

ANVIL HOLD DOWN TOOL

MATERIAL: 18" LENGTH 1/2" ROUND HOT ROLLED STEEL

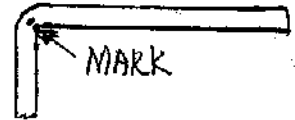
UPSET - HEAT ONE END TO JUST BELOW A WHITE WELDING HEAT
FORGE A DEEP UPSET BY USING A MEDIUM TO HEAVY HAMMER
AND QUICK BLOWS



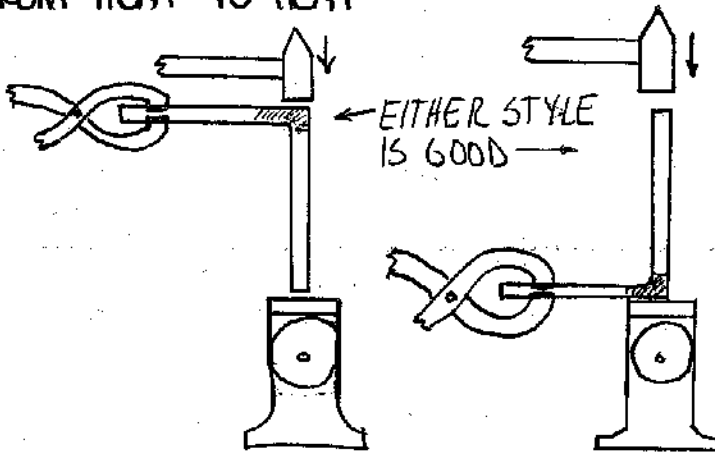
THIS WILL PROVIDE MATERIAL FOR TIP. REPEAT 2-3 HEATS

LAYOUT - PUNCH MARK 9 INCH FROM OPPOSITE END

BEND - HEAT TO A HIGH FORGING HEAT AND BEND TIGHT 90 DEGREE
BEND TO LEAVE PUNCH MARK ON SIDE



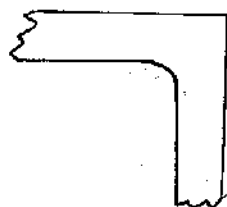
SQUARE CORNER - HEAT TO HIGH FORGING TEMPERATURE.
QUENCH METAL TO LOCALIZE HEAT, FORGE CORNER BY
UPSETTING ONE SIDE AND THEN THE OTHER ALTERNATING
FROM HEAT TO HEAT



WORK TO KEEP
PUNCH MARK IN CENTER
OF CORNER.
NOTICE HOW PUNCH
MARK MOVES SIDE TO
SIDE.

KEEP WIDTH CONSTANT

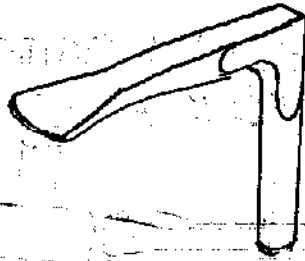
REPEAT TO ACHIEVE SQUARE CORNER,
AS ALWAYS KEEP MATERIAL STRAIGHT AND TRUE.



← IDEAL SQUARE CORNER
IS SQUARE ON OUTSIDE
WITH RADIUS ON INSIDE

CHECK FIT OF SMALL END IN PRITCHEL HOLE OF YOUR
ANVIL. FORGE TO FIT.

SPREAD TIP - HEAT UPSET END AND FORGE TO A SHORT WIDE TIP. MAKE SQUARE TO BEND OF CORNER.



BEND - HEAT AND BEND TO PLEASING SHAPE. CHECK FIT; TIP OF CLAMP SHOULD TOUCH EVENLY.

