



## Fabrication Steps For Hydraulic-Formed Vessel Pendant

Below are general steps I use when making my hollow-form vessels.

### Silhouette Die:

- Apply pattern to brass die plate
- Drill near inside edge of the silhouette pattern
- Saw out silhouette
- File, sand, refine shape
- Tape die plate onto acrylic square and trace with a scribe inside the pattern
- Drill inside this shape, insert saw blade and cut shape out of acrylic
- Check and refine fit of die plate and acrylic square
- Use double sided tape to adhere faceplate
- Drill through faceplate + die and insert brass wire; create rivet
- Scribe guidelines on faceplate for centering die blank

### Hollow Form:

- Cut metal blanks (2 pieces for hollow form)
- Anneal if necessary
- Apply surface design if applicable (roller print, file, flex shaft etc)
- Retrim blanks if necessary, esp corners
- Anneal blanks
- 1st die press
- Anneal and repeat die pressing as necessary
- Remove flange (or keep portions that are part of your design)
- Refine edges (file, sand)
- Check the fit of both halves together and refine as necessary
- Create jig to hold piece for soldering using solder block in kit
- Place 1 formed piece in jig, flux, premelt solder around inside edges
- Do not flux inside the half without solder, but flux to top of this half
- Fit pieces together and rotate solder plate to check all sides
- Gently heat and solder
- Pickle
- Repeat as necessary
- Finishing (filing, sanding, polishing etc)
- Sign and date work if possible