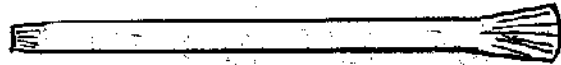




HOT CUT CHISEL FROM CAR SPRING



MATERIAL: 12" LENGTH OF COIL SPRING APPROX 5/8 DIA.

SELECT - SELECT A HEAVY COIL SPRING FROM TRUCK OR CAR
HEAT AND CUT 12" LENGTH WITH CHISEL OR TORCH.

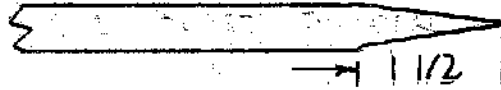
STRAIGHTEN - HEAT TO LOW YELLOW AND STRAIGHTEN.
FORGE BETWEEN YELLOW AND RED HEAT

FILE - HEAT AND HOT FILE TO REMOVE RAG EDGE

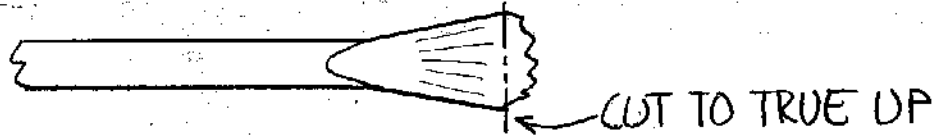
TAPER - HEAT AND FORGE A SHORT TAPER ON THE STRIKING END



FORGE - HEAT TO LOW YELLOW. FORGE TAPER ON FACE
OF ANVIL. FORGE EVENLY FROM BOTH SIDES

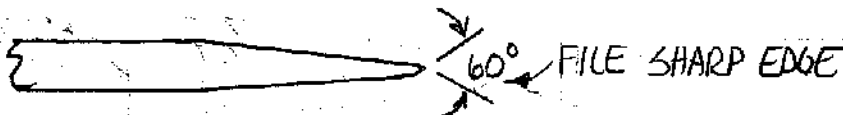


TRIM - HEAT AND HOT CUT TO STRAIGHTEN CUTTING EDGE



FORGE - HEAT TO LOW YELLOW. FORGE BOTH SIDES EVENLY
TO ACHIEVE NICE SHAPE

FILE - HEAT AND HOT FILE TO SHARPEN EDGE



HEAT TREAT AND TEMPER TOOLS

NORMALIZE - HEAT TO ORANGE HEAT AND THEN ALLOW TO SLOWLY AIR COOL. AVOID DRAFTS AND COLD SURFACES. ALLOW TO COOL BELOW 200°F. (ABOUT 15 MINUTES)

HARDEN - HEAT CUTTING END TO LOW ORANGE. ALLOW EDGE AND 3 INCHES TO SOAK IN HEAT.

QUICKLY WIRE BRUSH TO REMOVE SCALE.

WHILE STILL AT ORANGE HEAT, QUENCH 1-1½ INCH OF CUTTING EDGE INTO WARM WATER. SLIGHTLY DIP UP/DOWN UNTIL TIP IS COLD.

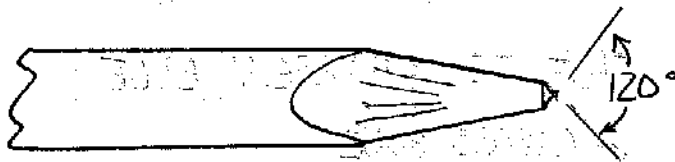
QUICKLY FILE OR SAND TO EXPOSE BRIGHT METAL

TEMPER - ALLOW REMAINING HEAT TO TRAVEL TO CUTTING EDGE. WATCH COLOR OF OXIDE CHANGE FROM LIGHT STRAW (428°F) TO GOLD (500°F) AND QUENCH WHEN PURPLE (536°F) APPEARS. COOL FULLY.

SHARPEN - SAND OR GRIND TO CLEAN UP CUTTING EDGE.

ALTERNATE TIPS

SQUARE POINT PUNCH



END VIEW

EYE PUNCH

