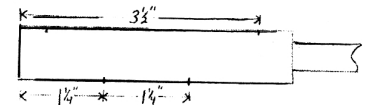


Bow Twist Tongs

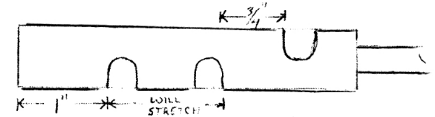
By Phil Travis

TONG BLANK: Start with a $\frac{3}{4}$ " X $\frac{3}{4}$ " X 4" long hot rolled steel welded to a $\frac{3}{8}$ " X 10" round bar.

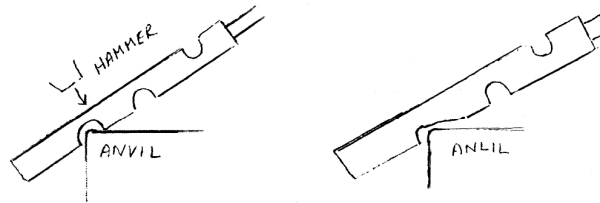
LAYOUT: Make a mark with a center punch approximately $1\frac{1}{4}$ " from the end and another at $2\frac{1}{2}$ ". On the opposite side make a center punch mark approx. $3\frac{1}{2}$ " from the end.



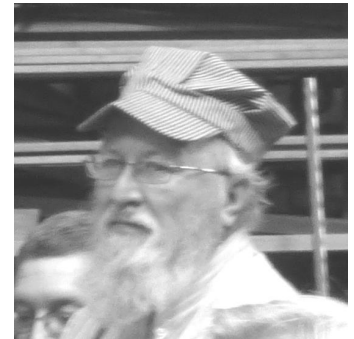
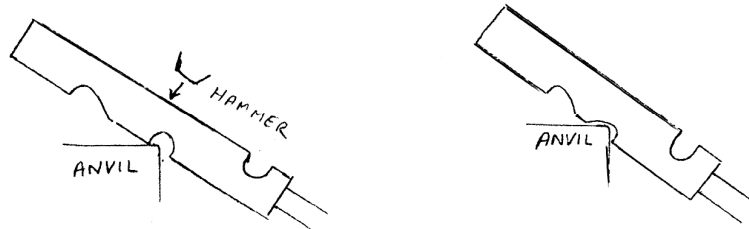
FULLER: Use a $\frac{3}{8}$ " round fuller and fuller in at the three punch marks to half the depth { $\frac{3}{8}$ " } of the $\frac{3}{4}$ " width of the blank.



OPEN OUT FULLER: Over the edge of the anvil, start widening the fuller toward the rein end.

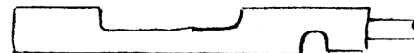
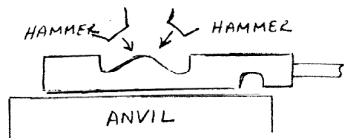


OPEN OUT NEXT FULLER:

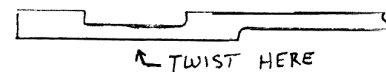


PAABA Member, Phil Travis contributed 3 articles for this issue, he is also a Gypsy Wagon Artist extraordinaire!

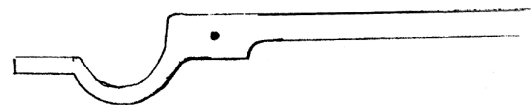
DRAW OUT: Continue to draw out and blend into what will become the bow. Forge to approx. $\frac{3}{8}$ " round. Draw out the part at the rein end and blend into round keeping it offset from the bow.



TWIST JAW: Clamp body of tong in vise and twist jaw 90° to right

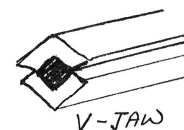
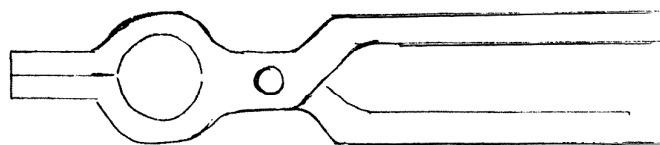


STRAIGHTEN: Straighten and align all segments of tongs Then forge bow around horn or in swage block with a top fuller tool.



RIVETING: Center punch for rivet, then punch or drill rivet hole, set rivet

ADJUST: Clamp jaws in vise, offset handles and align for good grip. Make sure handles and jaws are in line.



MODIFY JAWS:

Leave as flat jaws or insert square stock and forge around to create V-jaws