

# Small Scale Mass Production

## Pricing Information

<http://www.craftsreport.com/may99/pricingcraftwork.html>

[www.jewelrydesignermanager.com](http://www.jewelrydesignermanager.com)

## Suppliers

### Tools and Findings:

[www.riogrande.com](http://www.riogrande.com) - Rio Grande - you name it they have it... including Bellicold

[www.wholelottawhimsy.com](http://www.wholelottawhimsy.com) - rotary tool organizer, sanding sticks & pads and more

### Vibratory Finishing System:

GY-ROC Vibrahone- Model B

Green Plastic Media, Polished Ceramic Media, Burnishing Solution (GRB-5)

Available from :

TAGIT - P.O. Box 1534 San Juan Capistrano, CA 92675 562-949-8380

### Teflon Sheets:

J. Fred Woell - sells thick Teflon sheets - Email: [redwheel@acadia.net](mailto:redwheel@acadia.net)

Shape2BAKE sheets available on Ebay from Stephanie Bartley aka slinky1128

### Stamps:

[www.readystamps.com](http://www.readystamps.com) - 877-267-4341 Request matrix and plate with stamp - if desired, request extra deep matrix and inquire about soft polymer stamps.

**Mold Material:** (see Rio above) Microsonic Inc. 800-523-7672. [www.earmolds.com](http://www.earmolds.com)

**Mini Quiche Trays:** Nancy's Petite Quiche - came from BJ's Wholesale Club ;-)

## Tips, Tricks and Info

- Be organized, layout your space to work for you. Track your designs and materials.
- Use a tray system to rotate stations or make use of smaller space.
- Work in batches of 6-12 of something.
- Think about streamlining movements, processes, combining steps.
- Keep your tools easily accessible.
- Make a template riser from Plexiglas. Cut 2 windows and use strips of plexi to elevate the riser. Try a fine pin to cut out the clay.

- Templates can be organized in plastic trading card sleeves.
- Use teflon sheets to support work and rotate to warming tray.
- Make use of down time or schedule time for paperwork and creating components.
- Don't tax your body with repetitive motion. Take breaks and change positions.
- Use adequate lighting and ventilation.
- If you plan to drill holes after firing, make an indentation in the clay at the spot to drill.

## Mass Finishing Technique

For this process, I use a rotary barrel tumbler with stainless steel shot (be sure to use the correct amount of shot for your tumbler), and a vibratory finishing system (GY-ROC Model B) with green plastic media and polished ceramic media. The advantage of the rotary tumbler is the pounding and hardening effect in the burnishing process. The vibratory system allows faster cutting and burnishing because the media is in constant contact with the jewelry.

### Step one:

After firing, rinse PMC to remove any vermiculite or remaining ash from burnout of cores etc. Load the shot and jewelry into the tumbler. Cover the shot with water add a few drops of Dawn dishwashing liquid (or your favorite burnishing solution). Tumble to desired shine (about 1 hour).

### Step two:

Rinse and separate jewelry from shot. Patina with Liver of Sulfur. Rinse. Place jewelry and green plastic media in GY-ROC bowl. (I use a different bowl for each media to avoid contamination.) Cover the media with water and drain. Media should be wet, but not sitting in water. Run GY-ROC for 20 minutes and check. This step can take from about 20 - 45 minutes or so, depending on your pieces. It is worthwhile to check regularly to avoid removing too much patina.

This light cutting media will also smooth the edges slightly. Some material is removed, but it is less than if you were to buff with an abrasive polish. I don't recommend this step for pieces with keum-boo or very delicate textures. The excess patina in these cases it better removed by hand.

### Step three:

Rinse and separate jewelry from green media. Rinse jewelry again. Place in bowl with polished ceramic media. Wet media thoroughly with distilled water and drain. Add 1/2 teaspoon of GRB-5 (TAGIT) burnishing solution. Run GY-ROC to desired shine (about 30 minutes to 1 hour). Rinse and separate jewelry, and you're ready to add findings etc.

You may need to adjust the amount of burnishing solution. I found that the original recommended amount of 1 tsp. was too much with the distilled water. Some experimentation on your part may be necessary for your particular needs.

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