



# Impression Pattern Plate Instructions

## About the Plates

- Designed to be used in a rolling mill, but can be used with a 20-ton hydraulic press; you will get more accurate, complete patterns with a rolling mill.
- Size: approx. 7/64" thick x approx. 2" wide; length varies
- They sometimes arrive curved; that's okay!
- You **MUST** use annealed, non-ferrous metal.



---

**Potter USA** 1934 East 18th Street, Tucson, AZ 85719 (520) 777-6032  
sales@potterusa.com PotterUSA.com

## How-to: Rolling Mill

1. Place annealed, non-ferrous metal on top of the pattern plate, and insert it between the rolls of the mill.

NOTE: The steel used for the pattern plates is SOFTER than the rolls of a rolling mill, and will not harm or damage the rollers in any way.

2. Tighten the rolls until you can no longer easily remove the metal and pattern plate.

3. Slightly loosen the rolls and remove the metal/pattern plate.

4. Tighten your rolls approximately one-quarter turn, and roll the metal/pattern plate through the mill.

NOTE: Before working in silver or other precious metals, practice with the same-gauge copper or brass to make sure the pressure is correct.



## How-to: Hydraulic Press

1. Center the magnetic tool steel pusher (this isn't required, but will make it easier) on the upper platen of your 20-ton press.
2. Place annealed, non-ferrous metal on top of the plate, and center it on the lower platen of your press, beneath the magnetic tool steel pusher; use additional spacers, if needed. Place a small piece of urethane on top of the metal.
2. Raise the lower platen, and press the non-ferrous metal into the plate to approx. 1100 -2000psi.
3. Lower the platen, and move the urethane piece slightly on top of the metal. Make sure the metal does NOT move on the plate, or the design will be out of alignment. Press again.
4. Continue to move the urethane around, keeping it centered in the press, and continue to press until you have pressed the entire pattern.

### Notes about use with a press:

- You can use these plates in a 20-ton hydraulic press, but the results won't be the same as with the rolling mill; you'll get faster results with a rolling mill.
- You must use small urethane pieces and press multiple times to approx. 1100-2000psi. This will take time and effort.
- The key to success when using the press is to not allow the metal to shift at all on the plate. Using painter's tape to secure the metal to the plate is helpful, but isn't a guarantee that it won't move; take care not to move the metal or you'll get an offset impression.