

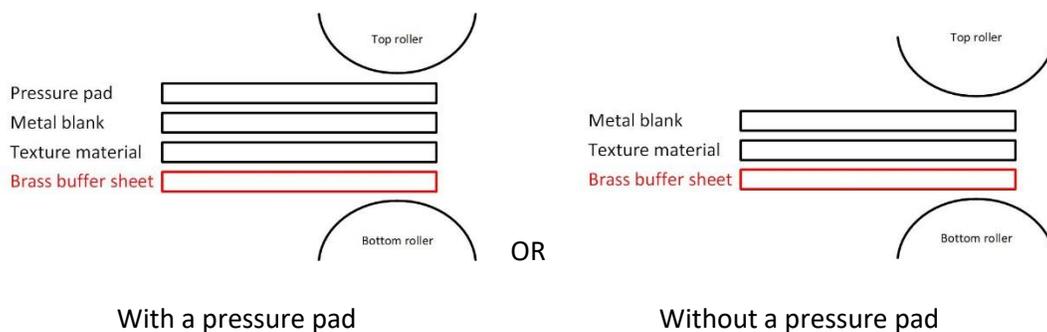
Texturing with a Rolling Mill

A rolling mill is a very handy tool for adding texture to a soft metal such as copper or silver. Just remember, adding texture to a blank using a rolling mill will elongate the blank, and therefore the blank needs to be textured before cutting to the final size and shape.

The pattern material will commonly be damaged or destroyed by this process. One exception would be a steel texture plate, but even a steel plate may become curved after repeated use in a rolling mill.

Important: If the texture material is hard, or rough, place a piece of copper or brass between the texture material and the roller to protect the roller.

The metal blank may be textured either with, or without, using a pressure pad.



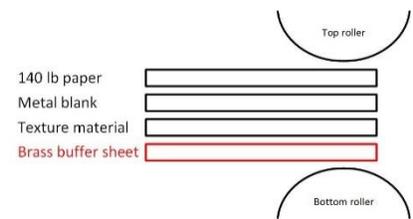
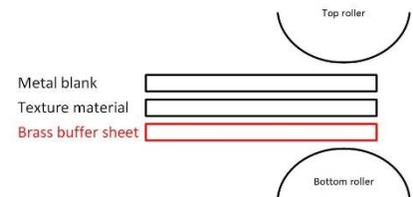
Note that when using a pressure pad (left photo) the raised areas in the sample are rounder, and probably higher, than when the sample is done without using a pressure pad (right photo).

However, if additional forming is going to be done to the sample using a hydraulic press, e.g. doming, etc., the sample created using a pressure pad will suffer more damage than the sample created without using a pressure pad.

Texturing with a Pressure Pad

I have good results texturing copper and silver using a piece of 140 pound watercolor paper as the pressure pad as described below:

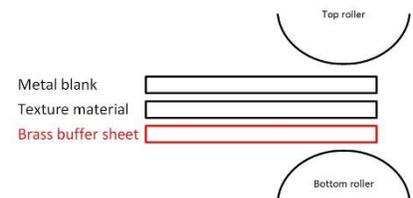
1. Anneal the metal blank.
2. Place the texture material on top of the buffer sheet, and the metal blank on top of the texture material.
3. Place the stack, without the watercolor paper, between the rollers and adjust the rollers together so they are tight on the stack.
4. Remember the setting for the rollers, open the rollers a bit to allow the stack to be removed and return the rollers to the remembered setting.
5. Place the pressure pad, in this case, a piece of 140 pound watercolor paper on top of the stack.
6. Run the stack all the way through the rolling mill.



Texturing without a Pressure Pad

I have good results texturing copper and silver without a pressure pad as follows:

1. Anneal the metal blank.
2. Place the texture material on top of the buffer sheet, and the metal blank on top of the texture material.
3. Place the stack between the rollers and adjust the rollers together so they are tight on the stack.
4. Remember the setting for the rollers, open the rollers a bit to allow the stack to be removed and return the rollers to the remembered setting.
5. Close the rollers another quarter to half a turn. Test the pressure by starting to roll the stack through the mill. If the force required seems to be too much, back the stack out and open the rollers a wee bit. If



the force required seems to be too little, back the stack out and close the rollers a wee bit more.

6. Run the stack all the way through the rolling mill.