



DESIGNER: NICOLE JACQUARD

## ▶▶ Get Set

Fine silver sheet, 18 gauge,  
 $\frac{7}{16} \times 2 \frac{3}{16}$  inches  
 (1.1 x 6 cm)

Bench tool kit, page 9

Soldering kit, page 9

Nylon synclastic stake or  
 steel sinusoidal stake

Nylon hammer with narrow  
 shaped end

**FINISHED SIZE**  
 Size 6½ ring, 8 mm wide

## ▶ Get Ready

SAWING • ANNEALING • FILING • SOLDERING  
 SANDING • HAMMERING

## ▶▶▶ Go

**1.** Use dividers to scribe a 10-mm-wide strip on one edge of the 18-gauge fine silver sheet. Shear or saw out the strip. Cut the length to 5.8 cm for a size 6½ ring.

**2.** Begin shaping the strip around the anticlastic stake using the narrow end of the nylon hammer. Curve the sides into a U-shape, and form the strip into a band at the same time. Anneal the metal, and continue forming the band until you have a circular ring. Anneal the ring again.

**3.** Bring the ends of the ring together and file flush. (The ring does not have to be completely round at this point. The two ends only need to meet and be flush.) Solder the ends together with hard solder; pickle, rinse, and dry the ring. Remove any excess solder with a file, then sand the ring with 320- and 400-grit sandpaper.

**4.** Place the ring on a mandrel, and use your hands to twist the ring down to bring it back to a round shape. Tap the inside of the U-shape with the narrow end of the nylon hammer. If you need to enlarge the ring, tap the inside of the U-shape with an embossing hammer to stretch it.

**5.** To make the edges level, place the ring on a flat steel block, and hammer gently with the flat face of a planishing hammer. Repeat this step on the opposite side of the ring. Take care to be gentle—too much pressure will collapse the ring.

**6.** Place the ring on the mandrel and tap the edges with a narrow-faced hammer to give them texture. Sand the inside and outside surfaces of the ring with 400-grit sandpaper, then use a brass brush.

**7.** Add colored rubber bands to the U-shape by twisting them around the ring and layering them as desired.



PS. If you want to add a new process to your repertoire, or if you need a quick refresher on a specific metalworking method, look no further than *The Ultimate Jeweler's Guide* by Joanna Gollberg. This hardworking book covers all the essentials. It is a comprehensive, step-by-step resource for learning metalwork that fits easily on your worktable and is sure to become your go-to source. (And check out the 30-minute prong-set ring designed by Gollberg on page 108).



## Bench Tool Kit

- Bench pin
- Steel bench block
- Jeweler's saw frame
- Saw blades
- Beeswax
- Needle files
- Bastard file
- Sandpaper, 220 and 400 grit
- Emery paper
- Chasing hammer
- Rawhide or wooden mallet
- Forging hammer
- Mandrels
- Dapping block and punches
- Flexible shaft
- Wood block
- Drill bits
- Burrs
- Scribe
- Stainless steel ruler
- Dividers
- Calipers
- Pliers
- Wire cutters
- Center punch
- Burnisher
- Safety glasses
- Safety gloves
- Hearing protection
- Dust mask



## Soldering Kit

- Soldering torch
- Striker
- Heat resistant soldering surfaces (charcoal blocks, firebricks, or ceramic plates)
- Flux
- Flux brush or other applicator
- Solder (hard, medium, and easy)
- Snips
- Small embroidery scissors
- Solder pick
- Tweezers
- Cross-locking tweezers with wooden handle
- Third hand
- Copper tongs
- Water for quenching
- Pickle
- Pickle warming pot
- Safety glasses
- Fire extinguisher