

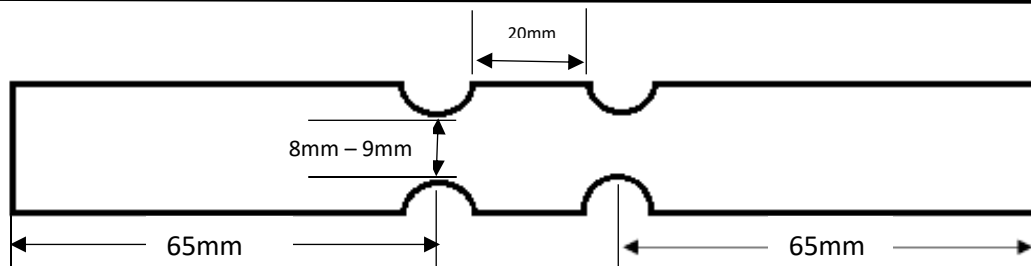
STEP – BY – STEP Guide

NOT DRAWN TO SCALE

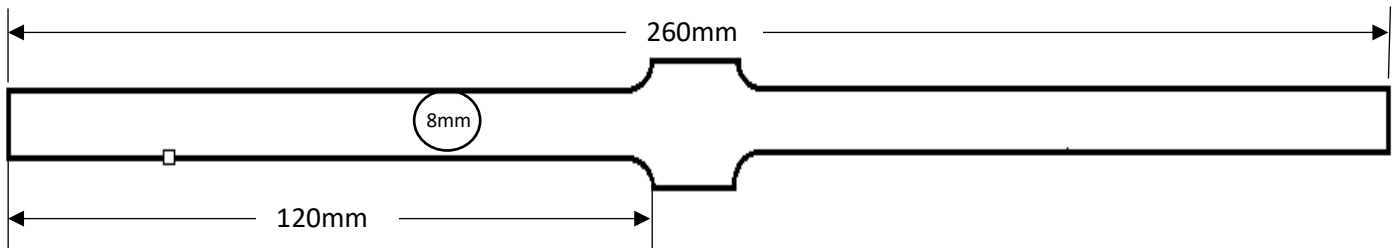
Units: Millimetre's

Starting stock/section – **20mm x 8mm Flat, 150mm Overall length.**

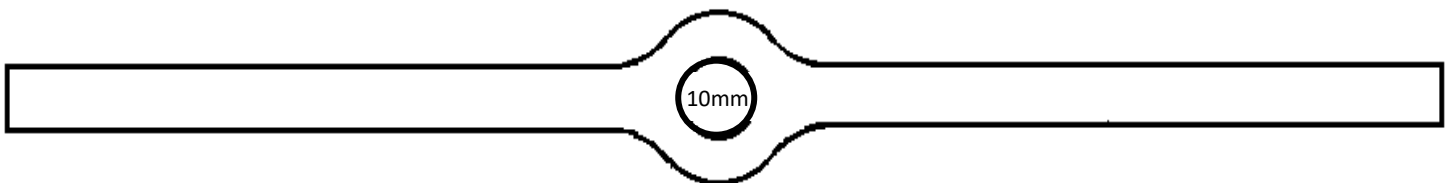
150mm



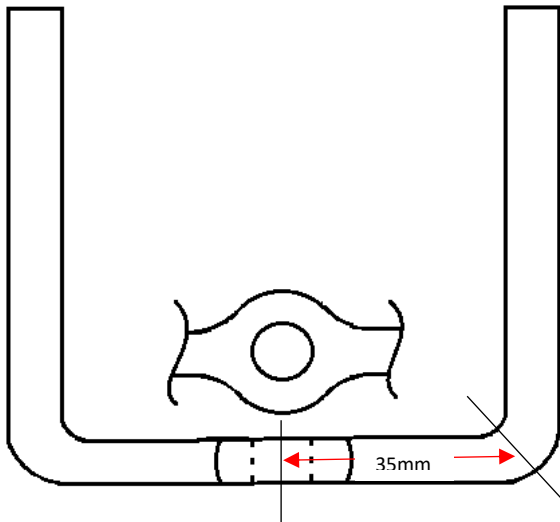
1. Centre dot material at the required marks. Required marks from each end of the bar at **65mm**, leaving a **20mm** section in the middle. Fuller down to the middle of these marks. Desired section, **8mm-9mm** square.



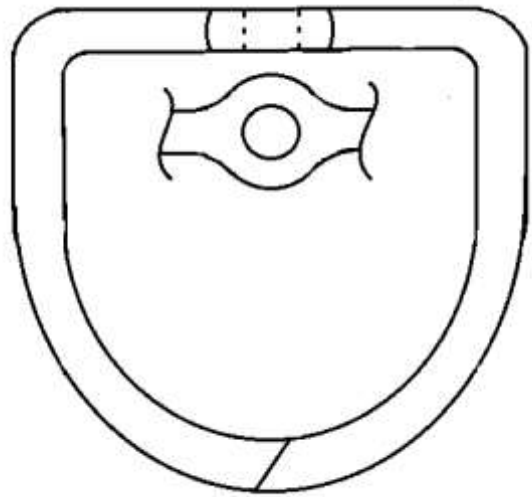
2. Forge out section either side of fullered down area, each individual leg is to be forged out to **8mm** round and a length of **120mm**. Overall Length of the bar desired is **260mm**.



3. Round up section in the middle of the bar. Punch and drift a **10mm** round hole in the centre. +/- 1mm tolerance for the punched hole.



4. Bend the required bends. Centre of the bend desired should be **35mm** from the centre of the punched hole. Prepare ends of bar for fire welding.



5. Bend toes of prepared material around, successfully weld the two ends together. Blend area back into apparent section (8mm round) **ANY** wastage to be taken into consideration when judging.



6. FINISHED ARTICLE; Once fully welded. Form the sides of the shackle, this will replicate the desired shape of the sample.