

H. L. Worden Co.

"Make a Lamp" System

SC20-3 Poppy Cone T

Rev. 9/14

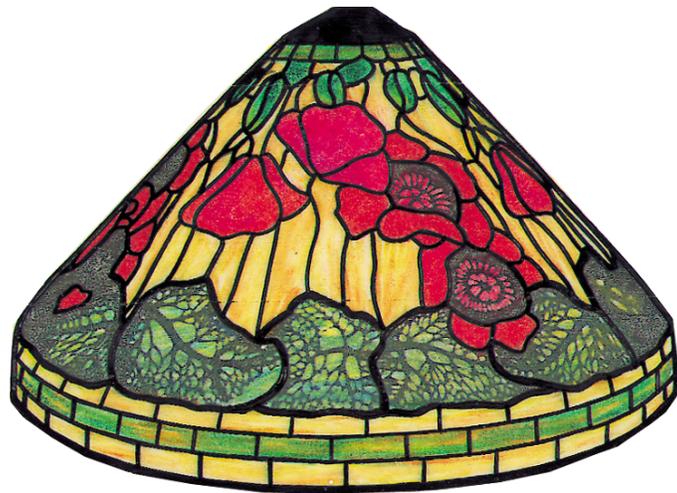
Cartoon Pattern Packet

Lamp Specifications

No. Glass Pieces: 472
 Glass Needed: 9 sq. ft.
 Diameter: 20"
 Height: 9.5"
 Aperture: 4"
 Design Repeats: 4

Needed to make this lamp

Pattern Packet No. SC20-3*
 SectionalForm™ No. SC20**
 Stained Glass
 4" Vase Cap***
 Lamp Base or Hanging Hardware
 to Swag



Additional Items Needed

Basic Supplies
 Basic Tools

*No. SC20-3 Pattern Packet

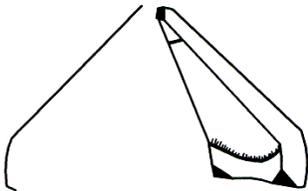
Includes:

2 Paper Pattern Sheet
 3 MagicStrip™ Sheets
 1 Instructions
 1 Color Key w/Glass Descriptions
 1 Set Leaf & Flower Filigree (Lg.)

**No. SC20 SectionalForm™

Sectional form embossed and
 numbered to accept glass

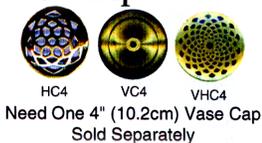
Lamp		Key	Description	Glass Type	Sq. Ft.
	BG	Background	Amber Opal	3.5	
	L	Leaves	Green Opal	3	
	FP	Poppies	Ruby Opal	2.5	



placement guides (cartoon)

One Reusable SectionalForm™ is
 used to make this 4-repeat design

** 4" Vase Cap



Paper Pattern
 MagicStrips™
 MADE IN USA

Filigree
 MADE IN TAIWAN

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Leaf & Flower Filigree-Tinting and Antiquing- The leaves on the original poppy lamp shades made by the Tiffany Studios were made in two ways: (1) They were made with flat one-piece leaves, raised as much as 1/2" (see large pattern pieces) with the filigree placed on the outside. (2) The leaves were made of smaller pieces (see the multi-piece patterns) with the filigree placed on the inside.

NOTE: The seed pod filigree was always placed on the outside.

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 tinting it first.

To tint, lay it on a flat wooden surface, leave the filigree fastened together, clean by rubbing with steel wool (glass conductors bear; 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, set apart, and solder it on top of the foil covering around each glass part, build up a nice rounded seam and carefully antique the edge trying not to heat the glass under the filigree. Use household shears to trim the filigree apart.

The leaves in the original poppy shades were made in two ways: (1) They were made with flat one-piece glass leaves, raised as much as 1/2" (see pattern L-3, the filigree was placed on the outside); (2) The leaves were made of smaller pieces, (see patterns L, the filigree placed on the inside). The seed pod filigree was placed on the outside on both.

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.



Use our No. 330 Positioner forms. The No. 330 is also available in full size. Use 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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