

Forming Techniques

Extruded Brass – Brass may be pushed through a flat steel plate in the same manner as pasta is extruded through a pasta machine. Almost all brass tubing is produced in this manner. The back bar of our *Palladian Bath* model #8012 is an elegantly shaped extrusion of heavy brass. Extruded brass has a small amount of lead mixed into the copper and zinc alloy to ease its flow through the extrusion machine.

Forged Brass – A stamping process in which brass sheet or ingot is heated to a plastic state (between solid and liquid) and then stamped to final size. The process produces extremely high quality and density. It is used especially for components with a broad smooth surface where there is no opportunity to camouflage even the slightest imperfection. Typically Nulco uses forgings for canopies (back plates) on models such as *Claremont* model #2501 and *Kingston* sconces, such as model #1741.

Sheet Brass – Many of Nulco's series are formed by stamping or spinning sheet brass. Examples are our *Larchmont* foyer lanterns model numbers 860,870 and 880 and our *Mission* and *Vintage* bathroom brackets. Nulco uses sheet brass that is 70% copper and 30% zinc alloy, which is most often supplied on coils. This exact combination makes for a rich finish that polishes to a most beautiful luster.

When our brass components are formed, either by stamping or by spinning on a lathe, we heat-treat the components to a temperature of 850°F taking several hours. This heat treatment removes all of the internal stress in the brass so that the components will not fracture over a period of time. Many products on the market are made of alloys with lower copper content and are not heat treated for stress relief. These fixtures may fracture in time.