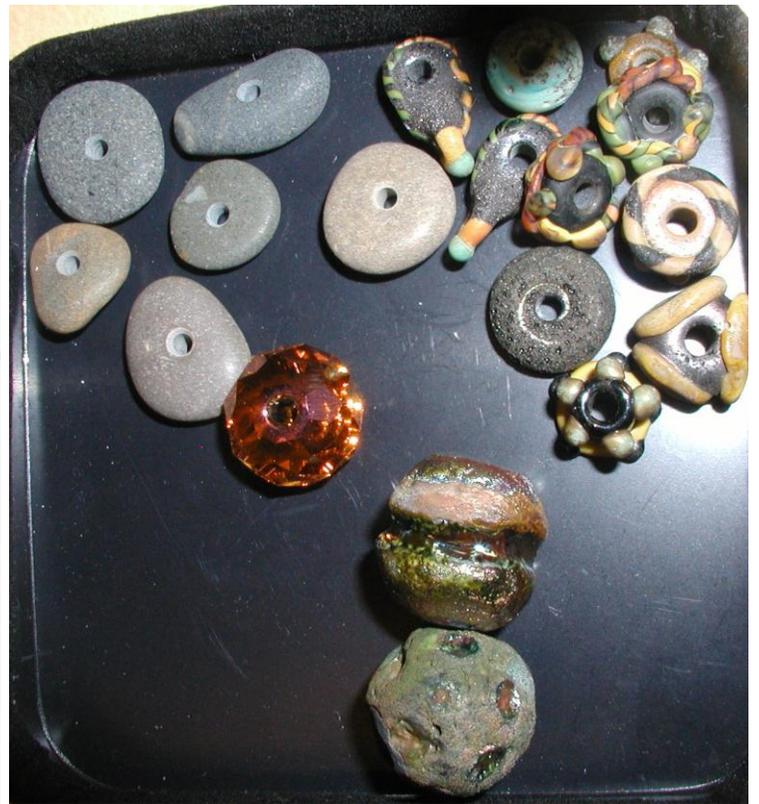


1505-3

Kim St. Jean shows how to measure, solder and texture thick silver wire to make the “Floating Bead Bangle” bracelet.



Tools:

- Titanium soldering pick
- Solderite soldering board
- Butane torch
- Anvil/bench block
- Small ball peen hammer

- Bracelet Bending Pliers and/or mandrel
- Bangle gauge
- Wire cutters
- File
- Cross locking tweezers
- Copper tongs
- Pickle and pickle pot
- Brass brush

Materials:

- 8-1/4” inches 14g sterling silver wire, depending on the size of the fist the bangle needs to fit over
- Lampwork bead or rock with 3mm hole
- Medium silver solder paste

Instructions:

1. Use a bangle measuring tool to determine how much wire is needed to make your bangle. Tip: Bangle measuring gauge from Eurotool.
2. Cut the wire to the appropriate length and file the ends of the wire flat on both ends.
3. Use bracelet bending pliers or a bracelet mandrel to form a circle with the wire.
4. Line up the two ends of the wire as close as possible. If necessary adjust the ends of the wires with a file.
5. Place a bead that can withstand the heat of the torch on the bangle wire. Tip: stone or lampwork beads work well.
6. Put a 2mm size ball of solder on the joint of the bangle
7. Lay the bangle on your soldering board with the bead dangling over the edge of the solder board.
8. With a torch, begin moving a medium flame around the wire gently heating up the entire bracelet. Move the flame to the area around the solder joint and begin heating.
9. After the solder flames up and dies back down, the solder should flow within 30 seconds.
10. Turn the bangle over and briefly heat the joint again to ensure the solder flows all the way through the joint.
11. Hold the bracelet in the pickle by the bead with your copper tongs.
12. Rinse and brass brush
13. Use a file to remove any excess solder
14. Lay the bracelet on your bench block and gently texture the surface with a lightweight ball peen hammer
15. Reshape if needed using a bracelet mandrel.

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Guest:



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