

## General Project 20—Jewelry: Titanium and Stone Rings/Mark Stone

Mark Stone is a tool and die maker, a machinist and a machine designer. He also does his own lapidary work. He uses Sherline tools to make his jewelry, which combine both his metalworking and lapidary skills. In the letter accompanying his photos he said, "When I purchased the milling machine I was afraid that it might be too light and fragile to machine the titanium I planned to use. Enclosed please find pictures of jewelry which I have machined from solid titanium bars and sheet. The faceted stones are primarily cubic zirconia. The blue stone in the man's ring is lapis lazuli. I do my own lapidary work and the Sherline mill is very useful in making special tools."



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### **A simple project in Titanium**

This ring was not made by an expert jeweler like Mark Stone. I made it out of a 1" diameter bar of Titanium just to see what the material was like to turn. I have been wearing it constantly for over two years, so it's a little beat up, but it was fun and easy to turn. I found it cuts about like stainless steel when using inserted tip carbide tools. I used both TiN coated carbide and plain carbide and didn't notice a lot of difference between the two—both worked fine. I was warned not to let the chips pile up, as they can catch fire if ignited, much like magnesium. I found this to be a simple fun project, and whenever Titanium comes up in a conversation I have a sample with me.

—*Craig Libuse*

