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Mark Nelson demonstrates how to forge a neckwire.

Please continue to page 2 for project instructions.

Guest:

Mark Nelson

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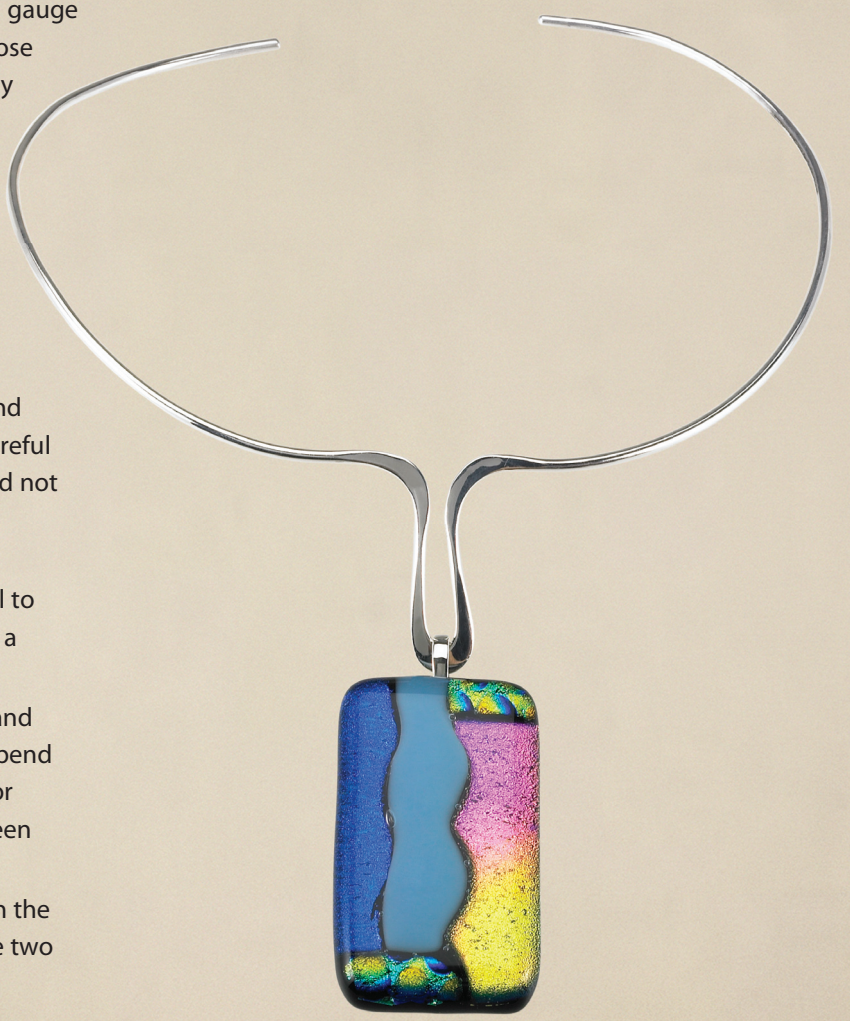
Making A Forged Neck Wire

For the neck wire, use about 18–22 inches of wire; 8–12 gauge round wire is good to start with. For this project, we chose 10 gauge sterling wire, but the project is suitable for any type of thick wire. **Please Note**: The small amount of metal working required for this neck wire shouldn't cause undue work-hardening, so that annealing should not be necessary to restore lost flexibility.



Steps:

1. Fold the length of wire in half, place it on an anvil and pinch the bent end using a mallet or hammer; be careful not to pinch it completely flat—the two wires should not be touching. Lay the pinched area flat on the anvil.
2. Using a ball peen or flat face hammer, flatten the pinched end so that it spreads out evenly. Be careful to avoid thinning out the wire too much; leave at least a 1mm-thick edge.
3. Mark each wire about 2" up from the pinched end, and bend the wire outward at a 90° angle. Hammer the bend so that the bend evenly spreads out. Do the same for each bend, taking care to maintain symmetry between the two bends.
4. Using a mallet or bending by hand, form the wire on the neck mandrel. It typically takes a combination of the two to get to the correct shape.
5. Once the correct shape is obtained, file or sand as necessary and then polish. **Note:** If done properly, there should be very little or no need for filing after forging.
6. Complete the neck wire by sliding on a pendant.

Note: Neck wires may need to be adjusted for each customer. You might offer a fitting for each customer.

See next page for forging notes, safety notes and supply list.

⚠ **CAUTION!** Always wear eye protection when performing these processes.

Forging Notes

- Make sure all of your working surfaces are as highly polished as possible—hammers and anvils.
- Make sure the anvil is at a comfortable and secure working height.
- Don't work the metal too far or make it too thin. For this project, there is no need to anneal the metal, but in other situations you may find that you will need to anneal in order to continue. The metal makes a high-pitched 'ting' sound when it becomes work hardened, or it won't move at all.
- Ensure that your grip on the handle is relatively light. Very little strength or force is needed to forge; let the weight of the hammer do the work. Your job really is to just direct the blows.

Safety Notes

- You might need ear protection.
- Keep your fingers out of the way.
- Relax and let the hammer do the work.

Supplies:

Order #	Description
112-309	Neck mandrel
113-812	Anvil
113-834	Anvil stump
100-312	Sterling silver round wire, 12ga.
100-310	Sterling silver round wire, 10ga.
112-406	Peddinghaus forming hammer
201-659	Ear protection
201-054	Citation safety glasses