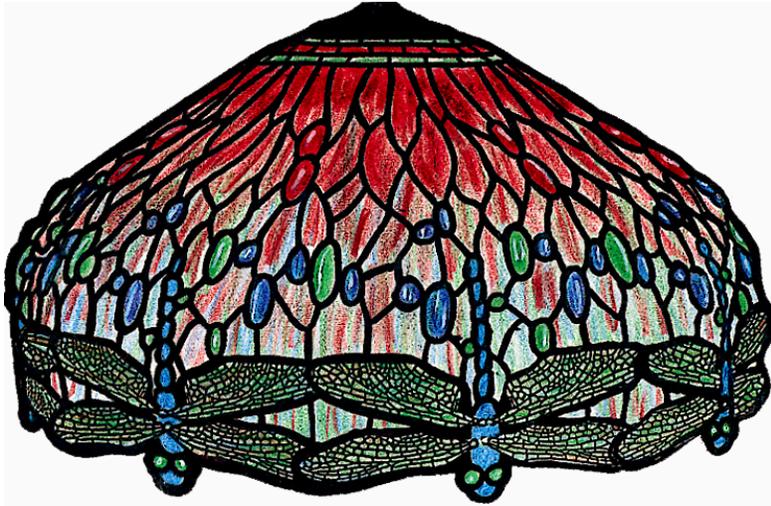


H. L. Worden Co.
"Make a Lamp"
System

B24-7 Hanging Head Dragonfly

Rev. 4/13

Cartoon Pattern Packet



Lamp Specifications

No. Glass Pieces: 675
 Glass Needed: 12 sq. ft.
 Diameter: 24"
 Height: 11"
 Aperture: 5"
 Design Repeats: 9

Needed to make this lamp

Pattern Packet No. B24-7*
 SectionalForm™ No. B24**
 Stained Glass
 5" Vase Cap***
 Lamp Base or Hanging Hardware
 to Swag

Additional Items Needed

Basic Supplies
 Basic Tools

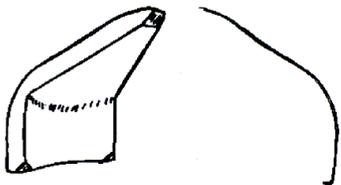
***No. B24-7 Pattern Packet**

Includes:

1 Paper Pattern Sheet
 3 MagicStrip™ Sheets
 1 Instructions
 1 Color Key w/ Glass Descriptions
 1 Sheet Alternate Color
 Descriptions
 9 Sets (36 wings) Etched Filigree

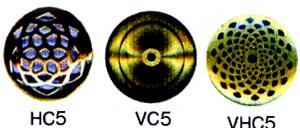
****No. B24 SectionalForm™**

Sectional form embossed and
 numbered to accept glass



One Reusable SectionalForm™ is
 used to make this 9-repeat design

*****5" Vase Cap**



Need One 5" (13 cm) Vase Cap
 Sold Separately

Lamp

Color	Key	Description	Glass Type	Sq. Ft.
	A-E	Lower Background	Blue, Yellow, Gray with red	4
	B-E	Middle Background	Red with gray, yellow, blue	
	C-E-M	Upper Background	Blood Red	2
	W,U,L	Dragonfly Wings	Bright Green	2.25
	M	Head and Body	Blue	.25
	H	Eyes	Flat Glass or 18 - 13mm jewels	

Paper Pattern
 MagicStrips™
 MADE IN USA
 Filigree
 MADE IN TAIWAN

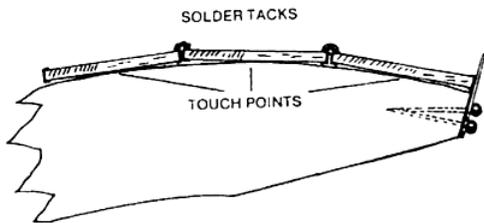
Sectional Form Construction Update

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

Construction Tip

Wings-The wings in this shade are quite large and will not lay flat to the mold. They will protrude 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



Glass pieces balanced at center points so that each end of the glass is the same distance off the form. (method one)

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.

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.

Pin Information

Hold the glass parts securely to the form with pins. This is a foolproof and inexpensive part of the WordenSystem™ allowing for the clean and easy removal of your lamp shade after soldering. Be sure you have an ample supply of pins - use glass head pins about 1 to 1 1/4" long.

Common pins about 1 to 1 1/4" long work well to hold parts up by placing the pins under the glass parts.

Flux will rust steel pins. Rinse and dry steel pins after each use and they will last for years.



GlassHouseStore.com
Decatur IL

