



“Rings” in the New Year - Part 3

You can create beautiful seamless rings, with all your metal clays, using a Ringmaker Kit. Ringmakers are made of durable acrylic, are easy to use, and are easy to clean. They can be used over and over again to make perfect rings.

Supplies

The Basics

Teflon Sheet (TFLR)
Badger balm (BHM)
Water and brush
Scalpel (SCP-X)

Clay

Any metal clay!
We used PMC PRO
for strength and
durability.

Other Tools & Components

Ring Sizing tool (PRSIZE or MRSIZE)
Ring Pellet Mold kit (RPM) or
Hattie’s Patties or (HPAT)

Soft Sander Oval (SSO-X)
Ring Sizing tool (PRSIZE or MRSIZE)
Ring Mandrel and Stand (MULTIM)

Firing container (SSFV or FFC)
Coconut Shell Charcoal (CSC1LB)

Finishing

Wire or Brass Brush
Tumbler/Shot
Shine Brite Polishing Compound (SHNBRT)
Agate Burnisher (BTSONE3)
2” x2” Ultra Polishing Pad (ULTPOLPAD)

Step by Step



1) The first step is to determine what size ring you are going to make. There are several types of sizing tools. We used PRSIZE which is both accurate and durable. After you have determined your size, use the conversion chart below to determine which size RingMaker mold to use.

Japanese Size	US Size (after fired)
17	4.5 to 6
21	6 to 7.5
25	7.75 to 9
29	9.15 to 10.50

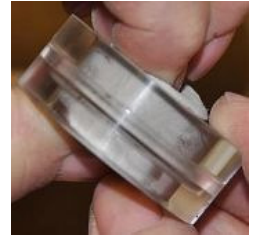
2) Coat the inner surfaces of the mold with a very light film of Badger Balm.



3) Roll a ball of clay that is somewhat larger than the center hole of the RingMaker mold and flatten just a bit.

4) Put the mold parts together and place the clay in the center hole.

5) Holding the mold with both hands, compress the ring parts together tightly and press the clay together with your thumb and forefinger. Make sure the clay gets squeezed into all parts of the mold by turning and continuing to press.



6) Push the small extruder through the center, maintaining the pressure to keep the mold tight. Remove the excess clay.

7) You may leave the clay in the RingMaker for a few hours or overnight before opening it. Before opening, give the mold a slight twist and pull off one side. Remove the ring and allow to completely dry before the final finish and firing. If you are very careful, you can give the mold a slight twist and open it at once. This allows you to see if the ring is properly formed. Allow the ring to dry in half of the mold only until you can easily lift it out without disturbing the shape. Remove the ring and let dry before readying it for firing. If you leave the clay in half of the mold until it is completely dry it will shrink unevenly.



8) Clean the RingMaker of any clay bits and recoat with Badger Balm before re-use.

Flat Band RingMaker

1) The basic process is the same for this ring as the one above with the exception that you have the ability to vary the thickness of the band by using different inserts found in the RingMaker Joint Set.

2) The Basic set includes one insert (joint) which will produce a ring that has a shank width of either 5mm, 8mm or 12mm (3/16", 5/16", or 15/32") and a shank thickness of 2mm (5/64")



3) If you want to make a flat ring shank in any thickness except 2mm, you will need to buy a RingMaker Joint Set in the same size RingMaker you are using. The Joint Set includes three inserts (joints) which will allow you to make ring shanks with a thickness of 1.5mm, 2.5mm and 3.5mm (1/16", 1/10", 9/64").

4) You can remove the joint you are using with the wet clay still in it, set it aside to dry, and create another ring shank immediately of another size.



5) These flat bands make a wonderful canvas to work on. You can apply syringe or other clay parts, carve into them, or use resist to create wonderful one-of-a-kind reliefs. (But that's another Project Guide!)

6) Smooth and refine all the surfaces when the clay is bone dry.



Thoughts About Firing:

1) Before firing any ring that has been created to a specific size, insert an investment pellet in order to maintain that size and shape while firing. You can purchase premade pellets (Hatties Patties) or you can make your own pellets with our Ring Pellet Starter Set. **CAUTION:** Never dispose of investment or any water containing investment in your drains.

2) To use the PMCC Fiber Firing Container, line the bottom of the container with an inch of Coconut Shell Carbon.

3) Lay pieces flat on the carbon with as much separation as possible and cover with another 1/2" on carbon. Our fiber containers are very efficient and **we recommend firing with no lid for PMC PRO.**

4) Place container in the middle of your kiln.

5) For PMC PRO, fire to a temperature of 1400 F degrees for one hour. Follow manufacturer's instructions for firing all other clays.

6) Firing temperature is critical with PMC PRO. Do not fire PMC PRO above 1425 degrees F. A well-calibrated kiln is a must and we strongly encourage you to fire a few small test pieces to understand how PMC PRO responds to your kiln and container before you fire a finished piece. On items which have some degree of thickness, we have found that decreasing the ramp speed from "full" to 700 degrees per hour significantly increases firing success with PMC PRO.

7) When your pieces are finished firing, remove the firing container from your kiln as soon as possible and set on a heat-proof surface. Quench the pieces in cold water and brush with the wire brush. Tumble for approximately an hour.