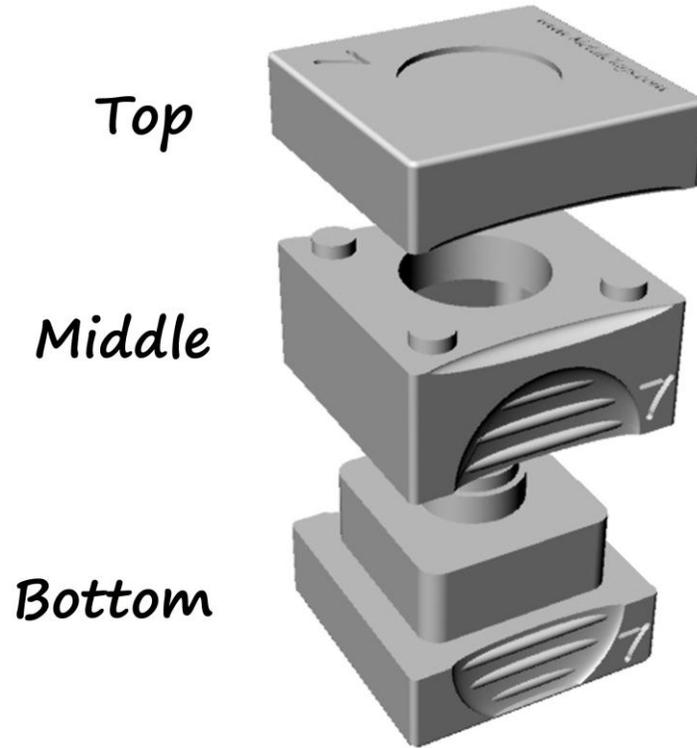


Thank you for purchasing this Bezel Builder. Please review this document to get started

11-13-2013

The parts of your Bezel Builder

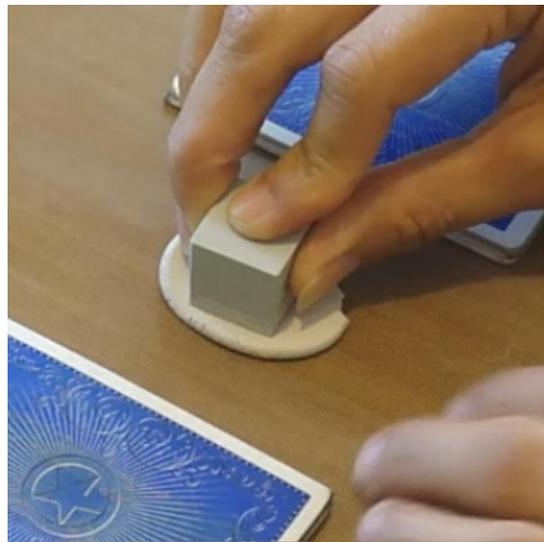


### Instructions for use

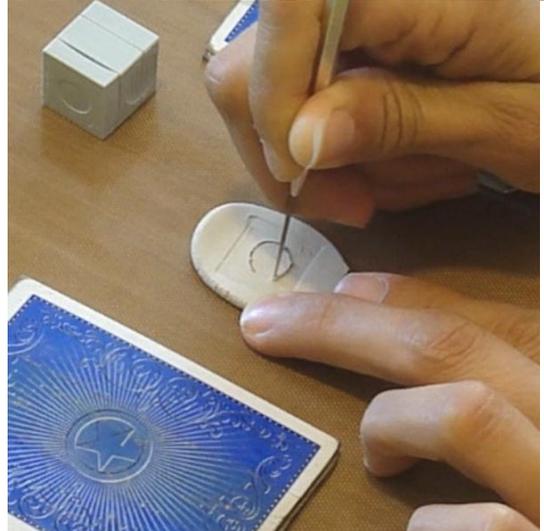
1. Lubricate all 3 parts. Preferably with brush.
2. Roll out clay to thickness require by stone size see (chart on last page)



3. Make light impression using top layer of Bezel Builder.



4. Cut out this shape with needle tool or tissue blade.



5. Placing finger underneath middle layer to block hole while loading through the top your clay cut out



6. Place top layer on the middle layer .Turn upside down and neatly push clay so it evenly fills middle layer shape cavity



7. Now press bottom layer into to the bottom of middle layer.



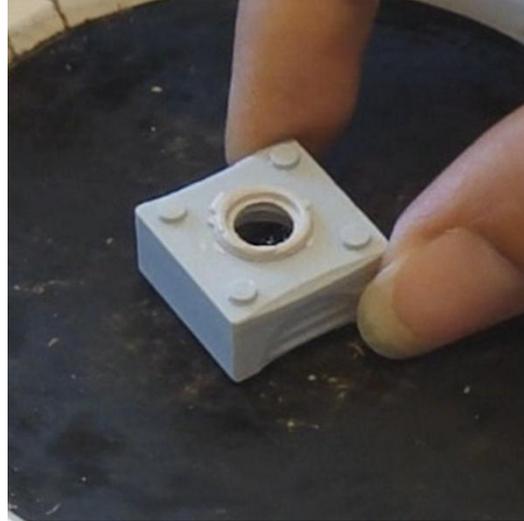
8. Compress with c-clamp if you have (highly recommended)



9. Now place entire mold upside down on table and slowly pull out bottom layer while holding the finger grip of middle layer. The main thing here is to remove the bottom layer before top layer so that clay ends up attached to top layer.

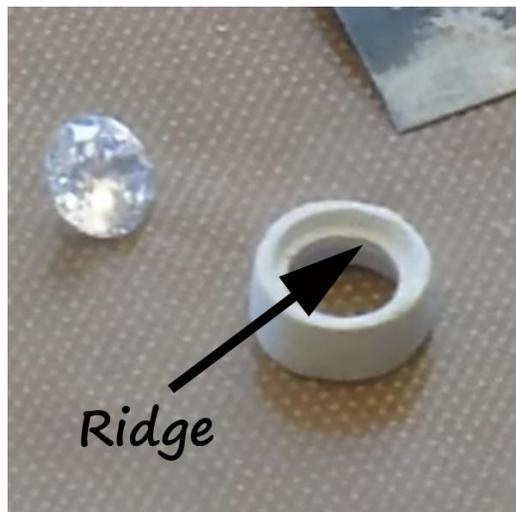


10. Remove excess clay and set your bezel to dry.



11. Using your fingers, blunt tool or bottom layer. Slowly push out bezel if it is in middle layer. If it ends up coming out attached to bottom layer then slow work it off with fingers after loosening with tissue blade.

13. Sand as needed. Make sure that centering ridge is clean and even so stone sets evenly during firing

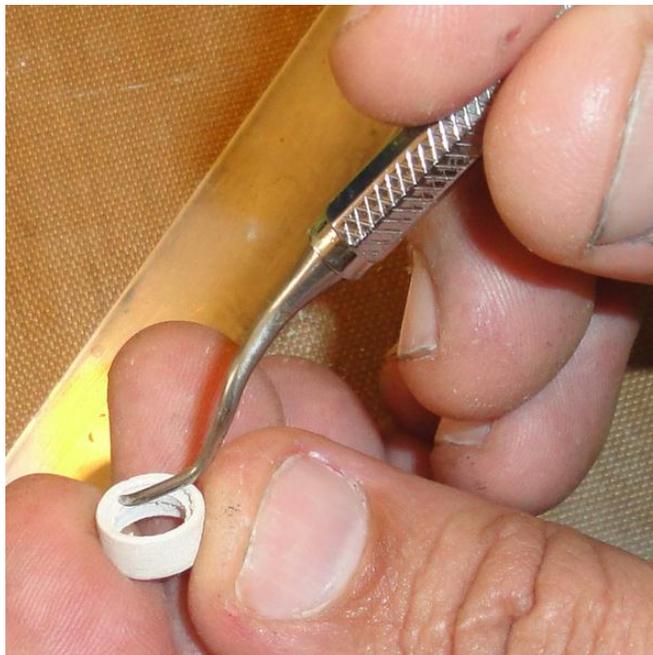


## **Firing with stones.**

The Bezel Builder is designed to shrink around and encapsulate the stone from edges. There is no reason to add slip or paste. The stone will sit on ridge loosely during dry phase and be fixed after firing. Having said that it may be easier to work with and set stones on angles if you use a bit of "white glue" such as "Elmers Glue" to set stone after clay is dried but not yet fired. It will harmlessly burn off in kiln. We also recommend firing at highest temp possible that is safe for stone for 2 hrs. This is to insure maximum shrinkage with silver.

### **For best results/tips**

1. Watch our videos. We will release several and you will find them on product pages and YouTube.com under the "MetalClays " channel
2. Fresh clay is always best.
3. Clean your molds after use and in between bezels. The easiest way is to soak in a glass of water for 5 minutes and brush with soft tooth brush. This tip is essential as it will make sure you get consistent results.
4. Practice. The tool works great. But as with all tools it is only as great as the experience that uses it.
5. When working with large stones beware that extended tumbling will eventually loosen your stone if it has no back. Meaning you have left both sides of bezel open. We have tested and 20-30 minutes isn't a problem but after the shot will beat the stone out. We would suggest firing for maximum strength for your material. If it has backing (closed on bottom) there should be no problem.
6. The Bezel Builder is designed around the shrinkage of PMC+ and PMC3. However other materials can work by moving sizes and grooving the inside of bezel right above ridge line with pick tool while leather dry. This technique can be employed even for PMC+ and PMC3 when you need to tumble for extended periods of time. We will be posting video of this process. In concept though it is similar to traditional stone setting techniques of creating undercut to seat stone in(see picture below).



7. When lubricating use brush to spread/coat mold in areas that clay touches. This is for 2 reasons. We want to insure that everything is fully coated and that there is not too much lubricant.
8. If too much clay is left over on inside of middle layer there was probably too much clay inserted. You can clean this and recompress. Also note that you may need to use less cards next time.
9. If the bezel does not seem well formed when you open then you probably need to use a little more clay.

### Size Chart

Using playing cards as guide roll out clay to thickness defined below then cut out shape. Each box is label with largest measurement of stone in mm. New shapes will be added and this chart will be expanded so check for new instructions if your shape is not listed below.

Size	Round	Square	Marquise
3 mm	5 cards	5 cards	
4 mm	7 cards	7 cards	
5 mm	9 cards	9 cards	
6 mm	10 cards	10 cards	
7 mm	11 cards	11 cards	7 cards
8 mm			9 cards
10 mm			11 cards

### Quick Tips

Bezel Builder does not fit together anymore

The solution to this is very quick and easy

1. Place middle layer on hot plate for 3-5 minutes till warm
2. While warm fit middle layer on to bottom layer and allow to cool
3. After cooling 5 minutes everything should fit perfect. Repeat as necessary.

All tools mentioned in this document are available on our website.

If you have questions or comments you can contact us at

[sales@metalclays.com](mailto:sales@metalclays.com)

818-698-7047

**www.MetalClays.com**