



Making a Rose Process

To make a rose, I try to use recycled steel. I have used the sides of an old drum, scrap sheet I found in the bulk scrap pile, or any other flat thin piece. For the petals, thinner is better. For the stem, it is around a 10mm or $\frac{3}{8}$ ". The leaves are scrap square stock, $\frac{5}{8}$ " to $\frac{3}{4}$ ". I also use a sacrificial tree stump/log to put a nice cup and texture on the petals

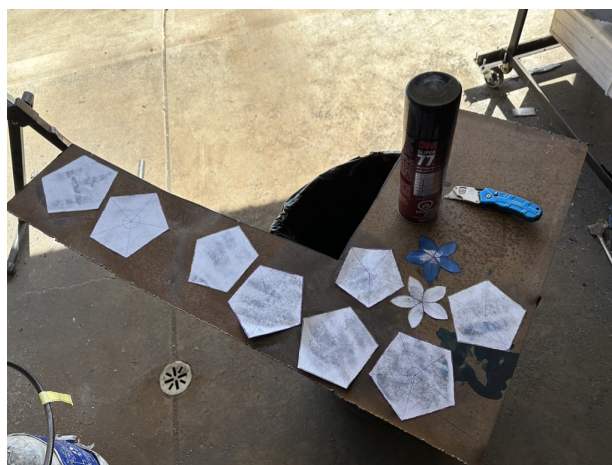
For tools, I have use:

- Cheap \$10 hammer that I use my angle grinder to cut lots of lines in the face to create "bark"
- A ribbon burner forge (the first thing I built). It will hold a 20" billet, and reach about 2400 degrees with the ends blocked. I based my design off of Bonifab Custom's videos
<https://youtu.be/CYvM3gL-IME>
- Cheap chipping hammer that I rounded the head on to
- I use a cheap Canadian Tire Mig welder for the billets. Really all that is required is to hold them together so a big fancy welder is not required. Disclaimer: When you see the welds, I am NOT a welder.
- 5" Angle Grinder to do all of my cutting.
- Metal Bandsaw, but an Angle grinder is what I used to use.



Cutting out the blanks:

To cut out the blanks, I first cut out the papers (shapes on the last page). They are really just pentagons and star. I then glue the paper shapes to the steel using Yellow 77 spray on glue.



Cut out all of the shapes with an angle grinder or a band saw. I just got a bandsaw it took me $\frac{1}{4}$ the time that the angle grinder did. Once all of the shapes are cut out, cut the lines from the corners to the center circle



Drill out the center holes with a $\frac{1}{8}$ " drill bit while the paper templates are still good so that you know where the center is. We are going to make this bigger later, just don't want to lose center once the paper burns off.



Next I go over to the 2x72 grinder, (an angle grinder still works here if you don't have one), and round off the corners of each petal. I bend the petals up and down to make it easier to round off the corners.



Do this for all 4 petals and the bottom star shape. Its actually better if they aren't uniform, nature isnt. Im making 2 roses here.

