



# Humpback Ring Pressing Kit Instructions

Kevin Potter designed this forming kit to be used with the ring impression dies we sell that have a deep “hump.” The hardest part of using this type of die is getting all the detail in the shoulder of the ring ... that’s where this kit comes in! This 4-piece kit allows you to easily form this difficult style of ring.



## Kit Includes:



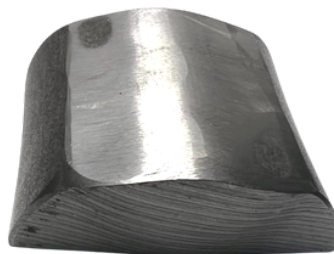
**Ring Blank Template with 3 shapes/sizes**

- Use to mark metal for cutting ring blank



**Top Pusher #1 (Half-round)**

- Pushes metal into deep center of the ring



**Top Pusher #2 (Shoulder)**

- Pushes metal into the shoulders of the ring



**Ring Shank Pusher (Flat/Square)**

- Pushes metal into the shank/band of the ring

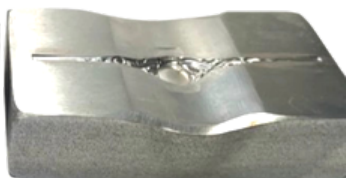
## Additional Tools Needed (not included in kit)

- 12-gauge sterling silver
- Bracelet Former Frame with Ring Bender attachment
- Urethane puck (95 durometer)
- Small urethane pieces
- Ring mandrel with rawhide mallet
- Jeweler's saw



**Humpback Ring Master Hub**

(not included; used to make the impression die you receive)



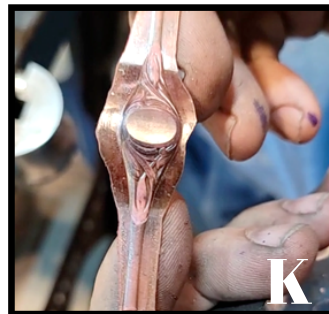
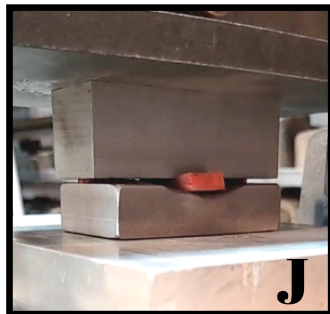
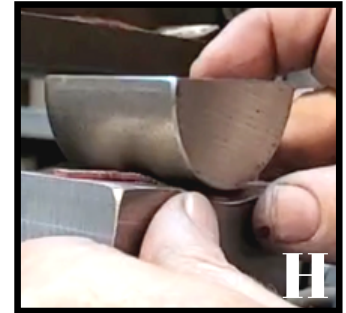
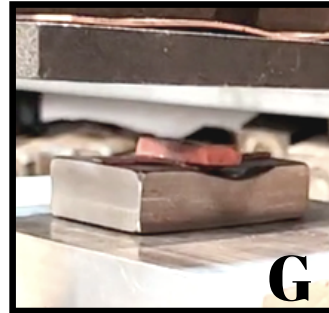
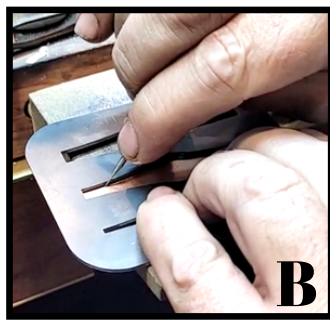
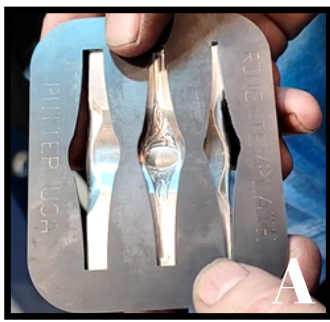
**Impression Die**



**Humpback Ring Pressing Kit**



**Finished Ring**

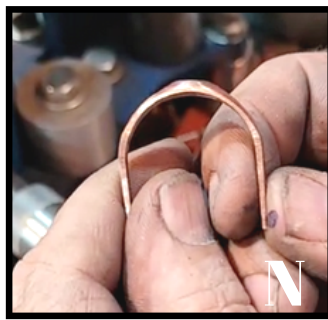
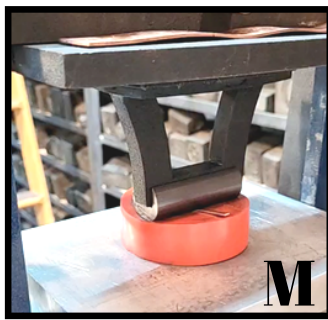
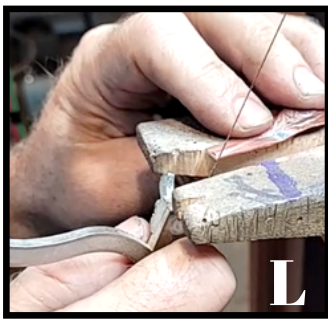


**Watch Kevin  
Potter  
demonstrate how  
to use the kit!**


[https://youtu.be/  
6PnKPL2QqSA](https://youtu.be/6PnKPL2QqSA)

## Create the Ring Impression

1. Choose a Ring Blank Template size slightly larger than your ring die [A].
2. Use a scribe to trace template onto your 12-gauge metal [B,C].
3. Use a jeweler's saw to cut out the blank [D]. No, there's not a pancake die or FSS die for it.
4. Anneal your metal. Quench, pickle, rinse, and dry the ring blank.
5. Rest the ring blank on top of ring impression die [E]. Make sure to center the blank on the impression die.
6. Use a small piece of urethane in the center of the humpback ring [F]. Press the urethane into the die to get the basic form of the ring [G].
7. Balance the Top Pusher #1 (Half-round) on top of ring blank in the die, flat-side up [H].
8. Press Pusher #1 to form the center of the ring. Check the metal impression, and press again, if needed. Remove Pusher #1.
9. Place Top Pusher #2 (Shoulder) on top of the metal, and press again to form the shoulders of the ring [I]. Remove Pusher #2.
10. Place a small piece of urethane on top of the metal in the center depression of the ring (this is to prevent the center of the ring from popping up as you form the ring shank). Place the Ring Shank Pusher (Flat/square) on top of the die, covering both ends of the ring [J]. Press the ends of the ring shank into the die to finish forming the ring impression.
11. Remove the ring impression from the impression die [K].



## Form and Finish the Ring

1. Use a jeweler's saw to remove the flange from around the ring impression [L]. File the edges of the ring, but don't finish it completely; you'll do that after soldering the ring.
2. Use the Ring Bending Die with your Bracelet Former Frame in the hydraulic press to form the crown of the ring [M, N]. The die-struck ring is very hard and thick, and it will be hard to form by hand.
3. Anneal the ring [O]. Pickle, rinse, and dry the ring.
4. Use a rawhide mallet and a ring mandrel to round-out the ring and bring the ends of the band together [P]. If you need a smaller or larger ring size, add or remove material now.
5. Use a snap-on sanding disc, file, or other flat abrasive to make the ends of the ring band meet flush with no gaps [Q].
6. Solder the ends of the ring band with hard silver solder [R]. Pickle, rinse, and dry the ring.
7. File, sand, and finish the ring as desired. Be sure to remove any remaining flange from around the impression [S], and clean up any excess solder. 

### "Cliff's Notes" for Making the Ring Impression

*Scribe template shape onto 12-gauge metal.*



*Use urethane to pre-form the center of the ring.*



*Form center of the ring with Top Pusher #1.*



*Form shoulders of the ring with Top Pusher #2.*



*Form shanks of the ring with Ring Shank Pusher*

