

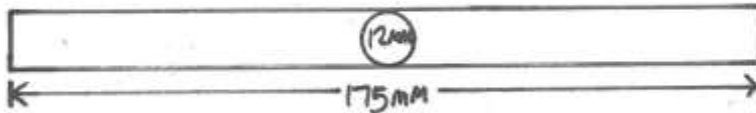


STEP – BY – STEP GUIDE

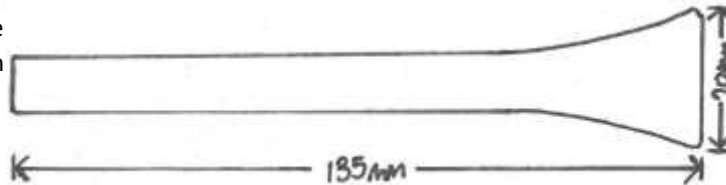
NOT DRAWN TO SCALE

Units: Millimetre's

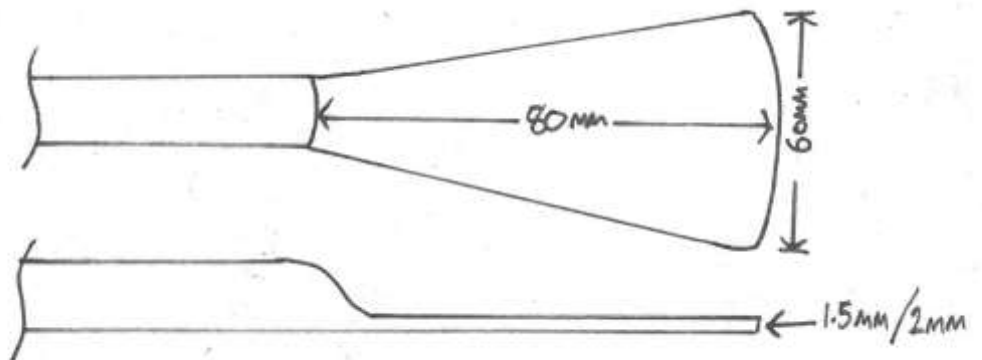
1. Starting stock;
175mm x 12 round
section.



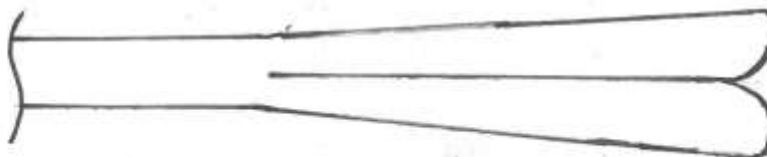
2. Take an isolated heat, upset the
section. Repeat until upset section
is 20mm x 12mm. Total length of
bar approximately should be
135mm long.



3. Spread the material, until
thickness of profile is
1.5mm/2mm thick. Fish tailed
profile will be 60mm at its
widest point. Overall length
desired is 80mm.



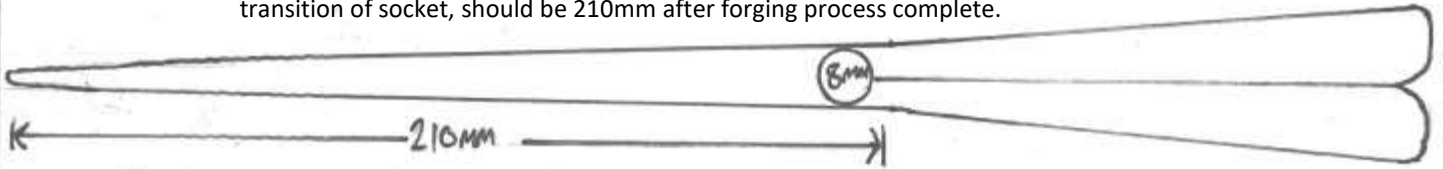
- 4(a). Roll the desired profile up. Use
bottom swage's, anvil stakes provided
to assist in completion of socket.



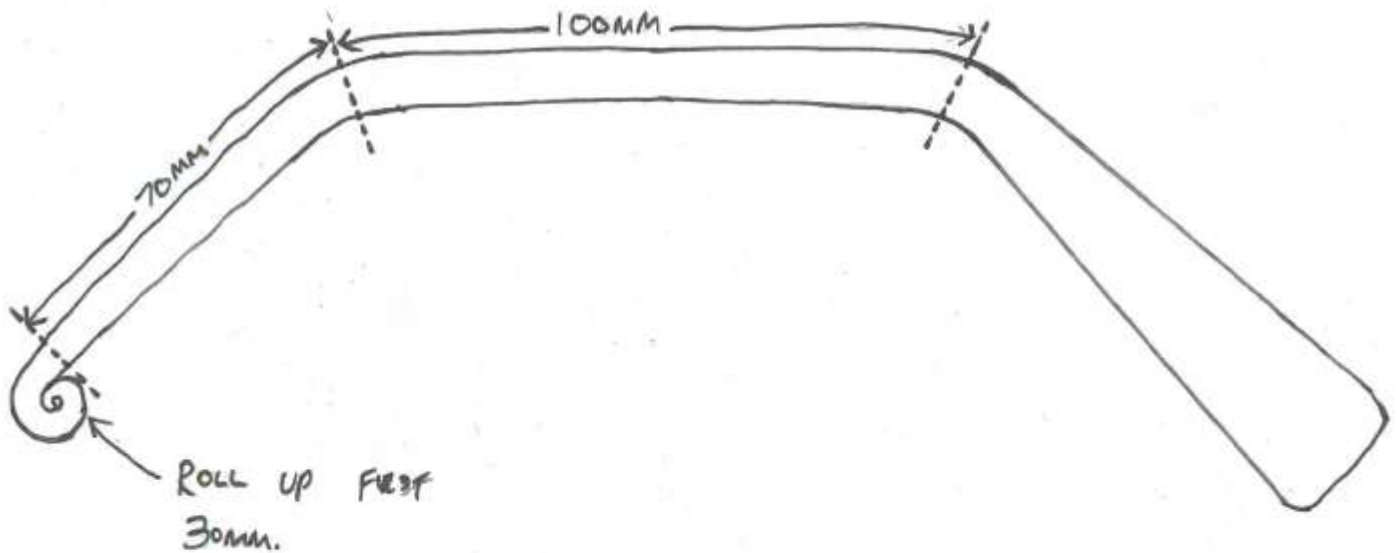
- 4(b). Internal dimension of socket to be
as close to 20mm. Tolerance +/-1mm-
2mm.



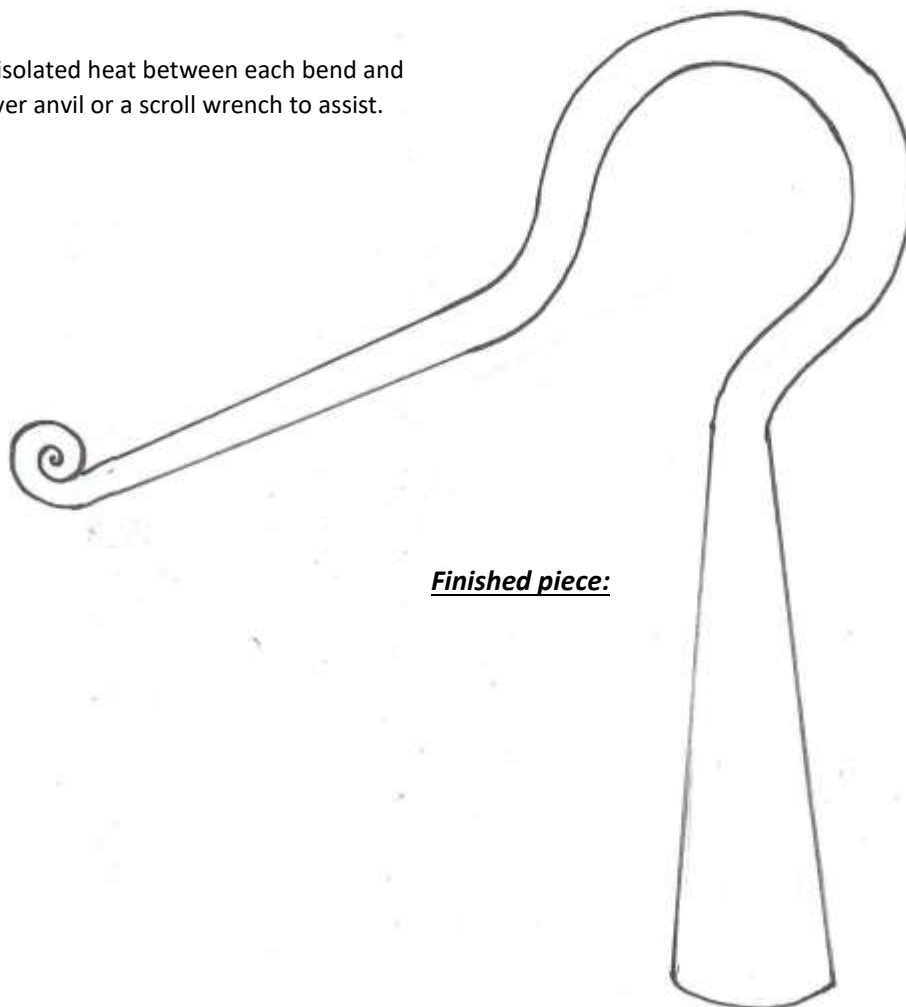
5. Forge the remaining 12mm round section to a slender round tapered point. Overall section from transition of socket, should be 210mm after forging process complete.



6. Roll the first 30mm of the taper up. Put the first initial bend in, this should be 70mm from the back end of the roll to the middle of the bend. Complete the second bend nearest the socket, this should measure 100mm from previous bend to this bend nearest the the socket.



7. Take and isolated heat between each bend and form loop over anvil or a scroll wrench to assist.



Finished piece: