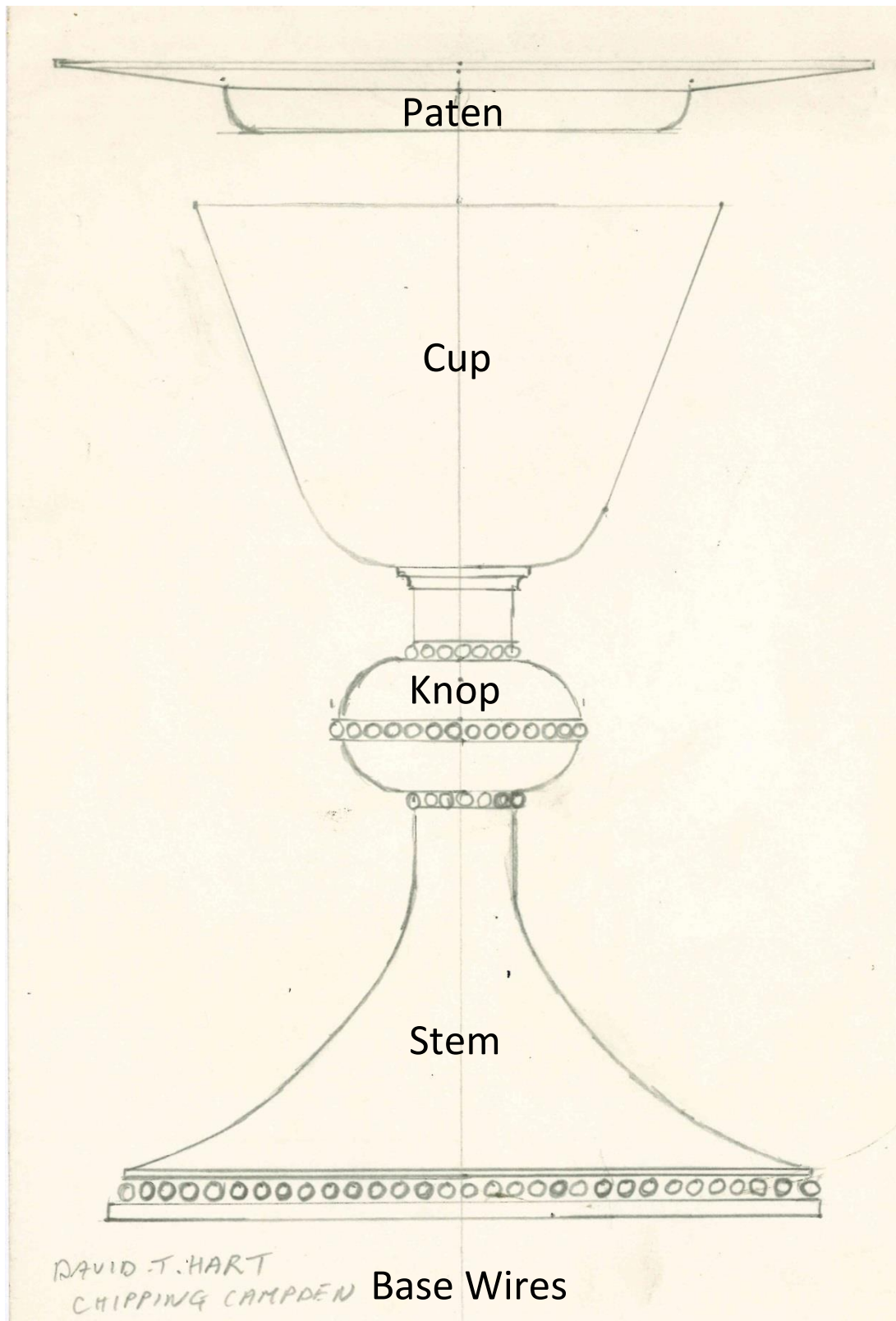


Making a Chalice





It all starts with a full size drawing of what we are going to make.



The blanks for the cup, the foot and the knop are drawn and then cut from the sheet of silver. The centre point is kept for subsequent operations.



There is a large tree stump in the middle of the workshop with depressions carved into its surface in which the first shaping operation is done. This is called 'blocking'.



Silver, like most metals, becomes hard and brittle when hammered and has to be annealed at intervals. The parts are heated until they are just starting to glow red and allowed to cool slowly in air. This is called 'annealing'.



After annealing, the shaping of the foot and the cup can be taken to a further stage by hammering on a suitably shaped stake held in a vice. This is called 'raising'.



Once the basic shape is achieved through raising, the surface is very rough and bumpy. The surface is then smoothed by hammering the silver with a lighter hammer over a stake that matches the shape perfectly giving an appearance which is characteristic of hand-raised silverware. This is called 'planishing'.



All the parts are now ready to be joined together. The decoration of the base consists of two rectangular wire rings, one twisted wire ring, a trumpet shaped stem and a knop.



All the parts are joined together by heating and melting a stick of solder into the joints to create one whole piece. This is called 'soldering'.



When the knob has been soldered to the stem, the foot is set up on the surface plate to check everything is level.



Using the centre point of the original blank, a circle is drawn onto the bottom of the cup to mark the position of the base and then the base and the cup are soldered together.



The chalice and the paten are now complete and ready to be sent to the Assay Office for hallmarking.



A sample of the metal is scraped from the surface and analysed. It must contain not less than 92.5% of pure silver before receiving the hallmark.

The original maker's mark of the Guild of Handicraft from 1908 is still used to this day.



The final operation is polishing with an electrically-driven motor on which polishing mops and brushes are fitted.



The finished chalice with its engraved paten.



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