

Wie ich meine Clips baue!

Many roads lead to Rome, so it is with clips!

In the following I describe my method to you and maybe this is a suggestion for one of you.

What material do I use?

I prefer to work with nickel silver. This time with 1.5mm thickness.

I have planned a clip with a visible decorative ring, on the front I want to solder a piece of bronze, for more material thickness.

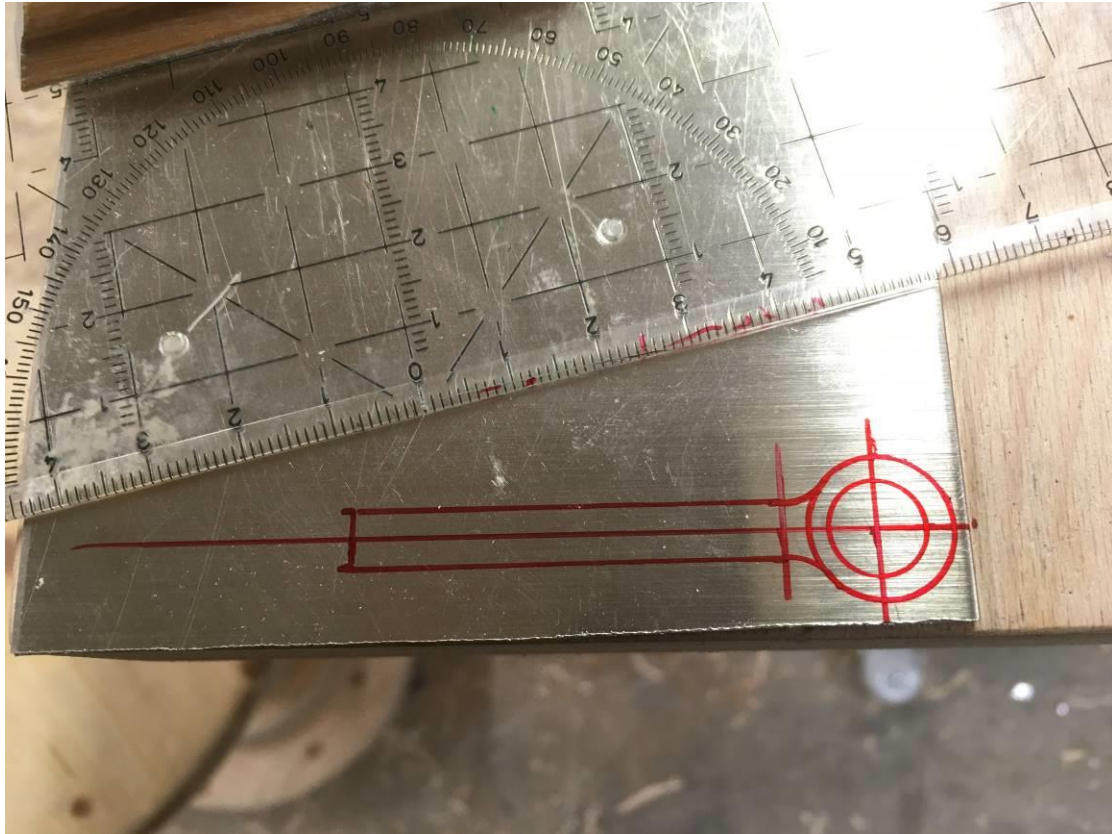
Which tools do I use?

Jigsaw, files, hammer, sandpaper, drill, buffing wheels, self-made auxiliary devices and hardened bolts



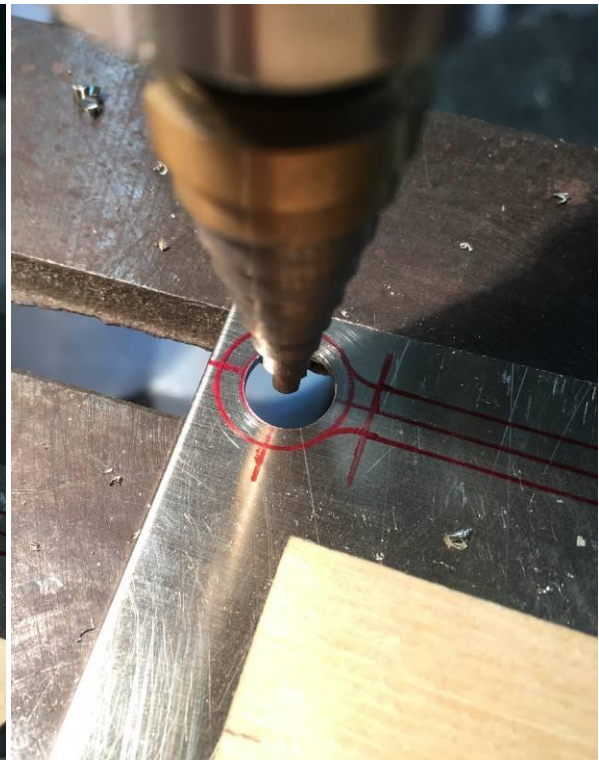
Let's go!

1. **Transfer the template to the sheet:**



2. **Drilling holes**

I used a step drill because this is safer than drilling through the sheet with a large drill. Still clamping the sheet!



3. Saw out the blank

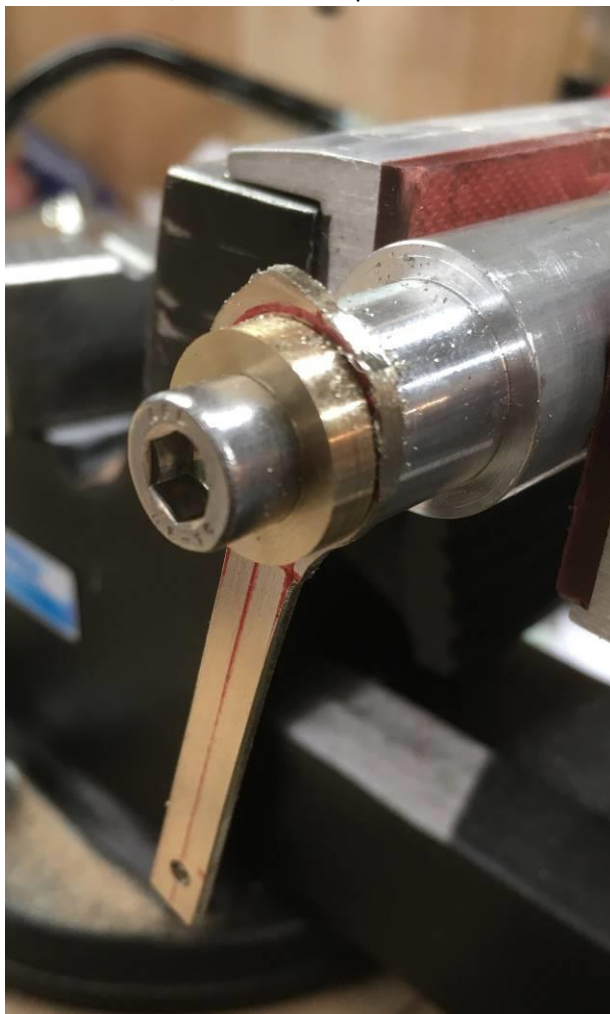
I did that with a jigsaw with a hacksaw blade, some cutting oil and it works wonderfully.



4. Rohling Außenkontur feilen



For the radius, I turned a template with the finished outer diameter.



5. Bend the blank

Second little aid. The diameter of the mandrel is 4mm larger than the decorative ring, so that there is a 2mm gap between the clip and the cap. I filed a 1mm radius on the bending edge. I bent my first clips over a steel block, it works the same way



With light hammer blows (100g hammer) I nestle the half clip on the mandrel.





6. Adding the Bronze piece

For this I made a 2mm hole in the blank, over which I riveted the bronze piece to the blank after I soldered the two parts.



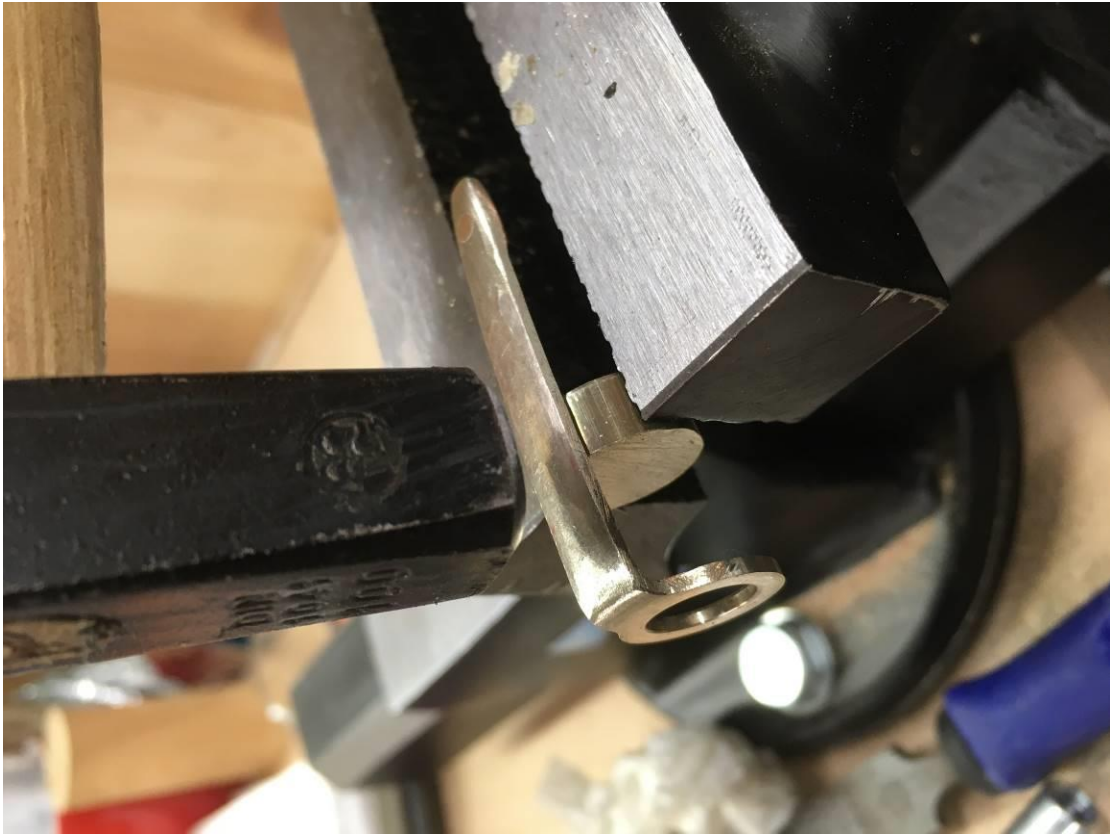
7. File the clip shape



8. Clip forging

The nickel silver is softly annealed by soldering. That's why I cold-hardened it again by "forging". The clip also makes the clip more stable.

Hammering also creates a slight swing along the longitudinal axis

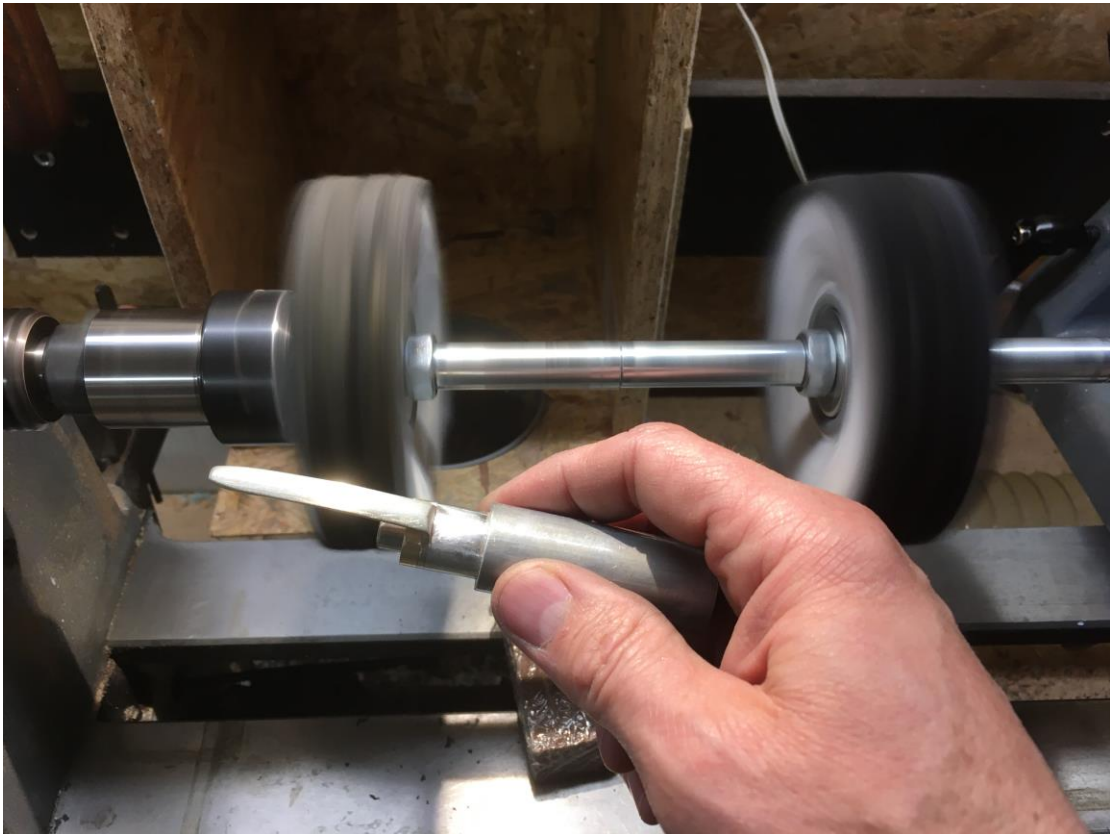


9. Grind the clip to grit 400



10. Clip polishing

It is polished in two stages. Pre-polish on the linen disc. Gloss polish on the cotton disc



Have fun tinkering!