



# Make a simple silver box

by John Ross

## Step 1

### Getting started

To start, take a piece of 85mm x 10mm, 0.6mm sterling silver sheet. Using the steel bar bend the sheet using the rawhide mallet. Then file a neat joint surface and solder together using enamelling solder.



## Step 2

### Hammer time

Pickle the silver outer body, clean and dry. Then hold a small piece of lead and lightly hammer, using the triblet and planishing hammer, through the lead onto the soldered seam. This will gently lay the seam flush on the inside without distorting the main body. Finally using a fine file clean any excess solder and material from the outside edge.



## What you'll need:



<i>Piercing saw</i>	999 738
<i>No.2 cut saw blades</i>	999 4353
<i>Planishing hammer</i>	997 3111
<i>Rawhide mallet</i>	997 3118
<i>Triblet stake</i>	997 3616
<i>Domed stake</i>	997 174D
<i>Soldering probe</i>	999 AAFA
<i>Short length of clean 20mm steel bar</i>	
<i>Small amount of 0.6mm thick silver sheet, 40 x 85mm</i>	CSA 060
<i>Enamelling silver solder</i>	CTE 500
<i>Hard solder</i>	CTD 500
<i>Tenacity No.5 flux powder</i>	PZZ 050
<i>Argo-tect</i>	PZZ 090



## Step 3

### Hammer the body

Using a rawhide mallet hammer the body lightly until egg shaped, hammering either end of the triblet alternately.



## Step 4

### Perfect the edges

Using either a grind stone, or emery paper on a flat surface, grind the edges of the body until flat. Then use a circular motion to deburr the edges.



## Step 5

### Polish the inside

The Dremel 3000 (999 3321) with a flexible shaft and a felt mop and Tripoli polish is an ideal tool to use for this.

## Step 6

### Prepare and solder

Take a piece of 25mm X 30mm, 0.6mm sterling silver sheet and polish the surface, this will be the inside surface for the base of the box. Then mix a thin paste using Argo-tect and methylated spirit and paint the polished inside surfaces of the box, this



will help to protect the polished surfaces from fire stain. Allow the meths to dry or gently burn off. Then apply a small piece of hard solder to the outside base of the main body and coax it around using the soldering probe. This will enable the use of less solder. Allow to cool and place in a pickle to clean. Once clean and dry, cut the excess material away using a piercing saw.

## Step 7

### Make the lid

Take another piece of 25mm X 30mm, 0.6mm sterling silver sheet. Planish it onto the doming stake, hammer in circular rings from the middle working outwards until the sheet is lightly domed.



Then lightly file the top edge of the main body, until it fits comfortably onto the inside of the domed lid.

Mark a line about 2mm from the top edge which is parallel with the flat base. Then using a piercing saw carefully start to cut around the line, but only start and stop as soon as a small hole in the sheet appears. This is to act as an air vent during soldering. Complete cutting the lid off after soldering.

Paint the inside surfaces again with Argo-tect and solder the domed top, using the same technique as before. Allow to cool and pickle till clean. Check to make sure that the cut hole is still open and if not carefully reopen it. Then gently heat pointing the cut hole away from you into a suitable receptacle until the pickle is expelled from inside.

## Step 8

### Polish the lid

Using the piercing saw once again cut off the excess material from around the top of the box lid and then file around the side of the box. Then remove any hammer marks on the top using a fine flat file and polish the whole box carefully, without rounding any sharp corners.

Re-mark the line marking the cut line for the lid and carefully complete cutting off the lid. Roll the saw forward whilst cutting to avoid cutting on the underside. Grind or sand the two cut surfaces until flat and deburr.

Make the lid bezel using a piece of 4mm x 85 mm, 0.6mm sterling silver sheet. Shape as before and carefully fit the bezel into the inside of the cut lid. Then solder the seam using enamelling solder. Pickle the bezel and polish the inside edge as before in preparation for soldering into the lid.



## Step 9

### The finishing touches

Paint the whole lid inside and out with Argo-tect, then solder the bezel in place into the lid using hard solder.

Apply a small amount of solder into the inside edge only and coax it around using the soldering probe.

Pickle the whole box and when clean and dry assemble the box and give it a final outside polish whilst assembled and then polish inside. Degrease the box, which you can do using a variety of products available at Cooksongold and that's the finished box.

**Top tip:** Check out our other projects to learn how to turn this box into a locket.