

# The Process of Copper Enameling



#1  
Select a design.



#2  
Cut out design with a jeweler's saw.  
(See Logo)



#3  
Decide which side will be the front & if a pin or earring.



#4  
Drill holes (if needed).

Skip steps #5 a - #5 e if soldering isn't needed.

Soldering is used to attach tacks, pins and pendant to back.



#5a  
Flux the piece and tack or other finding(s).



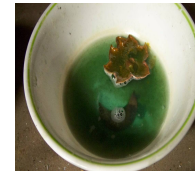
#5b  
Heat the piece(s).



#5c  
Heat the finding till the silver solder melts.



#5d  
Place the finding on the piece and heat



#5e  
Cool and place in cleaning solution and remove.



#6  
Clean with Alcohol Flip piece. Coat back Side with Scalex to help reduce oxidization.



#7  
Use counter enamel on opposite side of Scalex to coat back of piece.



#8  
Enamel is glass ground to a fine powder. Coat well



#9  
Use a metal spatula to pick up piece to place in Kiln.



#10  
Wait a few minutes until enamel is fired. Kiln temperature is at +1300 degrees.

**Caution HOT!**



#11 CAREFUL!  
Take piece out of kiln. Depending on temp.



#12  
Don't touch until Cooled.



#13  
Take flaking Scalex coating off, then clean.



#14  
Place on stand, add base coat (Top enamel).



#15  
Place in Kiln, to Refire.

## ENAMELING TECHNIQUES

**Basse-taille** - French word meaning "low-cut". The surface of the metal is decorated with a low relief design which can be seen through translucent and transparent enamels.

**Champlevé**- French for "raised field", where the surface is carved out to form pits in which enamel is fired, leaving the original metal exposed

**Cloisonné**- French for "cell", where thin wires are applied to form raised barriers, which contain different areas of enamel.

**Grisaille**- French term meaning "in grey", where a dark, often blue or black transparent enamel is painted on top, building up designs in a monochrome gradient, paler as the thickness of the layer of light color increases.

**Limoges** - enamel, made at Limoges, France, the most famous European center of vitreous enamel production. Painted enamel, a design in enamel is painted onto a smooth metal surface.

**Grisaille Plique-à-jour**, French for "braid letting in daylight" where the enamel is applied in cells, similar to cloisonné, but with no backing, so light can shine through the transparent or translucent enamel. It has a stained-glass like appearance

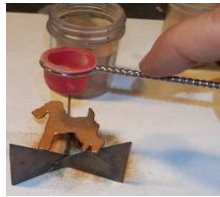
**Ronde bosse**- French for "in the round", also known as "encrusted enamel". A 3D type of enameling where a sculptural form or wire, framework is completely or partly Stenciling, where a stencil is placed over the work and the powdered enamel is sifted over the top. The stencil is removed before firing, the enamel staying in a pattern, slightly raised.

**Sgraffito**- where an unfired layer of enamel is applied over a previously fired layer of enamel of a contrasting color, and then partly removed with a tool to create the design.

**Serigraph**, where a silkscreen is used with 60-70in grade mesh.



#16  
Wait till cooled  
Before touching.



#17  
Sift contrasting  
Color of enamel



#18  
carefully place in  
Kiln to refire.  
to get effects.



#19  
Let cool.



#20  
Add distilled water  
To enamels use  
Brush to add details.



#21  
carefully place in  
Kiln to refire



#22  
Let cool. Check If  
you need more  
Details repeat steps  
20-22 as needed.



#23  
File sharp edges  
from enamel  
Build up and burrs.



#24  
Buff edges with  
Rotary tool to a  
Smooth surface.



#25  
Clean up with  
rubbing alcohol.



#26  
Attach ear wire  
Or other finding.



#27  
Finished piece of Art!!



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## Enameling Classes

#	Basic or Stenciling	Sgraffitto or Limoges	Plique-à- jour or Champlevé	Cloissonné
1-4	\$30	\$55	\$75	\$125
5-9	\$25	\$43	\$n/a	n/a
10-14	\$20	\$35	n/a	n/a

All Materials, Supplies and Instruction included!

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### CAUTION !!!!!!!

This process requires safety  
equipment due to high  
temperatures and use of sharp  
objects.

It also requires patience.