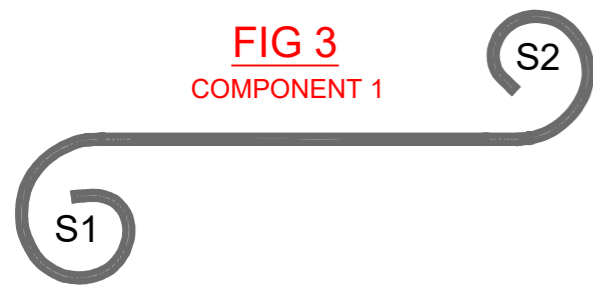


# INSTRUCTIONS: COCKTAIL & GIN TREE HOLDER

## COMPONENT 1 X5 MAIN LEG STRUCTURE 914mm (15mm x 3mm)

Stage 1: Cut all 5 lengths at 914mm.  
 Stage 2: Using a marker pen on each strip mark Bend positions B1. Mark Scroll positions S1 and S2. Mark Roll position R1. Mark Hole positions H1 and H2.  
 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 curve. Increase the pressure on the lever handle until you get your curve needed and check using template sheet 1.  
 Stage 4: Scroll S2 using your 2/3F or 2/2F scroll former. Opposite end scroll S1 using your 2/3F or 2/2F Scroll former. Take note that S1 is scrolled in the opposite direction, see Fig 3 below.  
 Stage 5: Bend a 90 degree bend on B1. Check on template sheet 1.  
 Stage 6: Adjust the platform to centralise the punch hole and punch both Hole positions H1 first. For H2, set the tape measuring device to 40mm and place H1 into the point holder and punch H2. This will give you an accurate 40mm gap between both holes. **\*\*\*If you do not have a tape measuring device please make sure to mark and punch the steel as accurately as possible\*\*\***. Repeat this method for holes H1 and H2 on the ARM component 2.

**FIG 3**  
COMPONENT 1



## COMPONENT 2 X10 ARM: 450mm (15mm x 3mm)

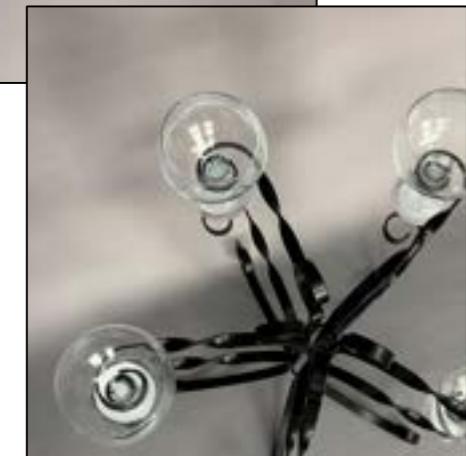
Stage 1: Cut all 10 lengths at 450mm.  
 Stage 2: Using a marker pen on each strip mark Roll position R2. Mark Twist position T1. Mark Scroll position S3. Mark Hole positions H1 and H2.  
 Stage 3: Using your PTW Twist T1, use Fig 2 for twisting set up on template sheet 2.  
 Stage 4: Attach the winding handle and insert your steel strip and apply light pressure on the lever handle and roll R2 using the winding handle to form your curve. Increase the pressure on the lever handle until you get your curve needed and check using template sheet 1.  
 Stage 5: Scroll S3 using your 2/3F or 2/2F scroll former.  
 Stage 6: Punch both Hole positions H1 first. For H2, set the tape measuring device, if available to 40mm and place H1 into the point holder and punch H2. This will give you an accurate 40mm gap between both holes. **\*\*\*If you do not have a tape measuring device please make sure to mark and punch the steel as accurately as possible\*\*\***. Repeat this method for holes H1 and H2 on the ARM component 2.

## COMPONENT 3 X2 Collar: 100mm (15mm x 3mm)

Stage 1: Cut 2 lengths at 100mm.  
 Stage 2: Using a marker pen, mark Bend positions B2. Mark Hole positions H3.  
 Stage 3: Remove the winding handle and create a shallow bend at B2 and repeat the same bend on all B2's. Adjust the bolt anti-clockwise only with the smallest of turns to be able to apply more pressure on the lever handle to increase your bend. Keep repeating this process until you form your Collar.  
 Check using template sheet 1.  
 Stage 4: Punch hole positions H3.

## ASSEMBLY

Attach your components together using 3mm Dia 12mm Long Nuts and Bolts. Use Fig 1 for assembling positions.



## LIST OF MATERIALS REQUIRED

11x Lengths of 15mm x 3mm x 3ft Steel Strip (MC037)  
 20x 3mm Dia 12mm Long Nuts and Bolts (MC061L)  
 5x Large Bumper feet (MC1275)

## TOOL LIST

**CUTTING:** PRAC P/SH, MASTER P/SH, XL5+ POWER BENDER  
**PUNCHING:** PRAC P/SH, MASTER M/PSH, XL5+ POWER BENDER 3mm Dia Hole  
**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  
**TWISTING:** PRAC TWISTER

**metalcraft**

## Contact Us

J & C R Wood Limited, 66 Clough Road, Hull, HU5 1SR

+44 (0)1482 345067

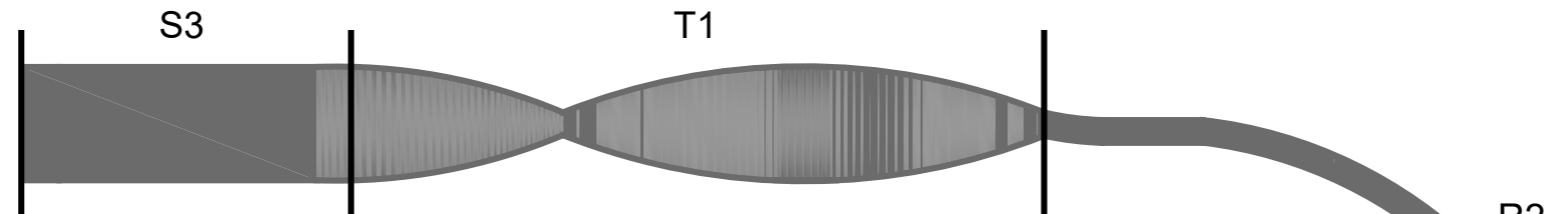
info@jandcrwood.co.uk

# INSTRUCTIONS: COCKTAIL & GIN TREE HOLDER

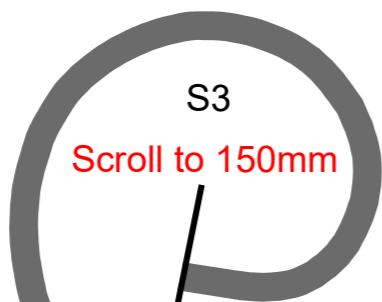
## TEMPLATE SHEET 1

**SIDE VIEW TO SCALE**

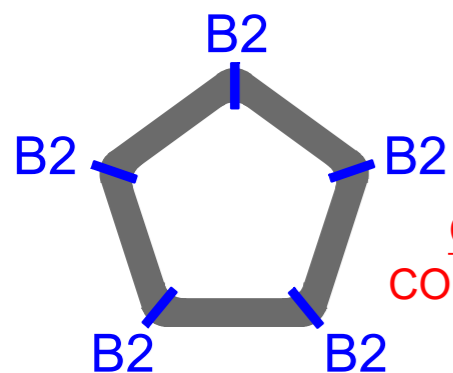
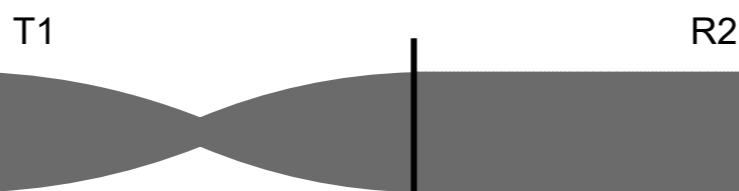
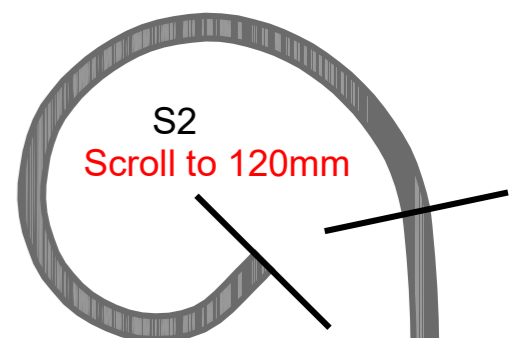
**B = BEND**  
**H = HOLE**



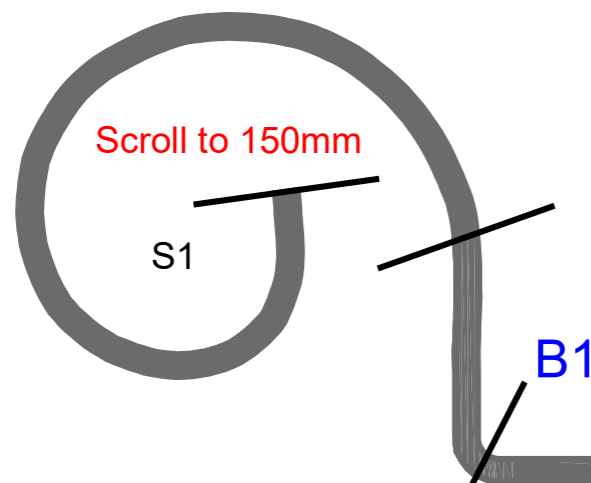
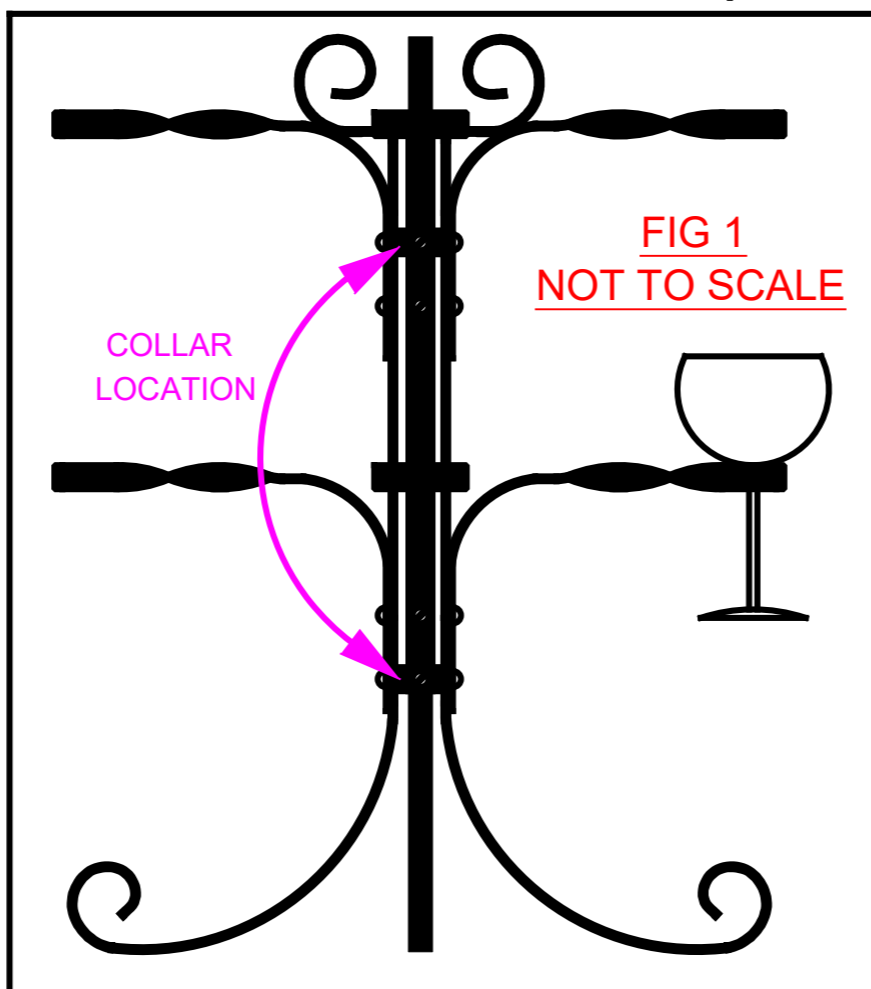
**COMPONENT 2 ARM SIDE VIEW**



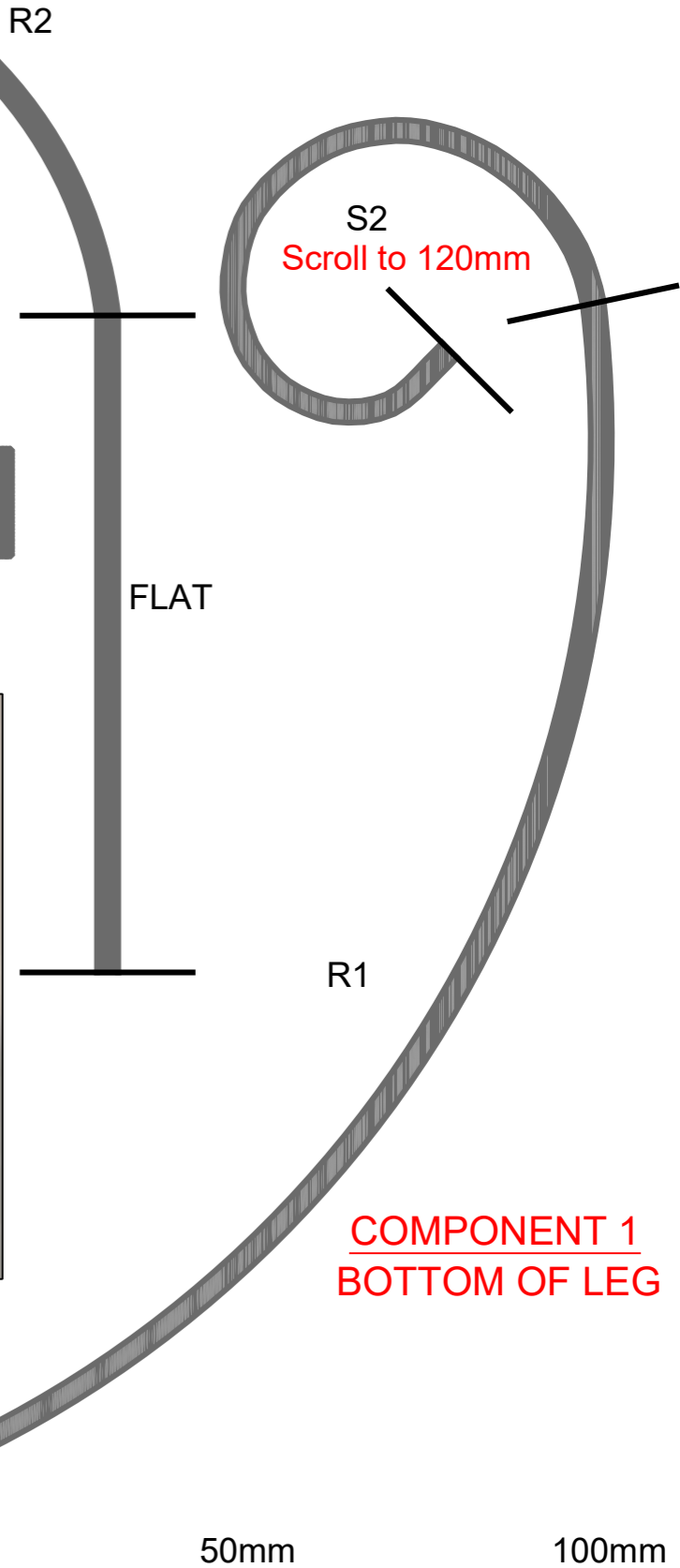
**COMPONENT 2 ARM TOP VIEW**



**COMPONENT 3 COLLOAR SIDE VIEW**



**COMPONENT 1 TOP OF LEG**



**COMPONENT 1 BOTTOM OF LEG**

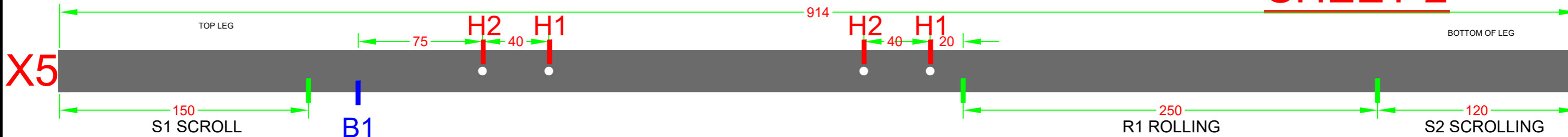


**SCALE BAR**

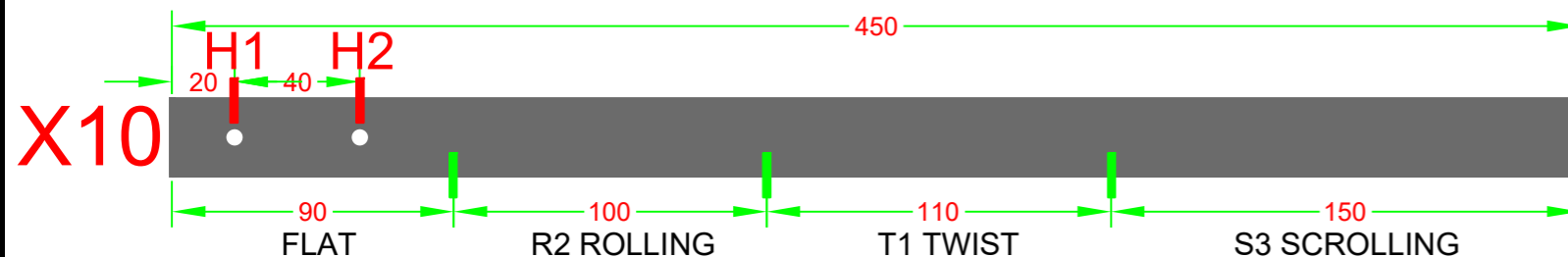
# INSTRUCTIONS: COCKTAIL & GIN TREE HOLDER

## TEMPLATE SHEET 2

COMPONENT 1 MAIN LEG STRUCTURE TOP/BOTTOM CUT LENGTH AT 914MM (15MMX3MM)

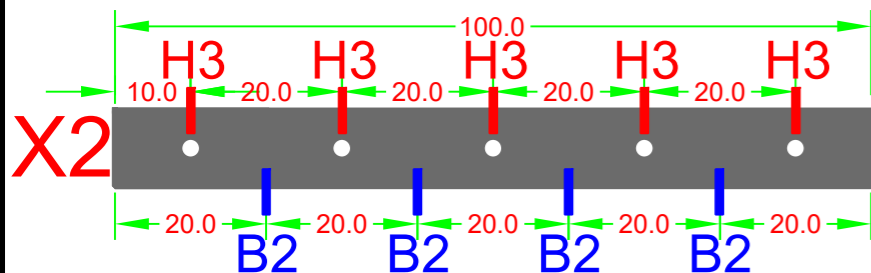


COMPONENT 2 ARM CUT LENGTH AT 450MM (15MMX3MM)

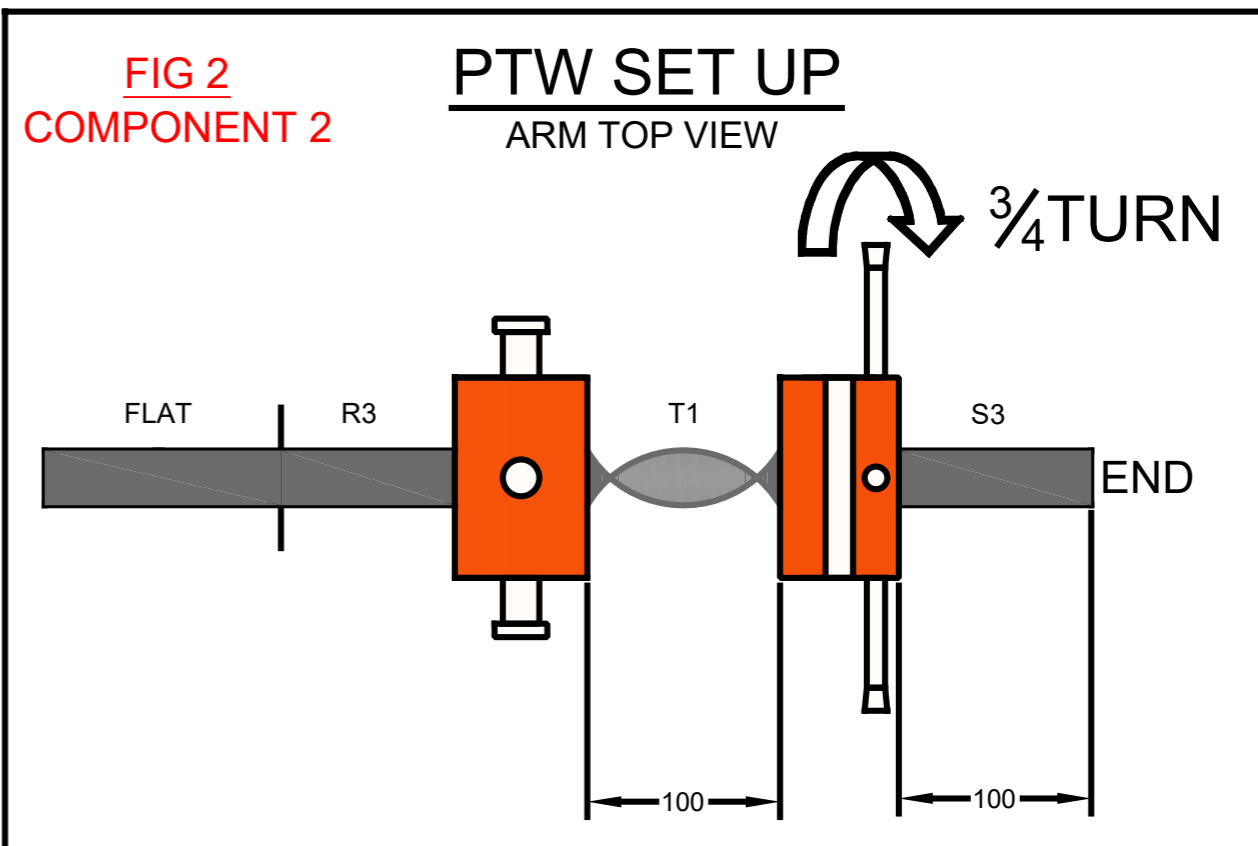


**B = BEND**  
**H = HOLE**

COMPONENT 3 COLLAR CUT LENGTH AT 100MM (15MMX3MM)



**FLAT VIEW**  
**NOT TO SCALE**



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**