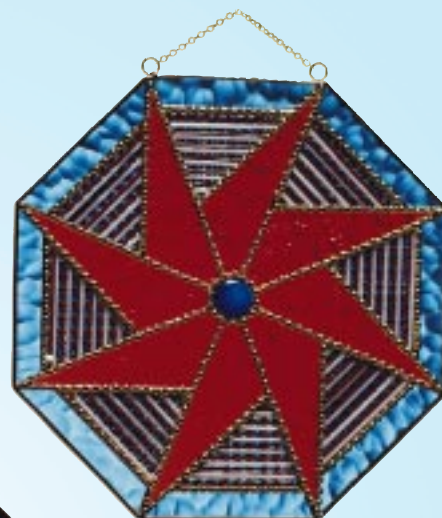
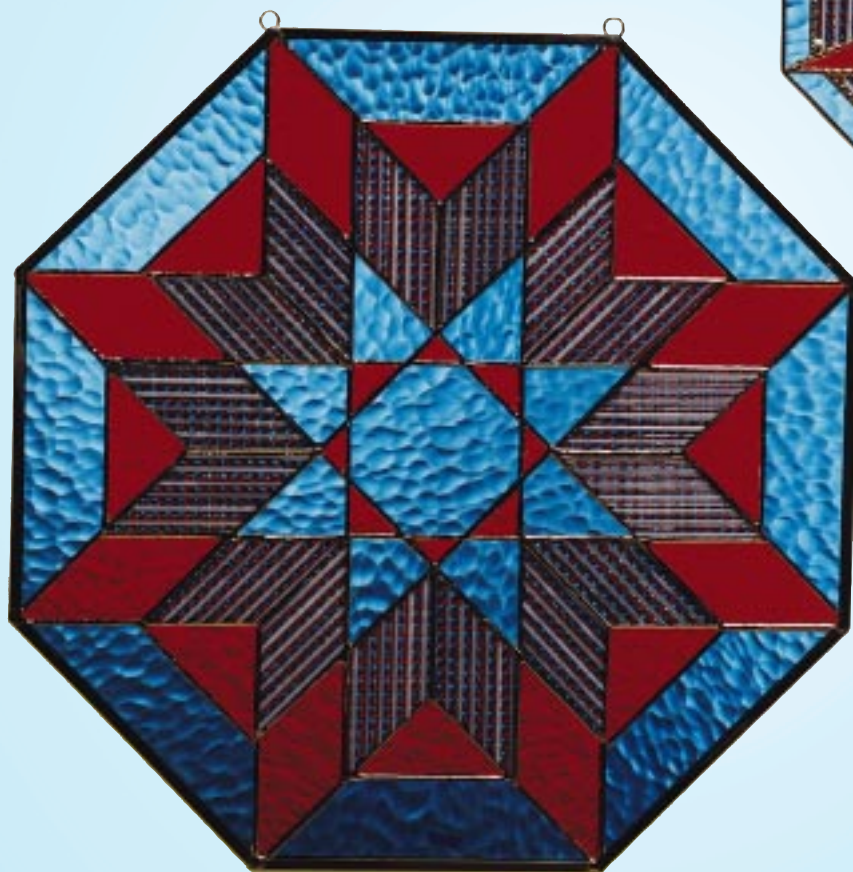


Celebrate America

Design by Pat Stanley

Fabrication and Text by Dave Burnett



Materials Required

Classical Heirlooms Celebrate America Kit™

Flux Solder 7/32" Copper Foil

1/8" U-Channel Brass Came

Copper Patina

The Celebrate America design is one of many kit designs from the Glassical Heirlooms series, *The Patchwork of America*. The kits include precut glass and hardware for patchwork angels, hearts, stars, and quiltblocks in all shapes and sizes.

Remember as you build this project, as with any other glass craft, to always work in a well-ventilated area, wear eye protection, and keep a clean work surface when working with glass and solder.

1. Remove the glass pieces along with the hardware for hanging the finished piece from the package with an X-acto® knife.

2. Check the glass pieces for fit before wrapping each piece with the 7/32" copper foil. Center the glass on the foil and wrap the edges. Overlap the end of the tape about 1/8".

3. Burnish all of the foiled pieces using a fid or lathkin. Burnishing smoothes the edges of the foil and adheres the sticky side of the foil to the glass. Hold the pieces in place with pushpins.

4. Apply flux with a brush to all of the copper-foiled lines. Flux comes in paste or liquid form, whichever you prefer, and prepares the copper to accept the solder.

5. Tack-solder all the joints to keep them from moving. Run a smooth, rounded bead on the front and back of the project. Keep the solder 1/8" away from the edges.

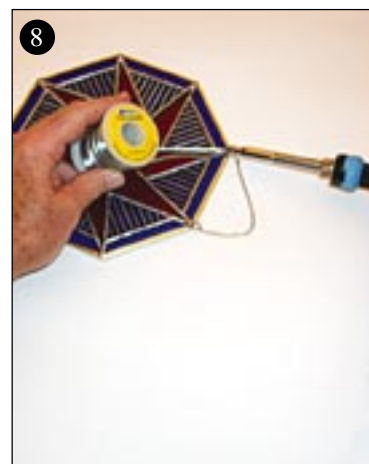
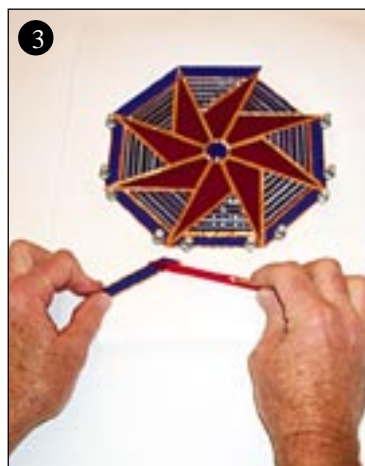
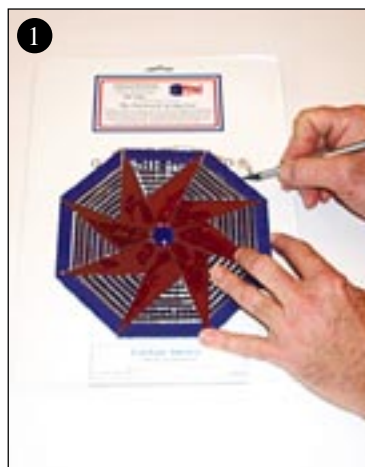
6. Run decorative solder drops on the beaded lines of the project. Adjust the temperature of the soldering iron with a rheostat. Adjust the iron temperature until you can form a solder ball. Practice on this before you start to solder the decoration onto the project.

7. Cut the pieces of the U-Channel brass came with a miter saw to fit around the outside edges of the project. Solder each joint where it meets the design lines of the project, front and back.

8. Solder the two jump rings and the small chain to the back of the project.

Clean the project thoroughly with warm soapy water and flux remover. Patina can be applied to the silver solder in either black or copper. After the patina is applied, clean the completed project again. Using a glass wax will prevent oxidation in the future. We applied copper patina to this project, which could also be gold or nickel plated.

GPO



*Design by Pat Stanley,
Classical Heirlooms, Inc.*

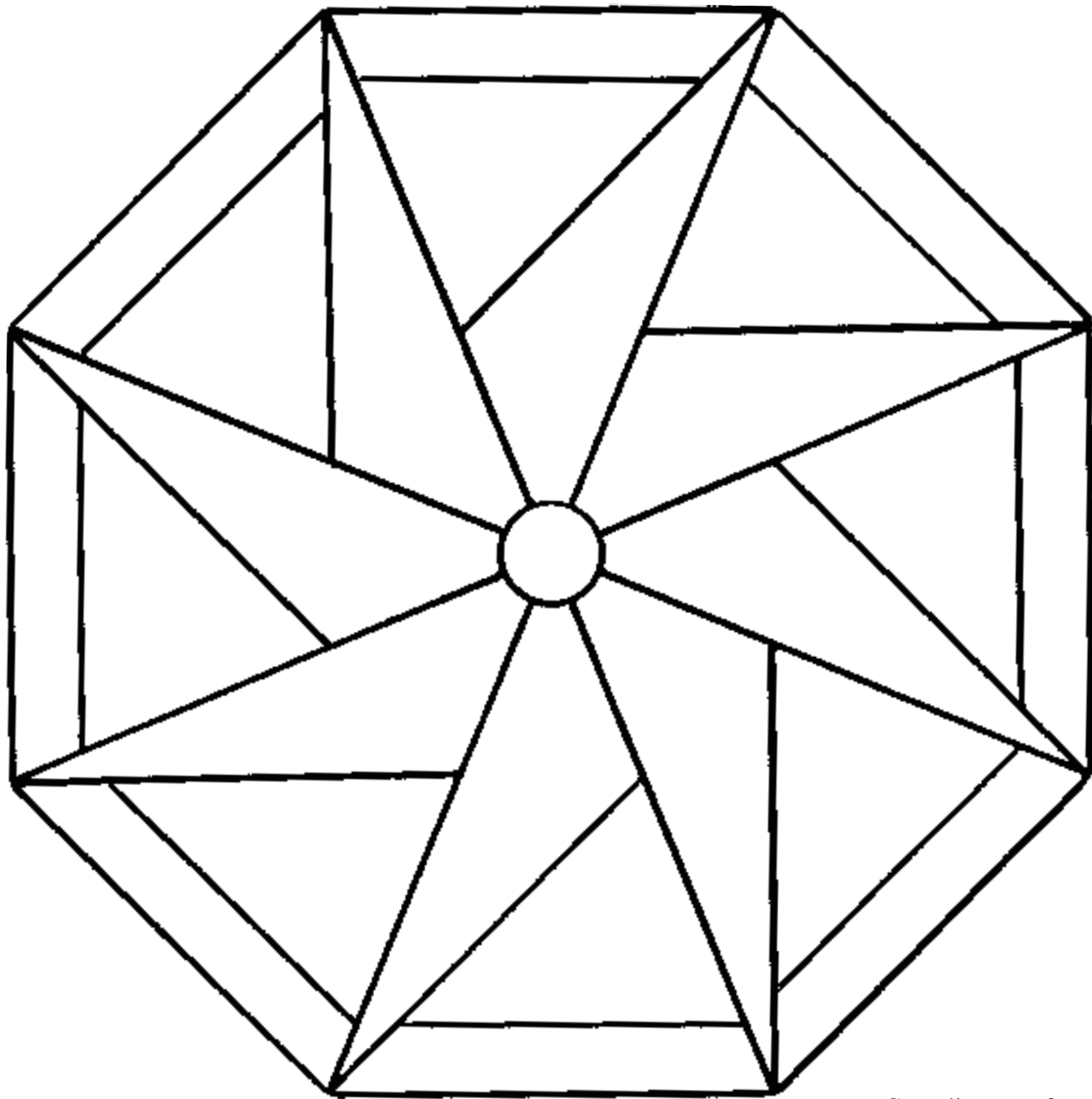
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