

DIPPING SHELLS

- A) **CUP:** Take a small paper cup, carefully stick the metal pipe through the center of the bottom, screw white coupling w/handle onto pipe on the inside of cup. Fill up the bottom of the cup up with hot wax. Allow to cool. Fill end of pipe with wax. Coat pipe and cup assembly with wax.
- B) **GATE and WEIGH:** Gate the wax pattern (HO#4) to bottom of the cup. Refer to the Gating Checklist (HO#5). Once gated and weighed, **check with the instructor** for final approval.
- C) **DIP:** Once approved, put on your **dust mask**. Remove lid and step on foot pedal to turn off mixer. Ceramic slurry should be well-stirred and creamy. Dip piece slowly, coating the entire piece with slurry, including the gating and the cup. Allow slurry to drain off at various attitudes for about 15 seconds, keeping the coating even. Support piece and gating assembly (two hands) as you rotate it.
- D) **STUCCO:** Quickly and carefully move piece to vented drum and begin sifting stucco onto piece. **Keep moving** to avoid puddling and dripping chunks as you sift. Cover the **entire** surface.
- E) **DRY:** Carefully hang piece on rack, rinse hands in tank, and **cover slurry** with lid. Once **yellow** and **thoroughly dry** (6-10 hours), brush off excess stucco and repeat steps C, D & E for 2 dips total.

MAKING INVESTMENT FLASKS

Measure Gating Assembly: '**W**' = widest part of gating assembly, '**H**' = height of entire assembly.

Cut Materials: **W x 5** = cut chicken wire and tarpaper to this length (should wrap piece ≈ 1.5 times).

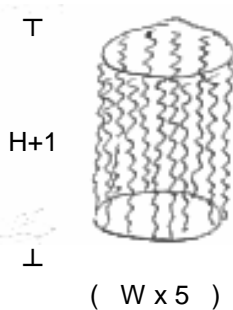
H + 1" = cut chicken wire and tarpaper to this height (so flask will be 1" taller than your piece).

Construct flask: weave loose ends. Leave only **one inch** on all sides! **Get Instructor approval!**

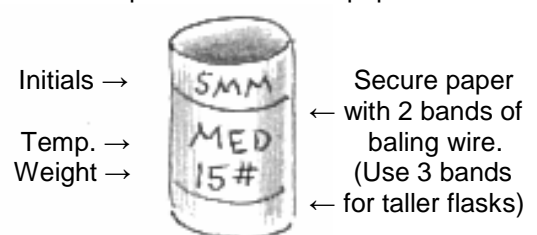
Gating Assembly



Chicken Wire Flask



Completed Flask w/Tarpaper



Before Assembly, Check Diameter w/Instructor! Only 1" extra on all sides!!!

INVESTING: Put down silver tarp. Get out buckets, plaster and sand--set up 'bucket brigades' for each station. (Plaster and water at 2/3 full, sand is FULL.) Set baskets in rows, with room to work. Pour (1) water into large bucket, add (1) plaster, allow to sit 1-2 minutes, or until air bubbles stop. Stir. Add (1) sand, stir out all lumps. Coat outside of baskets to tarp, in two rows. Once bases are set, begin investing. When set, **re-label** with iron oxide, remove wire and paper and set by kiln. **Clean up!**

DIVESTING BRONZES

The investments may be moved when the cups have turned black. Remove flasks and excess sand. Use tongs to drag investments out: (Do not disturb any unpoured ones.) The pieces are still very **hot!** Always wear: **dust mask, eye protection and gloves.** Carefully open investments by using an adz to cut wire down one side, split open and expose your bronze. Dip in water for final 2% cleaning. Shovel **investment only** into dump truck: **no chickenwire, etc.** Sweep and rinse area: **CLEAN UP!**