

Stone Setting

APPLICATION MANUAL

PRECIOSA

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Introduction

Preciosa round, fancy and no-hotfix flatback stones can be set in metal parts, rendering them suitable for a range of application techniques, such as sewing, soldering and gluing. In this step-by-step guide, we will show you how to securely fasten each type of stone into the two most popular kinds of metal settings: prong settings and bezel settings.

Whenever possible, stones should be set before plating the setting. Preciosa's assortment also includes pre-set stones and linked components, like crystal cupchain and banding.

I. COMPONENTS SUITABLE FOR SETTING

COMPONENT	 STONE SETTING
 Round Stones	✓
 Fancy Stones	✓
 No-Hotfix Flatback Stones	✓

II. TYPES OF SETTINGS

Preciosa crystals can be set by hand and by machine. This application manual outlines methods used for manual setting using hand-held tools like tweezers, a setting knife and fly press.

Prong setting

Suitable for: fly press | tweezers | setting knife | prong setting tool



Crystal is fixed in position by prongs

Bezel setting

Suitable for: fly press



Crystal is fixed in position by a bezel rim

Linked setting

Crystals in linked settings, like cupchain and banding, are usually secured by machines that gather, place and fix the crystals in position using a pressure head. This application manual does not provide instruction for this method; however, care instructions for both crystal cupchain and banding may be found on page 11.

Before You Begin

Make sure you have selected the **right setting** for the stone type, size and intended use, assembled the necessary tools and properly cleaned and treated the setting.

I. TOOLS AND EQUIPMENT



Tweezers



Setting knife



Fly press



Hand-held prong setting tool



Setting die set



A simple tool with a single groove for manual stone setting



Protective gloves



Protective eyewear

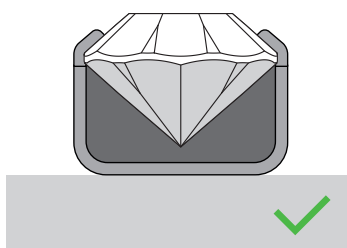
II. SURFACE PRE-TREATMENT

Take care to properly degrease and dry the setting cup before placing the stone inside.

Application

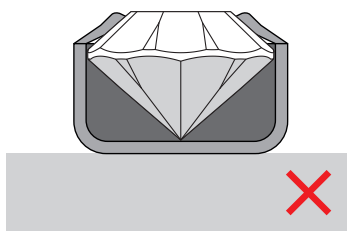
It is important to choose the right cup size. The crystal must precisely fit the setting so that it can be inserted without damaging the foiling or protective varnish. Take care not to block any holes in the setting (for sew-on application) with the underside of the stone.

Correct

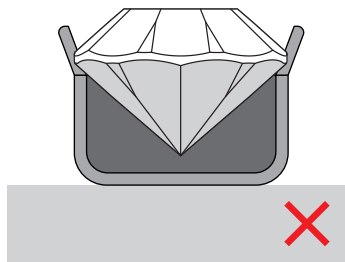


Stone has been set correctly.

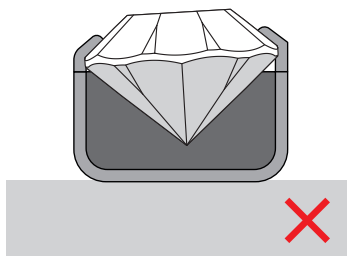
Incorrect



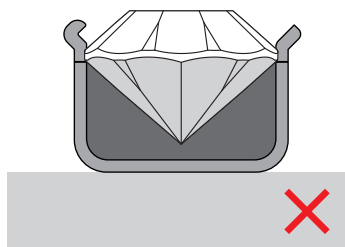
Setting cup is too big.



Setting cup is too small.



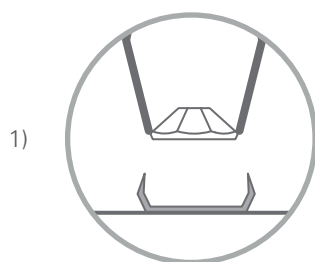
Stone is set askew.



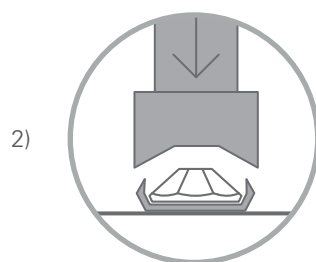
Prongs are incorrectly bent.

PRONG SETTING

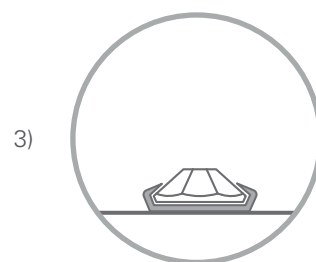
Fly press



Use tweezers to place the stone in the setting cup.

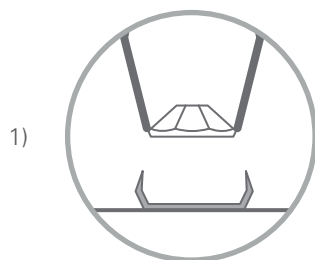


Use the appropriate size setting closer and fly press to bend and close the prongs.

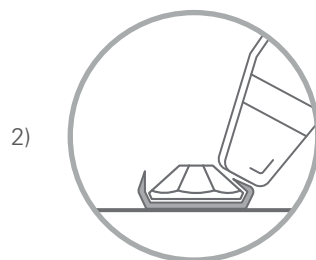


The stone is set.

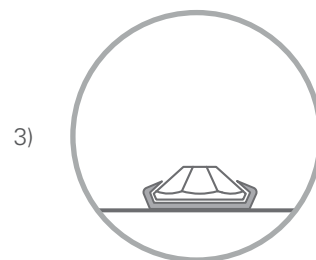
Tweezers



Use tweezers to place the stone in the setting cup.

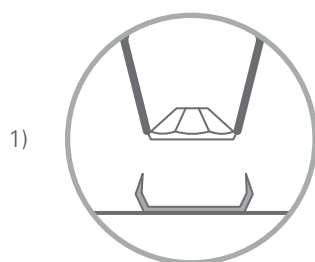


Use tweezers to bend and close the prongs.

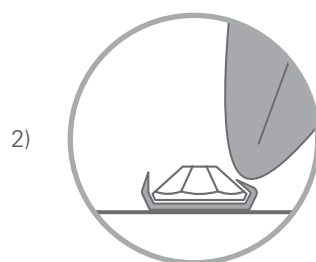


The stone is set.

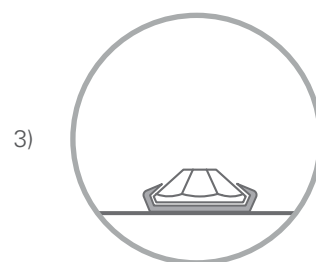
Setting knife



Use tweezers to place the stone in the setting cup.

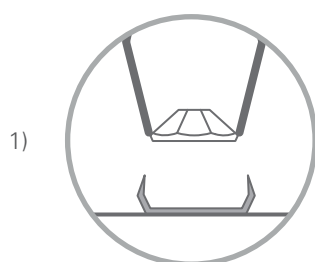


Use the setting knife to bend and close the prongs.

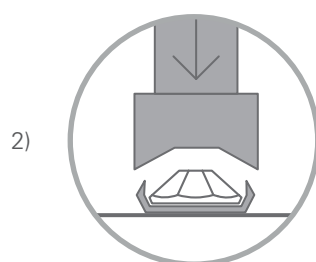


The stone is set.

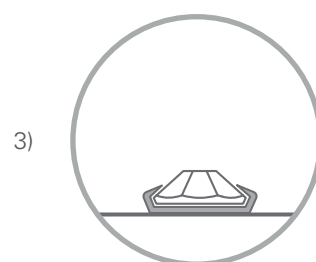
Prong setting tool



Use tweezers to place the stone in the setting cup.



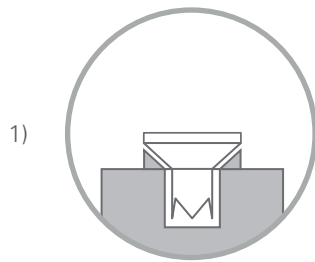
Use the prong setting tool to bend and close the prongs.



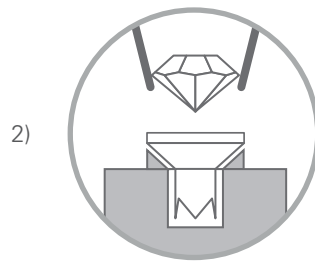
The stone is set.

BEZEL SETTING

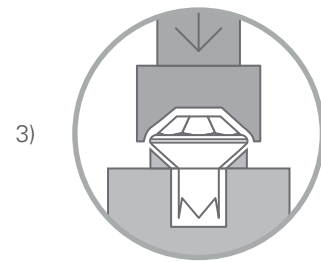
Fly press



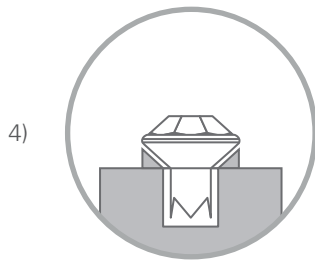
Place the setting cup in the fly press.



Use tweezers to place the stone in the setting cup.



Use the appropriate size setting closer and fly press to secure the stone.



The stone is set.

Troubleshooting and Diagnostics

PROBLEM	RECOMMENDATION
The stone is set askew .	Check the correct position of the stone in the cup. Check that the right cup size has been used.
The stone is too loose in the cup.	Check the correct position of the stone in the cup. Check that the right cup size has been used. Bend the prongs slightly. Re-calibrate the stroke height of the setting head . The prongs should barely touch the stone's surface.
The stone is chipped or otherwise damaged after setting.	Loosen the prongs slightly. Re-calibrate the stroke height of the setting head . The prongs should barely touch the stone's surface.



Care Instructions

		STONES IN SETTINGS	CRYSTAL CUPCHAIN	CRYSTAL BANDING
Stones with coatings — use only gentle wash cycle (30 °C).		Turn inside out, choose a gentle wash cycle and use mild laundry detergent. To protect the crystals as much as possible, the use of a soft wash bag is recommended.		
		Turn inside out, choose a gentle wash cycle and use mild laundry detergent. To protect the crystals as much as possible, the use of a soft wash bag is recommended.		
		Turn inside out and use mild laundry detergent.		
		Do not wash!		
		Do not use chlorine bleach!		
		Turn inside out and dry at reduced temperature.		
		Do not tumble dry!		
		Iron inside out using a silk/polyester viscose setting and pressing cloth.		
		Iron inside out using a wool setting.		
		Do not iron!		
To protect the crystals as much as possible, the use of a soft wash bag is recommended.		May be gently dry-cleaned using perchlorethylene. Turn inside out.		
		May be gently dry-cleaned using hydrocarbon.		
		Can withstand professional wet cleaning. Turn inside out.		
		Do not dry clean!		

Preciosa Components

A Member of the Preciosa Group

A global leader in luxury goods manufactured from crystal, the Preciosa Group stands upon centuries of glassmaking tradition and innovation. From the world's smallest faceted flatback stone to our cutting-edge, bespoke lighting installations,

Preciosa looks to our own unique heritage to draw inspiration for the future of responsibly crafted Bohemian crystal. Together, the Group operates regional offices across Europe, North America and Asia and melts 40 tons of glass every day.

PreciosaComponents.com