

This lesson shows you how to make a traditional oval shaped hinged locket.

This will teach you traditional goldsmithing techniques and prepare you well for complex jewellery repairing. To complete this project, you need advanced fabrication and soldering skills. I recommend that you complete the first four stages of the online apprentice program first.

Materials used; Sterling silver 0.7mm x 30mm x 20mm sheet, 1mm x 5mm x 80mm strip, 2mm outside diameter tube x 30mm long and 1mm x 1mm x 60mm square wire if you are going to make the twist wire border.



## Step 1:

Locket designs can be made in various shapes and complexities. You must consider where the hinge will be attached when designing the shape of your locket. The more complicated the shape, the more work will be required in fitting the internal flange and hinge neatly. The locket featured in the video has been decorated with a twisted wire border. I advise that you keep the first one simple.



## Step 2:

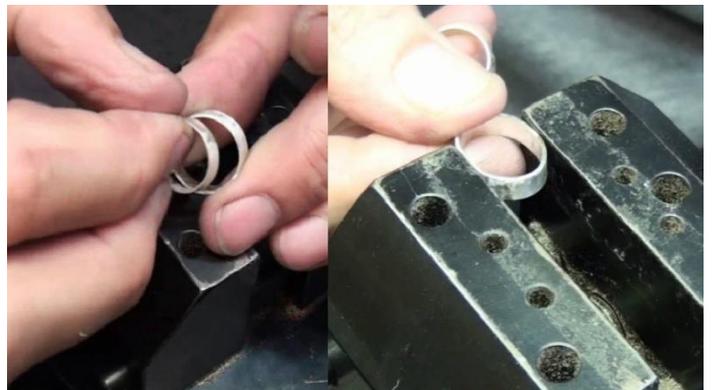
Make up the frame bezel using the 1mm x 5mm strip. Make sure it will fit comfortably onto half of the sheet dimensions. Solder it using hard grade solder then pickle to remove the oxides. Form it into a perfect round shape using a mandrel making sure it does not take on the taper of the ring mandrel.



## Step 3:

You can now roll the remainder of the strip to 0.5mm x 3mm to make the inner flange. It will be easier to make the flange to fit perfectly into the round bezel now, rather than try to fit it into the oval shape later.

Force the bezel into an oval shape using a vice making sure that you do not impart tool marks. Shape it so that the solder joint is on the long side (soft curve) Do the same with the inner flange and make it fit snugly.



### Step 4:

Mark a centre line along the frame with your dividers then saw pierce along the line with a 4/0 or 5/0 blade. This is just to start the separating process.

Cut right through at just a small section. This will allow hot air to escape when soldering the top plate later.



### Step 5:

Mark around the frame onto the sheet and pierce out for the top plate. Make sure it is a little larger so that it will over-hang when it's soldered.

Now solder the frame onto the remainder of the sheet. I recommend using hard solder again but pre-anneal the frame first to help reduce the chance of metal movement or the frame joint opening.



### Step 6:

Locket look more attractive with a domed face. Slightly dome the top plate with a large doming punch. The edges must remain flat to attach to the frame. You can tap around the edge of the domed plate with a chasing hammer on your block until its flat. Finish by rubbing it on emery paper, ready for attachment.



### Step 7:

Now cut the locket base from the sheet and set it up for soldering to the top plate. Use the slight over-hang to place your pallions of solder. Use medium solder.

Once both plates are soldered DO NOT put it in the pickle, as the pickle solution will enter the locket through the opening. Allow to cool and trim off the waste section of the top and bottom. Emery the locket



### Step 8:

Now carefully cut the locket in half. Clean up the flat base section and fit the inner flange. Both sections should close back together with the flange acting as an alignment piece. Perform any required trimming and shaping before soldering with medium grade.

Once it has been pickled, fit the two parts together and file out a slot at the side for the chenier to sit into around a third of its depth.



### Step 9:

The lesson includes instructions for making chenier tube. Cut a section of chenier to fit into the slot. Mark out for the centre section and cut out half the section along the seam so that you can remove the full section later.

To make an effective solder barrier the traditional way, make a rouge paint by softening the rouge compound with mentholated spirits. Coat the slot in the top section of the locket. Pay attention to the area that comes into contact with the base. The rouge will prevent the two separate halves being accidentally soldered together.



### Step 10:

Once the top is sufficiently coated, place the two halves together. Be careful not to spread the rouge onto the bottom half where the chenier will be soldered. Place the chenier into the slot making sure the chenier seam is in contact with the bottom piece of the locket. Carefully solder the chenier at the two points of contact. Use easy grade.



### Step 11:

Cut out the centre bridge section of the chenier. You now have two aligned cheniers. Cut a new piece of chenier to fit the gap. Repeat the process with the rouge paint on the bottom section. Place the two parts together again and solder the chenier to the top plate.

Solder a jump ring to the top of the base section ready for a bail. Now prepare the rivet pin, which is usually the same metal as the chenier. This allows for even wear. File a slight taper on the pin and inset it into the chenier.



## Step 12:

Place the locket on the edge of a steel block in the upright position with the fat end of the rivet in contact with the surface of the steel block. I use a Dremel (electric hammer) for precision riveting. The other way is to carefully use a punch and hammer. An extra pair of hands may be required. File a slight angle on the case lip opposite the hinge to allow you to open the locket with your nail.

Solder a bail or jump ring onto top of locket and finally remove all tool marks and polish.

