

How to make simple round basket setting

By Peter Keep

This tutorial shows the making of a simple four claw setting that can be made into a pendant or a setting for a ring.

To view the video, check it out under the free videos collection.

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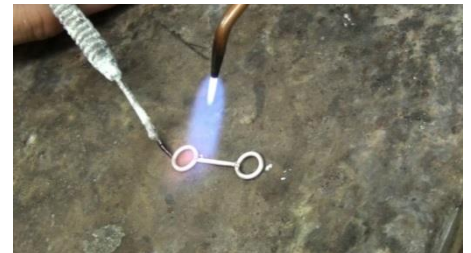
This project starts with a 7.5mm round CZ and sterling silver round wire 1.2mm x 110mm.

Anneal the wire and find a stake to form two jump rings. To calculate the correct size stake to use, deduct 2.4mm (2 x wire thickness) from the stone diameter.



Clamp the end of the wire between your vice and the stake and wrap the wire tightly around, enough to cut two perfect jump rings.

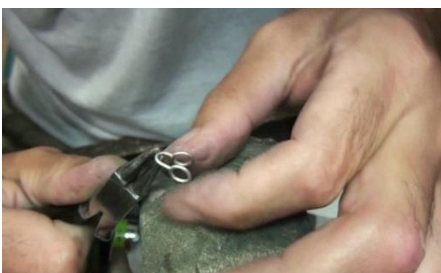
Check the outside diameter to make sure it matches the stone size or place the stone on top to ensure that the jump rings can barely be seen from top view.



Cut the jump ring coil and close the joints. Make sure the joints are lined up perfectly with no gaps.

Cut an 11mm piece of wire. Make sure it is straight. File the ends flat.

Bridge the wire between the joints and hard solder making sure that the components are perfectly symmetrical.



Clamp the bridging wire in the middle with round nose pliers, and carefully bring the two jump rings together.

Make sure they line up perfectly and stay parallel.

Do not squeeze too tight onto the wire with your pliers, as this will distort the bridging wire (the future bail)



Find a piece of metal sheet or a metal ruler that is approximately 1mm in thickness and tighten the jump rings onto it using parallel pliers.

It is a good idea to either fold a piece of paper over the silver or stick masking tape onto the plier jaws to prevent tool marks.

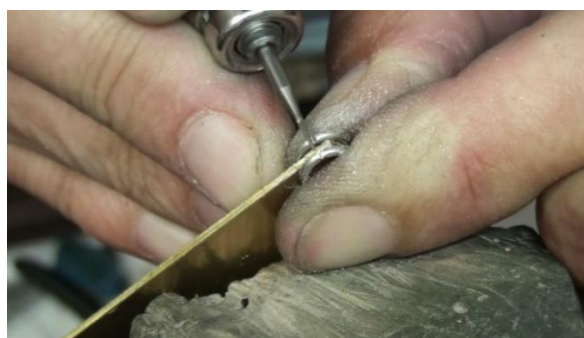


Mark out the four claw points on top of one of the jump rings.

The bridging wire needs to be positioned perfectly between two claws. It is good practice to perform your initial marking by eye. Use your dividers to ensure the spacing is perfect.



Hold the setting on the spacing metal to prevent movement whilst you perform the cut work. Use a 4/0 blade and cut from the top markings into both rings. Ensure the blade is perfectly square to the setting. Once the marks are cut in, double check with your dividers that the spacing is still positioned correctly.



Follow the saw cut with a three square needle file to widen them. Then use a 1mm tapered bur to shape the grooves. Bur approximately a third of the way into the wire thickness. Alternatively you can also use the shaft of a 1mm drill, or a slotting file if you have one.



Ensure that the remaining wire is straight, and clean it with 1800 emery paper before cutting four 10mm pieces. This will ensure that the claw wire is free from grease and oxides.

Flux the grooves on the setting and position one flux-prepared claw at a time. Solder using a minimal amount of medium solder. Make sure the claws are square to the setting and protrude longer on one side.



Check to make sure each claw is perfectly square to the setting before quenching and pickling the setting.

Force one jaw of your round nosed pliers into the bail to open it out; the other jaw should carefully shape it. Be careful not to add unnecessary tool marks.



Level off the top of the setting leaving 2mm – 3mm of claw wire for setting the stone.

Carefully file off any excess solder and remove any tool marking. Prepare for polishing with emery paper up to 1200 grit. Use cotton string rubbed with Tripoli or Hyfin followed by rouge to get into the small or tight places.



The quality of the finish reflects your workmanship

Once you master this technique you can apply the same principles to other shaped stones and other types of jewellery.