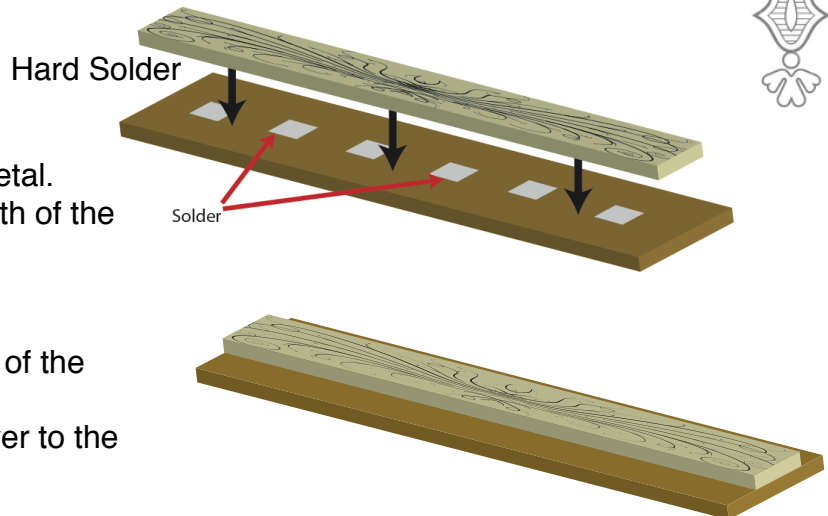


Soldering a Ring

USING HARD TO EASY SOLDER

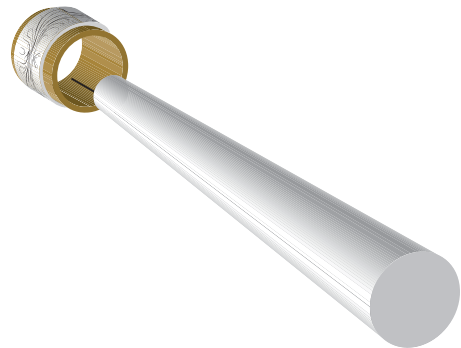
Hard Solder

1. First, brush flux to the base layer of metal.
2. Next, place hard solder the entire length of the base metal.
3. Melt down the solder.
4. Then, flux the etched layer of metal.
5. Carefully align the etched layer on top of the base layer with melted solder.
6. Finally sweat solder the top etched layer to the bottom base layer.



Tap Shape with Mandrel

Place a mandrel in the table vice or use a narrow end anvil and tap the ring round with a leather / rawhide mallet.



EASY or Medium Solder.

Ends MUST be lined up perfectly without any gaps. Some filing or sanding may be required. You MUST work the metal back and forth with pliers in order to line up the metal end to end.

Finish:

File all edges with rounded needle file.

Sand surface imperfections from 200-600 grit sandpaper or sanding stick.

Polish with ring clamp and buffing machine, or use a buff tip and Dremel Tool. Start with Tripoli, then Rouge

