



Construction Procedure

1. Cut all materials as shown in drawings and as indicated in bill of material.
2. Construct 3/4" hooks in forge. Drill holes in 2" pipe, insert hooks, align and weld.
3. Drill 5/8" hole in 1/2" x 3" x 9" flat and tack weld into position.
4. Bend hook loop on end of 1/2" round rod and shape to top of pipe as shown, tack weld in place. Use oxy-acetylene torch to make bends.
5. Shape 1/2" x 2" x 5" flat and drill 7/8" hole 1 inch from rounded end, flatten end of pipe around this piece and weld into position.
6. Drill 7/16" holes 1/2 inch from ends of 7/8" x 32" round rod.
7. Drill holes in part G as indicated, and make bends as indicated in drawing.
8. Cut 1/2" x 2" x 14" center brace using square setting of 2 and 4 1/2.
9. Align holes, insert 7/8" round rod and tack weld. Check alignment and weld all pieces solid.
10. Construct pin as indicated in drawing.
11. Prime with metal rust inhibiting point and finish with appropriate enamel.

Bill of Material

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| (A) | 1 - 2" x 6' - 6" black pipe |
| (B) | 3 - 3/4" x 10" round mild steel |
| (C) | 1 - 1/2" x 3" x 9" flat mild steel |
| (D) | 1 - 1/2" x 6' - 10" round mild steel |
| (E) | 1 - 1/2" x 2" x 5" flat mild steel |
| (F) | 1 - 7/8" x 32" round mild steel |
| (G) | 2 - 1/2" x 2" x 34" flat mild steel |
| (H) | 1 - 1/2" x 2" x 14" flat mild steel |
| (I) | 1 - 5/8" x 2 1/2" round mild steel |
| (J) | 1 - 1/4" x 9" round mild steel |