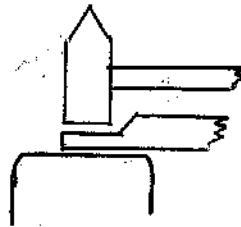
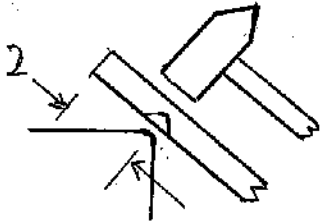


SIMPLE TONGS

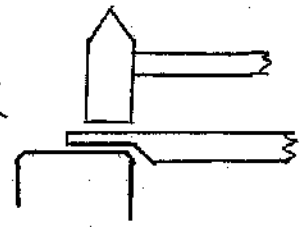
MATERIAL: 18 INCH $3/8 \times 3/4$ HR

1 $7/8$ INCH $3/8$ ROUND HR

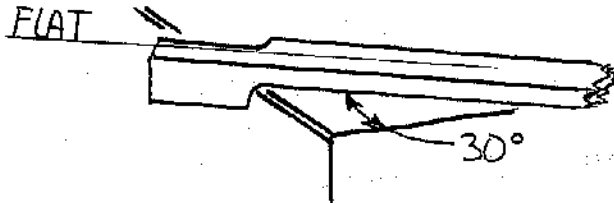
FULLER - LAYOUT 2 INCH MARK FROM NEAR EDGE OF ANVIL
SELECT EDGE OF ANVIL WITH GENEROUS RADIUS
HEAT TO HIGH FORGING HEAT, FULLER TO $1/2$ THICKNESS



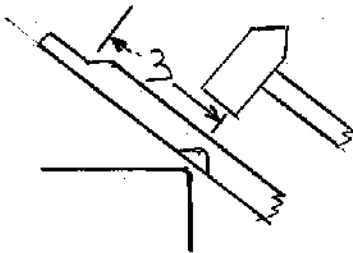
SPREAD JAWS
TO $3/8$ " THICK



OFFSET - HEAT AND OFFSET ON FAR SIDE OF ANVIL
FORGE TO FLATTEN TOP SURFACE TO MATCH 1ST OFFSET.
ROTATE 30° CLOCKWISE TO CREATE CLEARANCE FOR JAWS.

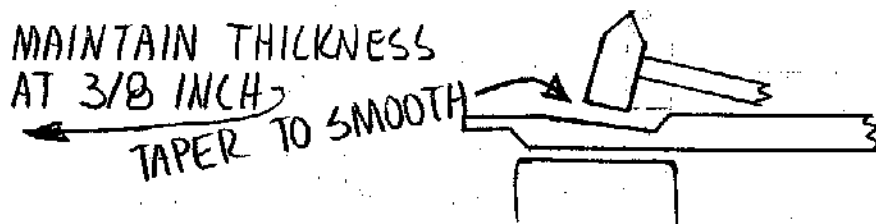


FULLER - LAYOUT 3 INCH MARK. HEAT TO HIGH FORGING HEAT
FULLER ON ROUNDED EDGE OF ANVIL TO $1/2$ THICKNESS

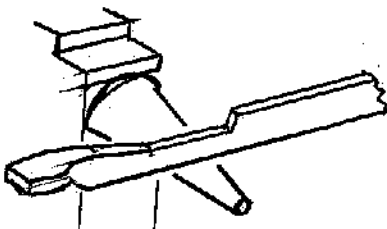


MAINTAIN THICKNESS
AT $3/8$ INCH

TAPER TO SMOOTH

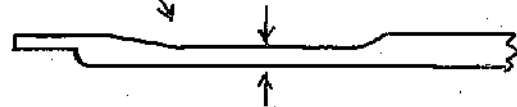


DRAW - HEAT AND DRAW ON HORN TO $3/8$ SQUARE FOR REIN



SMOOTH

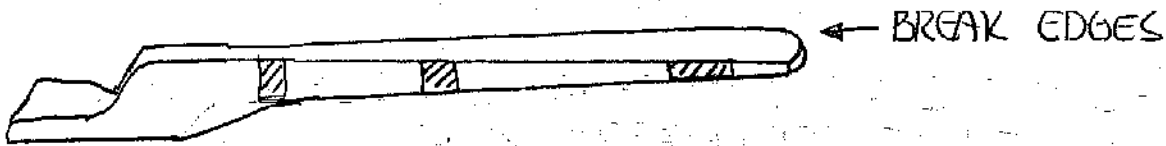
$3/8$ SQUARE



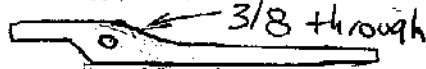
REPEAT - FORGE TONG JAW ON OPPOSITE END OF STOCK
SHAPE IS IDENTICAL NOT OPPOSITE HAND
TOTAL LENGTH SHOULD BE 26-28 INCHES

CUT - HEAT AND FIND CENTER BY BALANCING ON
CUTTING EDGE

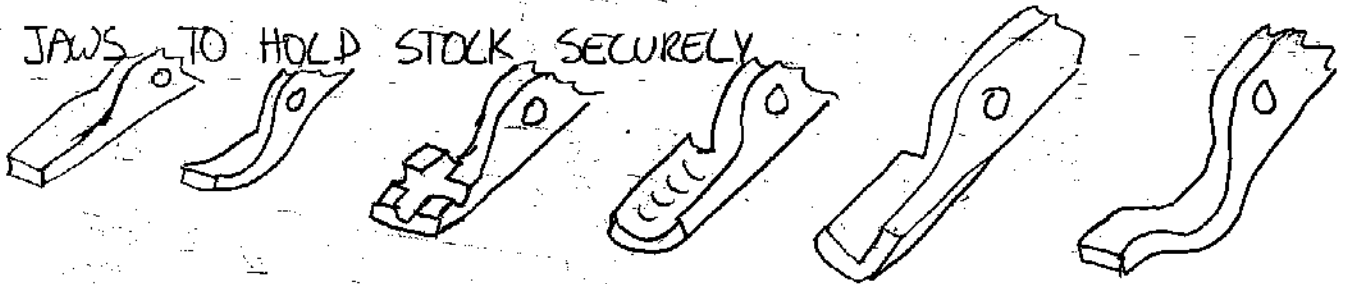
FORGE - HEAT AND FORGE TONG REINS MAKE MATCHED PAIR



PUNCH - HEAT TO HIGH FORGING HEAT & HOT PUNCH THROUGH CENTER OF PIVOT. PUNCH RAPIDLY UNTIL PUNCH STOPS. QUICKLY FLIP PART, COOL PUNCH AND PUNCH THROUGH DARK SPOT. KEEP PUNCH COOL TO RETAIN TEMPER.



FORGE JAWS TO HOLD STOCK SECURELY

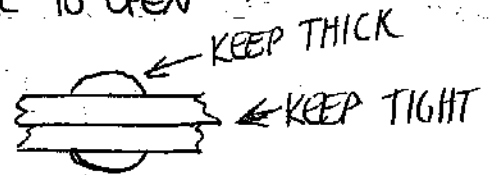


MAKE RIVET - CUT RIVET FROM 3/8 ROUND STOCK. RIVET LENGTH IS GRIP PLUS 1/2 TIMES DIAMETER FOR EACH HEAD.

HEAD 1/2 TIMES 3/8 IS 9/16 TIMES 2 HEADS IS 18/16
GRIP 2 TIMES 3/8 IS 6/8 OR

12/16
30/16
EQUAL 1 7/8"

RIVET TONGS - INSTALL RIVET AND CHECK FIT, HEAT - KEEP TONGS TOGETHER AND PEIN RIVET WITH ROUNDING HAMMER. WORK TO OPEN AND CLOSE TO KEEP FREE



ADJUST JAWS - HEAT AND TRUE UP JAWS BY FORGING TO TIGHTLY HOLD STOCK. REMEMBER THAT TONGS CAN EASILY BE ADJUSTED TO HOLD STOCK SAFELY

