

# Anti-clastic forming of bracelets with the hydraulic press

The system consists of four sets of split Delrin rings that are contained within either one or two solid steel rings (depending upon the height of split ring chosen). The Delrin rings are curved on the inside, providing an anti-clastic form, against which the metal is forced by a solid Urethane rod (80 durometer).

The Delrin rings are four different heights, enabling working with several bracelet widths. The heights are :  $\frac{1}{2}$ " ,  $\frac{3}{4}$ " , 1" , 1- $\frac{1}{4}$ " .

The Urethane is 2- $\frac{1}{2}$ " in diameter and is 1- $\frac{1}{2}$ " tall.

The two steel restraining rings provided are used as follows :

The  $\frac{1}{2}$ " and the  $\frac{3}{4}$ " Delrin rings use one steel ring.

The 1" and the 1- $\frac{1}{4}$ " Delrin rings use two steel rings.

## HOW TO USE THE SYSTEM

Starting with a flat bracelet blank, form it around the urethane rod. Typically, this can be achieved by using the rod like a rolling pin, and making the blank fit snugly around rod. The blank should not exceed the height of the Delrin ring set chosen.

Place a pair of the Delrin rings into the steel ring(s), and slide over the bracelet blank. Center the blank and the rings, making sure that the blank is centered both within the rings and around the Urethane.

Place the assembly within the press and apply pressure. This will cause the Urethane to become shorter, forcing the metal to contour itself around the anti-clastic Delrin ring. When forming is complete, release the pressure, remove the steel ring, and remove the delrin rings to release bracelet.

If more forming is desired, repeat the process, using the next smaller set of Delrin rings.