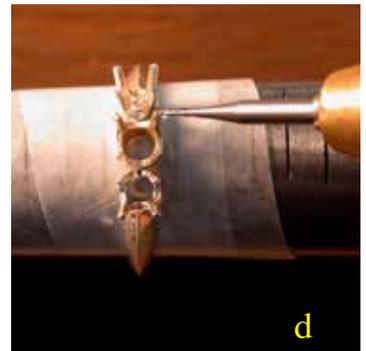
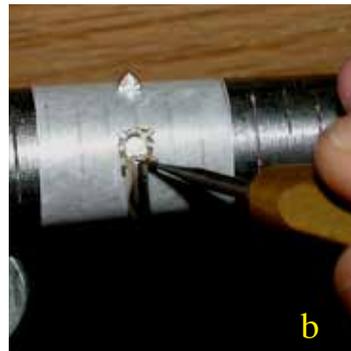


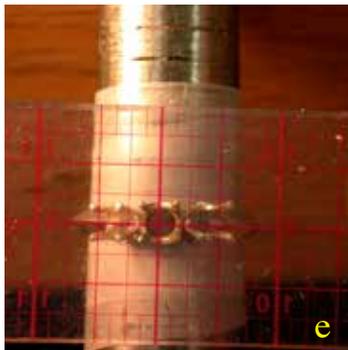
WOLF CLAY



Wolf Clay is a positioning clay used for soldering and as an aid for making contour fit shadow bands in wax.

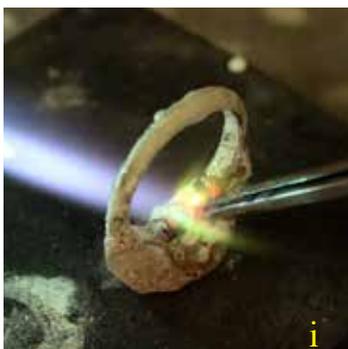
Wolf Clay does not swell, deform or burn and may be reconstituted by adding water. Do Not use with Platinum, palladium or rhodium! **Contents:** Water, Silica and Aluminum Oxide. Wolf Clay does NOT contain asbestos or other dangerous ingredients.

As with all soldering operations: start with a good fit between parts and clean, grease-free metal and solder. Use adequate ventilation when applying glue and soldering. b) Wrap strip of waxed paper around ring mandrel, secure overlapping end with a thin smear of Wolf's Wicked Sticky Positioning Wax. Use a minimal amount of cyanoacrylate* glue (such as Crazy Glue or Super Glue—regular formula).



c+d) Squeeze some glue out off to the side and transfer glue a drop at a time with a needle, feeding glue into the gaps where you want the solder to flow. Assemble parts on top of the wax paper at desired ring size. e) Look through clear grid ruler to ensure that all pieces are assembled properly—if not, take ring off the mandrel, put it on soldering pad and warm up until the glue gives way, then clean parts and reassemble. f) Press Wolf Clay around parts to support

them while soldering. g) Remove wax paper. h) Press down on clay to make flat spot to hold ring upright for soldering. i) Put ring on soldering block, flux ring and solder chips. Heat up ring with torch, aim the flame to the seams to be soldered. As soon as the flux runs glassy, apply the fluxed solder chips. As the flux runs glassy, the glue burns out clean and sucks the flux and solder into the gaps where the glue was. After soldering all the seams, let piece cool. If you want to reuse the clay put ring in a jar of water, and let the clay dissolve. After the clay settles to the bottom of the jar, drain the water off the top and allow the clay to dry to the desired consistency. If you don't want to reuse the clay, skip this step and put the piece in the pickle. Finish ring.



*Refer to glue, solder and flux manufacturer's MSDS for safety information.

©2010 Kate Wolf text and images.