cap at the top of the form; secure with a lock nut; cut and fit glass to the vase cap; tack solder before removing shade from the form.
- If not using positioner: place a 4" threaded rod through the hole in the form; place vase cap at top of the form; put a second vase cap or a check ring or washer inside the form; secure with lock nuts at both ends of the rod; cut and fit glass to the vase cap as above. If necessary, trim the top of the form to fit the vase cap in place.
- (3) To foil, pull the pins part way out, just far enough to remove each glass piece one at a time; foil & repin.
- (4) Tack solder all glass pieces together. Wipe and burnish with a wet cloth to stop oxidation.
- (5) Remove all of the pins. Leave the lamp on the form and make a flat seam by tinning all exposed copper foil. Wipe and burnish with a wet cloth.

Construction tip for 360° Form which curve in at the bottom: When making a lamp on a 360° FullForm™, such as the CF18 which curves in at the bottom, you must remove the shade in two parts either vertical or horizontal. You decide which is most appropriate for your particular lamp shade and skill level. **Please see instructions for details.**



- (6) DO NOT BUILD ROUNDED SEAMS ON THE FORM. Remove the lamp and fill and then build the inside seams then do the outside. By filling the inside first, any flow through will be removed when building the outside seams.

DRAGONFLY WING FILIGREE-TINNING AND ANTIQUING- 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. On some lamps the wings appear to lay above each other where they overlap. Use the paper pattern and notch the tips of the wing filigree to match the glass wing. **DO NOT CUT** the small round part on the other end, this represents the wing muscle attached at the top of the Dragonfly body (Fig. 1). 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.



Use our No. 330 Positioner on full forms. The No. 330 is also used 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.

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