

CAKE STAND

- Tools Required To Make this Design:
- Punching: Practical Punch/Shear (or Master Punch/Shear or XL5+ Power Bender fitted with 3mm Punch Block & Pins)
- Cutting: Practical Punch/Shear (or Master Punch/Shear or XL5+ Power Bender)
- Riveting: Practical RBR
- Bending: Practical RBR
- Rolling : Practical RBR
- Scrolling: Mk 2/2H or Mk 2/3 Scroll Former

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.

Component 1

Side Legs
15mm x 3mm x 600mm (2)

From 2 lengths of 15 x 3 x 914mm steel strip, using the Practical Punch/Shear Tool (PPS), cut 2 strips, each 600mm long. Chamfer all corners using the PPS. On each strip mark hole positions H1-H4, scroll position S1 and roll position R1. Using the Mk 2/2H or Mk 2/3 Scroll Former, scroll non punched end of each strip up to S1. Using the Practical Riveting, Bending & Rolling Tool (PRBR) roll strips between R1 and non scrolled end. Punch all marked holes using the PPS. See Component 1 on Template Sheet 1 for profile.

Component 2

Rear Leg
15mm x 3mm x 620mm (1)

From 1 length of 15 x 3 x 914mm steel strip, cut 1 strip, 620mm long. Set aside the remainder of steel strip for Component 3. Chamfer all corners. Mark hole positions H5-H8, scroll position S2 and Roll position R2. Scroll non punched end of strip up to S2. Roll strip between R2 and non scrolled end. Punch all marked holes. See Component 2 on Template Sheet 1 for profile.

Component 3

Front Leg
15mm x 3mm x 200mm (1)

From left over steel for Component 2, cut 1 strip, 200mm long. Chamfer all corners. Mark hole position H9 and scroll position S3. Scroll non punched end of strip up to S3. Once you have scrolled S3 trim the excess 70mm off from the end of the material. Punch hole position H9. See component 3 on design sheet as reference.

Component 4

Large Ring
12mm x 2mm x 914mm (2)

Take 2 full lengths of 12 x 2 x 914mm steel strip. On each strip mark hole positions H10-H15. **Note, H13 is only required on 1 ring. (This is for the front leg)** Roll both strips to form 2 complete rings. Punch all marked holes.

Component 5

Ring Connector
12mm x 2mm x 25mm (2)

From 1 length of 12 x 2 x 914mm steel strip, cut 2 strips, each 25mm long. Set aside remainder of steel strip for further components. Chamfer all corners. On each strip mark and punch hole positions H16 and H17. See Component 5 on Template Sheet 1 for profile.

Component 6

Ring Scrolls
12mm x 2mm x 445mm (10)

From left over steel for Component 5, cut 1 strip, 445mm long. From 5 additional lengths of 12 x 2 x 914mm steel strip, cut 9 more strips, each 445mm long. Chamfer all corners on all 10 strips. On each strip mark hole positions H18. Using the Mk 2/2H Scroll Former, form a complete scroll starting at Mark S4. Using the PBR, roll the remainder of the strip to complete the scroll. See Component 6 on Template Sheet 1 for profile. Ensure all scrolls are the same. Punch hole position H18.

Component 7

Top Scrolls
12mm x 2mm x 300mm (3)

From 1 length of 12 x 2 x 914mm steel strip, cut 3 strips, each 300mm long. Chamfer all corners. On each strip, mark hole positions H20 and scroll positions S5 and S6. Scroll each end of each strip to the nearest scroll position and punch hole H20. See Component 7 on Template Sheet 1 for profile.

Component 8

Heart Handle
12mm x 2mm x 400mm (1)

From left over steel for Component 5, cut 1 strip, 400mm long. Chamfer all corners. Mark hole positions H21-H23, bend positions B3-B4 and scroll positions S7-S8. Using the PBR, roll between B3 and S7, then between B4 and S8. Scroll ends to S7 and S8. Bend at B3 and B4 to create heart shape. See Component 8 on Template sheet 1 for profile.

Assembly Instructions

1) Lay both Large Rings (Component 4) on a flat surface and rivet loose ends together using the Ring Connector strip (Component C5). Make sure the Ring Connector strip is on the **inside face** of the Large Rings. See Fig 1 on Assembly Sheet 2.

2) Firstly start by filling the 3 or 4 punched holes on the large rings with a nut and bolt this is so these do not get accidentally riveted when fixing the inner scrolls. Start by arranging 5 Ring Scrolls (Component 6) inside each Large Ring using Fig 2 on Assembly Sheet 2 as a guide. Align H18 to the inside of the ring and mark where it touches ensuring holes are not too close to current holes in the outer ring. Adjust scrolls as necessary to ensure they touch each other and the inside face of the Large Ring, punch markings on the ring and nut and bolt together ensuring scrolls will not interfere with upright holes. Rivet when confident the correct holes are used.

3) With the bolts provided, connect the Front Leg (Component 3) using hole H9 to the Large Ring with hole H13 and finger tighten.

4) Using hole H19, rivet the Top Scrolls (Component 7) to the top ends of rear and side legs (Components 1 and 2) using holes H3 and H7.

5) With the bolts provided, connect the Side Legs (Component 1) using holes H1 and H2 to the Large Rings at holes H12 and H14 and finger tighten.

6) With the bolts provided, connect the Rear Leg (Component 2) using holes H5 and H6 to the Large Rings at hole H11 and finger tighten.

7) Using holes H20-H22, nut and bolt the Heart Handle (Component 8) to the top end of the rear and side legs (Components 1 and 2) using holes H4 and H8.

8) Remove each nut and bolt in turn and using the PBR Tool, rivet the relevant components together. Start by removing the rings from the cake stand and the front leg to the bottom ring.

Next Rivet the top scrolls and heart shaped handle onto the side legs and rear leg.

Rivet the bottom ring into position using hole positions H1 on side the legs only. You will have to rotate the ring into a flat position and gentle twist some of the internal scroll work in order to rivet with the PRBR.

Repeat the above process for the top ring using holes H2 on the side legs.

Finally using the nuts and bolts provided fasten the rear leg to the large rings to complete your cake stand.



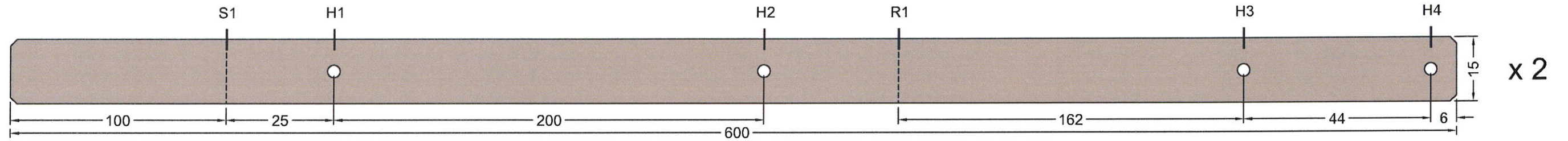
metalcraft™

Design Pack

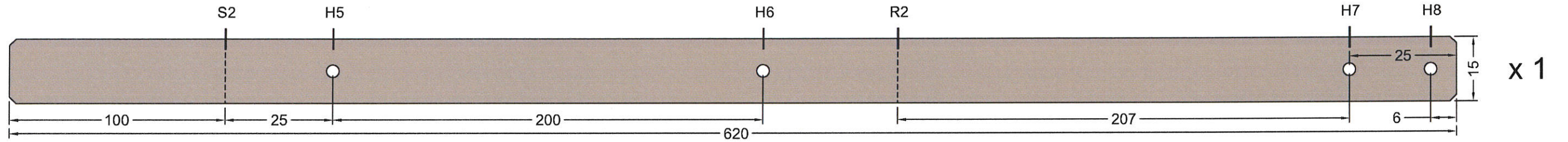
Cake Stand

Difficulty Rating:	
Easy	
Straightforward	✓
More complex	

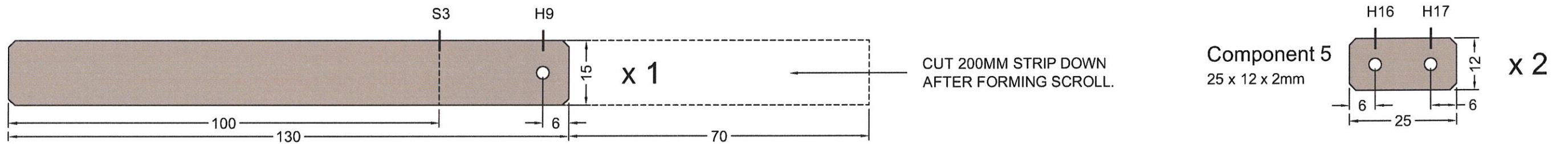
Component 1
600 x 15 x 3mm



Component 2
620 x 15 x 3mm

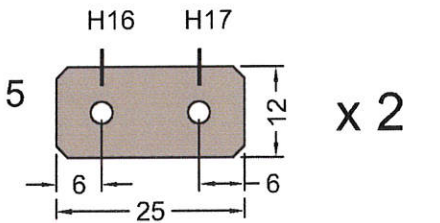


Component 3
130 x 15 x 3mm
(from 200mm strip)

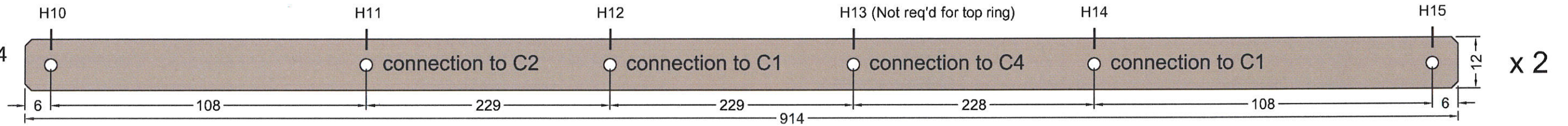


CUT 200MM STRIP DOWN
AFTER FORMING SCROLL.

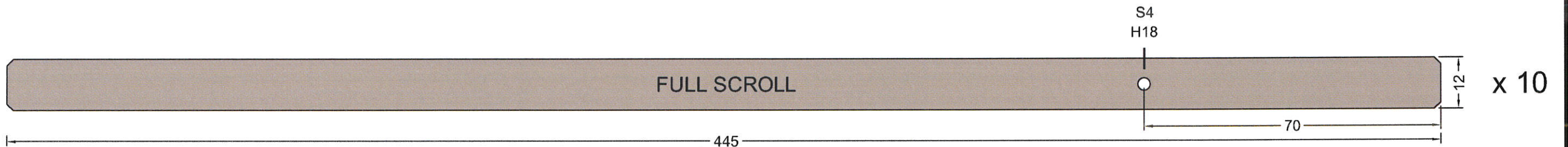
Component 5
25 x 12 x 2mm



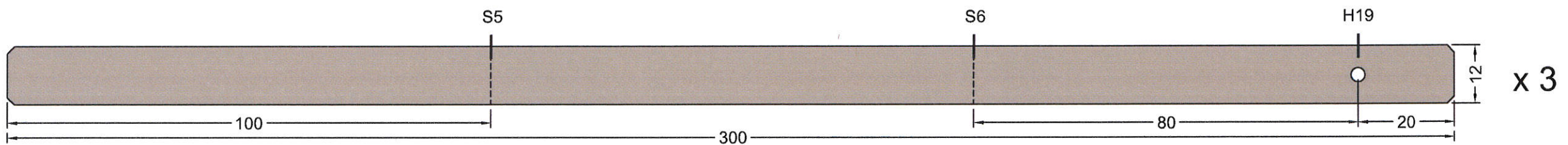
Component 4
914 x 12 x 2mm



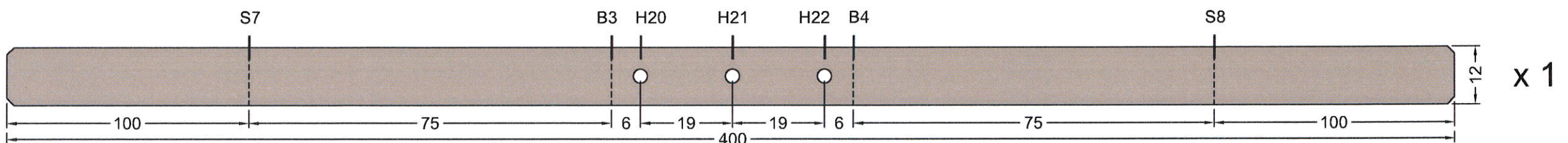
Component 6
445 x 12 x 2mm



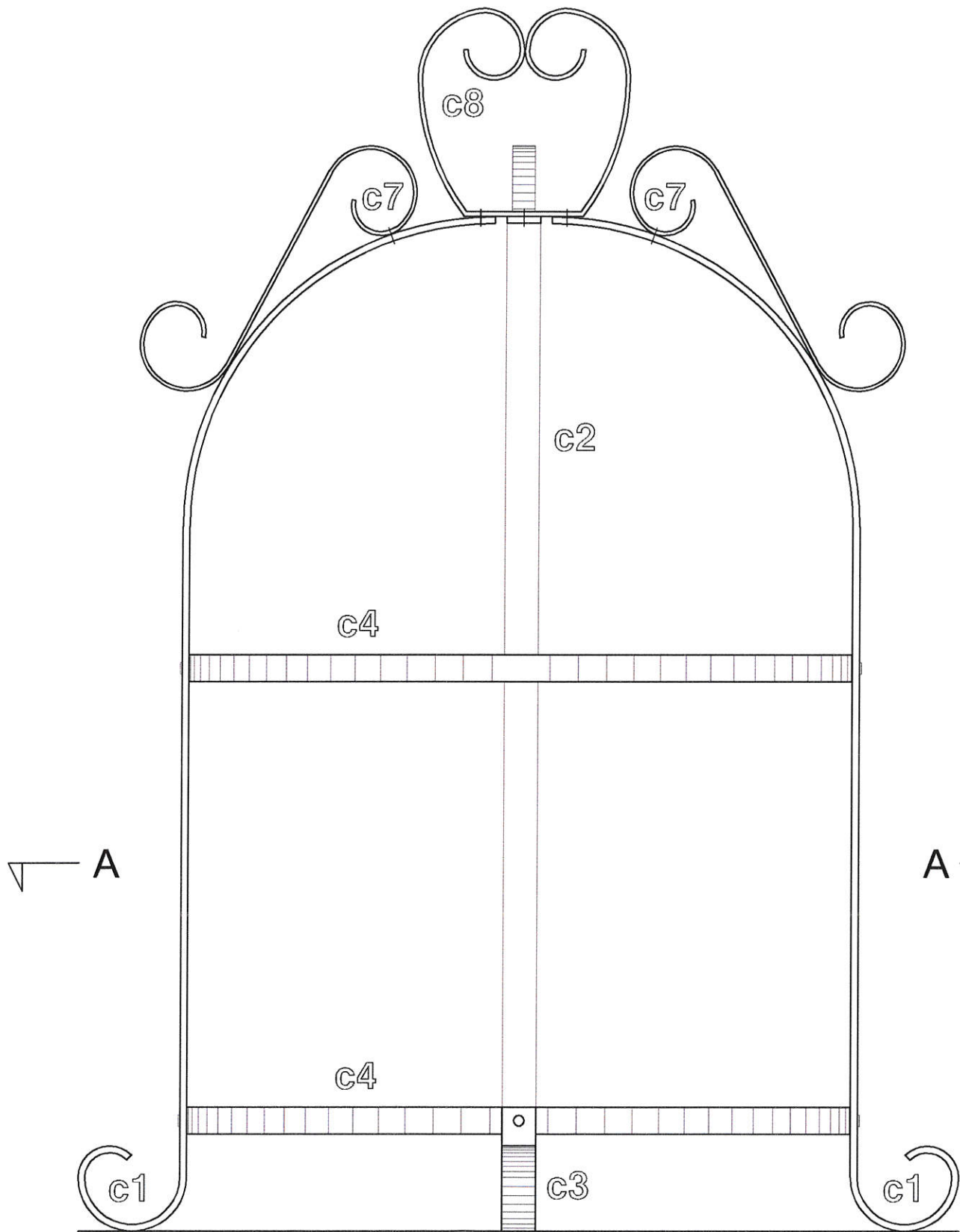
Component 7
300 x 12 x 2mm



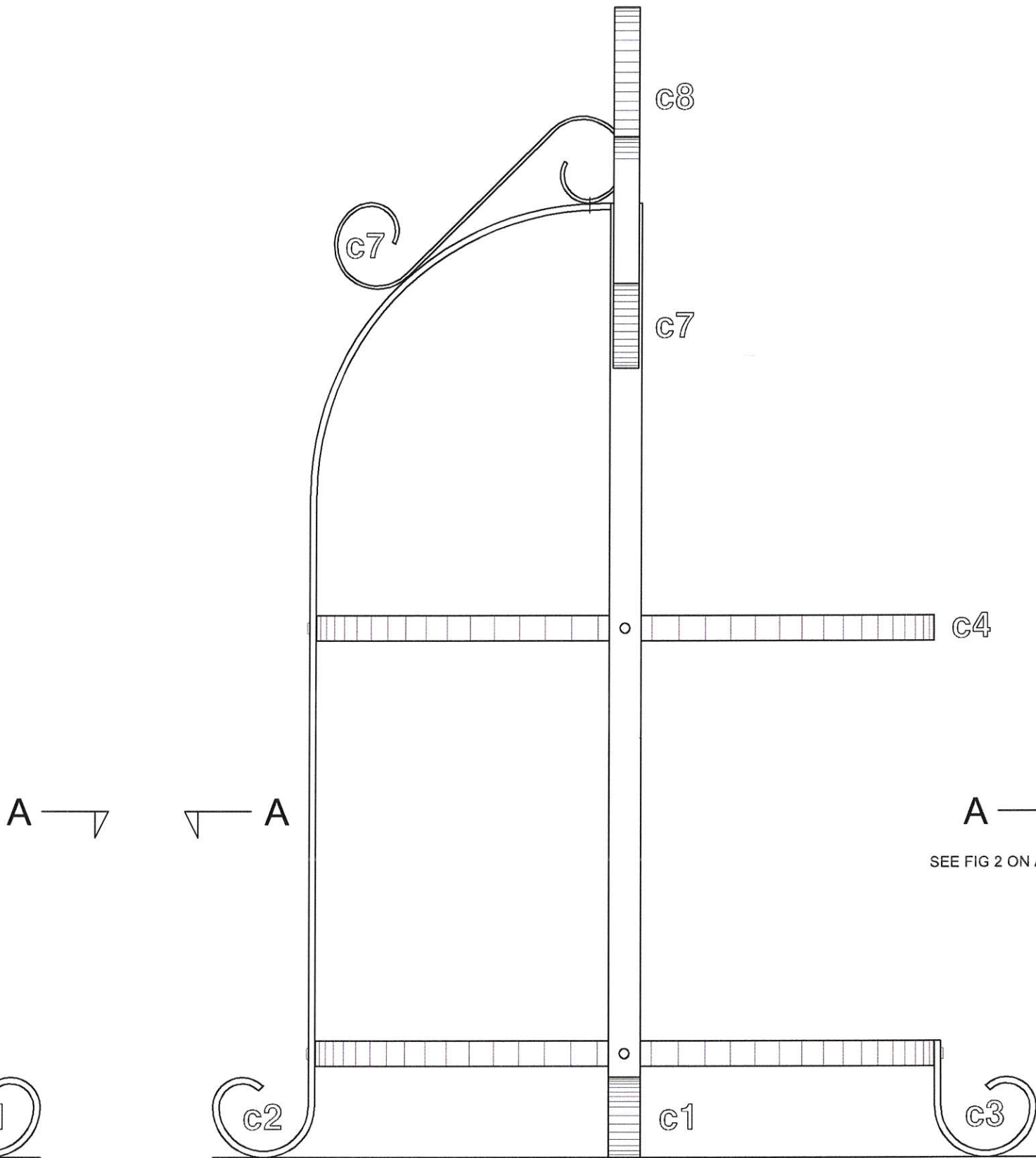
Component 8
400 x 12 x 2mm



NOT TO SCALE



FRONT VIEW

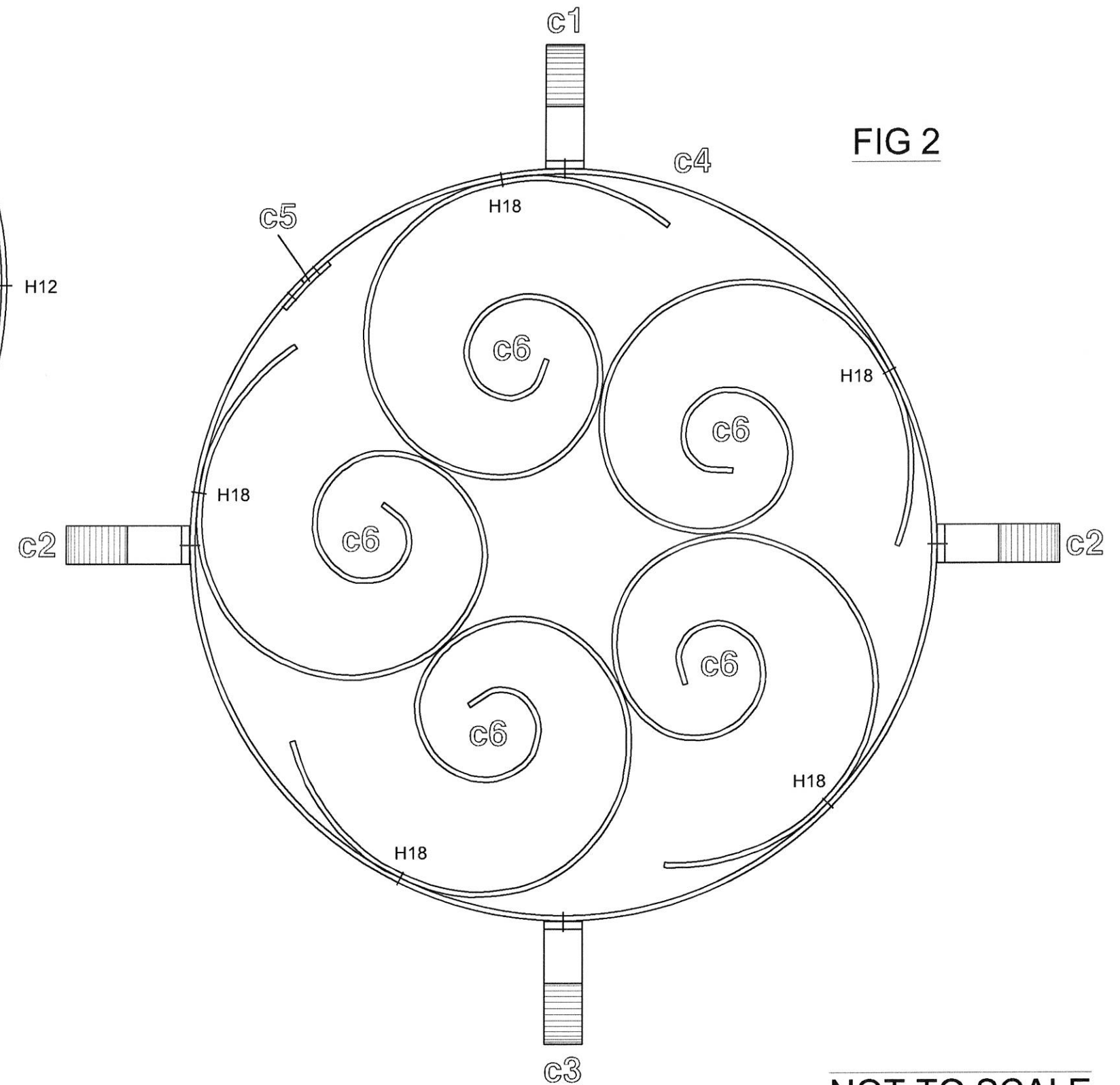
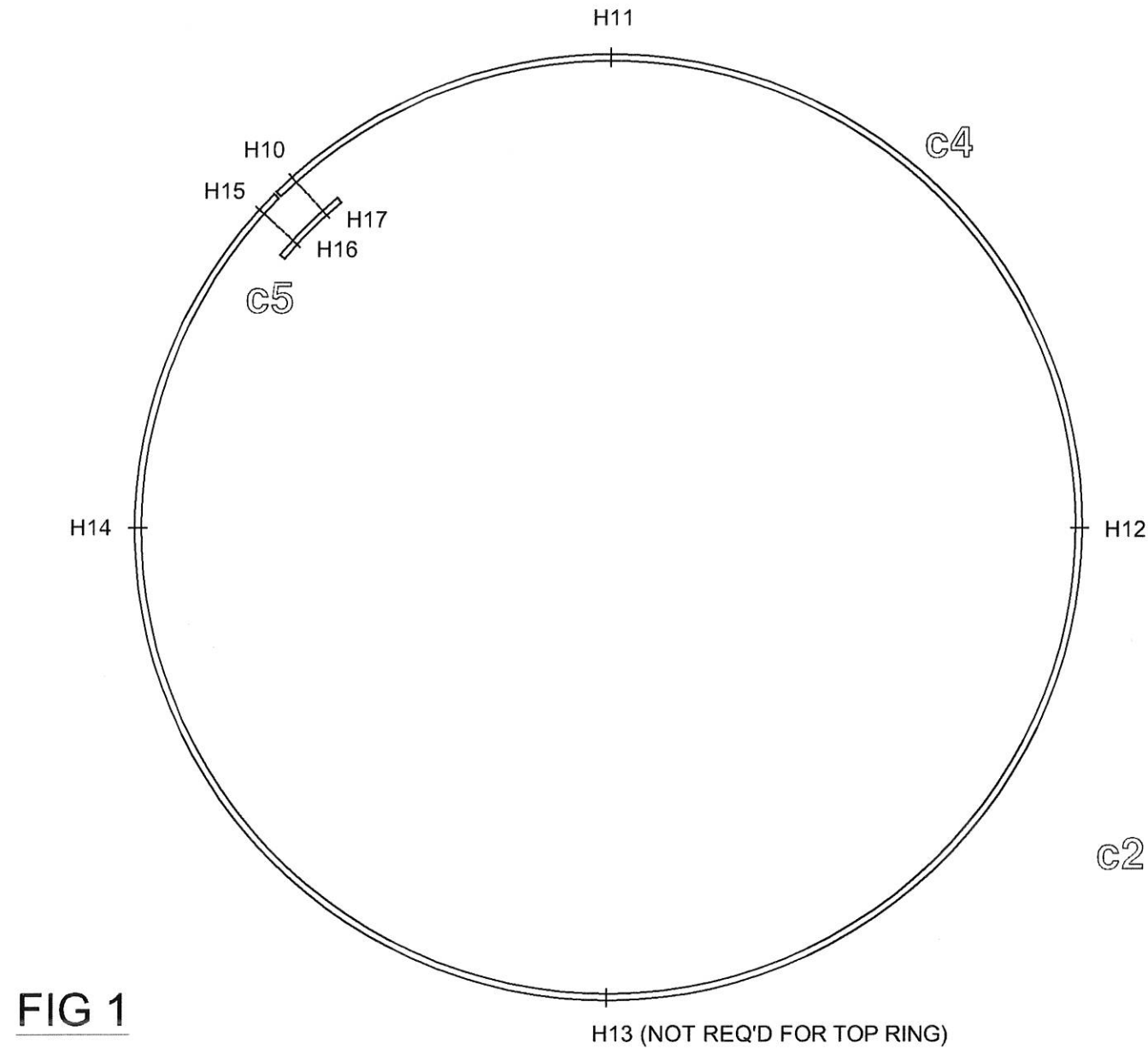


SIDE VIEW

SEE FIG 2 ON ASSEMBLY SHEET 2

NOT TO SCALE

KEY:
© denotes Component



NOT TO SCALE

List of Materials Required:

- 3 x 914mm (3ft) Lengths of 15mm x 3mm Steel Strip (Re-Order Ref: MC037)
- 9 x 914mm (3ft) Lengths of 12mm x 2mm Steel Strip (Re-Order Ref: MC034)
- 23 x 8mm x 3mm Nuts & Bolts (Re-Order Ref: MC059L)
- 23 x 8mm x 3mm Rivets (Re-Order Ref: MC051L)

