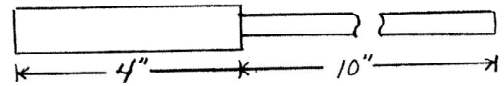


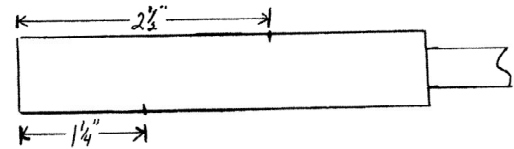
Twist Tongs

By Phil Travis

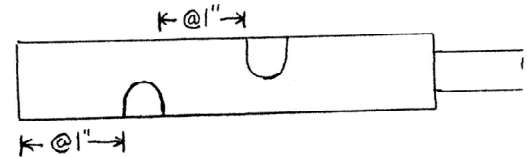
TONG BLANK: Start with a 3/4" X 3/4" X 4" long hot rolled steel welded to a 3/8" X 10" round bar.



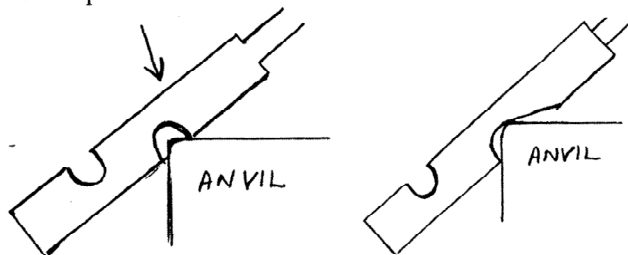
LAYOUT: Make a mark with a center punch approximately 1 1/4" from the end. On the opposite side make a center punch mark approx. 2 1/2" from the end.



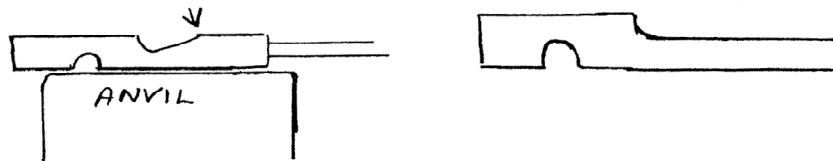
FULLER: Use a 3/8" round fuller and fuller in at the two punch marks to half the depth { 3/8" } of the 3/4" width of the blank



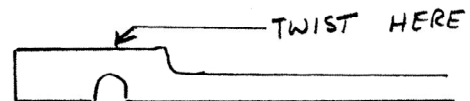
OPEN OUT FULLER Over the edge of the anvil, start widening the fuller toward the rein end. Once wide enough you can flip over.



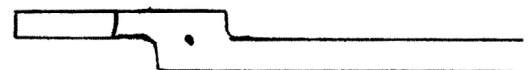
DRAW OUT: Continue to draw out and blend into reins forming the reins off center as drawn



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



STRAIGHTEN: Straighten and align all segments of tongs



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

