

Creating a Gypsy Setting

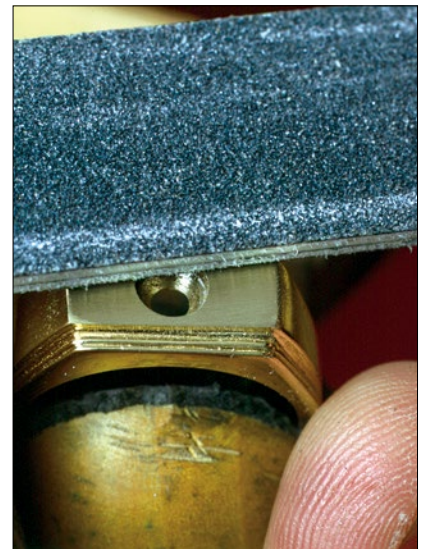
The tools needed for this project include a twist drill; a buff stick; 220-grit, 400-grit, and 600-grit emery paper; a 90° bearing burr; a 45° hart burr; a burnisher or gypsy tool; a three-corner scraper; a silicone wheel; and a highly polished flat graver.



1. Prepare the surface. If the mounting has a pre-drilled hole, smooth the surface with a flat hand file and emery stick to remove any rounded edges. The hole opening and the surface of the mounting should produce a sharp corner.



2. If there is not a pre-drilled hole, create one using a twist drill that is about two-thirds the diameter of the stone.



3. After filing, use a buff stick to remove all file marks from the surface. Start with 220-grit emery paper, switch to 400-grit, then finish with 600-grit. This will create a bright surface and save polishing time.



4. Measure the diameter of the stone and select a 90° bearing burr that is between 0.25 mm and 0.5 mm smaller than that measurement. (For stones that are more than 6 mm in diameter; use a burr that is 0.5 mm smaller; stones this size tend to have a heavier girdle, requiring a deeper cut into the wall to accommodate it.)



5. Use the 90° bearing burr to cut the hole in the mounting. When the top of the burr (the point where the cutting head meets the burr's shank) is flush with the surface of the mounting, the hole is deep enough.



6. The stone should be slightly larger than the hole. Check the fit before proceeding. If the stone drops into the hole, the opening is too large. If that is the case, either use a larger stone or plug and re-drill the hole.



7. Use a 45° hard burr to cut a seat for the stone completely around the inner wall of the burred hole, just above the point where the hole tapers. The seat should be about 0.5 mm deep.



8. Raise one edge of the hole with a burisher to produce an oval opening.



9. Tilt the stone and put it into the opening so it fits into the seat. The stone should fit snugly, with little if any lateral play.



10. Begin tightening the stone with a burnisher. Use the tip to push the metal down onto the surface of the stone at four opposing points. (Think of the face of a clock and push down at 3, 6, 9, and 12.)



11. Compress the metal surrounding the stone with the burnisher or with a gypsy tool—a small, specialized burnisher with a polished, elongated ball point that makes it easier to work around the stone without damaging it—until the metal is tight to the stone. If you are using a regular burnisher, work carefully to avoid damaging the stone with the tip.



12. Level the burnished surface by flattening any high spots with a three-corner scraper in preparation for bright cutting.



13. Use a silicone wheel to pre-polish the mounting and remove any marks.



14. With a highly polished flat graver, bright cut the interior surface of the hole opening.



15. Use a felt buff with rouge to polish the ring, then clean thoroughly.



16. The completed ring.