HOW TO USE JUNEERO

Patent Multi-Purpose Tool and Equipment

By following the instructions and advice given you will not only obtain successful results but will prolong the life of your equipment and prevent damage and waste of material.

The Juneero Patent Multi-Purpose Tool and other Juneero Tools and Materials provide a means of constructing and finishing a variety of articles, from complete working models to a host of practical and useful things for the home, garden, garage and workshop.

By following the specially prepared Juneero Design Sheets and instructions, everybody can make a success of Juneero from the start.

The Juneero Tool is a thoroughly practical device founded on the design of the big shearing machines, punches and presses employed in shipyards and general engineering works.

SIX PRACTICAL TOOLS IN ONE

With the aid of the Juneero Tool the special Juneero steel strips and rods which are sold by any authorised Juneero dealer, can be cut to any desired length and bent to any required form. Holes for the bolts necessary to fasten the strips together can be punched into them and threads cut on the rods.

HOW TO PUNCH HOLES AND SLOTS

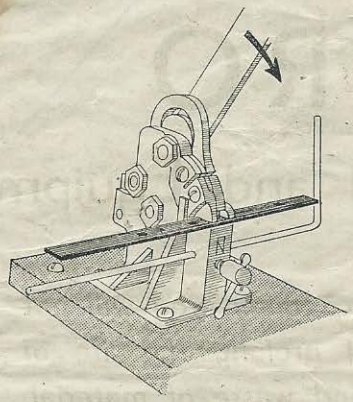

Fig. 1

The Juneero Tool will punch perfectly round, clean-cut holes to take the Juneero Bolts and Nuts. To punch remove vice and insert strip as shown in Fig. 1. Operate by pulling the handle down gently in the manner indicated.

Particularly in model engineering work, slots are occasionally required. These can be cut by punching one hole and then moving the work along in steps of 1/16th in., punching successive overlapping half-holes. With a little practice perfectly formed slots can be cut.

Oil the punch occasionally to preserve its cutting edge.

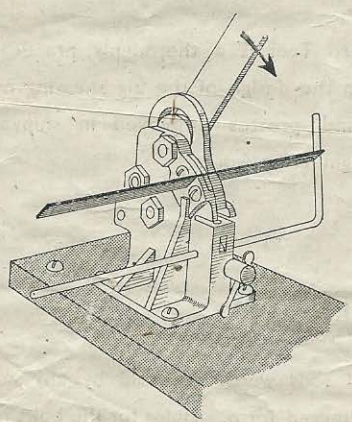

Fig. 2

HOW TO CUT STRIP

Fig. 2 shows how to use the Tool to cut Juneero flat strip. Place the strip as far as it will go into the jaws of the Tool and, on pressing the handle down, the shears will cut the strip. To ensure cutting the ends off dead square you will find it best to stand behind the tool and sight the strip along the gauge bar.

For some decorative work it is desirable to cut the ends of strip into a spear point. This can be done by holding the strip in the jaws at the required angle and cutting as usual.

HOW TO CUT ANGLE

Always cut on outside of Angle Iron with both edges pointing down.

Never cut right up to Angle as this strains the Tool.

Insert one side and cut where required, then reverse the Iron to correct position and cut other side. If necessary to snap the Iron any rough edges can be smoothed with a file.

HOW TO CUT ROD

Fig. 3 shows the Juneero Tool used for cutting rod. The bush in which the rod is inserted for shearing is to be found on left side of the tool.

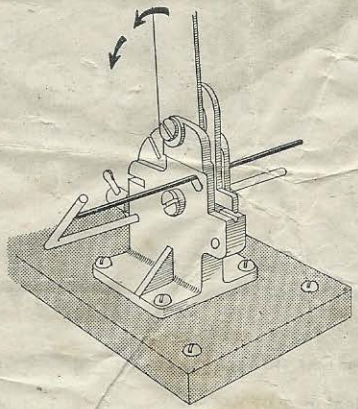

Fig. 3

HOW TO BEND ROD

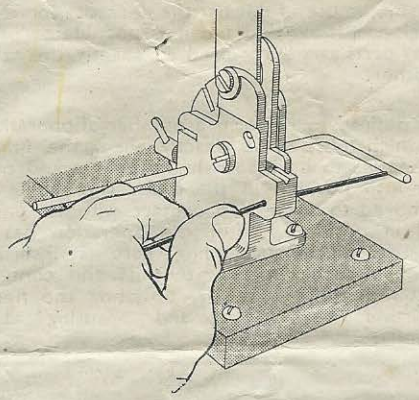

Fig. 4

At the front of the Juneero Tool is seen the bending die for bending Juneero strip only, and below it is a small hole which is used to effect sharp bends in Juneero rod. Rod must not be used in strip bending die.

The rod to be bent is pushed through the hole until the edge of the hole comes opposite the part of the rod that it is intended to bend. This can be marked on the rod or located by the gauge bar. The rod is bent by pulling it in the requisite direction with the fingers (Fig. 4).

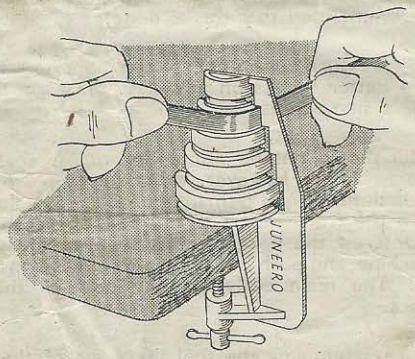

Fig. 6

HOW TO BEND STRIP

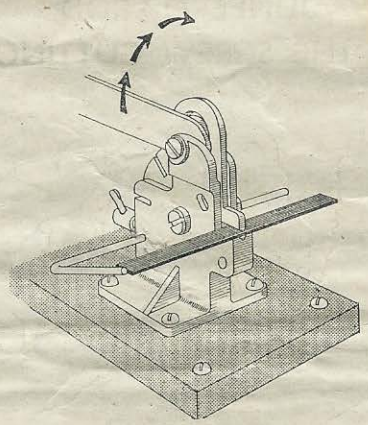

Fig. 5

Fig. 5 indicates how the Juneero Tool is used to bend Juneero strip. Here again the position of the bend may be marked on the strip or located by aid of the gauge bar.

To bend the strip press the handle right down towards the back of the tool. This opens the jaws to their full extent. Insert strip and then pull the handle up to bend the metal. The handle should not be jerked up sharply but pulled with an even, steady motion. Make sure to insert the metal as far as it will go into the jaws of the tool. Sight the strip along the gauge bar to ensure that it is parallel with the bar, and that it is truly at right angles with the strip.

When imitating wrought ironwork the decorative effects of the old smiths can be obtained by cutting the ends of the strips in the form of spear points and up-setting a rib along the point by aid of the bending die.

HOW TO USE THE CURVE AND SCROLL TOOL

The Juneero Patent Curve and Scroll Tool enables accurate curves and scrolls to be bent from rod or flat strip.

The tool, as illustrated in Fig. 6, provides for five diameters. This is invaluable when making certain objects, such as clips for the repair of water hose, which must be made to a definite size.

The use of the tool is simplicity itself. Just feed the end of the strip or rod into the guide plate as shown and hold it with the fingers of one hand. With the other hand, force it round the circular face of the tool. If it is required to form more than a semi-circle, first form a half-circle, and then feed as much of the formed portion as is necessary through the guide plate. Continue forming the rest of the curve with the fingers as before.

After a little practice you will be able to form circles, arcs, scrolls, etc., in an expert manner.

HOW TO CUT THREADS ON JUNEERO ROD WITH THE SCREW CUTTING DIE

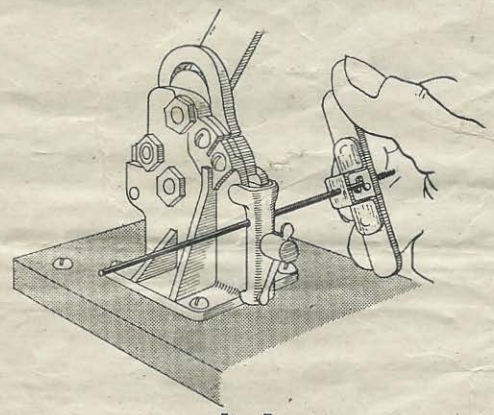

Fig. 7

A screw cutting die is included in each Juneero Set to enable you to cut threads on the Juneero rod.

Place clamp plate in positions as Fig. 7. This acts as a vice to hold the rod to be threaded, next insert the rod that is to be screwed, and tighten up nut so that rod is held in a tight grip. Next place the die on the end of the rod. It is important to hold the die perfectly square. Rotate the die slowly in a CLOCK-WISE direction. It will gradually feed itself on to the rod.

Before commencing to cut the thread drip a little lubricating oil on the end of the rod that is to have the screw cut on it. This will lubricate the die, causing it to cut more freely and to last longer.

After rotating the die for three or four complete turns in a clockwise direction, twist it in the opposite direction for quarter to half a turn to break up the chips of metal that are being cut off the rod.

After using, clean the screwing die by blowing the chips out of the holes, or poking them out with a matchstick.

THE DIE WILL ONLY CUT A THREAD ON ROD AS SUPPLIED BY JUNEERO DEALERS. ITS USE ON HARDER MATERIAL WILL DAMAGE IT.

HOW TO USE THE GAUGE BAR

The Juneero Tool is provided with a gauge bar. This bar can be moved endways to any gauge. It can also be rotated in its holder to bring its end opposite the punch or either of the shearing or bending positions.

After the gauge bar has been moved into position it is locked by tightening the wing-nut that projects in the back. By the use of this bar the necessity for marking out each part is avoided and it is possible to produce as many parts as are required all exactly the same as each other.

If it is desired to perform a number of operations on parts which must all be exactly alike, the first part of the series to be made should be marked off and placed into position in the tool. The gauge bar is then moved to come into contact with its end and locked in position. After the operation has been completed, each succeeding part is inserted in the tool, in such a manner that its end comes into contact with the gauge bar, obviating the necessity for further marking off and ensuring absolute uniformity.

CARE OF THE JUNEERO TOOL

On no account should metal strip or rod other than that supplied by a Juneero dealer be cut, bent or punched on the Juneero Tool. If metal that is thicker, of a harder temper, or otherwise unsuitable is used, the tool may be irreparably damaged.

Four holes are drilled at the corners of the base on which the tool is mounted. These enable it to be screwed or bolted firmly on to the work-bench, and it is recommended that this is done.

A steady pressure on the end of the operating handle will give better results on any class of work than a blow or a sharp jerk.

The Tool should not be dismantled unless absolutely necessary. It can, however, be taken to pieces very simply if desired. To dismantle proceed as follows:— Unscrew the front wing-nut and pull out the gauge bar. Unscrew the hexagon nuts seen on the side of the machine and push out the pin to release operating handle. The main body of the Tool can then be lifted out.

Before re-assembling the tool the sides of the main part should be smeared with oil, as should the cutting and forming faces. The pins on which the main part and the handle oscillate also need lubrication before replacement, as does the face of the eccentric on the end of the operating handle.

Before commencing each job, clear any chips out of the Tool and put a few drops of oil on the cutting edges and bending die. Oil the eccentric on the end of the operating handle. Use a good quality cycle oil, which may be purchased in tins, complete with nozzle.

Wipe the Tool over with an oily rag to prevent rusting before storing, and store in a dry place.