

INSTRUCTIONS: BALOON FIRE PIT

COMPONENT 1 X25 MAIN CURVE: 914mm (20mm x 3mm)

Stage 1: Cut all 25 lengths to 914mm.
 Stage 2: Mark Bend positions **B1**, **B2** and Hole positions **H1** and **H2** on each of the 25 cut length steel strips using a marker pen.
 Stage 3: Attach the winding handle and insert your steel strip and apply light pressure on the lever handle and roll R1 using the winding handle to form your first curve, check curve using template sheet 1 main curve in middle.
 Stage 4: Remove winding handle and bend **B1**, check your bend using template sheet 1, repeat bend for all 25 lengths. Bend **B2** and check your bend using template sheet 1 main curve bottom half and repeat bend for all 25 lengths.
 Stage 5: Adjust the platform to centralise the punch hole for using 20mm x 3mm for holes **H1** and **H2** and punch a 3mm Dia hole, repeat punch holes on all 25 lengths.

COMPONENT 2 X4 S-SCROLL FOOT: 600mm (20mm x 3mm)

Stage 1: Cut 600mm of 20mm x 3mm steel strip.
 Stage 2: Mark Scroll positions **S1** and **S2** on the steel strip using a marker pen. Preferably mark the lines on the side of the steel strip so they are not removed when scrolling.
 Stage 3: Insert your steel strip into your 2/2F or 2/3F and scroll until the segment meets your marked point. Check s-scroll on template sheet 1, repeat scroll forming using your magnetic markers.

COMPONENT 3 X1 TOP RING: 575mm (20mm x 3mm)

Stage 1: Cut 575mm of 20mm x 3mm steel strip.
 Stage 2: Mark Hole positions **H1** and **H3** on the steel strip using a marker pen. Preferably mark the lines on the side of the steel strip so they are not removed when rolling.
 Stage 3: Next stage you will be forming a circle, ****QUICK TIP****, insert your steel strip into your 2/2F or 2/3F and form a light curve at both ends. This little kink will help both ends blend on a curve when they meet so you don't get a flat edge. Attach the winding handle and insert your steel strip and apply light pressure on the lever handle and roll R2 full length using the winding handle to form your first curve, check using template sheet 2, the yellow highlighted area.
 Stage 4: After you've completed your curve, punch holes **H1** and **H3**.

COMPONENT 4 X1 BRACE: 150mm (After roll cut to 89mm) (20mm x 3mm)

Stage 1: Cut 150mm of 20mm x 3mm steel strips.
 Stage 2: Mark Hole positions **H3** on the steel strip using a marker pen. Preferably mark the lines on the side of the steel strip so they are not removed when rolling.
 Stage 3: Using the rolling machine, insert your steel strip and apply light pressure on the lever handle and roll the full length to form your curve and check using template sheet 1.
 Stage 4: After you have completed your curve, cut the waste material. See template sheet 3.
 Stage 5: Punch holes **H3**.

7" X 1.5" DEEP SAUCER (MC1443)

Using your 7" x 1.5" Deep Saucer, place upside down on the **BLUE** highlighted area on template sheet 2 and mark the punch holes **H2**.
 Adjust the platform for centralising a 3mm Dia punch hole using 20mm x 3mm, this will centralise the platform allowing you to punch your hole 10mm deep into the wall of the Deep Saucer.

ASSEMBLY

Stage 1: Start by assembling loosely component 1, component 3, component 4 and 7" x 1.5" Deep Saucer together using the nominated Nuts and bolts found in the 'List of material required' box on template sheet 3.

Stage 2: Using template sheet 2, using a permanent marker pen mark the 4 nominated component number 1's for the foot.

Stage 3: Using component 2, place each foot under the nominated component 1 and using a marker pen mark a line where both components meet for you to punch 2 holes in areas S1 and S2. Repeat this method on the remaining foot parts. Preferably mark each foot A,B,C,D and cross reference onto component 1 so they are paired.

Stage 4: Unbolt and remove the 4 nominated component 1's and punch holes in component 1 and component 2.

Stage 5: Remove winding handle and attach rivet posts. Rivet component 2 to component 1.

Stage 6: Re-attach component 1 with the foot attached and tighten all the nuts and bolts for holes **H2** on component 1 that attach deep saucer.

Stage 7: Remove Nut and Bolts one at a time from the top ring holes **H1** and **H3** and replace with your nominated rivets found in the 'List of material required' box on template sheet 3 and rivet each hole. You may need an extra person to help hold the fire pit upside down whilst you rivet.



LIST OF MATERIALS REQUIRED


30x Lengths of 20mm x 3mm x 6ft Steel Strip (**MC039/MC047**)
29x 3mm Dia 10mm Long Rivets (**MC052L**) > **x21** for **H1** Component 1, **x8** for component 2
4x 3mm Dia 12mm Long Rivets (**MC053L**) > **x4** for **H3** Component 4 and Component 3
25x 3mm Dia 10mm Long Nuts and Bolts (**MC060L**) > **x25** for **H2** Component 1
25x 3MM Dia 12mm Long Nuts and Bolts (**MC061L**) > **x25** for **H1** Component 1 and Component 3
1x 7" x 1.5" Deep Saucer (**MC1443**)


TOOL LIST

CUTTING: PRAC P/SH, MASTER P/SH, XL5+ POWER BENDER
PUNCHING: PRAC P/SH, MASTER M/PSH, XL5+ POWER BENDER
BENDING: PRAC RBR, MASTER RBR + MICRO BENDER, XL5+ POWER BENDER + MICRO BENDER
RIVETING: PRAC RBR, MASTER RBR, XL5+ POWER BENDER
ROLLING: PRAC RBR, MASTER RBR, XL5+ POWER BENDER
SCROLLING: 2/2F SCROLL FORMER, 2/3F SCROLL FORMER

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Contact Us

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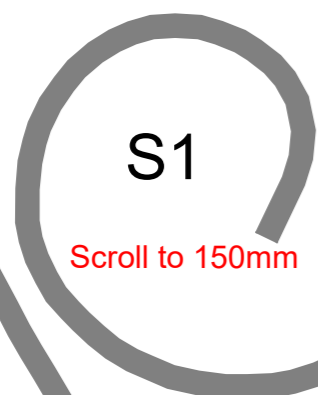
 +44 (0)1482 345067

 info@jandcrwood.co.uk

INSTRUCTIONS: BALLOON FIRE PIT

TEMPLATES TO SCALE

TEMPLATE SHEET 1

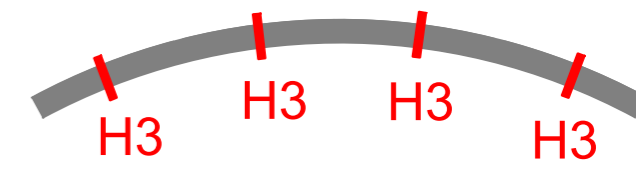


COMPONENT 2
S-SCROLL FOOT



R1
COMPONENT 1
MAIN CURVE TOP HALF

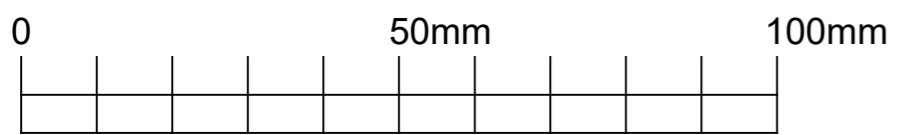
| B = BEND
| H = HOLE



COMPONENT 4
BRACE

COMPONENT 1
MAIN CURVE IN MIDDLE

R1
COMPONENT 1
MAIN CURVE BOTTOM HALF



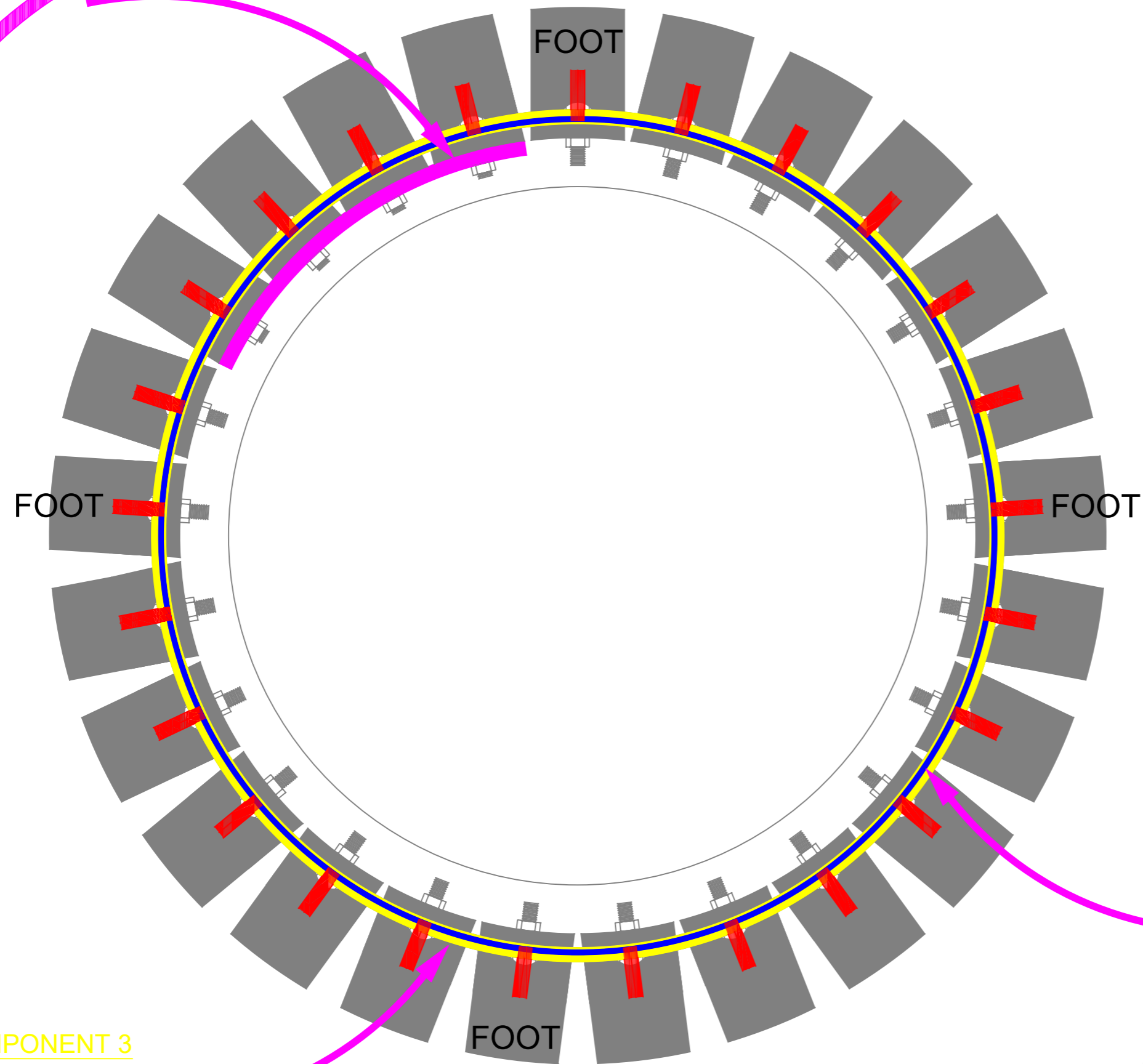
SCALE BAR

H1
B1

B2
H2

INSTRUCTIONS: BALLOON FIRE PIT

COMPONENT 4
BRACE



TEMPLATE SHEET 2

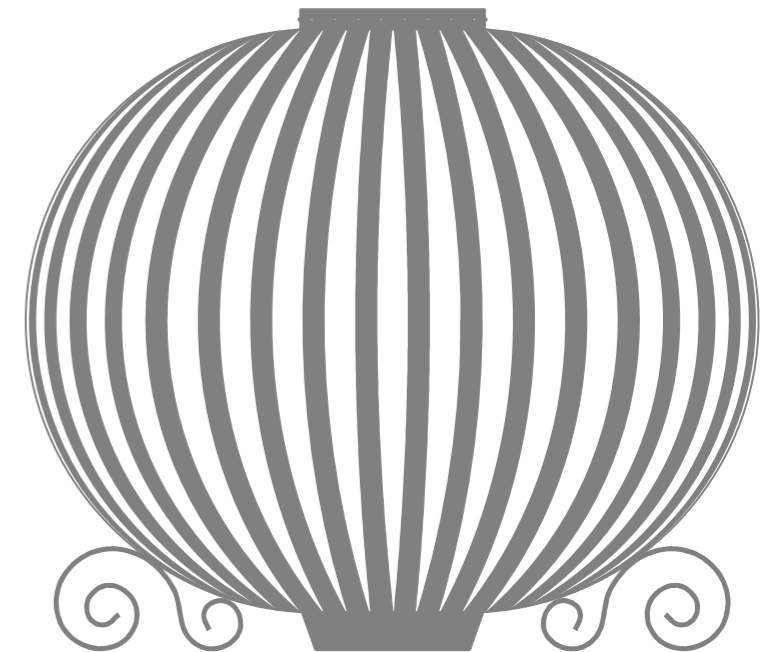


FIG 1
NOT TO SCALE

TEMPLATES TO SCALE

MC1443
7" x 1.5" Deep Saucer



SCALE BAR

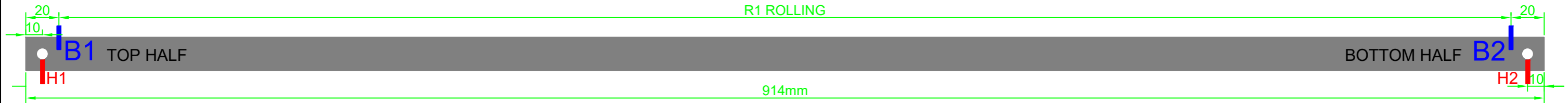
COMPONENT 3
TOP RING

I H = HOLE

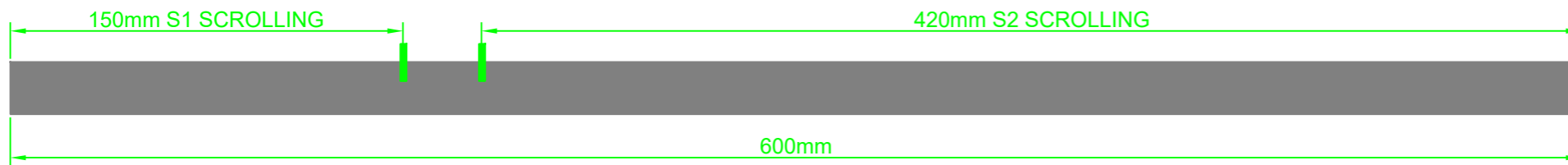
INSTRUCTIONS: BALLOON FIRE PIT

TEMPLATE SHEET 3

X25 COMPONENT 1 MAIN CURVE CUT LENGTH AT 914MM (20MM X 3MM)

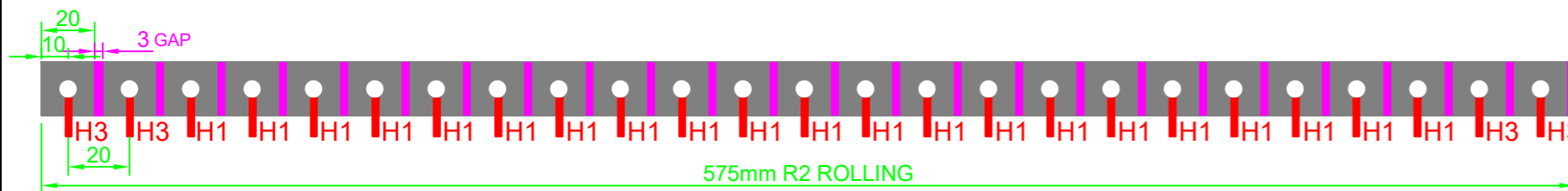


X4 COMPONENT 2 S SCROLL FOOT CUT LENGTH AT 600MM (20MM X 3MM)



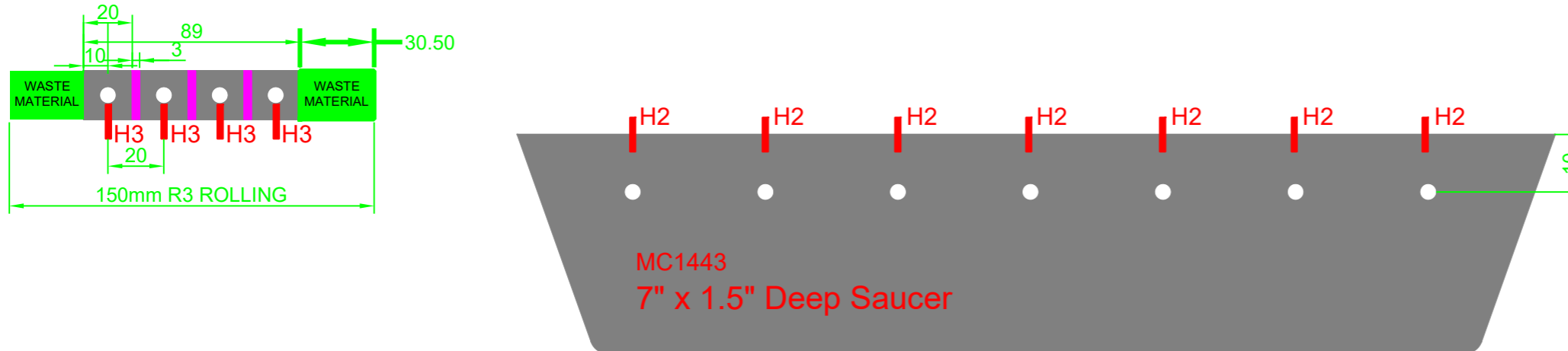
B = BEND
H = HOLE

X1 COMPONENT 3 TOP RING CUT LENGTH AT 575MM (20MM X 3MM)

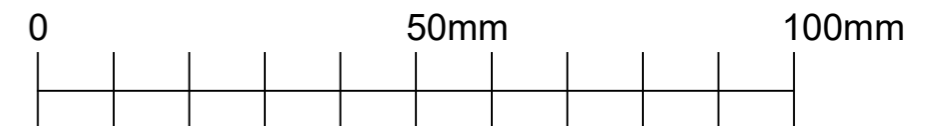


FLAT VIEW
NOT TO SCALE

X1 COMPONENT 4 BRACE CUT LENGTH AT 150MM (AFTER ROLL CUT TO 89MM) (20MM X 3MM)



We recommend that before starting you wipe all steel bars down so that they are free of grease, scale or dirt. After cutting any component, we also recommend that you trim the corners for a neater finish, if preferred, unless these instructions tell you otherwise. Use a fine tip marker pen, pencil or scribe for marking hole, bend, scroll, roll points on the bars.



SCALE BAR