Cooksongold Tutorial
Heimerle + Meule Group

Level of design: ***Intermediate***

Cabochon Ring with Gallery Strip Setting

By Lydia Niziblian

Find out how to create a ring featuring an inverted heart gallery strip cabochon gemstone setting in this step by step tutorial.

What you'll need:

Your choice of metal for the ring band, such as Sterling Silver D Shape Wire 3mm x 2mm Sterling Silver Sheet 1mm or Sterling Silver Round Wire 1.5mm	*LSA 150 CSA 100 HSA 150*
Saw Frame	*e.g. 997 3322*
Saw Blades	*e.g. 997 3323*
Nylon Ring Bending Pliers	*e.g. 999 716*
Needle Files	*e.g. 999 528*
Hard Silver Solder Strip	*CTD 500*
Soldering Equipment	*e.g. 999 096Q*
Round Marked Triblet Sizes A-z+6, Steel	*e.g. 997 3601*
Rawhide Mallet	*e.g. 997 3118*
Sterling Silver Inverted Heart Gallery Strip	*NVZ 029 or NVZ 020*
10mm Round Cabochon Gemstone	*e.g. 61AG CA01 or 61AG GA10*
Side Cutters	*e.g. 999 3053*
Easy Silver Solder Paste	*PAT 021*
Sterling Silver Sheet 0.5mm	*CSA 050*
Steel Mesh (optional)	*e.g. 860 092*
Wet and Dry Paper	*e.g. 975 070*
Polishing Equipment	*e.g. 999 096E*
Metal Burnisher or Agate Burnisher	*e.g. 999 AJL e.g. 997 1662*

Step 1

Shape Your Metal

Cut the chosen metal for your ring band to the desired size, then use your ring bending pliers to bend the metal for the ring band so the edges are touching.

Step 2

File the Edges

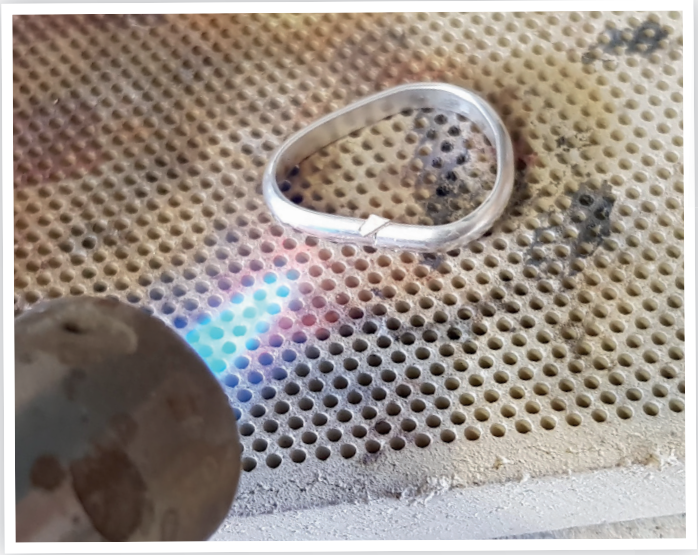
Use a flat needle file to make sure the two edges of the metal are clean and fit together snugly.

Hold the ring up to the light when the edges are pushed together to ensure you have a good join.

Step 3

Start Soldering

Place a small pallion of hard solder onto the join of your fluxed ring, and solder then quench.



Step 4

Form the Ring

Place the ring on the triblet and tap with a rawhide mallet to shape.

Step 5

Tidy Your Work

Use a needle file to tidy up the ring. If using a D shape band, file a flat plane on the edge as this will make it easier when soldering onto the gallery strip setting later.

Step 6

Cut the Gallery Strip

Wrap your chosen gallery strip tightly around your gemstone. Cut at the overlap using side cutters, or mark and saw where required. Use ring or half round pliers to line up the edges neatly, ready to solder.

TIP: Ensure your overlap is neat, so the pattern of the wire will run smoothly.

Step 7

Solder the Setting

Flux the join and place the gallery strip on a tiny pallion of hard solder. Solder, heating gently to avoid overheating the wire edges. Quench, then check the gemstone fits comfortably into the setting with no gaps. Remove the stone.

Step 8

Add the Base

Flip the setting over, and syringe easy solder paste around the base, then pace the setting onto a piece of 0.5mm sheet just larger than the setting.

Ideally you want to heat the piece from beneath to avoid melting the gallery strip, so use steel mesh to raise the setting and heat from below then quench.

TIP: Alternatively, you can turn the setting upside down and heat the base of the setting to solder.

Step 9

Cut and File

Carefully saw around the base of the setting and use a needle file followed by fine wet and dry paper to file the setting smooth. You should now have a smooth bezel cup ready to solder to your ring band.

Step 10

Solder and Pickle

Place the setting upside down on your soldering block, squeeze a small amount of easy solder paste into the centre, and hold your ring band in place with tweezers.

The flat edge you filed earlier should be flush to the back of the setting. Solder the pieces together, then quench and pickle.

Step 11

Polish the Ring

Polish the settings using your preferred method (using a barrelling machine is ideal for this). Gently push your gemstone into the clean, dry and polished setting.

Step 12

Set the Cabochon

Use a burnisher to gently push the setting over the stone. Start at the cardinal points, and gradually work your way around, ensuring the setting is flush to the top of the stone. If needed, give your piece a final polish.