

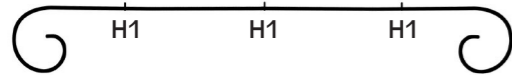
WINE RACK

Tools Required to Make this Design:

Scrolling: Mk 2/2H (or Mk 2/3) Scroll Formers
 Punching: Practical Punch/Shear (or Master Punch/Shear or XL5+ Power Bender fitted with 3mm punch block & pin - or use 5mm holes but 5mm rivets will be required*)
 Riveting: Practical RBR
 Bending: Practical RBR (or Master RBR or XL5+ Power Bender - *see above)
 Rolling: Practical RBR (or Master RBR or XL5+ Power Bender - *see above)
 Cutting: Practical Punch/Shear (or Master Punch/Shear or XL5+ Power Bender)

1 Bottom Scrolls (feet) 720mm (x 2) COMPONENT 1

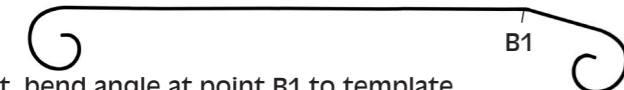
Cut both lengths, trim corners, mark the centre and at 130mm either side of centre and punch all 3 holes H1



Mark Scroll point S2 160mm from each end and form scroll to create 'C' scroll with an approx. overall length of 474mm.

2 Main Upright Scrolls 875mm (x 4) COMPONENT 2

Cut 4 lengths, trim corners, measure and mark Scroll point S1 160mm from each end. Mark bend point B1 190mm from one end. Scroll to S1 mark at either end - creating a 'C' scroll with a finished length of approx. 595mm.



Next, bend angle at point B1 to template No. 1 on all 4 lengths to produce this shape.

3 Top Wine Strap 200mm (x 2) COMPONENT 3

Cut 2 lengths and trim corners. Mark centre of bar and punch hole H2. From each end of the bar, now mark 20mm in for bend points B2 and bend angle as per Template No. 2 at each end.

4 Middle Wine Strap 340mm (x 2) COMPONENT 4

Cut 2 lengths and trim corners. From each end of the bar, now mark 95mm and punch a hole H3 at each mark. Now make the two bend marks at 20mm from each end and bend angle as per Template No. 2.

5 Bottle Holders 140mm x (12) COMPONENT 5

Cut all 12 lengths. Mark hole H4 in the centre of each. Then roll each strip to create shape as Template No. 3. Punch hole H4 in all 12 components. Rivet all bottle holders to: Component 1 (x 2), Component 3 (x 2) and Component 4 (x 2) using 10mm x 3mm rivets.



6 Top Brace 215mm (x 1) COMPONENT 6

Cut length, trim corners. Mark hole H5 10mm from one end and mark two holes from other end, H6, 5mm from end and other H7, 25mm from end and punch.

7 Bottom Braces 200mm (x 2) COMPONENT 7

Cut length, trim corners and mark holes H5, 10mm from each end and punch.

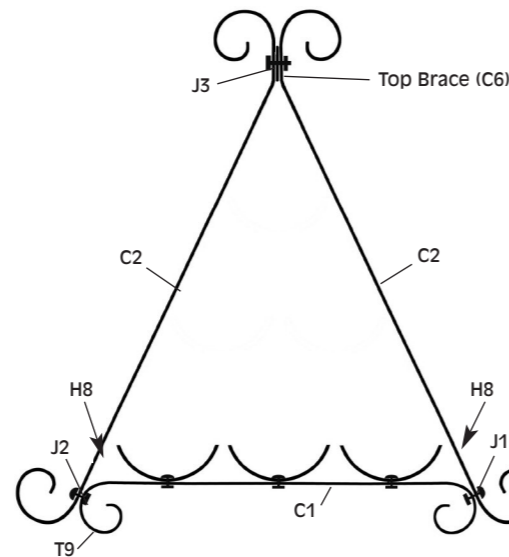
8 Packing Piece COMPONENT 8

From any offcuts, cut a short piece 20mm long, trim corners where possible and mark H9, 5mm from the end and punch. This is used as a packing piece to fit motif in place).

9 Assembly

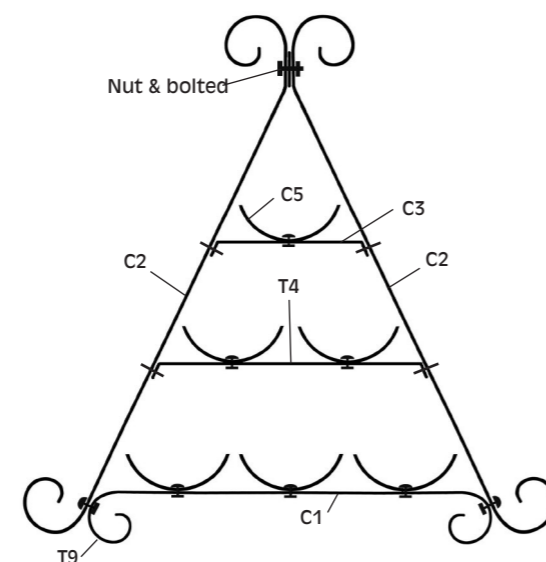
Lay out main uprights C2 (x 2) and bottom scrolls C1 as shown - so that bottom scrolls are just below the scrolls of the main upright. Make sure the flat portions of the uprights at J3 are flat against each other and adjust/increase bend B1 if necessary. Also make sure top brace is laid inbetween the flats below the scrolls and mark the rivet joints where metalwork touches at J1, J2, J3 (NB. mark a point just above B1 bend). Also, mark hole H8, 50mm up the upright from J2 and punch. Punch these holes and rivet joints J1 and J2 with a 10mm x 3mm rivet.

Leave J3 unriveted with top brace nut & bolted in place whilst riveting J1 and J2.



10

Next, lay components C3 and C4 (the top and middle wine straps) into the frame created in strip 8. At the four points where the wine straps touch the uprights mark the touching points, then punch and rivet in place with 8mm rivets.



metalcraft™

Design Pack WINE RACK

DIFFICULTY RATING:

EASY	
STRAIGHTFORWARD	
MORE COMPLEX	✓

11 Unbolt the top brace and place this in the other frame components and repeat steps **9** and **10** to create back frame.

12 Now join the front frame to the back frame using 12mm x 3mm nuts & bolts (x 6) in the top strip and bottom strips to hold structure together and check the two frames are properly aligned.

13 Starting with bottom braces, replace first nut & bolt with a 10mm x 3mm rivet and rivet the joint on the bottom brace. Move on to the next joint and again replace the nut & bolt with a 10mm x 3mm rivet and rivet. Repeat for the other two bottom brace joints.

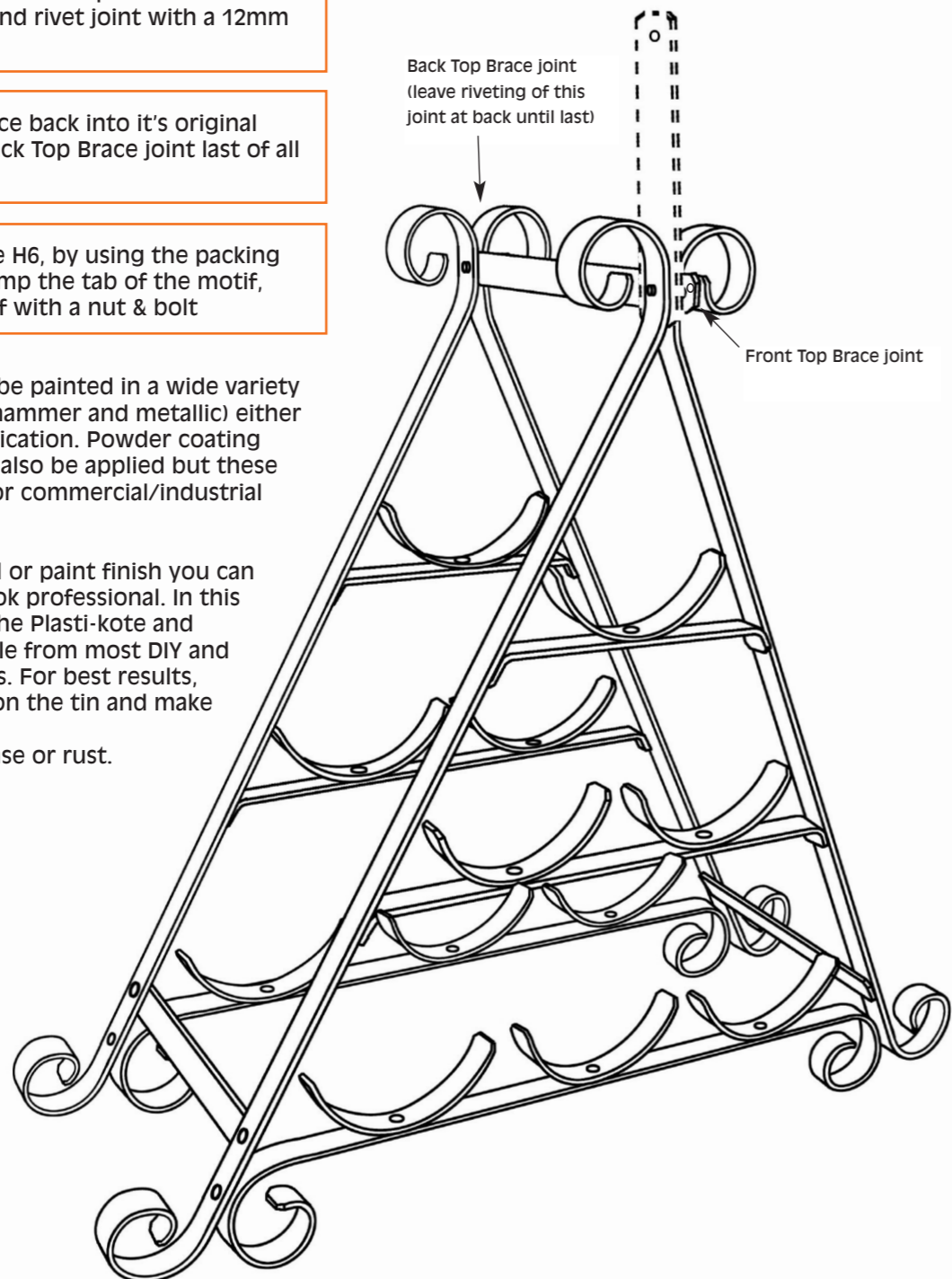
14 Undo the Back Top Brace nut & bolt and rotate the top brace so that it's in the position shown by the dotted lines in the diagram here. Replace the Front Top Brace joint nut & bolt and rivet joint with a 12mm x 3mm rivet.

15 Next, swing the Top Brace back into it's original position and rivet to the Back Top Brace joint last of all with a 12mm x 3mm rivet.

16 On the top brace at hole H6, by using the packing piece (Component 8) to clamp the tab of the motif, attach the fleur de lys motif with a nut & bolt

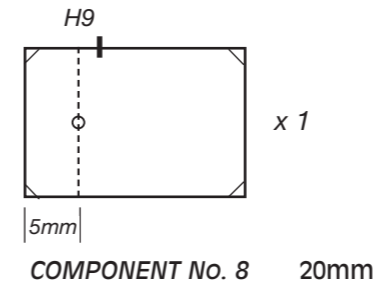
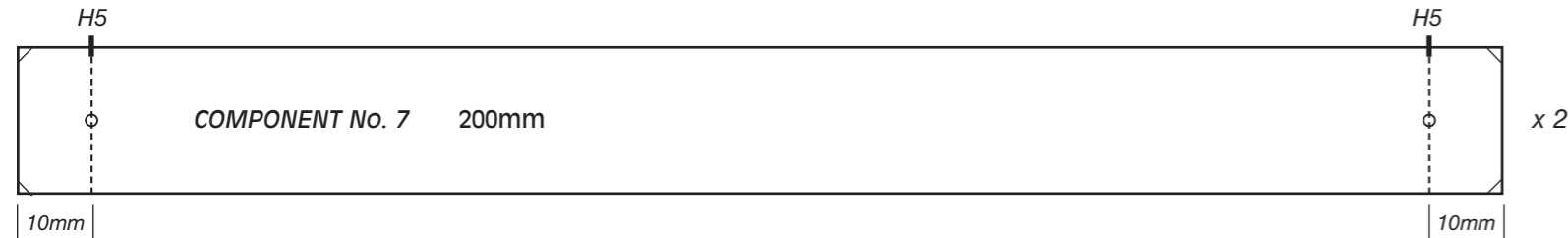
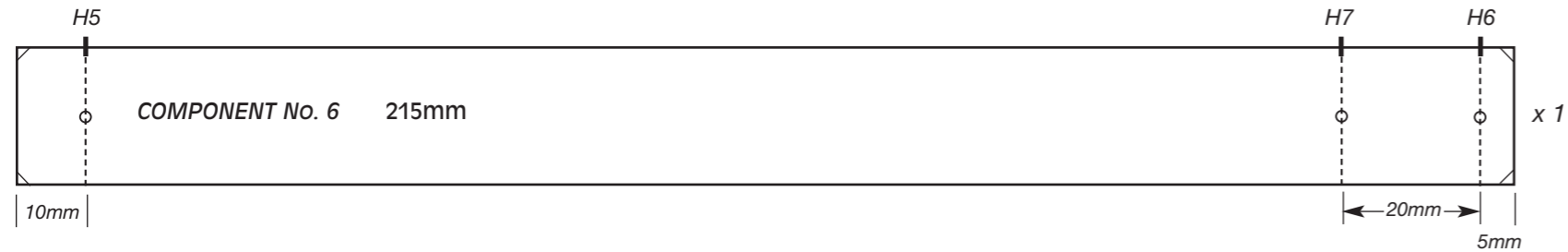
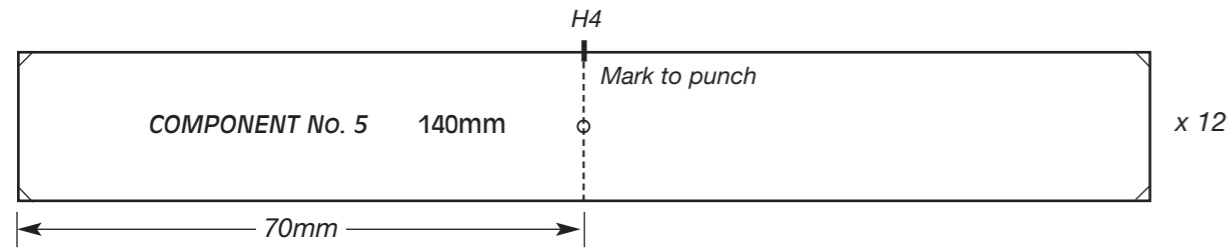
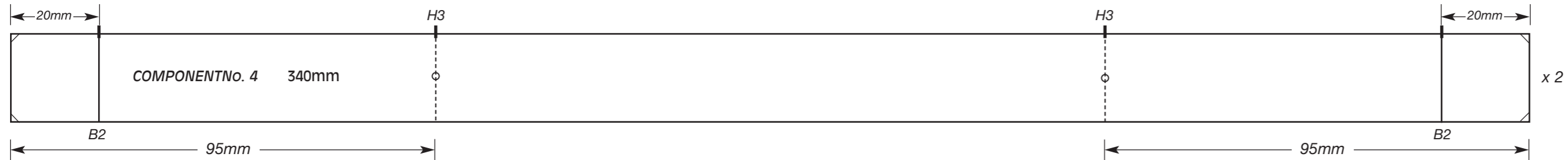
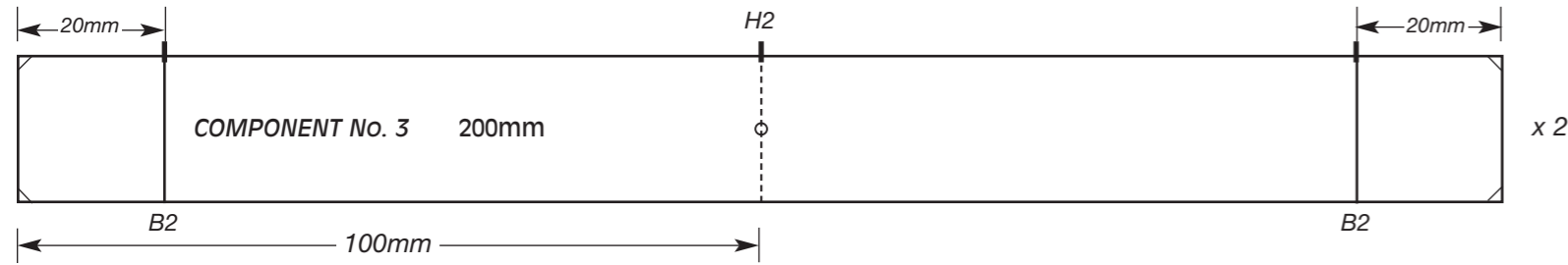
The finished item can now be painted in a wide variety of finishes (smooth, satin, hammer and metallic) either by aerosol or by brush application. Powder coating and plastic dip finishes can also be applied but these type of finishes are more for commercial/industrial scale finishing.

However, even with aerosol or paint finish you can make your finished item look professional. In this case we used paints from the Plasti-kote and Hammerite ranges - available from most DIY and Painting/Decorating outlets. For best results, always follow instructions on the tin and make sure the metal is free of all scale, dirt, grease or rust.

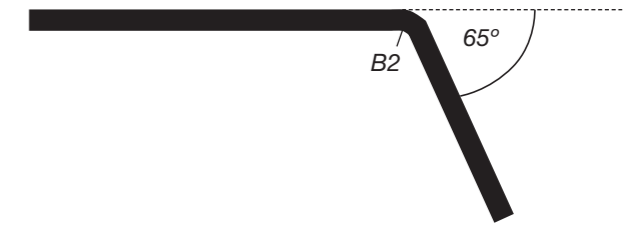


Design Pack: WINE RACK - DESIGN SHEET

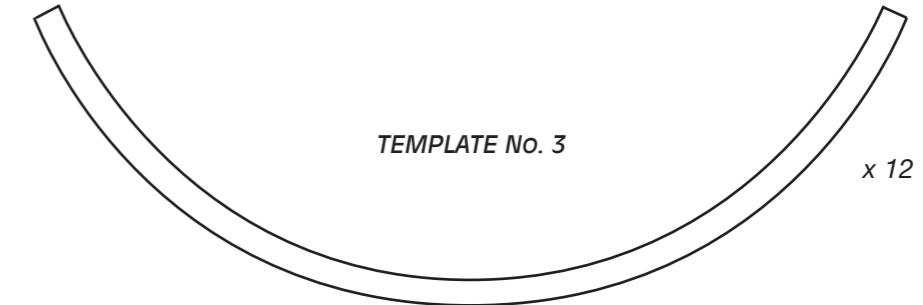
TO SCALE:



TEMPLATE No. 2



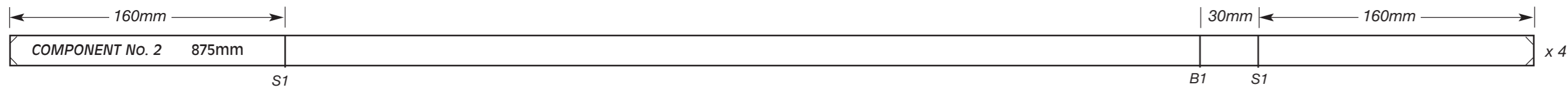
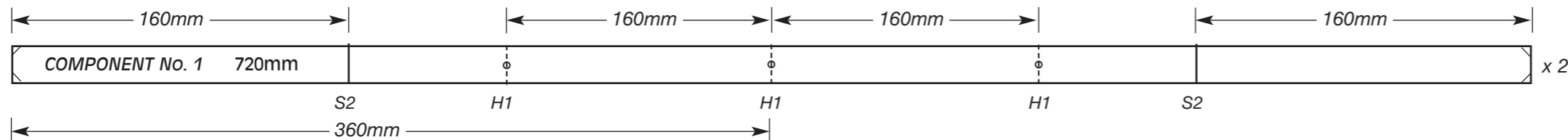
TEMPLATE No. 3



TEMPLATE No. 1



NOT TO SCALE:



List of Materials Required:

- 10 x 914mm lengths of 20 x 3mm Steel Strip [Re-order ref MC039]
- 2 x 12mm x 3mm Rivets [Ref MC053L]
- 28 x 10mm x 3mm Rivets [Ref MC052L]
- 6 x 12mm x 3mm Nuts & Bolts [Ref MC061L]
- 1 x W28 Fleur De Lys [Ref MC090]