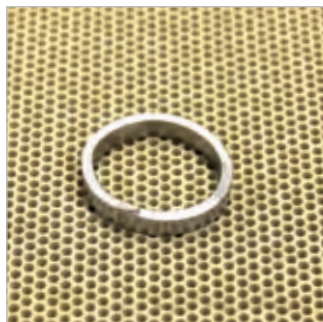
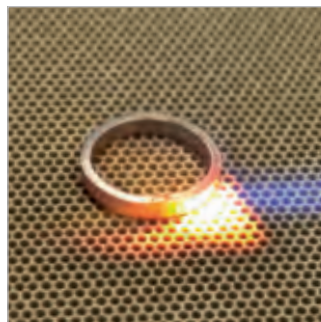




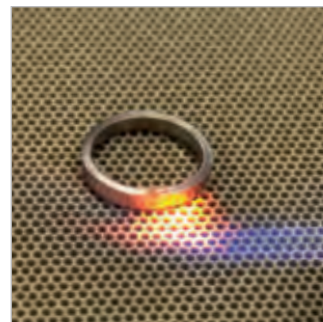
**1** Form the annealed palladium wire for the ring shank around a ring mandrel. Make the ends meet very tightly and neatly with a rawhide mallet and flat-nosed pliers if necessary. Palladium solder is not as smooth flowing as gold or silver, so be sure the seam is as tight fitting as possible.



**2** Place the ring onto a honeycomb board and put a paillon of fluxed medium palladium solder on top of the ring seam. Although there is no need to flux palladium, it is used to hold the solder in position.



**3** As the melting temperature of medium palladium solder is reachable with a standard torch, there is no requirement for special protective eye wear. Turn the torch to a fine oxidising flame: very hot and precise, it will make quite a loud noise.



**4** Using the high, intense heat from the torch, focus the flame around and just outside of the seam area. Unlike with silver, the heat should be directed around just the seam rather than the complete piece. Allow the piece to cool until no longer glowing (at least 2–3 minutes) before placing in water and pickle solution. The pickle solution might not remove the discolouration completely, but cleaning and finishing later will.

### Tip

Keep the solder seam of the ring shank at the base. This will allow further soldering work to be distant from this join, but it also allows the piece to be sized if necessary at a later date.



**5** Measure and mark the centre point along two sides of the base of the central piece. Drill indentations into these marks but do not drill all the way through: approximately 1mm ( $\frac{1}{32}$ in) depth is required. If necessary, extend the width of the holes with the 0.7mm ( $\frac{1}{32}$ in) burr until the two wire pieces slot in tightly and securely.



**6** Measure the top of the ring shank against the top piece drilled in step 5. Mark the position of the two holes and then drill matching indentations.



**7** The two pieces of wire should fit both the top section of the ring and into the upper side of the shank.

Images above captions 5 and 6 have been swapped as incorrect on first printing