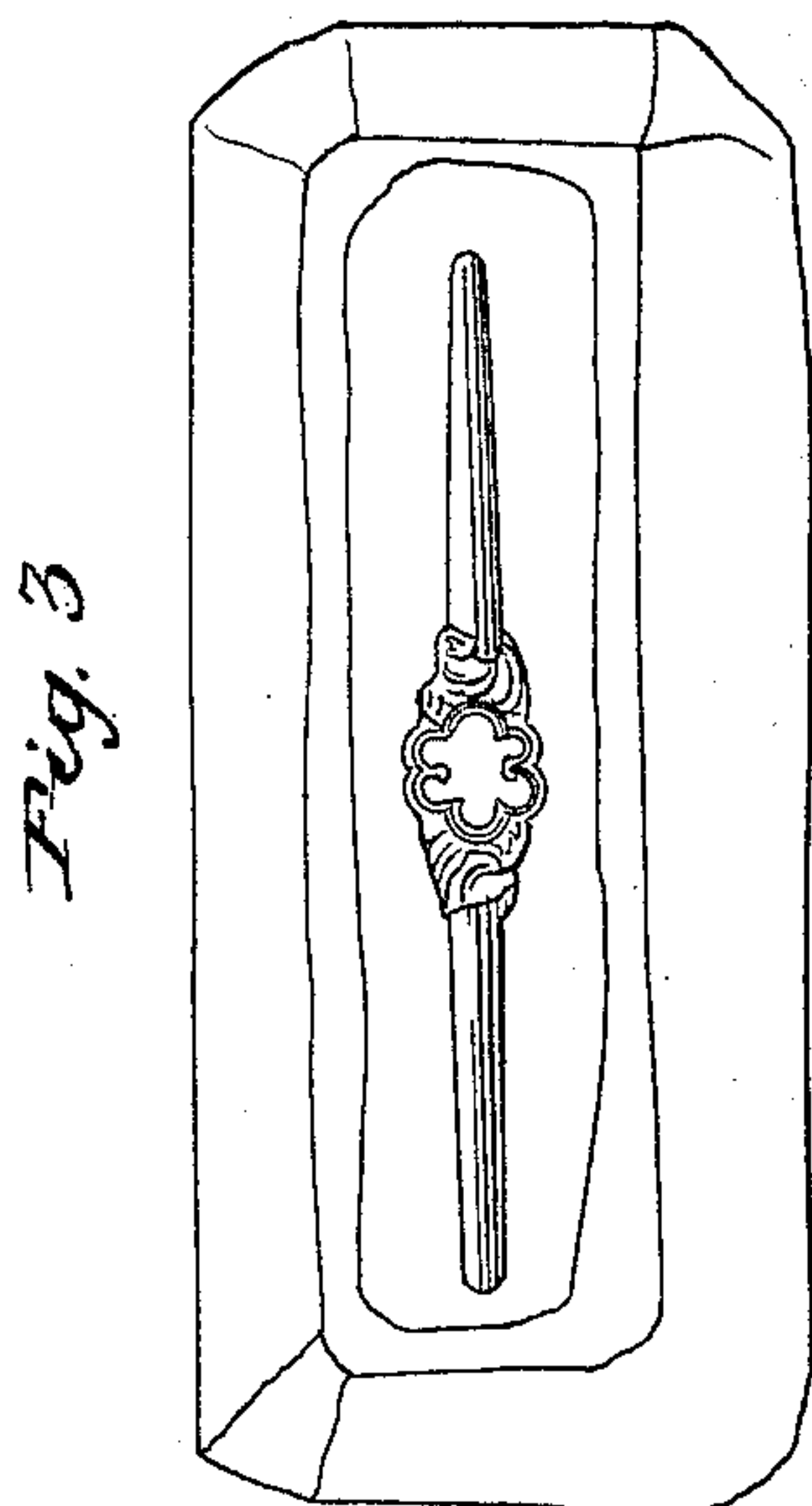
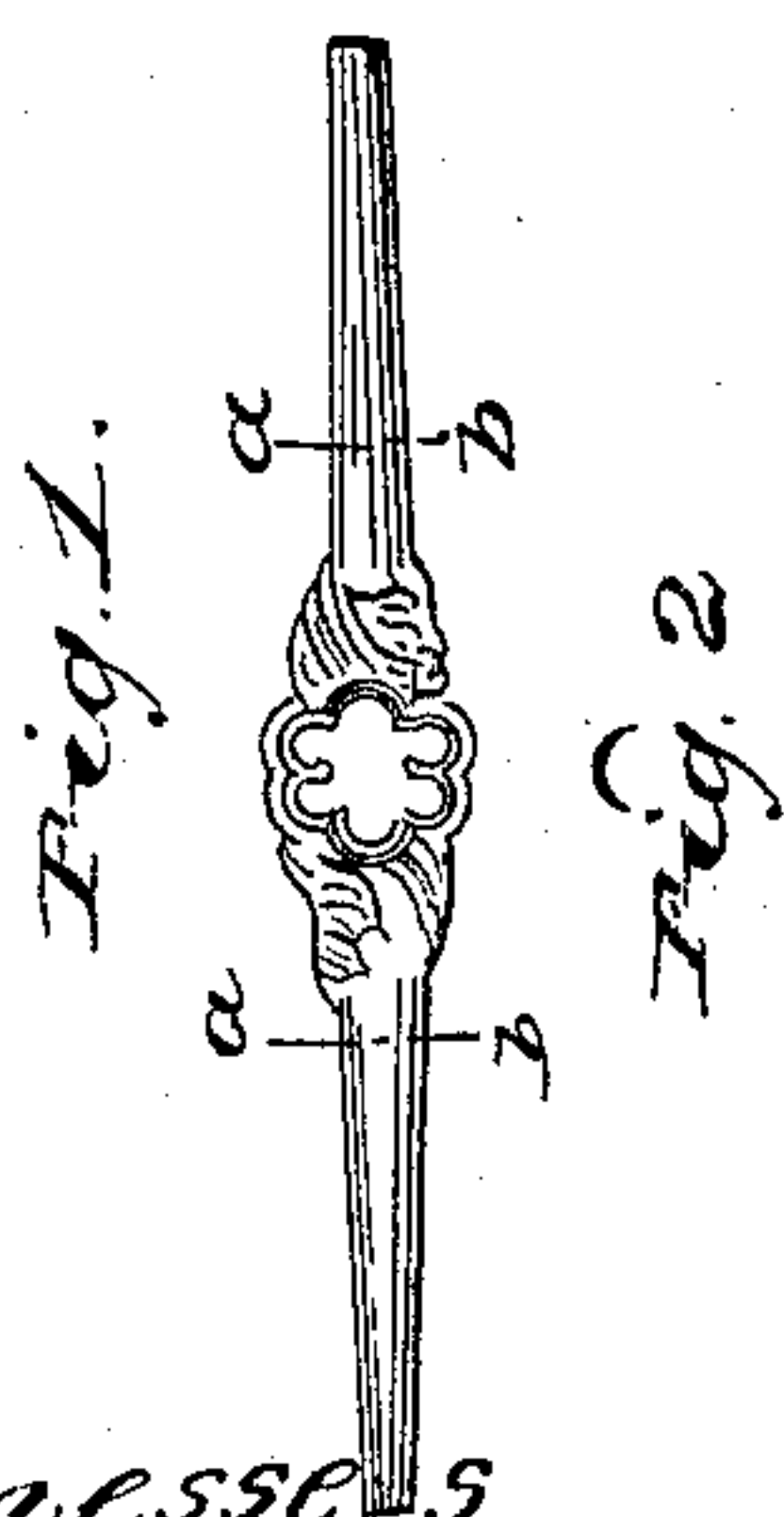
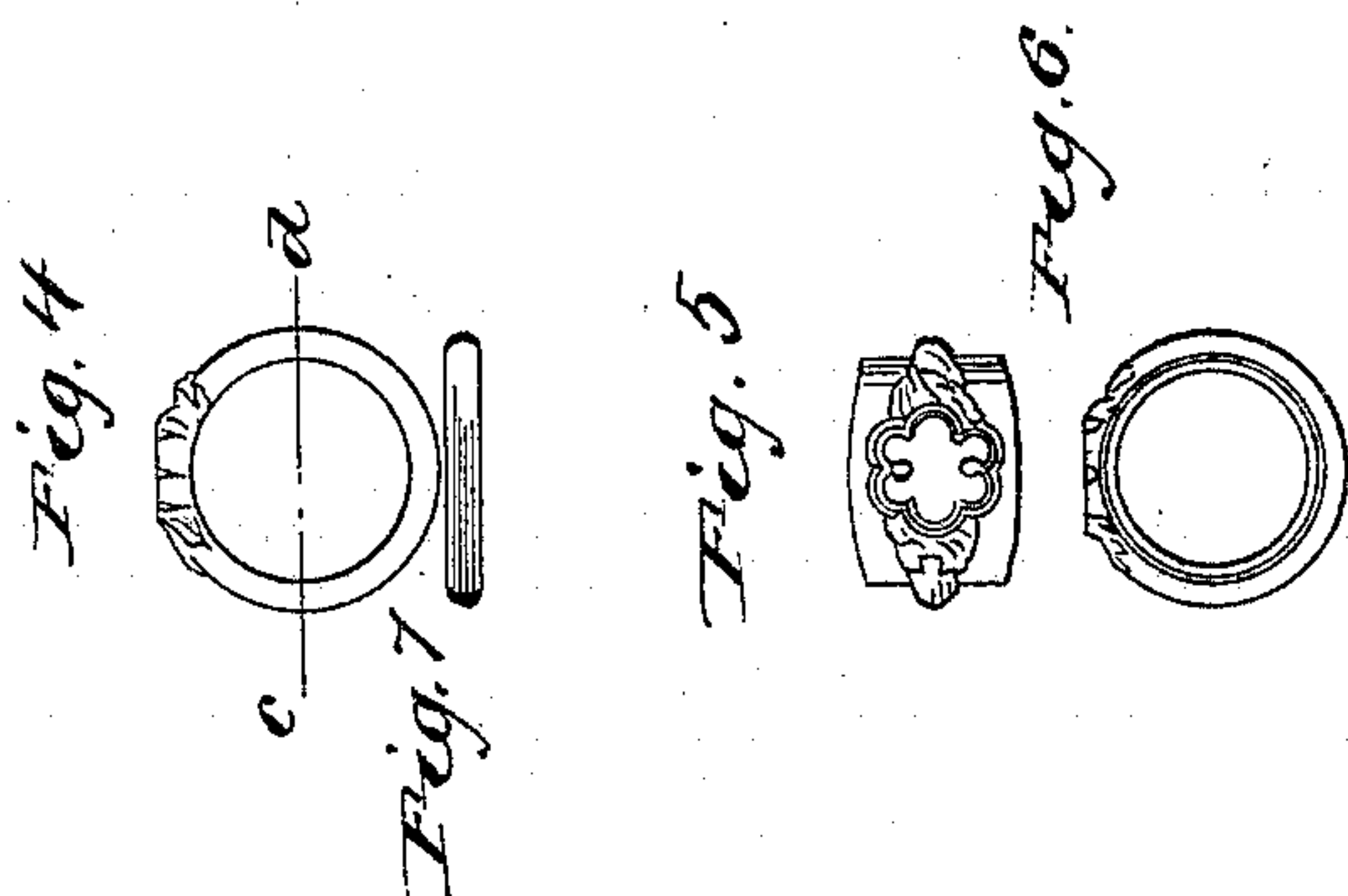


I. M. Potter,
Finger Ring,
No 30,246, Patented Oct. 2, 1860.



Witnesses
Robt Ralston
By J. Munson

Inventor.

I. M. Potter

UNITED STATES PATENT OFFICE.

ISAAC M. POTTER, OF PROVIDENCE, RHODE ISLAND.

MANUFACTURE OF SHEET-METAL FINGER-RINGS, &c.

Specification of Letters Patent No. 30,246, dated October 2, 1860.

To all whom it may concern:

Be it known that I, ISAAC M. POTTER, of the city and county of Providence, in the State of Rhode Island, have invented a new
5 and useful Improvement in the Method of Making Finger-Rings; and I do hereby declare that the following specification, taken in connection with the drawings making a part of the same, is a full, clear, and exact
10 description thereof.

Figure 1, is a view of the sheet metal as it comes from the die represented in Fig. 3. Fig. 4 shows a side view of the finished ring and Figs. 5 and 6 views of the
15 "former" by which the result to be described is effected.

Hitherto finger rings which belong to that class of work which is known to the trade as "soft solder jewelry" have been made by
20 the following process: The sheet metal of which the ring is to be made having been struck up in a die the interior is filled with pewter solder and then the ring is formed about a mandrel. The only object of the
25 solder is to enable the workman to fashion the ring about the mandrel as otherwise the metal would be "crimped" as it is termed. It is obvious that in making cheap rings of this class the cost of filling the sheet
30 metal blank must constitute a large item in the expense of manufacture.

My improvement consists in bending the blank after it has been struck up in a die without first filling it with solder. For this purpose I use a metallic "former" (Fig. 35 5), the diameter of which is smaller than that of the ring to be made. The "former" has upon its surface the same figure or device that is upon the blank after it comes from the die, so that the elevations and de- 40 pressions in the under surface of the blank will fit the corresponding elevations and depressions on the former. The blank having been struck up by the die as shown in Fig. 1, the former (Fig. 5) is placed on a mandrel 45 and the blank being adjusted to the former so that the figure on the two shall correspond it can be as perfectly bent into the form of a ring as if the interior had been first filled with soft metal. 50

What I claim as my invention and desire to secure by Letters Patent is—

The use of a "former" (Fig. 5) when used in the manner described for the purposes specified.

ISAAC M. POTTER.

In presence of—

ROBT. RALSTON,

BENJ. F. THURSTON.