



Dora is an adorable all-bisque head-torso doll with jointed arms and sculpted hair and hair bow. This version recreated and costumed by Kitty Murks.

Dora

By Kitty Murks

Mold: **S485** Dora mold

Finished Size: 3" (7.62cm)

Porcelain Slip: **Lady White**

Kitty nestled this Dora in a bouquet of silk flowers inside SC265 Victorian Slipper.



BACKGROUND for DORA

Adorable *Dora* is an all-bisque doll with jointed arms and molded hair and hair bow. The head, torso, legs and bare feet are sculpted in one piece, with the legs in a distinctive stance that allows the doll to stand on its own.

The antique *Dora* from which our mold was made is marked "Japan" and was produced around 1920-1930. Dolls with the same modeling were also produced by Hertwig & Co. of Germany. Dolls of this type were produced inexpensively in large quantities and in many different sizes. As a result, the bisque and painting are generally of lower quality. Often portions of the paint were not fired on, so it is not uncommon to find some of these dolls with paint that has worn away. The smallest versions of this doll were painted with fewer facial details.

The antique *Dora* from which our mold was made is cast in white bisque and has a pale pink overall wash, blond hair, red lips, lightly blushed cheeks and a bright blue hair bow. The thin, brown one-stroke eyebrows are about the same length as the eye opening and are slightly arched. The upper eye rim is lined with black and the eyes are simple black dots.

Variations of this model were cast in pink-colored bisque or have light brown hair; green, yellow or pink hair bows; and short eyebrows--almost like dots--either straight or slanted downward toward the nose.

You do not have to copy the features of the antique shown here when painting your *Dora*. Use your imagination to come up with painting variations. Soften the color of the lips and paint them with a smiling expression. Emphasize the eyes with a blue or brown iris and a black rim around the entire eye. Add a little blush to the belly, knees and elbows.

Because *Dora's* legs are sculpted in one piece, costumes and undergarments must be kept simple in design. Antique versions of this type doll have been found dressed in original one-piece playsuits that were hand crocheted or knitted or constructed of thin knitted material. Other original costumes consisted of little sundresses or one-piece "teddies" made of scraps of lace and ribbon.

Dora is the perfect size for one of your larger dolls to hold or to be used in miniature displays. There are many other creative presentations for *Dora*--just use your imagination and have fun!

CASTING and CLEANING

1. The pour holes are tiny, so you will need to thin Lady White porcelain with Slip Thinner. This is a product which allows you to thin porcelain slip with less water, resulting in a better casting with less mold saturation. The directions on the Slip Thinner label are for thinning a whole gallon. Use a proportionately smaller amount of the mixture if thinning less than a gallon.
 2. After adding the thinning solution stir slip thoroughly with the stirring stick in the Casting Kit. The slip should be the consistency of very light cream. If additional thinning is needed, add a few drops of the mixture at a time until you achieve the desired consistency. Too much Slip Thinner can cause an opposite reaction to the thinning desired. Let slip sit for about 30 minutes to allow air bubbles to rise to the top.
 3. When you open the molds you will see that the pour hole for *Dora's* head-torso is in one of the arm openings. Because the head-torso is lying horizontally in the mold you won't have gravity on your side when pouring the slip in. To avoid casting rings, which are caused when the mold cavity fills too slowly to push the air out, you need to do several things. If the mold is dry mist the cavity lightly with water from a spray bottle before re-banding. Prop up the feet end of the mold about one inch. Fill a 16-oz. Plastic ketchup dispenser with thinned slip. Insert the nozzle of the dispenser into the pour hole and fill the mold cavity with one long squeeze. Do not stop squeezing until the mold is filled. Forcing the slip into the mold in this manner pushes the air out rapidly. Cast the arms in the same manner.
 4. Wait about two minutes before emptying the head-torso mold cavity. Use a cocktail straw to blow as much of the slip out as possible. After emptying the head torso mold position it so that excess slip can settle in the feet. The thicker casting of the feet will help prevent the doll from being a little top heavy. Let the arms set up solid.
 5. Let the castings set up for about 45 minutes, or until the molds open easily. Use a Mold Cleaning Tool to scrape around the pour holes to loosen the spares. After you open the molds remove the spares with a Featherknife.
 6. When the castings are leather hard, scrape away the seams with the edge of a Lace Tool. Use water and KwikClean Brushes to pre-clean the greenware by removing any imperfections and smoothing the seam lines. The tip of a Clean Up Brush can be used to smooth any pinholes and the tiny imperfections around the face and hair that are caused by air pockets trapped during the casting. Use a small KwikClean Brush to patch the pour holes in the tops of the arms with a drop of slip. When the patched area is dry brush it smooth with a damp KwikClean Brush.
- The arms of our antique *Dora* were strung to the torso through the loops sculpted onto the top of the arms, but this method will be extremely tedious in our reduced size *Dora* recreation. If you want to tackle it, however, use a large needle to pierce holes all the way through the stringing loops, then use a Featherknife to carefully enlarge the holes to accommodate EL17 Stringing Elastic, allowing for shrinkage during the bisque firing. Use the Featherknife to cut out an opening in the torso large enough to accommodate the stringing loop at the top of the right arm. The pour hole forms the opening for the left arm.
- Some versions of *Dora* were strung with wire through holes that were pierced through the tops of the arms. We suggest you use a similar stringing method called "pegging". Stringing instructions from this point forward refer to the pegging technique. Use the Featherknife to remove the sculpted stringing loops and to pierce a 1/4" stringing hole in the right arm of the torso. Use the Lace Tool to pierce a stringing hole horizontally through the top of each arm. Hold the arms in place against the torso to make sure the stringing holes are properly aligned.
- Use the tip of a damp KwikClean Brush to smooth the stringing holes and the arm openings. Let castings dry.
7. Soft fire to cone 019.
 8. Use a Comfy Scrub, Multipurpose Blender/12 and the GreenClean Brushes to finish cleaning the soft-fired pieces in the Dust Free Cleaning technique. Use a Double Ball Stylus to re-carve any detail that was lost during cleaning and to incise your initials and date. Make sure the stringing hole in the right arm is large enough to accommodate EL17 Stringing Elastic. Rinse the pieces and let the water dry off to check for any remaining imperfections. After you are satisfied the pieces are cleaned well rinse them under the tap, using a Greenware Duster to remove any greenware debris.

BISQUE FIRING

Coat kiln shelf with a fine layer of Firing Sand. Set pieces on shelf at least 1" apart. Stand the head torso upright in a small pile of sand. Bisque fire to cone 6 using witness cones 5, 6 and 7 on the shelf. After bisque firing witness cone 5 should be touching the shelf, cone 6 should be bent to a 10 to 11 o'clock position and cone 7 should not be bent at all.

CHINA PAINTING

Sand surface of bisque with a #220 Grit Scrubber and rinse pieces clean. Let pieces air dry.

Use a Palette Knife to mix the china paints on a Glazed Tile. All paints are mixed with Line Medium to a creamy consistency unless otherwise directed.

Use a permanent marker to identify the color of each puddle of paint. The markings can be removed with alcohol at clean up.

All china paint firings are to witness cone 018.



Kitty painted this version of Dora with a pink hair bow and blue eyes.



Antique Dora has a pale pink overall wash, blond hair and bright blue bow. The eyes are simply black dots and only the upper eye rim is outlined. The light brown eyebrows are the one-stroke type.

CHINA PAINTING

First Firing

Overall Wash

Bisq-Tone #2, Raspberry
Area Medium
Multipurpose Blender/6
Mini Complexion Brush
Large China Mop
Clean Up Brush
Lace Tool

Mix Bisq-tone #2, Raspberry, with Area Medium to a light consistency. Use a Multipurpose Blender/6 to apply color to face, torso and arms. Blend color with a Mini Complexion Brush, pouncing paint into the crevices. Finish smoothing with a Large China Mop. Use a damp Clean Up Brush to remove paint from eyes and hair. Paint the arms while holding them with the tip of a Lace Tool inserted through the stringing holes. When you have finished painting each arm push it off the tip of the Lace Tool onto the side of a kiln post and place the post into the kiln for china firing. Fire the head-torso on a Doll Caddy.

Iris

Mini Detail Brush
Tropical Blue

Use a Mini Detail Brush and Tropical Blue to paint a round iris positioned in the center of each eye. You also have the option of positioning the eyes so that they glance to one side. The upper edge the iris is touching the upper eyelid.

Second Firing

Eye Rim, Pupil

Eyelash Liner #1
Ebony Black
Mini Detail Brush

Use an Eyelash Liner #1 and Ebony Black to paint a fine line inside the upper eye rim. Use a Mini Detail Brush to paint a tiny pupil inside each iris.

Eyebrows

Eyelash Liner #1
Finishing Brown

Use an Eyelash Liner #1 and Finishing Brown to paint one-stroke "thin-thick-thin" type eyebrows that are slightly arched. Refer to photo above.

Lips

Mini Lip Definer
Chili Powder
Petite Shader
Mini Detail Brush

Use a Mini Lip Definer and Chili Powder to paint little "rosebud" lips in a solid coat of color. If needed, use a Petite Shader for blending. If you want to paint the nostrils use the tip of the Mini Detail Brush to apply two tiny dots of color.

Second Firing, continued

Hair

New French Gold
Eyebrow #1, Caramel
Multipurpose Blender/6
Super Doll Sponge
Clean Up Brush

For light blond hair use New French Gold. For darker blond mix equal parts New French Gold and Eyebrow #1, Caramel. Use a Multipurpose Blender/6 to paint the hair with an even coat of color. Pounce hair color smooth with a Super Doll Sponge. Use a damp Clean Up Brush to remove any hair color on the face or bow.

Hair Bow

Ultimate Shader/2
Dusty Rose

Use an Ultimate Shader/2 and Dusty Rose to paint the hair bow with a smooth coat of color. Optional bow colors are Tropical Blue or Jungle Green.

Cheeks

Super Doll Sponge
Ultra Fine Line Medium
Ruby Cheek Blush
Line Medium
Mini Stippler
Small Filbert

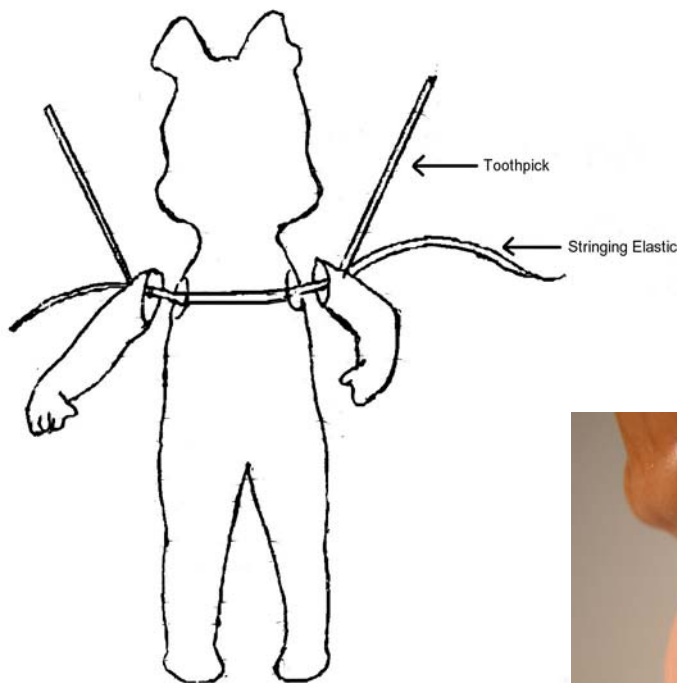
Use the corner of a Super Doll Sponge to apply a thin coat of Ultra Fine Line Medium on cheek area, being careful not to touch lips, eyes and hair. Mix Ruby Cheek Blush with Line Medium to a thick consistency. Lightly touch the tip of a Mini Stippler into the paint. Place a dot of color in the center of the cheek and start blending the paint with a pouncing motion of the brush. Use a Small Filbert to finish blending. Color is quite rosy and confined to the "apple" of the cheeks.

Third Firing

Darken the hair, hair bow and facial features as needed. The lips are bright red and there is no shading on either the lips or eyebrows.

STRINGING

1. This doll is so tiny there is no need to line the joints. The joints on the antique doll were not lined.
2. Cut a 3" piece of EL17 Stringing Elastic. Thread one end of the elastic through the hole in one arm.
3. Dip the end of a round toothpick in white tacky glue. Insert the toothpick into the stringing hole on the outside of the arm, wedging it in tightly next to the elastic. Let the glue dry completely before proceeding to next step.
4. Thread the other end of the elastic across the torso and through the stringing hole in the other arm. Dip the end of a toothpick in glue. Pull the elastic taut and insert the glued end of the toothpick into the stringing hole on the outside of the arm. Let glue dry completely.
5. When glue is completely dry use wire cutters or fingernail clippers to clip off the excess elastic and toothpick on each arm as close to the surface of the porcelain as possible. If you still have a little bit of wooden toothpick protruding, use a tiny piece of fine grit sandpaper to sand it down. Be careful not to sand the overall wash.



Stringing Supplies

Stainless Steel Stringing Clamp
EL17 Stringing Elastic
Toothpicks
White tacky glue
Wire cutter or fingernail clippers
Fine grit sandpaper



After the glue has dried use wire cutters or nail clippers to clip off the excess elastic and toothpick as close to the surface of the porcelain as possible.

ONE-PIECE COSTUME



Kitty created this charming one-piece costume for Dora using tiny bits of ribbon and lace.

Materials

3" of 1" Lace edging

3" of 1/4" Lace edging

8" of 1/8" Silk ribbon

Large eyed embroidery needle

Air disappearing marking pen

Tape measure

Basic sewing kit

1. Sew the straight edges of the 1" and 1/4" lace pieces together.
2. Wrap the lace strip around the doll's torso and pin in place, lapping one edge over the other at center back.
3. Use an air disappearing marking pen to mark the front and back placement of two ribbon shoulder straps.
4. Cut two 1-inch strips of silk ribbon for shoulder straps. Measure the distance from the front shoulder strap placement mark to the back mark. Transfer this measurement to each ribbon strap, beginning 1/4" from one end.
5. Remove lace strip from doll. Thread a large-eyed embroidery needle with the remaining 6" piece of ribbon. Sew the ribbon through the 1/4" lace edging in 1/4" stitches to form a sort of sash or draw-

string. If the lace has open spaces in the weave thread the ribbon in and out through the spaces.

6. Hand sew each ribbon strap to the underside of the lace at the front and back placement markings, being careful not to catch the drawstring in the stitches. Trim any excess ribbon from the end of the straps.
7. Pin the lace strip back on the doll. Make adjustments in shoulder straps, if needed. Turn under the raw edge of one end of the lace strip piece and hand sew the center back seam with hidden stitches. Do not sew the ends of the drawstring into the seam.
8. Tie the ends of the drawstring together in a little bow at center back. Trim any excess length from the ends of the ribbon.
9. Hand sew the lower edge of the lace strip together at center front and center back, pulling stitches between the doll's legs. The front and back of the lace will not actually be touching, but will rather be pulled inward at the crotch to make it appear that the little suit has legs.

CASTING, FIRING, & CHINA PAINTING SUPPLIES

Casting Kit:

- Stirring stick
- Strainer
- Synthetic Sponge
- Greenware Duster
- Featherknife
- Mold Cleaning Tool
- Slip Thinner
- Firing Separator
- Round Taklon Brush
- 2 KwikClean Brushes
- Casting Instructions

Stoneware and Porcelain Cleaning Kit

- Featherknife
- Synthetic Sponge
- Comfy Scrub
- #220 Grit Scrubber
- Multipurpose Bender/12

Lace Tool

Firing Sand

16-oz. Plastic squeeze bottle with nozzle

Cocktail straws

Permanent marker (fine point)

Junior cones 6 and 018

Witness cones 5, 6, 7 and 018

Doll Caddy

Kiln posts

Lint Free Towel

GreenClean Brush Kit

Palette Knife

Glazed Tile

Multipurpose Blender/6

Mini Complexion Brush

Large China Mop

Mini Lip Definer

Mini Detail Brush

Petite Shader

Ultimate Shader/2

Clean Up Brush

Eyelash Liner #1

Mini Stippler

Small Filbert

Double Ball Stylus

Super Doll Sponges

Bisq-Tone #2, Raspberry

Tropical Blue

Ebony Black

Finishing Brown

Rich Henna Brown

Chili Powder

Ruby Cheek Blush

New French Gold

Eyebrow #1, Caramel

Dusty Rose

Jungle Green (optional)

Line Medium

Area Medium

Ultra Fine Line Medium

For detailed instructions on the Waterbase Technique™ see *General Instructions 2 (#GI23)* and Dollmaker's Worksheet, *General Instructions 4, Casting, Cleaning, Firing (#GI4)*.

Please follow color suggestions, as colors in photo may vary in printing.

All molds, porcelain slip, and casting, firing, china painting and stringing supplies available from Seeley's. Other items can be found at craft and fabric stores.

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Kitty painted this version of Dora with short eye-brows that slant toward the nose.