



Jewelry Making Daily

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Learn Metal Stamping
for Design, Texture,
or Words



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SPEAK YOUR HEART

Stamp, texture, and rivet a one-of-a-kind cuff.

BY TAYLOR SALEEM

Stamping metal is a fun way to customize jewelry designs quickly and permanently. It works well on several kinds of metal, and you can highlight your stamped designs with many coloration methods and patinating agents. Truly, the sky's the limit!

In this collection, we offer three projects to encourage you to grab a hammer, a few stamps, and some metal, and give metal stamping a whirl.

Use metal stamps to create texture and whimsical patterns as you whip up Kate Richbourg's Riveted

Flower Rings. Add a personal touch by stamping words into metal in Taylor Saleem's Speak Your Heart bracelet design. Finally, expand your skills and throw a disc cutter into the mix as you combine three metals and accent them with decorative stamping in Joanne Ortiz's earthy Warrior Princess earrings.

Whether you're looking to make a patterned design, add some texture, or personalize a piece, incorporate metal stamping into your process for custom, one-of-a-kind jewelry.

Happy stamping!
Mallory Leonard
Associate Editor, Interweave Jewelry Group

riveted flower ring

Turn stacked metal
blanks into blossoms.

By Kate Richbourg



The focal bead for this project has a hole that is slightly loose on 14-gauge wire, so it has some wiggle room to spin on the wire. Movement also prevents the bead from cracking and breaking. If you are nervous about using a glass bead, use a metal one, or stack metal components. Or, try the small and large flower charms from Glass Garden Beads. These are flat flower components made from recycled bottle caps and are perfect for adding a touch of whimsy to your design.

tools & supplies

- 7x1mm flat sterling wire, 3½"
- 1 focal bead, hole must fit 14-gauge wire
- 1 sterling 24-gauge 1" flower blank
- 1 copper 24-gauge 19mm 8-petal flower blank
- 14-gauge copper wire, ¾"
- Steel bench block
- Brass hammer
- Chasing hammer
- Riveting hammer
- Fretz small embossing hammer (or any small hammer with a similar tapered head)
- Plastic or rawhide mallet
- Power Punch Pliers or drill fitted with a 3/32" bit
- Heavy-duty flush cutters (must be able to cut through 1mm or 17g flat wire)
- Round-nose pliers
- Table vise
- Wooden dapping block
- Large wrap and tap pliers or nylon jaw ring-bending pliers
- Metal ring sizing mandrel
- Half-round needle file
- Liver of sulfur or Silver Black
- Pro Polish polishing pads



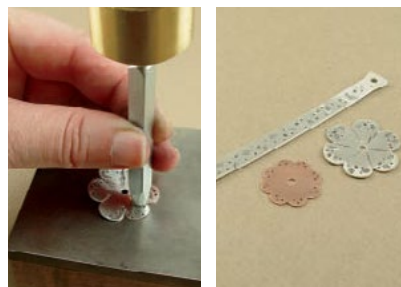
1 Use 3½" of flat wire for a size 8 ring band. Adjust the size by measuring ⅛" more or less wire for each half size up or down. The ring size is an estimate at this point, adjustments will be made later in the project. Use a chasing hammer and bench block to flatten and spread ¼" on one end of the wire.



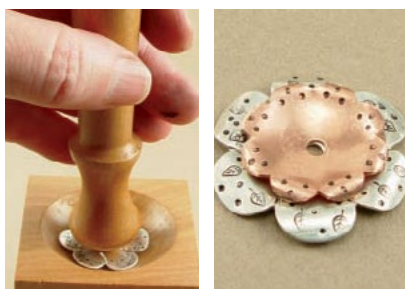
2 Use the permanent marker to place a dot ⅛" from the end on the flattened end of the wire. Use the 3/32" die in the Power Punch pliers to punch a hole at the dot. Also punch a hole in the center of the flower and petal blanks.



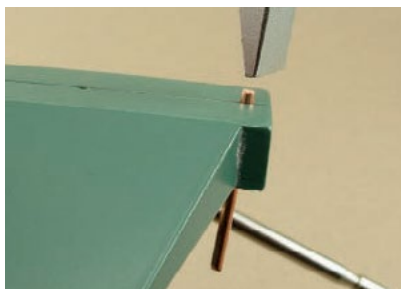
3 The flower blank used for this project had a loop attached to the top. Remove the loop with wire cutters and use a fine file to remove any burrs left by the cutters.



4 Stamp a random pattern of dots and on the edge of the petals of the large flower blank. Stamp the smaller copper blank with a pattern of three dots on the tip of each petal. Oxidize and polish each of the pieces.



5 Use a wooden dapping block to slightly dome each flower blank. Use a plastic mallet to strike the wood daps. To further shape the blanks, use round-nose pliers to slightly roll each petal under at the tip.

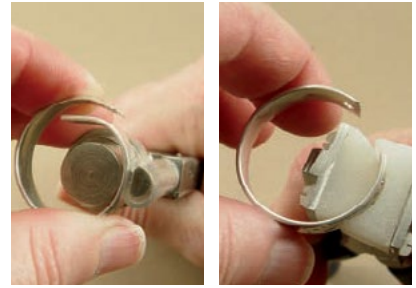


6 Clamp the 14g copper wire securely in the vise, leaving about 1/16" of wire above the jaws of the vise. To form a rivet head, tap the top of the wire using the long side of a riveting hammer first across one direction and then the other. Finish tapping with the round head of the hammer. Check the size of the rivet head by placing the wire through the hole in the ring band to make sure that the rivet will not slip through the hole.



wire tips

- To make a perfect rivet, make your hammer blows precise by not lifting the hammer too high before striking the wire. Make slow, light strikes. It may take several minutes to make the rivet, but patience coupled with slow and steady strikes will do the trick.
- My vise has rubber covers on the jaws which prevent the ring from being marred. You can also use felt or fabric to cover the jaws.



7 Use a large Wrap and Tap pliers or nylon jaw ring-bending pliers to form the ring band into a circle.



8 Slip the band onto a metal ring mandrel to size. If the ring is too large, cut the band down to size using the heavy-duty flush cutter. File the cut end smooth. Flatten the cut end as you did in Step 1. Pull the cut end out slightly so the wire lies flat at the end. Place that end on the bench block and use a chasing hammer to flatten and spread the end.

9 Curve the wire back into the band shape. The ends of the band need to overlap about $\frac{1}{4}$ " to leave enough room for the rivet holes to line up. Use a fine-tip permanent marker to mark placement for the second rivet hole.

10 Pull the band out one more time and use the Power Punch pliers to make the second rivet hole. Reshape the band and line up the rivet holes. Insert the wire rivet through both holes and stack the flower components on top. Slide the ring tightly on the metal ring mandrel.



11 Cut the rivet wire, leaving about $\frac{1}{16}$ " above the bead hole. Clamp the ring on the mandrel, in the jaws of the vise. Use a small embossing hammer or similar hammer with a small tapered head, and using short light blows, spread the top of the wire into a rivet head. Check the rivet as it begins to spread to make sure the components can move freely on the rivet wire, but not fall off the end. When you have finished the rivet, check the interior of the ring; if the rivet feels a little rough, use a half-round file to smooth it out.



Simply put, **Kate Ferrant Richbourg** loves jewelry. She loves to teach it, make it and wear it! Kate has been teaching and designing jewelry since 1992.

She teaches at national shows, bead societies and bead shops, and is published in a variety of jewelry magazines. She has also appeared on several episodes of the DIY and HGTV network shows DIY Jewelry and Craft Lab. She currently rocks the Director of Education post at Beaducation.com. Contact Kate at katerichbourg@gmail.com.



tools & supplies

- 16-gauge copper wire, 6"–8"
- 20-gauge 2" sterling ball headpins, 2
- 22-gauge or 24-gauge 1½" brass disc
- 26-gauge or 28-gauge soft round sterling wire, 2½'
- Copper rolo chain, 5"
- Ruler
- Flush cutter
- 1000-grit sandpaper and/or metal file
- Ball-peen hammer
- Flat-nose pliers
- Round-nose pliers
- Plastic or rawhide mallet
- Liver of sulfur or handheld torch
- 000 or 0000 steel wool and/or brass bristle brush
- ¼ drill bit
- #56 (.047") high speed miniature drill bit
- Dremel or other rotary tool
- Metal design stamp
- Disc cutter with 6mm and 8mm sizes
- Center punch
- Fine-point Sharpie
- Circle template
- Steel bench block
- Metal shears
- Brass hammer
- Preserving wax (ex. Renaissance Wax)

Resources: Copper rolo chain, copper wire: Monsterslayer, monsterslayer.com. Brass discs, silver wire: Thunderbird Jewelry Supply, thunderbirdsupply.com.

warrior princess

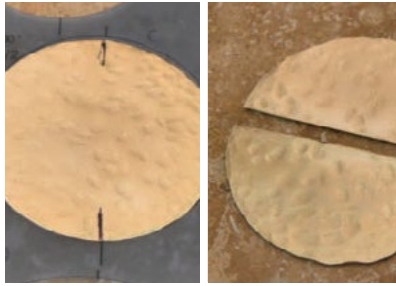
Mixed metal showpieces.

By Joanne Ortiz

I am such a fan of mixing metals for jewelry designs. The three metals in these earrings give a tribal feel. I will show how to take a few design elements that are staples in my studio, and make a rustic, substantial, yet lightweight pair of earrings.



1 Clean and straighten all of the wire, chain, and the disc with steel wool. Take the brass disc, and hammer it until you get your desired look. Give the disc a few hits from the rawhide mallet to make sure it is flat.



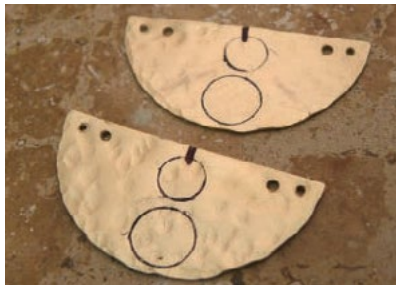
2 Using a ruler or a circle template, mark the diameter of the disc. Cut the disc in half with metal shears. Line up the two halves to make sure they are cut evenly, correct this if needed.



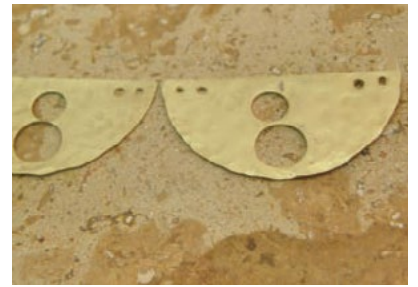
3 Use the metal file or sandpaper and clean the cut edges of the two halves. Round the edges, slightly. With the Sharpie and ruler, find the center of both halves, and make a mark at the cut edge. Measure $\frac{1}{4}$ " in from each edge and make a dot. Eyeball the next measurement. Make a dot halfway between the mark you just made, and the edge of the disc.



4 Punch holes where you placed the two dots in Step 3. Use the #56 (.047") high speed miniature drill bit, and drill holes on the outside corners. Use the $\frac{1}{16}$ " drill bit, and drill the holes at the $\frac{1}{4}$ " measurement. Clean the holes with the mallet and 1000-grit sandpaper.



5 Using the Sharpie, trace two circles using the 6mm and 8mm punches. Use the center mark made in Step 3 as a guide. Trace the 6mm one at the top and the 8mm a little under it. This doesn't have to be exact. Don't draw the circles too close to each other, or too close to the edges.



6 Carefully cut out the two circles made in Step 5 with the disc cutter. Try to line up the Sharpie measurement inside the disc cutter. Make sure to work on a hard flat surface, and make sure the bench block is stable. Use the brass hammer and give clean, hard whacks. In this example, the whacks are slightly slanted, rather than straight down the middle.



7 Make 10 dots along the outside of the circles. Use the photo as a guide. Use the center punch to punch the 10 dots. Drill the four inside holes with the $\frac{1}{16}$ " drill bit. Drill the rest of the holes with the #56 (.047") high speed miniature drill bit. Clean the holes as in Step 4.



8 With the stamp and brass hammer, stamp on each side of the circle design three times. The placement of the stamps doesn't have to be exact. Use the rawhide hammer to flatten the pieces, if needed.

wire tip

Keep lubricating oil and/or water nearby when using the drill. The drill bits tend to get a little hot. Make sure to wear safety glasses, too.



9 With the torch, evenly heat the surface of the disc halves until you get the color you desire. Quench the pieces quickly to get a rustic-looking patina. The metal will soften after being in the flame. Harden the disc halves with the rawhide hammer. Use steel wool to take off some of the fire scale, and go over the pieces with sandpaper to highlight the raised parts. Use a preserving wax to keep the finish and slow down oxidation. Just apply, let dry, and buff until you get a nice sheen. Alternatively, you can get a similar effect by using liver of sulfur.



10 Cut the chain into two equal pieces. You can patina the other components if you wish in a liver of sulfur bath. Wait to clean the components after the whole piece is put together.



11 Cut the 16g wire in half. Make a curve in the middle of both, using the hammer handle as a mandrel. With round-nose pliers, start a wrapped loop, about a 1/2" from the ends. Mark the round-nose pliers so the loops are even. Bend both wires at the same time to ensure both are the same.



12 Put one of the loops into one half disc, into a hole that was marked 1/4" from the edge. Complete the wrapped loop. Repeat on the other side. Reshape the 16g wire. Use the flat-nose pliers to help you bend the 16g wire if needed. With the ball-peen hammer, hammer the curve of the 16g wire. Repeat this step for the other earring, and make sure the curves match.



13 Cut the 26g or 28g wire into four equal pieces. Anchor the wire to the hole on the outer corners of the discs. Start with a 1" tail, add the first link of one of the pieces of chain, and wrap the tail a few times into the hole until the tail is gone. Make a few more wraps from the long part of the wire, until the chain link is secure. Continue wrapping between the link and the metal, around the previous wraps. Use flat-nose pliers to secure the wire to the bundle of loops. Repeat on the other side and the other earring. Clean the chain, the wire, and the arches with steel wool and/or sandpaper.



14 Take the round-nose pliers and make loops at the ball ends of the head pins. Use the mark that you made on the pliers earlier as your guide. Adjust them if they are not the same length, or if the loops are not the same size. On the other end of the head pins, take the 1000-grit sandpaper and remove any burs. Use the Sharpie to form them into ear wires.



15 With the very tip of the flat-nose pliers, make a slight bend at the ends of the ear wires. If you wish, use the rawhide mallet to work-harden the ear wires, or you can use your ball-peen hammer to flatten them. Add the ear wires to each earring.



Joanne Ortiz

a self-taught artist, has been making jewelry for over 15 years.

She recently added handmade findings to her line of lampworked

beads and jewelry. Her husband also makes jewelry with her from time to time, and she has five children who also enjoy crafting. She works from her home studio which her husband built. Her work can be found on her website, thepurplelilydesigns.com. Contact Joanne at purpleli@thepurplelilydesigns.com.

Speak your heart

BY Taylor Saleem

CREATE A UNIQUELY PERSONALIZED BRACELET with a ready-to-use bracelet blank and the sterling silver shapes of your choice.

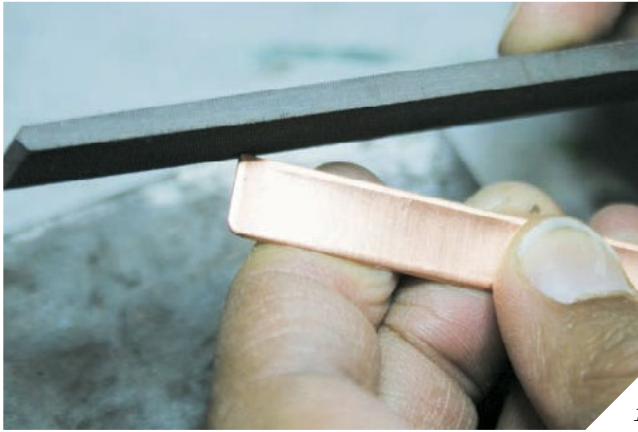


Stamp, texture, and rivet a
ONE-OF-A-KIND CUFF.

TOOLS & SUPPLIES

- 18-gauge copper bracelet blank
- 18-gauge copper wire
- 26-gauge $\frac{3}{16}$ " wide sterling or fine silver bezel wire
- Sterling silver stamping blanks
- Heavy file
- Riveting or ball-peen hammer
- Heavy household hammer
- Steel bench block
- Permanent marker
- Letter stamps
- Butane micro-torch
- Cross-locking tweezers
- Quenching cup
- Center punch
- Hole-punch pliers
- Drill and #65 drill bits
- Flush cutters
- Bracelet bending tool or bracelet bending pliers
- Liver of sulfur
- 0000 steel wool
- Polishing cloth

RESOURCES: Bracelet blank, bending tool, letter stamps: supplyzone.etsy.com. Silver stamping blanks, beaducation.com. Bezel wire, drill bits: riogrande.com.



1. Use the heavy file to round the corners of the bracelet.

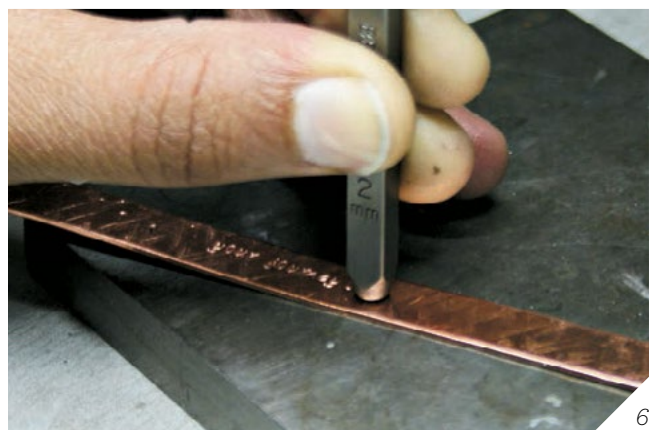
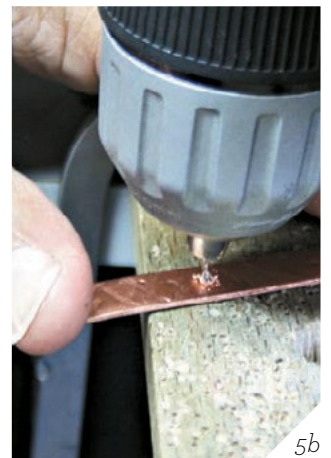
2. Create a pattern or texture on the cuff by hammering it in a criss-cross pattern with the back side of a riveting hammer or the ball side of the ball-peen hammer.

3. Mark the spot for the rivet on the sterling blank with a permanent marker and make a small hole using the hole-punch pliers.

4. Place the blank with the hole where you would like it to be on the cuff; mark this space with the permanent marker.

5. Center the center punch over the mark on the copper cuff and strike it once, sharply, with the household hammer to create a small dent. Use the drill to make a hole through the dent for the rivet.

6. Use the letter stamps to create a special message on the front of the cuff.



another idea

To make a plaque on your bracelet using the bezel wire, first stamp your word or phrase and then make your holes on either side. This way, you'll ensure your word is centered on the silver.



7

7. Cut $\frac{1}{2}$ " piece of copper wire to make a rivet. Use cross-locking tweezers to hold the end of the wire in the torch flame and create a small ball at the end of the wire. Quench the wire in the cup of cool water.

8. Slip the rivet through the sterling blank and copper cuff so the ball is on the top of the silver. Snip the back end of the copper wire, leaving about 2mm extending from the back.

9. Flare the back of the rivet by tapping it with the riveting hammer, then tapping and turning several more times.

10. Turn the bracelet over to the front and strike the balled-end of the wire several times with the household hammer until it begins to flatten.

11. Slip one end of the copper cuff into the lip of the bracelet-bending tool and gently arch the cuff around the curve. Rotate the cuff and shape the other end. Bracelet-bending pliers can also be used to shape the cuff into a C-shape.

12. Dissolve a pea-sized lump of liver of sulfur in hot water and submerge the cuff in the solution. Rinse and dry.

13. Remove some of the oxidization from the cuff by using a small piece of steel wool, polishing lightly to achieve the desired patina.

another idea

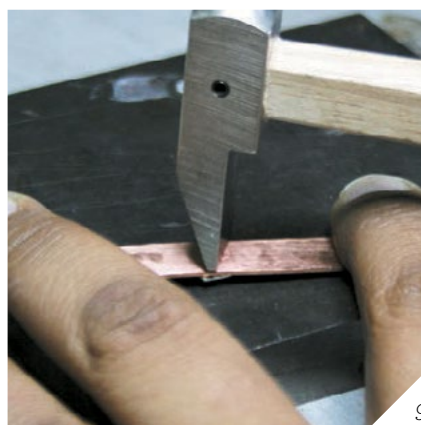
To make the tops of your rivets look like screws, hold a letter "I" from your stamp set across the flattened top and strike it once, sharply.



8a



8b



9



10



11



12



13



TAYLOR SALEEM is a full-time mom and jewelry artist. She started making jewelry in 2003 while working at a local bead store. She teaches workshops from her home

studio in St. Louis, MO, and enjoys hitting the road to sell her works at shows and art fairs. Contact Taylor at rarebirdcreations@yahoo.com. See more of her work at rarebirdcreations.com.

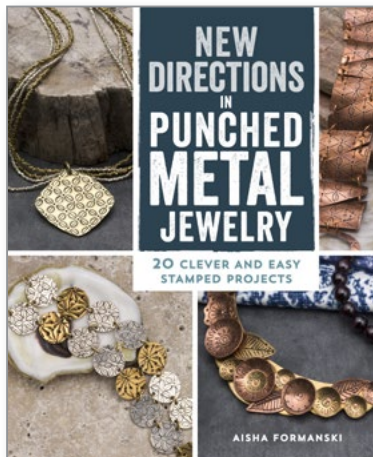


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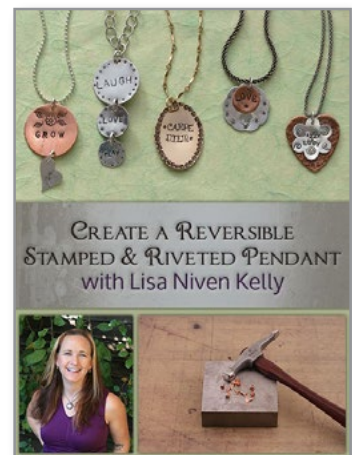
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