



Convert a simple silver box into a locket

by John Ross

This shows how to convert the simple silver box in my previous project into a silver locket.



What you'll need:

Piercing saw
999 738

Piercing saw blades
999 4353

Fine blowtorch for soldering the chain
999 7701

Larger blowtorch for soldering the locket such as the Aquaflame Micro Welder 997 6403

Joint tube cutting tool 999 596

Third hand and base 999 AAA

Jeweller's pliers 999 3058

Needle files 999 528

1mm diameter twist drill and pin vice 999 FAU

Rotary drill e.g. the Dremel 300 999 3354

50mm of 1mm sterling silver wire WVE 4N2

15x3mm 0.6mm sterling silver sheet CSA 060

Sterling silver joint tube 1mm inside diameter RSA 016

Sterling silver chain and fittings

Easy silver solder CTB 500

Silver solder flux PZZ 050

Argo-tect PZZ 090

AA rouge 998 191

Polishing materials to personal requirements

Paraffin and methylated spirit



Step 1

Create a groove

Using a triangular needle file start to file a straight slot into one side of the box, along the join between the top and the base. Finish with a half round needle file.

File until it is about 12mm in length so that the silver tube fits snugly along the groove.

Step 2

Cut tube lengths

Using the joint tube cutting tool, cut one piece of silver tube 5mm long and two pieces 4mm long, removing any burrs.





Step 3

Prepare for soldering

Mix a paste of AA rouge and paraffin. Separate the two halves of the box and paint all surfaces that

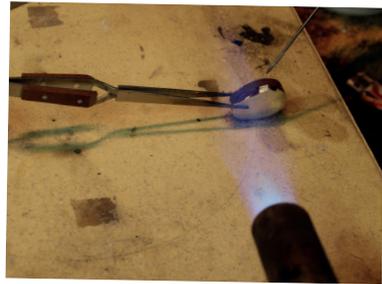
will be touching that you do not want to be soldered together, except at the centre of the groove on the lid. Here you will be soldering a single 5mm length of tube.

Mix a paste of Argo-tect with methylated spirit and paint the inside and outside of the box ensuring you don't touch any mating surfaces and assemble the box. The Argo-tect is intended to help prevent fire stain to the polished surfaces.

Step 4

Solder the tubes

Support the box on its side with the groove uppermost on your soldering table. Place the 5mm silver tube in the groove, add a little flux and a small piece of cut easy solder. Using the soldering probe coax the solder to help solder the tube into place on the



lid only. Allow to cool and pickle till clean. Separate the two halves of the box, rinse and dry. Repeat the whole process this time soldering the main body. If you have not overheated the work or applied too much flux the two halves should separate after pickling.



Step 5

Make the bail

Form a small ring from 0.6mm silver sheet using pliers. Slightly flatten and file it to a pleasing taper and solder the join.



Open a jump ring of 1mm wire into a horseshoe shape. These will act as the links to the chain.

Paint the box base with Argo-tect inside and out to protect surfaces from fire stain. Using the third hand to hold the links in place,

solder the horse shoe link onto the box body using easy solder. Leave the other part of the link loosely attached. Be careful not to solder the two parts of the link together, a little of the rouge paste could help to keep them apart.



Step 6

Form a simple handle and clip

Take a piece of silver sheet about 3mm wide and 15mm long and bend over 2 or 3 mm from one end. File that end round and polish the outer side.

This will form the simple handle and clip mechanism.

Paint the lid inside and out with Argo-tect and using the third hand to hold the handle in place onto the lid, solder using a small amount of easy solder.

Step 7

Clean and tidy

Pickle the whole piece. Then use the 1mm twist drill to clean any debris from inside the joint tubes and trim the two ends.

Using a pendant drill polish the inside and a standard polishing motor to finish the outside, after filing any excess solder with a fine file. Polish carefully so as not to round off any corners or

edges. The outside is best polished once assembled. Use a length of 1mm silver wire for the hinge pin and assemble the locket.

Finally using flat nosed pliers bend the clip mechanism as in the photo and cut it back and file the end until a pleasing clip mechanism is formed, and polish.



Step 8

The finishing touches

The chain will be stronger if the links are soldered. Once assembled apply a small piece of cut easy solder. Coax the solder to flow by using the soldering probe, and apply flux. This will be more easily achieved using a fine soldering torch such as the Dremel Versaflame indicated. Solder the links and jump rings in the same manner. When soldering close to any spring loaded clip mechanism be sure to use a fire brick to deflect the heat.

Use heated clean water only to clean the flux away from chain link mechanisms, in case there is steel in the spring which may contaminate the silver if pickled.

Once cleaned and dried, the chain can be brushed to a pleasant finish using the brass wire brush.



Job done! The locket is now ready for hallmarking.