

All the Answers, How To's and What To's
for Making your own Fishing Lures

The Canadian Guide to Lure Making

Updated Edition

For all Anglers and Lure Makers

**Real Pro's
SPORTFISHING**

A Real Pro's SportFishing Guidebook
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TABLE OF CONTENTS

INTRODUCTION	5
BEFORE YOU BEGIN	7
TACKLE COMPONENTS	10
WEIGHTED SPINNERS	25
SPINNER TABLES	31
UNWEIGHTED SPINNERS	35
WEIGHT FORWARD SPINNERS	36
LAKE TROLLS	38
SPINNERBAITS	40
BUZZ BAITS	44
MOLDING LEAD	45
SPOONS	48
HARNESSES	49
PLASTIC CRANKBAITS	55
WOODEN CRANKBAITS	56
LEADERS	59
STINGER RIGS	60
TYING DRESSED TREBLES & BUCKTAIL JIGS	61
PAINTING YOUR COMPONENTS	63

INTRODUCTION

Well, here it is! The guide many of you have waited many years for. I am sure you are much like I am. Whenever I sit at my work bench and begin making a few lures my mind begins to drift off into nowhere land. I begin thinking of fishing trips, and I even recollect the many individual fish I've taken in the past and dream of trips and excursions of the future.

This is an updated version of my first guidebook. I've added many new illustrations and many more details. The instructions to making more lures and many more tips which I hope will make your tackle making life more enjoyable.

What you will read here is information gathered from my own experience, as well from many of you who have been making and selling tackle for years. I would like to take this opportunity to thank many of the tackle manufactures and fishing guides who I am in contact with on a regular basis and do not hesitate to share valuable information on the making of fishing tackle.

I hope you find this guidebook easy to follow, practical and most of all I hope it gets you started in what I believe is an incredibly fun hobby or possibly even a business. This manual has been written with the simple goal of introducing anglers to the world of luremaking in a concise and practical manner. As owner of Real Pro's SportFishing I am lucky to speak with thousands of anglers across Canada and the United States each year, many of whom said they wanted a simple guide to making the most practical lures.

Please remember that not every lure you assemble, design from scratch, or copy from a brand name lure will work perfectly without a little tinkering or redesigning. It would be great if they all worked on our first attempt. Don't get discouraged if a few, or even all of them don't work out as planned. Be prepared to take a few apart and rebuild them from scratch. It's part of the fun. But in no time at all you too will be building a wide variety of incredible fish catching lures.

BEFORE YOU BEGIN

Before we jump into the fun stuff lets go over a few basic necessities of lure making. It is extremely important that you have a few basic tools. The following is a guide to deciding which tools you need, before you begin, based on the types of lures you will be building.

SPINNERS, SPINNER BAITS, BUZZ BAITS, AND MUSKY SPINNERS

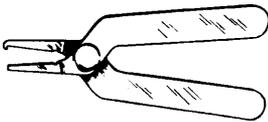
Spinners are by far the most popular lures used in Canada.

Required Tools	Production Volume		
	Low	Medium	High
Needle / Round Nose Pliers	Yes	Yes	Yes
Wire Cutters	Yes	Yes	Yes
Split Ring Pliers*	Optional	Optional	Optional
Wire Forming Tool†	Optional	Optional	No
Commercial Tackle Maker‡	No	Optional	Yes

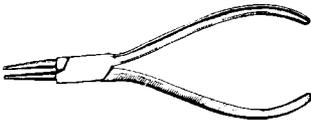
* Split ring pliers are only required if you decide to attach the hook using a split ring.

† The Wire Forming Tool will only form wire under 0.026" used on smaller spinners.

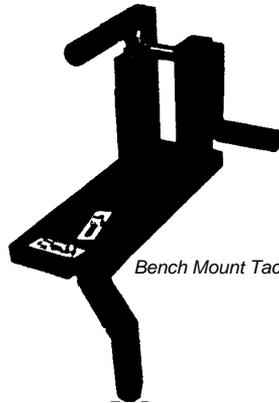
‡ Not required for making Spinner Baits or Buzz Baits.



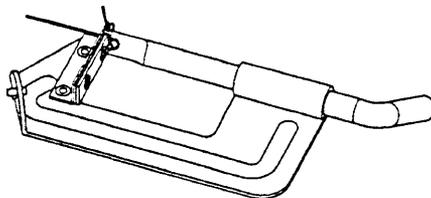
Split Ring Pliers



Round Nose Pliers



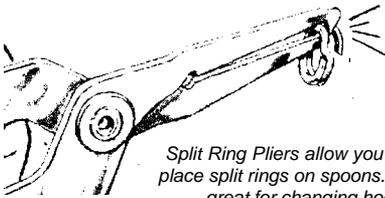
Bench Mount Tackle Maker



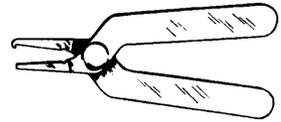
Wire Forming Tool

CASTING AND TROLLING SPOONS

Spoons require only a pair of split ring pliers to quickly assemble. You will also need a sharp knife if you will be applying lure tape.



Split Ring Pliers allow you to easily place split rings on spoons. They are great for changing hooks.

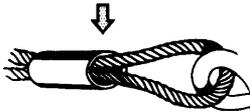


Split Ring Pliers

WORM, MINNOW, LEECH HARNESSES AND CASTING HARNESSES

Required Tools	Production Volume		
	Low	Medium	High
Needle Nose Pliers	Yes	Yes	Yes
Wire/Line Cutters	Yes	Yes	Yes
Crimping Tool	Yes	Yes	Yes

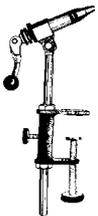
Simple but effective lures. These only require a line cutter if using monofilament or a pair of wire cutters being made of nylon coated wire. A crimping tool is used to crimp connection sleeves if you decide to use connection sleeves and nylon coated wire.



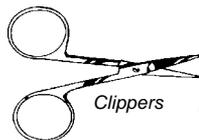
Crimping Tool

TYING BUCKTAILS AND CALFTAILS

Required Tools	Production Volume		
	Low	Medium	High
Hook Vise	Yes	Yes	Yes
Bobbin	Yes	Yes	Yes
Clippers	Yes	Yes	Yes



Hook Vise



Clippers

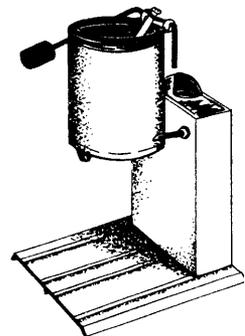
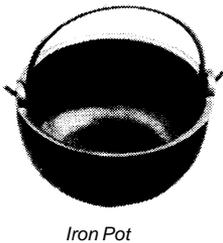
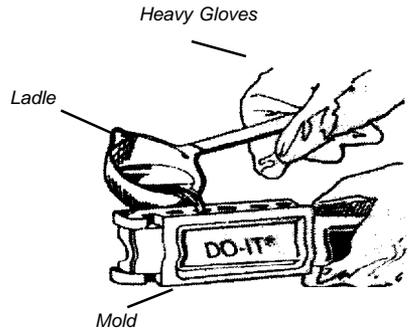
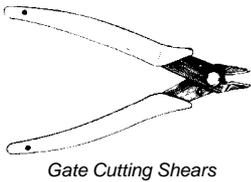


Bobbin

MOLDING LEAD

Required Tools	Production Volume		
	Low	Medium	High
Goggles	Yes	Yes	Yes
Heavy Gloves	Yes	Yes	Yes
Iron Melting Pot	Yes	Yes	Yes
Mold(s)	Yes	Yes	Yes
Ladles	Yes	Yes	Yes
Gate Cutting Shears	Yes	Yes	Yes
Wire Cutters	Yes	Yes	Yes
Heat Source*	Yes	Yes	Yes

* Heat Source may be a commercial lead furnace, propane camp stove, propane barbecue or old kitchen stove.

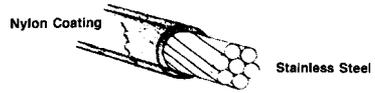


TACKLE COMPONENTS

Tackle Components come in many different sizes, styles, shapes, and weights. Just take a quick look through Real Pro's SportFishing's Tackle Kit and Component catalogue and you might get confused and intimidated by all the different components. Let's take a minute and describe the most popular components and explain their different uses.

STAINLESS STEEL WIRE (SOLID AND STRANDED)

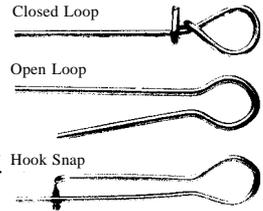
Wire is wire, right? Wrong! There are several types of wire and many different diameters. Each has its own use in lure making. There is single strand stainless steel wire which is used for virtually all spinners built around a wire shaft. Many anglers fishing for pike and musky make their wire leaders out of single strand wire. The advantage is the wire is smaller in diameter than equal strength nylon coated wire.



There are a few different brands of stranded stainless steel wire is six wires braided around a core wire with a thin coating of nylon covering the stranded wire. Stranded wire is used for leaders and walleye harnesses. It can easily be knotted or crimped using the proper sized connection sleeve.

WIRE SHAFTS FOR SPINNERS

Stainless steel shafts can be purchased ready made or you can save money by forming them yourself from bulk wire. There are three types of wire shafts: a) closed loop, b) open loop, c) safety pin or hook snap.



Use a closed loop when you want to attach the hook to a spinner with a split ring. This permits the changing of hooks without having to take the spinner apart. Most large spinners use a closed loop shaft.

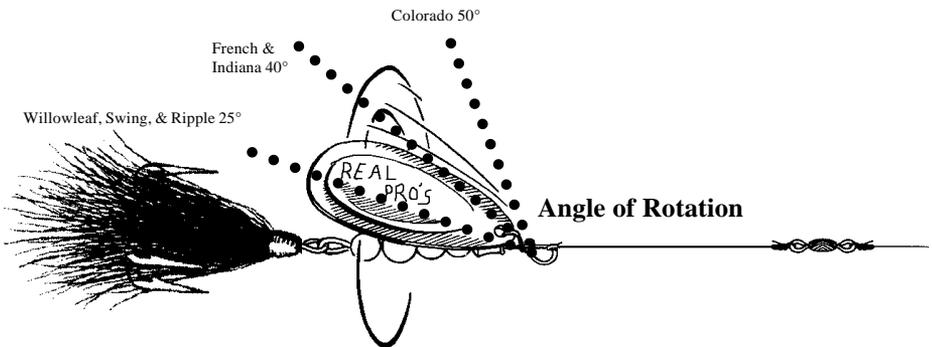
Use an open loop when you build most of your spinners. (See next section on building spinners.) It can be held closed by the spinner body or coil spring if making a bait hook spinner.

Use a hook snap when you build a spinner where you want to easily and quickly change hooks. These spinners are usually unweighted.

Wire Use Chart	
Wire Diameter	Popular Uses for Different Wire Diameters
0.012"	Leaders, stinger rigs
0.020"	Leaders, stinger rigs
0.024"	Spinners with blade sizes 0 to 4
0.028"	Spinners with blade sizes 3 to 6
0.030"	Spinners with blade sizes 3 to 6
0.035"	Spinners with blade sizes 5 to 8, spinner baits
0.040"	Musky spinners, spinner baits, buzz baits
0.050"	Musky spinners, spinner baits, buzz baits

A note about making your own wire shafts. Always use spring tempered pre-straightened stainless steel wire. It is stronger, straighter than non-tempered and pre-straightened wire. A straight wire is important because if the shaft is not straight you will get spinner wobble. If the shaft is not spring tempered your bends may fail when playing a fish.

SPINNER BLADES



Spinner blades have to be the most confusing item in our catalogue. Just think, we sell more than ten different types of blades in multiple finishes and sizes. Each blade has a distinctive angle of rotation, vibration, feel, flash and popular use. A blades angle of rotation is determined by the broadness of the blade. As an example the Colorado blade is one of the most broad of the blades available and has the largest angle of rotation as well as having a great amount of water resistance. On the other hand the willowleaf blade is one of the most narrow blades with a small angle of rotation and thus has little water resistance.

The basic rule is the wider the blade the slower the spin, the narrower the blade faster the spin. Use a wide blade for a slow and shallow retrieve and use a narrow for a fast and deep retrieve.

Blade size is also an important consideration when making a spinner. A blade which is too large or small will effect the spinner's performance and balance. A spinner will not perform well if the blade is either oversized or undersized.

BLADE FINISHES

Polished Brass: Is a brass blade stamped and polished. It will tarnish over time. A tarnished blade is often exactly what you want. I often purposely tarnish blades to make a less flashy spinner. Have you ever wondered why some old tarnished spinners catch so many fish? Usually it is because the fish are a little nervous of too much flash.

Polished & Lacquered: Is a brass or copper blade stamped and polished then lacquered. The lacquer protects the blade from tarnishing.

Copper: These blades are much more expensive than brass or plated blades. Copper blades are great in dark water, copper tarnishes quickly and becomes very dark. Copper is great when you need a dark blade to minimize flash but maximize vibration. If you want the polished copper finish to remain over time your must purchase a lacquered blade or lacquer them yourself.

Plated: Plated blades are available in several different finishes. Popular plated finishes are nickel, black nickel, genuine silver, and genuine gold. Nickel plate is by far the most popular because they produce a bright flash which attracts fish from great distances. Black nickel plate is used when you wish to minimize flash. Genuine silver plate is brighter than nickel and will reflect more light than nickel plate. However, silver plated blades must be lacquered in order to prevent them from tarnishing. Genuine gold plate gives off a deep yellow flash that is brighter than polished brass.

Painted: Painted blades are blades that have been etched, primed, then painted with the desired colour of paint. They are available in a wide range of colours. Real Pro's SportFishing stocks painted Colorado blades in red, blue, orange, chartreuse, green, pink, yellow, white, black, purple and glow-in-the-dark. We have the largest selection of painted Colorado blades in Canada. In addition to painted blades there are striped and five of diamond blades. Striped blades have a different colour stripe painted over the base colour, while five of diamond blades have five diamonds of a different colour painted over top of the base colour.

Laser Fleck: Laser Fleck blades are blades which might have been painted or

plated then lacquered and in the lacquer are tiny flecks of gold or silver material. These flecks help reflect light in all directions at once. You can easily make your own laser fleck blades by first dipping the blade into a clear lacquer then by sprinkling glitter onto the blade.

BLADE SURFACES

The blade surface may be smooth, hammered, fluted or ribbed. These are often a matter of preference to the angler, but there is a difference between the surfaces.

Smooth Blades: Smooth blades are generally the most popular blade. The surface is smooth and thus creates the least amount of water resistance.

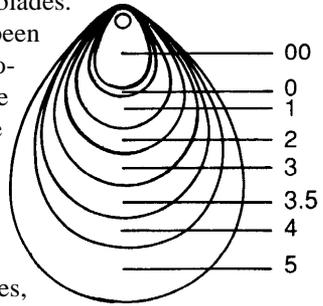
Hammered Blades: Hammered blades have many small dimples stamped into the blade. These dimples effect the blade in two ways. First the dimples create some additional water resistance which creates a small amount of additional vibration. Secondly, they reflect light (flash) differently, reflecting light (flash) in many directions at once.

Fluted and Ribbed Blades: Fluted or ribbed blades effect the way light is reflected (flash) and the way the water slides over the blade. The light is reflected in several directions at once. Many anglers will exclusively use fluted blades for big bass, pike and musky.

BLADE TYPES AND THEIR USES

COLORADO BLADE

The Colorado blade is one of the most popular blades. Designed by John J. Hilderbrant, in 1899, it has been catching fish, for almost 100 years. Due to the Colorado blades being almost round in shape it has a large amount of water resistance and a rotation angle around the spinner shaft at about 50 degrees. Use the Colorado blade for slow retrieve situations and light currents.

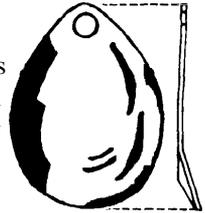


It is a popular blade for walleye spinner harnesses, spinnerbaits, Colorado spinners, weighted spinners and of course the popular unweighted baitholder spinners.

Colorado blades are ideal when you require a spinnerbait that will buzz the surface on a slow retrieve and for free falling (helicoptering) spinnerbaits on short arms.

DEEP CUT COLORADO BLADE

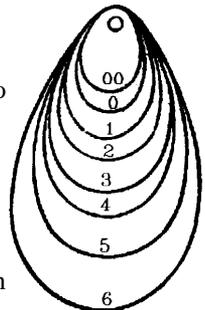
This blade is very similar to the Colorado blade in shape. It is almost round in shape except it has a deep cut on the bottom of the blade. This deep cut enables the blade to spin at very very slow retrieves.



Use the deep cut Colorado Blade for extremely slow rolling spinnerbaits and walleye harnesses when you will drift or backtroll very slowly and require the blade to spin. Don't forget to use them on bass when the water is cool in the late fall.

INDIANA BLADE

The Indiana blade is slightly more narrow than the Colorado blade and has a rotation angle of about 40 degrees. It is used on all lures that the Colorado blade is used on. Use for situations where a slow to medium retrieve is required.



Due to the blade being slightly more narrow than the Colorado blade, it is very popular in current situations. The flash given from this blade is greater than with the Colorado blade.

The Indiana Blade is great for walleye harnesses and spinnerbaits where more flash and less vibration is required.

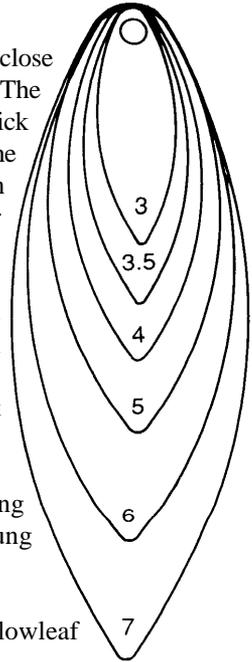
WILLOWLEAF BLADE

The willowleaf blade is a very long narrow blade. It spins very close to the shaft and has an angle of rotation of about 20 degrees. The blade spins very fast and tight to the shaft so it is ideal for quick retrieves and swift currents on weighted spinners. Due to the tight spin, it gives a lot of flash. It's most popular use is on spinnerbaits, lake trolls and extra large bucktail spinners for big pike and musky.

Use the willowleaf when speed and flash are needed. It will allow you to get deeper than any other blade on quick retrieves because there is minimal lift from this blade. The willowleaf blade will maximize flash because of the tight angle of rotation.

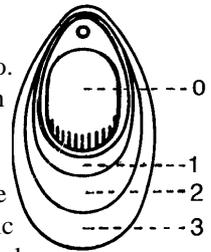
The willowleaf is fantastic on spinnerbaits when fishing weedlines because this long slender blade seldom gets hung up on grass, weeds or brush.

When the game fish are feeding on minnows use a willowleaf blade to imitate the flash of the shiny bait fish.



FRENCH BLADE

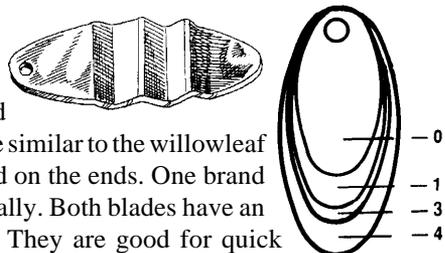
The French blade was developed in France over fifty years ago. Since then it has been most commonly referred to as the French blade. It is used on many of the popular weighted spinners. The French blade is used on more trout spinners than any other blade. This blade's angle of rotation is about 40 degrees. The idea is the recessed domed blade creates a fish-calling sonic effect. This blade is a medium depth running blade and is good for still to slow moving currents.



The French blade is generally used on weighted trout spinners in sizes 0 to 3. It is also very popular with pike and musky anglers in the larger sizes on bucktail spinners. Although not very popular on spinnerbaits it does work extremely well for bass and pike when rigged on spinnerbaits.

SWING AND RIPPLE BLADES

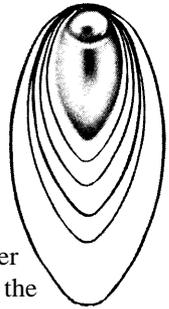
The swing and ripple blades are both transplants from Europe. They are used on many very popular spinners. It is quite similar to the willowleaf blade except that they are more rounded on the ends. One brand alone sells over 7 million spinners annually. Both blades have an angle of rotation of about 20 degrees. They are good for quick



retrieves and swift currents. Little lift is created by these blades so they will run deep with properly weighted bodies. The ripple blade is different in that it will reflect light in all directions because of the unique bends in the blade.

SONIC IN-LINE BLADE & PRO SONIC IN-LINE BLADE

The Sonic In-Line blade, originally from Italy, is a uniquely designed blade. It is the one of the few self clevising blades. The in-line blade does not require a clevis to attach to the spinner shaft. The Sonic in-line blade has a direct to shaft rotation giving this blade the ultimate in spinner vibration. It spins extremely fast around the shaft which produces a lot of flash. The sonic in-line blade is the standard blade found on the popular Italian spinner while the pro sonic in-line blade is a redesigned version of the original.

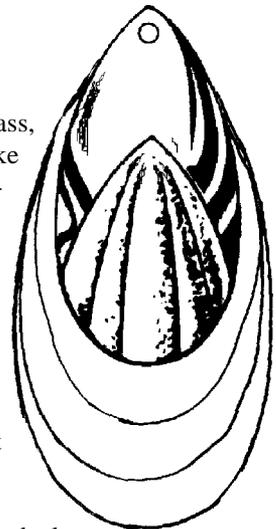


The pro in-line blade has a ridge somewhat similar to the French blade. Is stamped out of a heavier gauge 0.025" and creates a louder more fish attracting vibration. It is not available in as many sizes as the more popular traditional sonic in-line blade.

The in-line blades are popular on weighted spinners for trout in smaller sizes and bass, pike and musky in the larger monster sizes.

FLUTED BLADE

The fluted blade is a much sought after blade in the bass, pike and musky angler community. Many musky and pike spinner manufacturers use this exact blade in the manufacture of their oversized pike and musky bucktail spinners. This is the largest blade we sell and boy do we sell a lot of them. It's design is similar to an Indiana blade that has been somewhat longated with diagonal ripples down the back half of the blade.

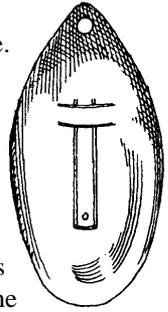


The ripples create extra flash and vibration. The angle of rotation is about 37 degrees and it creates a lot of lift because of its large size.

The ripple effect creates a different sort of turbulence and a lot more resistance in the water. This is definitely the blade for big bass, pike and musky. I don't think there is a single musky hunter out there who does not have a dozen or so big fluted musky spinners ready at all times.

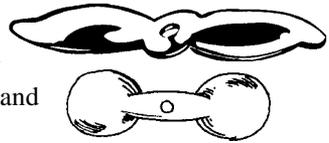
JUNE BUG BLADE

The June bug blade is considered by many as an old timers blade. Originally used as a bait hook spinner (unweighted spinner with a removable hook locked in place with a coil spring or hook snap wire shaft). The angle of rotation is derived from an adjustable arm attachment which come from the centre of the blade to the shaft. The shaft passes through a hole in the from of the bade and then the arm attachment (no clevis is used), the adjustment of the arm determines the angle of rotation. The major advantage of this blade is it can be retrieved at any speed and will always spin at the correct angle.



PROPELLER BLADE

Propeller blades are amazing little blades. They are generally available in two styles, pointed and round and in several sizes.



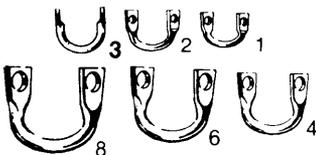
Every angler should have a few ready to put to use. Propeller blades will spin rapidly at the slightest movement. Excellent for use on crawler harnesses, various spinners, and both surface and underwater plugs.

CLEVISES

Clevises are the small pieces of metal which hold the spinner blade in place and permit the blade to spin freely around the spinner shaft or monofilament. Clevises come in two basic styles. Stirrup (easy spin) and folded. Stirrup clevises are the type you use on spinners with solid wire shafts while folded clevises are use on monofilament and nylon coated wire.



Stirrup clevises are formed from spring hardened brass wire for maximum strength. Folded clevises are stamped then formed by folding the clevis in half. Clevises should be matched to the blade. A clevis too large can affect your spinner's action. Here is a basic guide to clevis sizes and when to use them.



Stirrup Clevises



Folded Clevises

BLADE SIZE FOR STIRRUP CLEVISE						
Size	Colorado	Indiana	Willow	Swing	French	Fluted
1	00,0,1,2	00,0,1,2	0,1	0,1	0,1	na
2	3,3½,4	3,4	3,3½	2,3,4	2,3,4	na
3	5,6	4,5,6	4,5,6	4,5	5,6	5
4	6,7	7	7	na	na	5,6
6	7	na	7	na	na	7
8	na	na	na	na	na	8

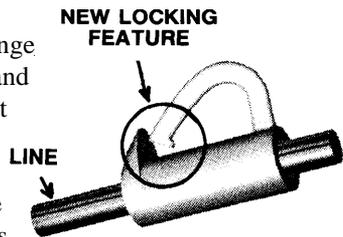
BLADE SIZE FOR FOLDED CLEVISE						
Size	Colorado	Indiana	Willow	Swing	French	Fluted
2	00,0,1	00,0,1	0,1,2	0	0	na
4	1,2,3,3½,4	1,2,3,4	3,3½,4,5	1,2,3,4,5	1,2,3,4	na
6	5,6,7	4,5,6	4,5,6,7	5	3,4,5,6	na

Chart For Clevis Use	
<p>Use Stirrup Clevises</p> <ul style="list-style-type: none"> French Spinners In-Line Spinners Bucktail Spinners Hook Snap Spinners Hook Spinners Spinnerbaits (tandum) 	<p>Use Folded Clevises</p> <ul style="list-style-type: none"> Walleye Harnesses Live Bait Harnesses Leader Spinners Lake Trolls

QUICK CHANGE CLEVISE

A relatively new clevis is the “Quick Change Clevis”. This is a plastic clevis designed and patented by Gregg Pauley of South Dakota. What makes this clevis so unique is that the spinner blade can easily be removed and replaced with a different blade without having to rebuild the spinner or harness. This is the clevis for anglers

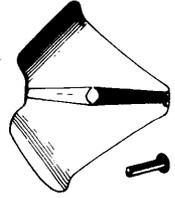
who wish to change blades while out on the water without changing lures. Popular for walleye harnesses and many weighted spinners. It is available in three sizes and there is even a quick change bottom bouncer clevis.



I had a chance to use and test the bottom bouncer clevis with outstanding results. When ever I needed to change the weight while searching out different depths all I needed to do was to quickly change bottom bouncers without cutting my line and retying.

DELTA BUZZ BAIT BLADE

Delta blades are completely different in both design and use from other traditional blades. They are self cleaving and are designed to maximize lift and noise. A properly assembled buzz spinner will chop up the water's surface.

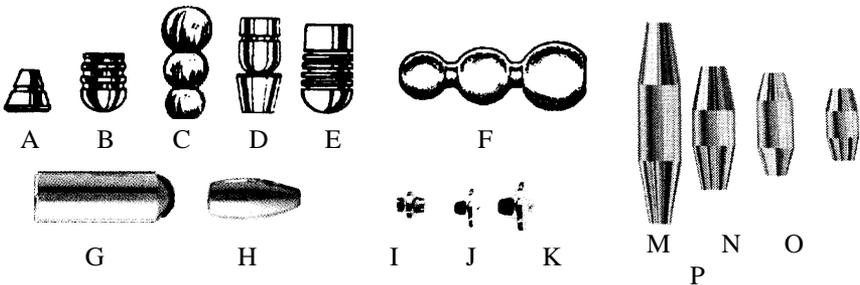


The most popular are made from aluminium. They come in three sizes to fit the four popular buzz bait heads, 1/8, 1/4, and 3/8 or 1/2 ounce. (Note size 3/8 and 1/2 ounce use the same blade).

WEIGHTED SPINNER BODIES

Spinner bodies come in different shapes, sizes, weights, finishes and are manufactured in solid brass, molded from lead or plastic. Solid brass spinner bodies are turned one at a time, polished then plated or painted. Lead spinner bodies are generally molded right on the wire shaft then painted. Plastic lure bodies are either injection molded or ground to size.

The purpose of a spinner body is for spinner weight and added attraction. The idea is to get the spinner quickly to the depth the fish are holding and maximize attraction at the same time. Not always an easy task but with practice it can be done.



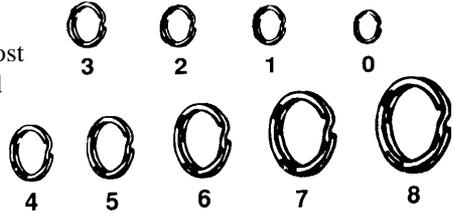
A sampling of brass spinner bodies available from Real Pro's SportFishing

OTHER IMPORTANT COMPONENTS

There are other components which individually may not seem very important to mention here but sometimes missing a single small component may hinder the completion of your lure. Lets take a look at a few of these components which every angler should stock in the work shop. They might just save the day.

SPLIT RINGS

Split rings are perhaps one of the most important components the angler should stock in the workshop.

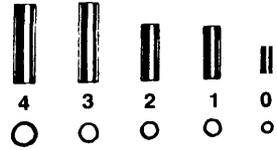


They are most often used to attach hooks to spoons, spinners and other lures. But they serve many other purposes. Such as line attachment on crankbaits,

blade attachment on spinnerbaits. Keep a few of several sizes ready for use.

CONNECTION SLEEVES

Connection sleeves are a necessity for the assembly of leaders made from nylon coated wire but do have several other uses. Most notable as spacers on spinners.



SWIVELS

Crane Swivels: Are the most popular swivels. There are many different quality crane swivels. Stay away from most imported crane swivels because many do not perform very well. I recommend you use Real Pro's Deluxe Crane Swivels. They are inexpensive and work very well. Use crane swivels where ever you require a swivel: spoons, spinners, spinnerbaits, harnesses and more.



Barrel Swivels: Barrel swivels are an inexpensive swivel but unfortunately do not perform very well. Their main use is in bass sinkers and other lead molding applications. You should not use them on spinnerbaits or other spinners.



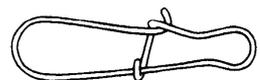
Ball-Bearing Swivels: Ball-Bearing swivels are the highest quality swivel and the most expensive. Here again stay away from cheap import models. Many cheaper models are not made from stainless steel and do not perform very well.



These swivels revolve on stainless steel ball bearings and will generally work well for long periods of time. Ball bearing swivels should be used where line twist is a major problem.

DUO-LOCK SNAPS

There are several styles of snaps on the market. The most popular and one of the strongest for their size is the duo-lock snap. What I like about the duo-lock snap is that both ends may be opened. This makes the duo-lock snap great for attaching to lures, swivels and they have many other practical uses.

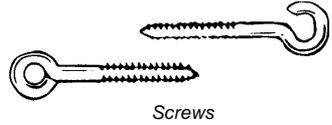


BEADS

Round beads, faceted beads, plastic beads, glass beads, hollow metal beads, solid brass beads, plated beads and glow in the dark beads in many different colours is just a start. Look through the Real Pro's SportFishing catalogue and you will quickly realize how many beads are available for making lures. No angler can survive without beads.

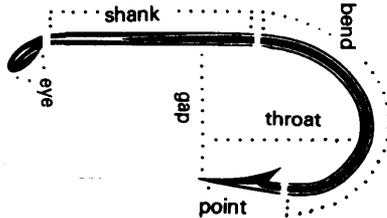
EYE SCREWS

Eye screws are used for line and hook attachments on wooden plugs. See page 58 for additional crankbait components.



FISH HOOKS AND THEIR USES

There are many different styles and sizes of fish hooks. So many in fact that an entire book could be written on just their special uses. Over the years, fish hooks have become very specialized. I will be very general in covering fish hooks. One thing I must stress is that fish hooks just may be the most important part of your lure. If you skimp or use the wrong hook your results may suffer.



Look over the above figure of the different parts of a typical fish hook. Probably the two most important dimensions are the gap and throat. The larger the gap the easier it is for hook setting. The larger the throat the better the holding power of the hook.

In each category of hooks there are generalist and specialist hooks. Generalist hooks are designed to serve many uses while a specialist hooks are designed for limited use but are almost always superior for the purpose they have been designed for.

Below are a number of popular fish hooks and their general uses. Please remember there are many more hooks than can be mentioned here.

Treble Hooks: There are several different designs of trebles. Each hook is somewhat different.



Eagle Claw 374



VMC 9649



Eagle Claw 954

Look at the above trebles and you will notice that each is different in design.

The **Eagle Claw 374** is a general purpose treble. Use on spoons, spinners and anywhere you might require a treble hook.

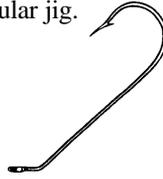
The **VMC 9649** is a thin wire wide bend (larger gap), and has much larger throat. This thin wire hook will penetrate the fish's jaw easier and the large throat means the hook will have more holding power. Use this treble hooks on spinners and stingers where you require better hook sets. This is an ideal hook on all spinners and stingers.

The **Eagle Claw 954** is very similar in design to the VMC 9649 except the wire is much heavier. Use this hook when fishing for large bony jawed fish. This hook is one of the best hooks for crankbaits and plugs.

Jig Hooks: Jig hooks come in many styles and serve many purposes. Below is a small sampling of different jig hooks. Most jig hooks are specialist in design. Often they have been designed for a single jig. Check the mold you are using to determine the exact hook you require for that particular jig.



Eagle Claw 570



Eagle Claw 1623



Eagle Claw 2190B

The **Eagle Claw 570** is the most popular jig hook. Almost all round head, banana, Erie, tube, and many other jigs use this 90° leg hook. Some fly tiers also use this hook.

The **Eagle Claw 1623** is a specialist hook and is used exclusively for standup jigs.

The **Eagle Claw 2190B** is another specialist hook and is used exclusively for swim jigs.

Live Bait Hooks: Live Bait Hooks were originally designed for salmon and steelhead. They have a short shank and wide gap so the hook can easily be hidden by the bait (eggs or yarn flies). They are also extremely popular on walleye harnesses. Use smaller sized 6,4 and 2 for walleye harnesses. These are excellent hooks for snelling with their up turned (away from hook point) eyes.



Eagle Claw 183



VMC V7356BN

The **Eagle Claw 183** is a standard live bait hook.

The **VMC V7356BN** is a new generation of live bait hook. It is made from vanadium a new alloy which permits the manufacture of smaller diameter hooks which are up to 25% lighter and stronger than any other. This is a needle cone sure set hook. A super hook but it is expensive.

Open Eye Siwash Hooks: Siwash hooks are extremely strong hooks. They are wide gaps with an extremely deep throat. Once a salmon or trout is hooked on this hook you will seldom lose him. Also becoming popular on musky bucktail spinners.



Eagle Claw 210 Open Eye

The **Eagle Claw 210** Open Eye siwash is used on spoons, plugs and other salmon lures. A good hook on spinners where a single hook is required.

Spinnerbait/Buzz Bait and Trailer Hooks: Spinnerbait/Buzz Bait hooks have small eyes and are used for molding spinnerbait and buzz bait heads. Trailers on the other hand have a longer shank and a large eye. The larger eye permits the hook to be slid over the barb of the spinnerbait hook. They are usually held in place with latex tubing or a piece of rubber band.



Eagle Claw 253



Eagle Claw 261

The **Eagle Claw 253** is the industry standard spinnerbait/buzz bait hook.

The **Eagle Claw 261** with its large eye is used when a trailer (stinger) hook is required.

Other Popular hooks: There are many other popular hooks, each with a different purpose, far too many to mention here. The following hooks are very popular hooks with many uses. The first two are excellent hooks for snelling with their down turned (towards hook point) eyes. The third is often used on bait hook spinners with a solid wire shaft or when using a snell knot is not required.



Eagle Claw 080



Eagle Claw 181 Bait Holder

Eagle Claw 80: The Eagle Claw 080 is a plain shank hook with a down turned eye. Use where snelling is important (walleye harness, snelled hooks etc.).

Eagle Claw 181: The Eagle Claw 181 is a bait holder (small barbs on the shank to hold bait in place) hook with a down turned eye. Use where snelling is important (walleye harness, snelled hooks etc.).

Eagle Claw 84: The Eagle Claw 084 is a plain shank hook with a straight eye. This is one of the more popular hooks for every day use. Use when a straight eye is required such as for tying direct to line and bait hook spinners.



Eagle Claw 084

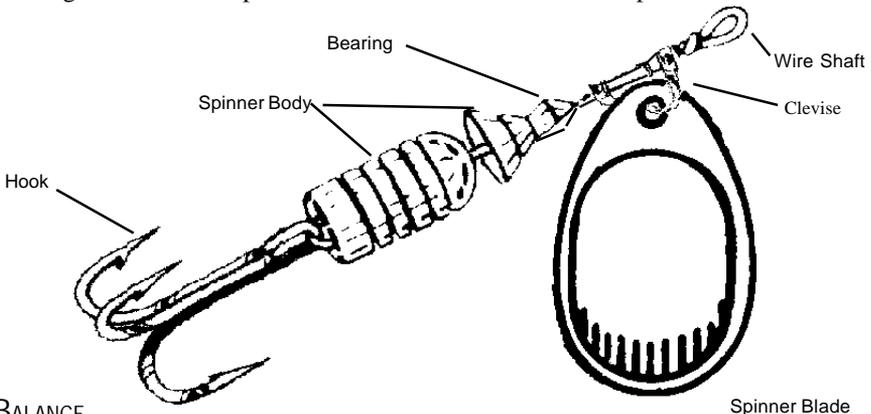
MAKING WEIGHTED SPINNERS

Spinners are by far Canada's favourite lure. The reasons for their popularity is rather simple. They catch a lot of fish. More than any other lure. They work well in both clear and murky water conditions. The revolving blade creates a fish attracting flash which is visible in clear water from great distances. In murky water the blade vibration attracts fish from great distances. Clearly, spinners are the most effective and popular lure so I will dedicate a lot of space to their assembly.

Spinners are easy and inexpensive to make. I am sure after you make a few spinners you will quickly become hooked on making spinners. From then on you will never need to buy another spinner. Remember, there is no single right way of making a spinner from scratch. Nor is there only one right combination of spinner bodies, beads, or blades to make a perfect spinner. Over the years I have made tens of thousands of spinners in all shapes and sizes for all game fish. The tables in the following pages list spinner bodies, blades, hooks, and beads combinations which when assembled in proper order will make well balanced and easy blade rotation spinners. These are my favourite spinners. You will be the one who ultimately determines which components to use. Do not limit yourself to only the spinners designs I list in this book. Experiment, experiment and experiment with your own designs. There exists a limitless array of spinner designs.

DESIGN ELEMENTS OF A WEIGHTED SPINNER

Take a good look at the spinner shown here. Note the different parts and their names.



BALANCE

The most important element of a good working spinner is balance. You must have a well balanced spinner. An unbalanced spinner will either have spinner wobble, improper blade rotation or no blade rotation at all. What I mean by balance is simply balance the weight of the spinner so the weight is spread evenly over the length of the spinner body. Don't overweight your spinners or the blades will not rotate properly.

BLADE AND LENGTH

The style of blade you choose to use is up to you but remember the key to a successful spinner is it's blade. Because there are so many different styles of blades, I can only recommend that you make spinners using different blades so you can get a feel for the blade's responsiveness. But take note, the blade, with a few exceptions, when hanging on a spinner when held upright should extend just past the spinner body.

CLEVISE

The clevis holds the blade to the spinner shaft. Most blades with a few exceptions require a clevis. Always use a stirrup clevis when making spinners using a wire shaft. Your blade will spin more freely. Never place any beads above the clevis. These would serve no useful purpose other than to put more friction on the clevis and make your spinner less effective.

BEARING

Always have a bearing between the clevis and spinner body. The bearing can be a small metal or plastic bead or a small brass disk (body "I"). The purpose is to reduce friction so the blade can spin more freely. Never let a spinner leave the workshop without a proper bearing.

SPINNER BODY

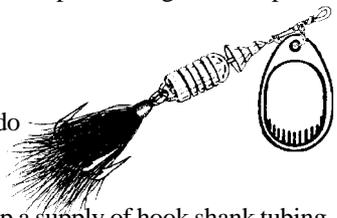
The spinner body serves two purposes on weighted spinners. First, it weights the spinner so it may be cast easily and more importantly reach the depth the fish are holding. Which is one reason why you might have to have a few spinners with the same blade but differently weighted bodies. Secondly, it adds to the overall fish attracting features of the spinner. It must also be well balanced. Never overlook the possibility of using solid brass beads as spinner bodies. They are great for maximizing weight.

WIRE SHAFTS

Aside from the gauge of the wire shaft you have two choices in shafts. Open or Closed looped shafts. I prefer open loop shafts for my smaller spinners and closed loop shafts for my larger musky and pike spinners. A spinner can be made much more quickly with an open loop and you also save the step of having to use a split ring to attach the hook to the spinner.

DRESSED TREBLES/SHANK TUBING

Dressed trebles and shank tubing have nothing to do with spinner function and everything to do with attraction. Tie your own trebles or purchase them pre-tied but do have a few handy. Don't forget to keep a supply of hook shank tubing. Latex tubing is the absolute best available. The fluorescent colours just scream fish attraction. The bright fluorescent colours helps direct the fish to strike at the hook.



PUTTING IT ALL TOGETHER

To over simplify, building spinners, is basically placing a hook on a wire shaft, sliding on a spinner body, then dropping on a blade and forming a closed eye. Before you actually build a spinner look over the three methods of bending the eyes in the wire shafts, listed in the next section, and decide which method you want to try. Then look over the tables listing different spinner designs and choose a few to assemble. The quickest way to end up with a finished spinner is to begin with an open loop preformed wire shaft and then make the finishing eye with a pair of pliers or wire forming tool.

A. USING A PAIR OF NEEDLE OR ROUND NOSE PLIERS AND WIRE CUTTERS

When making spinners using this method use a purchased open loop wire shaft or make your own using a wire former.

1 Place hook in eye of open wire shaft. Pinch the two ends together and slip the desired spinner body over both ends. Now slide any remaining spinner body component(s) down the shaft. With small spinners you may have to trim the short end of the spinner shaft a little.

2 Apply any die cut prism tape to the blade. Now slide the clevis in the blade hole. Slide the wire shaft through the holes in the clevis, making sure the concave side of the blade faces the spinner body.

3 Using your needle nose pliers grab the wire shaft firmly 3/16" to 1/4" above the clevis.

4 Do not twist the pliers. Hold the pliers still and slowly bend the wire shaft over the top of the pliers 90 degrees. You may wish to slide a crane swivel on the shaft at this time.

5 Continue bending the wire shaft down and around the pliers in the opposite direction. A total of 270 degrees. Remember do not move the pliers only the wire.

6 Now simply wrap around the shaft two times, closely to the pliers as possible. Remove pliers and trim excess wire as close to the shaft as possible. That's it.

A NOTE ABOUT METHOD "A"

If you use a pair of standard needle nose pliers, the final closed eye will look much like a "D" in shape. It looks a little strange at first but it's appeal grows in time. If you prefer a round eye, use a pair of Real Pro's round nose pliers for a perfectly round eye.

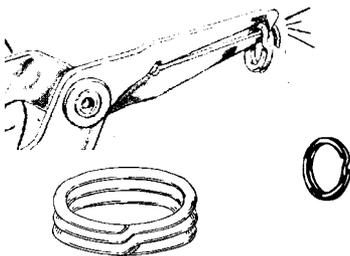
Using this method you can make spinners in many different sizes. You can even form closed eyes in surprisingly large gauge wires. With practice you will be able to quickly form a closed loop.

B. USING NEEDLE NOSE PLIERS, WIRE CUTTER AND SPLIT RING PLIERS.

Use this method when using a closed loop wire shaft, purchased or made using a wire former. The hook will be attached with the aid of a split ring. The major benefit is you will be able to change the hook at any time in the future without having to cut apart and rebuild the spinner. We generally use this method for larger spinners like those used for pike and musky.

On these large spinners we must often cut the trebles when removing the spinner from the fish's mouth. So having the ability to change the treble after construction is important. Likewise big fish often destroy the bucktail tied to the trebles. So the need to change trebles might again be required.

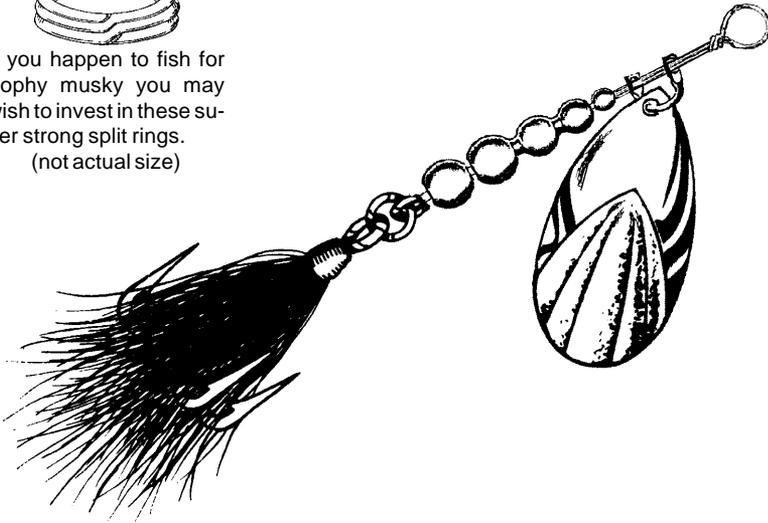
LARGE FRENCH AND FLUTED BUCKTAIL SPINNERS



If you happen to fish for trophy musky you may wish to invest in these super strong split rings.
(not actual size)

Simply follow steps 1 through 6 as in method "A" on the previous page, except you do not have to slide the spinner body through both end of the wire because you are using a closed wire shaft.

After the spinner is complete add the split ring and desired hook.

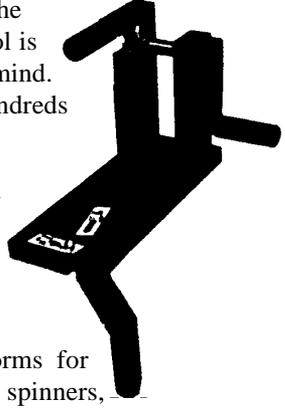


Large spinners should have the hook attached with a split ring.

C. USING REAL PRO'S COMMERCIAL TACKLE MAKER

Here you can use open or closed loop wire shaft because you will actually be making the shafts as you go. When using Real Pro's Commercial Tackle Maker you can easily make all of the loops in a totally professional manner. This handy tool is designed with the manufacturer or serious hobiest in mind. With a little practice, using this tool you can turn out hundreds of professional looking spinners a day.

Real Pro's Commercial Tackle Maker is fully customizable. It can handle wire from as light as 0.018" all the way to 0.045" with no problem. It comes with all the parts with nothing else to buy.

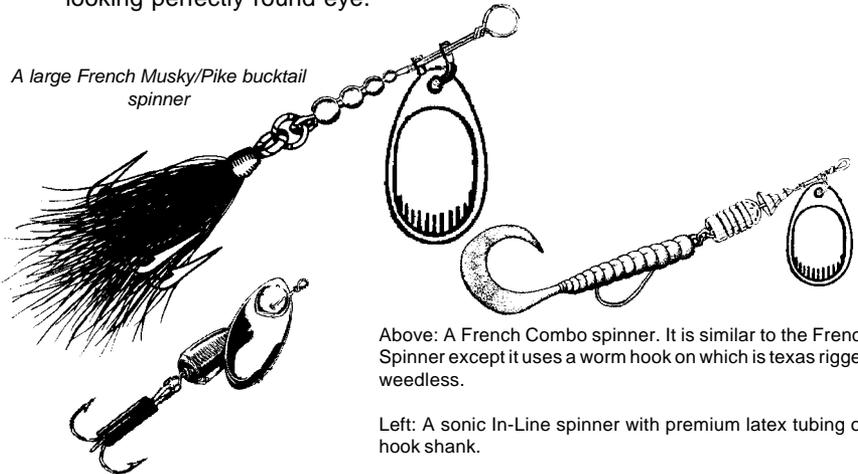


Using this tool you can make all of your wire forms for spinnerbaits, buzz baits, ice fishing spreaders, musky spinners, and rigs of all kinds.

Clear instructions are included with Real Pro's Professional Tackle Maker. Here is a quick summary of the steps involved.

- ① Cut a length of wire about two inches longer than the finished spinner will be. Now using the Real Pro's Professional Tackle Maker form the required loop.
- ② If using an open loop place hook in eye of wire shaft. Then slide spinner bodies down wire shaft while pinching the two ends together. Continue with the blade and clevis.
- ③ Now using the Real Pro's Professional Tackle Maker create a professional looking perfectly round eye.

A large French Musky/Pike bucktail spinner



Above: A French Combo spinner. It is similar to the French Spinner except it uses a worm hook on which is texas rigged weedless.

Left: A sonic In-Line spinner with premium latex tubing on hook shank.

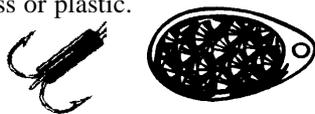
TABLES FOR WEIGHTED SPINNERS

Use the tables, on the next several pages, to assemble well balanced, functional spinners. Each table is for a different series of spinners. I have and continue to use most of the following spinners. I do have my own favourites but you have to decide for yourself which will be yours. The spinners meet the requirements of all fisherman. First, they are well balanced, have instantaneous blade spin the second the spinner hits the water. Which is exactly what you want in a spinner. Secondly, because they work so well they catch a lot of fish. Lastly, they just plain look good. Many anglers will simply not use a spinner if it does not look good. Well you can rest easy because these look good and catch a lot of fish.

The spinner bodies are listed in order from hook to clevis. So If you were to assemble a size "3" French spinner, a very popular spinner I might add, the spinner body would be made up as follows. First you have the "E" body right above the hook, then the "J" body resting on top of the "E" body and the "I" body (small disk used as a bearing) resting on top of the "J" body.

Beads are listed as their diameters. e.g. 3/32", 1/8", etc.. Notes below the table explain if the beads are hollow metal or solid brass or plastic.

ADDITIONAL SPINNER COLOUR

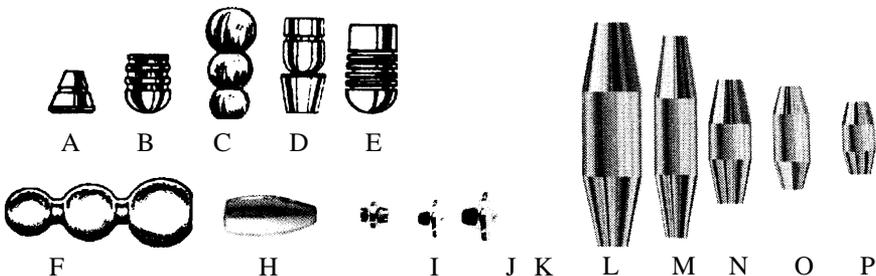


If I want to have some additional colour other than the blade or body I use *latex tubing* on the hook shank, *die cut prism tape* on the blade, or a dressed treble. Remember the die cut French tape fits well on many other blade styles.

HOOKS — TREBLE OR SIWASH

All hooks listed in the tables on the next few pages are trebles. If you prefer the siwash hook on your spinners use the conversion chart below.

Treble	8	6	4	2	1/0	2/0
Siwash	6	4	2	1	1/0	2/0



FRENCH SPINNERS

One of the world's most popular spinners. It will almost always get the attention of all game fish.



French Spinner Component Chart						
Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 0	10 or 8	P	1 or 3/32"	1	0 French	0.024"
No. 1	8 or 6	B,J	1 or 1/8"	1	1 French	0.024"
No. 2	6	B,A	1 or 1/8"	1 or 2	2 French	0.024"
No. 3	6 or 4	E,J	1 or 1/8"	2	3 F	0.024" or 0.030"
No. 4	4	F	1/8"	2	4 French	0.030"
No. 5	2	F,A,	1/8"	2	5 French	0.030"
No. 6	2 or 1/0	F,3/32",A	1/8"	2 or 3	6 French	0.030"

The 3/32" and 1/8" beads used on French spinner can be solid brass or hollow metal.

SONIC IN-LINE SPINNERS

A fantastic spinner for all trout species in the smaller sizes (size 1 to 3). A killer spinner on bass, pike and musky in sizes 4 to 7.



Sonic In-Line Spinner Component Chart						
Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 1	8 or 6	P	3/32"	n/a	1 Sonic	0.024"
No. 2	8 or 6	H	3/32"	n/a	2 Sonic	0.024"
No. 3	6	H or 3/16",H	3/32"	n/a	3 Sonic	0.024"
No. 4	6 or 4	7/32",H	3/32" or 1/8"	n/a	4 Sonic	0.024"
No. 5	4	5/32",N	5/32"	n/a	5 Sonic	0.030"
No. 6	2	M	5/32"	n/a	6 Sonic	0.030"
No. 7	1/0	7/32",L	5/32"	n/a	7 Sonic	0.030"

Use 3/16" and 7/32" Solid brass beads as part of the body if you need maximum weight otherwise use hollow metal beads. All bearing beads are hollow metal.

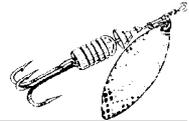
TROUT DRIFT SPINNER

A great spinner for all species but excels at catching large trout in medium sized rivers. The Indiana blade is standard on this spinner but you can use an equal sized French Blade.

Drift Spinner Component Chart

Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 3	8	B,5mm,J	3/32" or 1/8"	1	3 Indiana	0.024"
No. 4	6	B,6mm,A	3/32" or 1/8"	1	4 Indiana	0.024"
No. 5	4	B,6mm,H	1/8"	2	5 Indiana	0.024"

The trout drift spinner use a plastic bead in the middle of the spinner body. Any colour may be used but I believe a cherry red or salmon red coloured bead is the most effective. The bearing bead is a hollow metal bead.



WILLOW LEAF SPINNERS

Willow Leaf Spinner Component Chart

Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 2	10 or 8	O	1/8"	1	2	0.024"
No. 3	8	6mm,B,J	1/8"	1	3	0.024"
No. 3½	6	6mm,1/8",B,A	1/8"	1 or 2	3½	0.024"
No. 4	4	6mm,E,J	1/8"	2	4	0.024"

The willow leaf spinner uses a plastic 6mm bead above the hook. The other 1/8" beads may be solid brass hollow metal.

FAST CURRENT & DEEP WATER FRENCH SPINNERS

Here is a series of French Spinners that have evolved for fishing fast current and deeper water situations. *A word of warning before using these spinners is that they cast like bullets and sink like rocks.* They do however, catch a lot more fish in special situations. Situations like when the fish have moved deeper than you can normally get with an average weighted spinner or when the current is just too strong for achieving anything more than surface skipping with your average weighted spinners.

Extra Heavy French Spinner Component Chart

Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 0	10 or 8	3/16",7/32"	1/8"	1	0	0.024"
No. 1	8 or 6	3/16",1/4",5/32"	1/8"	1	1	0.024"
No. 2	6	1/4",5/16",3/16"	5/32"	1	2	0.024"
No. 3	6 or 4	5/16",11/32",7/32"	3/16"	2	3	0.024"-0.030"
No. 4	4 or 2	9/32",11/32",5/16"	5/32"	2	4	0.030"
No. 5	2	5/16",11/32",9/32",1/4"	7/32"	2 or 3	5	0.030"

The entire body is made of solid brass beads to maximize weight.

When making the Heavier French spinners you should use an open loop wire shaft. If you decide to use larger diameter wire you may have to drill the holes on the first few beads larger to fit the wire shaft. Use a 1/16" or 1/20" drill bit.

LARGE FLUTED BLADE BUCKTAIL SPINNERS

These spinners have an extremely large following with the die hard musky fishermen. And for good reason, they catch a lot of big musky and pike. Note they can be made using our spinner body combination or you can make them simply using only solid brass beads as an effective and heavy body.



Large Fluted Blade Bucktail Spinner Component Chart

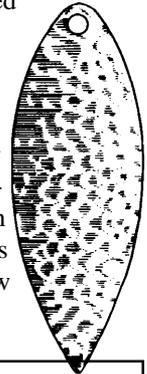
Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 5	2/0	F	5/32"	4	5	0.040"
No. 6	2/0 or 3/0	F,7/32"	5/32"	4	6	0.040"
No. 7	3/0 or 4/0	5/16",F,7/32"	5/32"	6	7	0.040"
No. 8	5/0 or 5/0	11/32",F,7/32"	5/32"	8	8	0.040"
No. 5	2/0	4 x 9/32"	5/32"	4	5	0.040"
No. 6	2/0 or 3/0	6 x 9/32"	5/32"	4	6	0.040"
No. 7	3/0 or 4/0	6 x 5/16"	7/32"	6	7	0.040"
No. 8	4/0 or 5/0	6 x 11/32"	7/32"	8	8	0.040"

All beads should be solid brass to maximize weight. The "6 x 11/32" means use 6 size 11/32" solid brass beads. As always, feel free to experiment with different combinations of bodies and beads. You will be amazed what you can do with a few solid brass beads.

When making the large Fluted bucktail spinners you should use a closed eye wire shaft of at least 0.040". Attach the bucktail with a split ring (use size 4 to 7) so you may easily change bucktails with damaged hooks or with worn, torn or damaged bucktail.

LARGE WILLOW LEAF BUCKTAIL SPINNERS

These spinners are very much like the above Fluted Bucktail spinner except the blade used is an oversized willow leaf blade. The advantage with a willow leaf blade is that this spinner can be fished much deeper than the French or the Fluted bucktail spinner. Every serious pike and musky angler should have a selection of these large willow leaf bucktail spinners.



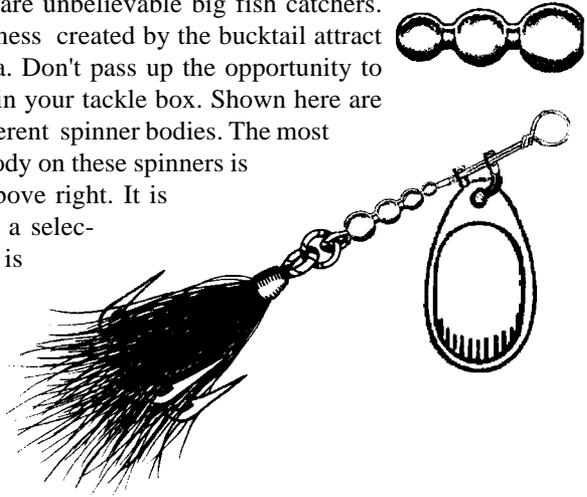
Large Willow Leaf Bucktail Spinner Component Chart

Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 6	3/0	5/16",F,	5/32"	4	6	0.040"
No. 7	4/0	11/32",11/32",F,9/32"	5/32"	4 or 6	7	0.040"

Use solid brass beads on all of these spinners.

LARGE FRENCH BUCKTAIL SPINNERS

French Bucktail spinners are unbelievable big fish catchers. Their large size and bulkiness created by the bucktail attract the largest fish in the area. Don't pass up the opportunity to have these fish attractors in your tackle box. Shown here are similar spinners using different spinner bodies. The most commonly used spinner body on these spinners is the "F" body as shown above right. It is used in combination with a selection of solid brass beads. It is also used on the Fluted Bucktail spinners and the Willowleaf spinner. You can also use a selection of solid brass beads to vary the weight of these amazing big fish catching spinners.



French Bucktail spinners are proven fish catchers for musky, pike and bass.

Large French Bucktail Spinner Component Chart

Size	Hook	Body	Bearing	Clevis	Blade Size	Shaft
No. 4	2/0	F	1/8"	3	4	0.040"
No. 5	3/0	5/16"F,7/32"	1/8"	3	5	0.040"
No. 6	4/0	11/32",F,7/32"	1/8"	3	6	0.040"
No. 4	2/0	9/32",11/32",5/16",1/4"	5/32"	3	4	0.040"
No. 5	3/0	11/32",F	5/32"	3	5	0.040"
No. 6	4/0	11/32",F,7/32"	5/32"	3	6	0.040"

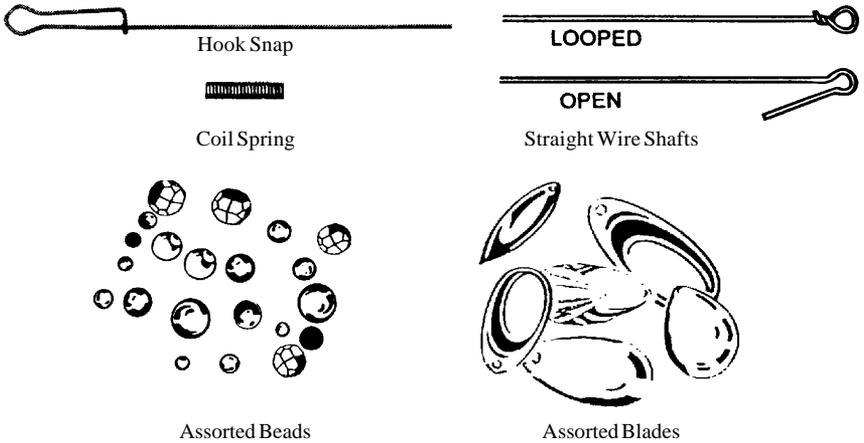
The bearing beads can be hollow metal or solid brass. Solid brass is recommended to maximize weight. All beads in the body should be solid brass beads but many anglers will put a size 8mm coloured plastic bead on the lower end of the body.

When making the larger French bucktail spinners you should use a closed eye wire shaft of at least 0.030" wire but a 0.040" or larger wire is highly recommended for large pike and musky. Attach the bucktail with a split ring (use size 4 to 7) so you may easily change bucktails with damaged hooks or worn, torn or damaged bucktail.

UNWEIGHTED SPINNERS

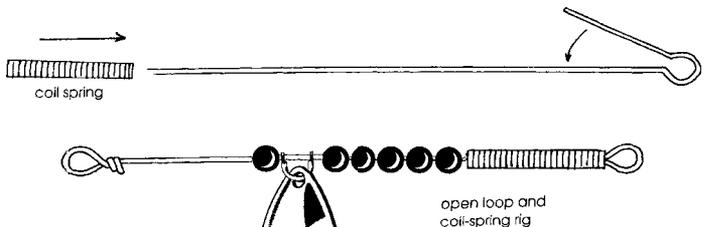
There are many unweighted spinners in use. June bug, swing, ripple, Colorado and Indiana blades are just a few of the blades used on these types of spinners. These spinners are built on a straight wire shaft. Usually an open loop shaft with a coil spring to hold the loop closed. You may also use the hook snap shaft which opens and closes easily.

Most of these spinners consist of a straight wire shaft, several beads, a coil spring, one or two spinner blades and a stirrup clevis for each blade. The coil spring permits the angler to quickly change hooks on-the-fly. The open looped shaft with coil spring may be substituted with a hook snap (easily opened and closed) or a looped shaft which must have hook attached with the aid of a split ring.



ASSEMBLING UNWEIGHTED SPINNERS

Assembling these popular spinners is very easy. Simply slide the coil spring down the open loop wire shaft to securely fasten the loop closed. Now slide the desired number of beads and spinner blade. Now simply form a closed loop on the end of the shaft. Use one of the methods mentioned earlier to form the closed loop.



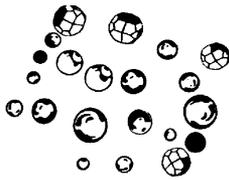
NOTE: If making a double spinner simply crimp a size "0" connection sleeve, with an inside diameter of 0.033" onto the shaft at the desired location.

WEIGHTED FORWARD SPINNERS

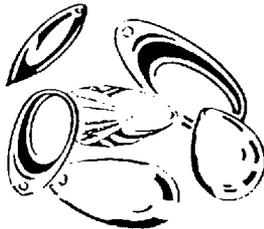
Weight forward spinners are popular spinners for walleye on lake Erie and many other walleye lakes. The advantage with these spinners is that they are one of the best lures for suspended fish. They take many thousands of walleye, bass, pike and many other game fish each year. They also troll extremely well and don't twist line.

These spinners consist of a straight wire shaft (looped), a molded on lead head, a spinner blade (usually a French blade) several beads and a hook. You can mold your own heads or you may purchase the weight forward heads already molded. Some anglers prefer to paint the weighted lead head while others do not.

WEIGHT FORWARD COMPONENTS



Assorted Beads



Assorted Beads



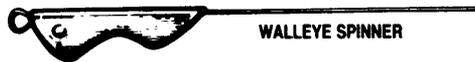
ERIE RIG



STYLE F SPINNER



STYLE "M" WEIGHT FORWARD



WALLEYE SPINNER

Assorted Weight Forward Head Styles

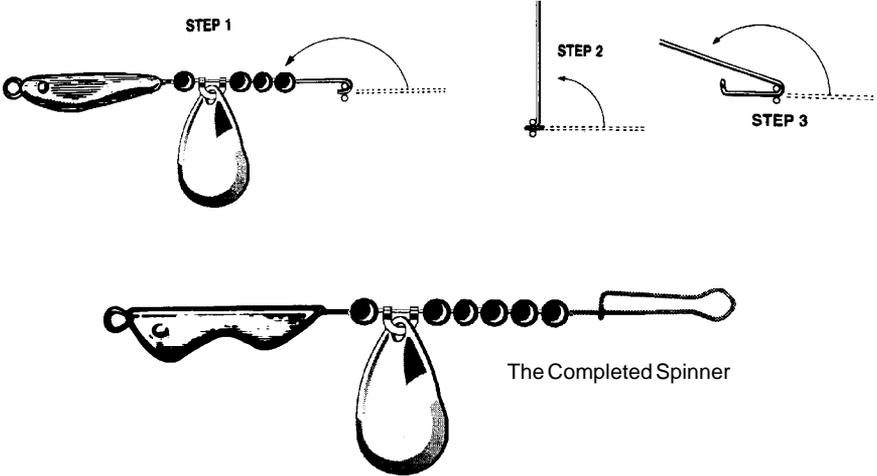
There are several styles of weight forward spinner heads. It is only a matter of angler preference. The purpose of the head is to act as a keeled weight. The most popular sizes are the 3/8oz. and 5/8oz. heads. There are several Do-It Molds available for molding your own heads.

ASSEMBLING WEIGHT FORWARD SPINNERS

1. First paint the weight forward spinner head if you desire a painted head. Then slide the spinner blade (usually a French blade) and clevis. Ensure the blade is facing the right direction.
2. Next slide on the desired beads (colour and size). Use hollow metal or plastic

beads so as not to unbalance the spinner.

- Using your round nose pliers follow these three simple steps to form a hook snap (safety pin snap). Use a hook snap style loop so you can easily change hooks.



RECOMMENDED BLADE SIZES AND HOOKS

Look over the chart below to determine the best blade and hooks sizes.

Weight Forward Spinner Component Chart						
Spinner Weight	French Blade	Indiana Blade	Clevis Size	Bead Size	Hook Size	Hook* Style
3/8oz.	3	3	2	5mm	1/0 or 2/0	072 or 261
5/8oz.	3 or 4	4	2 or 3	6mm	2/0 or 3/0	072 or 261

* Eagle Claw Hooks - Style 072 has a longer shank than style 261.

There are many suitable hook styles including trebles. The major problem with trebles is they tend to snag up on bottom while a single hook is less likely to.

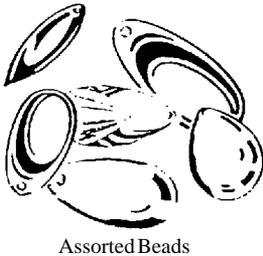
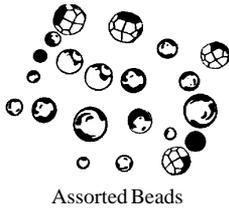
If you are molding your own weight forward heads use 0.030" lure making wire. Also look through the Real Pro's SportFishing catalogue for pre-molded heads.

LAKE TROLLS

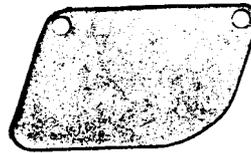
Lake trolls consist of several spinner (3 to 7) blades spaced apart on a length (12" to over 60" long) of nylon coated wire with a trolling rudder on the front end to ensure there is no line twist and a crane snap swivel on the rear for lure or leader attachment. Generally they are used for trolling for lake trout.

Lake trolls have been the backbone for lake trolling many years, and still are in many areas. They are extremely expensive but can be made for a fraction of the cost of store bought versions. Their construction is rather simple and no special tools are required.

LAKE TROLL COMPONENTS



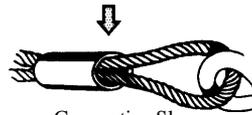
Nylon Coated Wire



Trolling Rudder



Crane Snap Swivel



Connection Sleeves

ASSEMBLING LAKE TROLLS

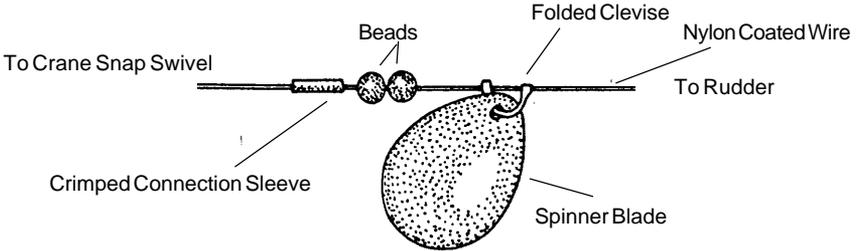
Assembling your lake troll is a rather simple task.

1. Begin by cutting a length (a few inches longer than the finished length of your Lake troll) of nylon coated wire and attach the snap swivel to the wire using the correct size connection sleeve. (See page 59 for crimping methods)
2. Slide another connection sleeve down the wire and crimp at the desired location of the blade closest to the snap swivel.
3. Slide several beads down the wire for attractors and bearing for the spinner blade.

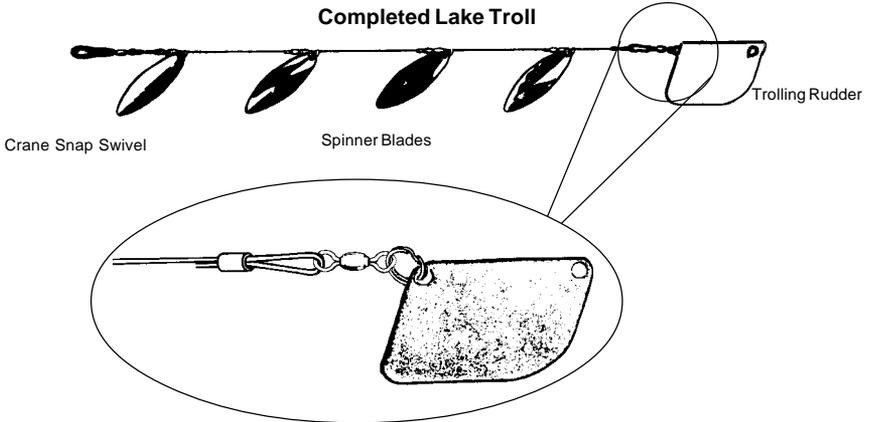
- Now using a **folded clevis** to attach the desired blade to the wire, slide the blade so that it rests on the beads. A folded clevis will not damage the nylon coated wire.



A Typical Section of a Lake Troll



- Repeat steps 2 through 5 for each additional blade. Remember to leave enough space for each blade to spin freely.
- After the desired number of blades have been added attach the trolling rudder with a split ring as shown below.



LAKE TROLL BLADES

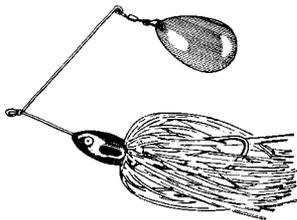
The traditional lake troll uses willowleaf blades but consider using a variety of different blades to alter the flash and vibration of the Lake troll.

Connection Sleeve Chart

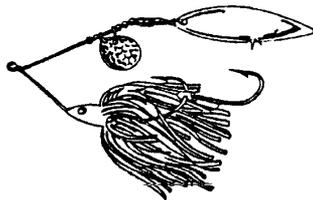
Size	Use with Nylon Coated Wire Size
1	15 lb. test
2	20 lb. test
3	30 lb. test
4	over 45 lb test

SPINNERBAITS

One of the most popular bass lures ever developed. Now even popular for pike and musky as well as panfish. I have even taken trout on these amazing baits. The Spinnerbait is one of the few truly weedless spinners. It can be tossed into the heaviest cover and still not get caught up. If you only use a few dozen baits per season, purchase the spinnerbait heads pre-made and perhaps even painted. If you

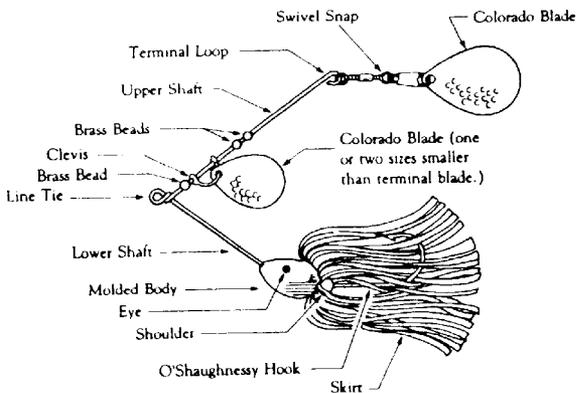


Standard Spinner bait



Tandem Spinner bait

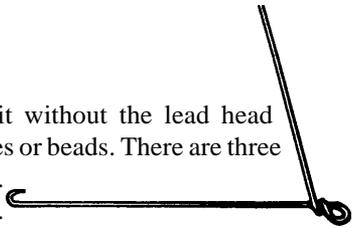
go through more, you may want to mold your own spinner bait heads to save even more. Spinnerbaits come in many sizes with the 1/8 oz., 1/4oz., 3/8oz., and 1/2oz. being the most popular sizes. Spinnerbaits are extremely easy to assemble. The figure on the right shows the different components used making spinnerbaits.



Looking at a standard spinnerbait you will quickly realize that spinnerbaits are rather easy to assemble from an assortment of components. In fact, spinnerbaits are perhaps one of the easiest of lures to assemble. No special tools are required and you can assemble a seasons worth of spinnerbaits in a few hours. Before we actually get to the steps of putting together spinnerbaits, lets take a closer look at the spinnerbait forms (wire).

CLOSE UP LOOK AT SPINNERBAIT FORMS

Think of the spinnerbait form as a spinnerbait without the lead head molded onto the wire form and without any blades or beads. There are three sections of the spinnerbait form to look closely at. The line tie, the upper shaft, and the lower shaft. There are several styles of line ties and modifying the upper or lower shaft will directly modify how the spinnerbait will perform. Lets look at a few variations.



LINE TIES

There are two popular line ties in use today. The twisted eye and the "R" Bend eye, both offer advantages.



"R" Bend



Twisted Eye

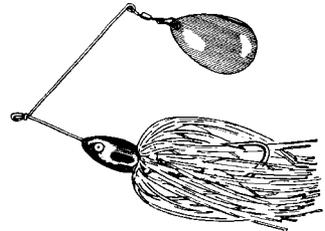
The "R" bend is an easier bend to form and has become more popular with some manufactures. Anglers using spinnerbaits with an "R" bend quickly realize that you can't use a snap to attach it to your main line. The snap will slide up or down the one of the shafts and foul the action of the lure. Some anglers use a piece of latex hook tubing and slide it over the "R" Bend before connecting a snap to eliminate the snap sliding problem. One advantage of the "R" bend when you tie your main line directly to the "R" bend you don't have to worry about your line wrapping around the bend and damaging your line as with the twisted eye.

The twisted eye is good for use with snaps or leaders because you know the snap is securely locked in the eye and can not slide up or down the shafts.

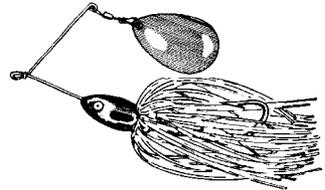
SHAFT LENGTHS

Aside from changing blade and skirts an easy modification to make to spinnerbait is to modify the upper arm length. Most standard spinnerbaits uppershaft length is roughly equal to the length of the lower shaft plus the hook length. Lets look at what happens when you shorten the upper shaft or lengthen it.

Look at the spinnerbaits on the right. The top spinnerbait has a regular length upper shaft. The middle one has a short upper shaft and the lower one has a longer upper arm.

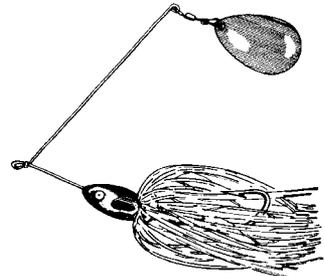


By changing the upper shaft length you effectively change the position of the blade in relation to the hook. If the shaft is too short it will not protect the hook from snags. If the arm is too long the fish may strike the blade missing the hook.



A shorter shaft is great for helicoptering the spinnerbait. Helicoptering is when you let the spinnerbait drop vertically. Use a larger blade Colorado to slow the drop.

A longer arm will protect the hook from snags better. I recommend that you modify a few of your spinnerbaits by changing the upper arm lengths.



BLADE SIZES (BALANCE)

Look over the chart below. It lists the recommended components and their sizes for each of the single and tandem spinnerbaits.

The most important thing to remember is that blades which are too large for the spinnerbait will sometimes cause the entire spinnerbait to roll while being retrieved. You may be able to use oversized blades but you may have to retrieve them very slowly to avoid the lure rolling.

Spinnerbait Component Chart					
	1/8oz.	1/4oz.	3/8oz.	1/2oz.	3/4oz.
Colorado Size⁽¹⁾	1 to 3	3 to 4	3½ to 5	4 to 5	5 to 7
Willow Size⁽¹⁾	2 to 3	3 to 4	3½ to 5	3½ to 5	5 to 7
Colorado Size⁽²⁾	0 to 2	1 to 2	1 to 3	2 to 3½	2 to 4
Willow Size⁽²⁾	1 to 2	2 to 3	2 to 4	3 to 4	3 to 4
Stirrup Clevis⁽²⁾	1	2	3	3	4
Swivel Size⁽³⁾	12	10	7	7	5
Split Ring Size	1	2	3	4	5
Bead Size⁽⁴⁾	3/32"	1/8"	1/8"	1/8" or 5/32"	5/32"
Skirt Length	4"	4"	4" or 5"	5"	5" or larger
If You Plan to Mold Your Own Heads Use:					
Wire Shaft Dia.	0.035"	0.035"	0.040"	0.040"	0.040"
Hook Size⁽⁵⁾	1/0	2/0	3/0	4/0	5/0

- (1) Blade size for the terminal blade
- (2) Blade size for the secondary blade. This blade should be smaller than the terminal blade. It is placed on the upper arm before the terminal blade using a stirrup clevis.
- (3) The swivel may be a snap swivel or a crane swivel with split rings. The advantage of a snap swivel is that you easily change the blade while out on the water.
- (4) These are usually hollow metal beads but you may use plastic beads as well. They act as a bearing and should be both above and below the clevis.
- (5) Use an Eagle Claw style 253 or 255 hook.

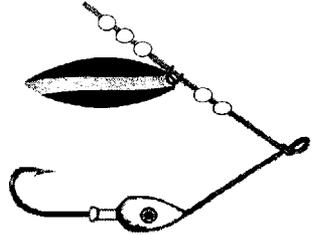
Spinnerbaits are extremely versatile lures and deserve a place in every anglers tackle box. Experiment with blade colours, sizes and styles as well with a variety of skirts.

PUTTING THE SPINNERBAIT TOGETHER

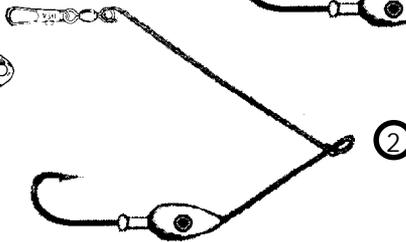
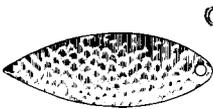
Before you begin assembling your spinnerbaits decide if you want a single or tandem spinnerbait. If you want a tandem bladed spinnerbait you must first put the secondary blade on the upper arm. Have your pair of needle nose pliers handy.

- ①a *Tandem spinnerbaits only.* Slide one or two beads on the upper arm. Then slide the blade down the upper arm. Now slide a few (2 to 3) beads down on top of the clevis. Always use at least one bead above and below the clevis.

Form loop here

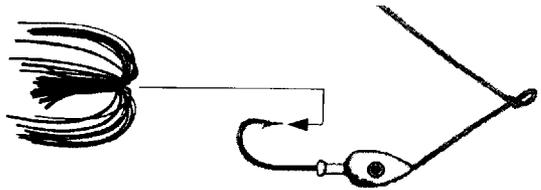


- ①b *All spinnerbaits.* Using your needle nose pliers form a small loop at the end of the upper arm. Leave enough room to insert the snap swivel.



Now insert the snap swivel or split ring into the loop. Now pinch the loop closed with your pliers. Attach the desired terminal blade on the swivel.

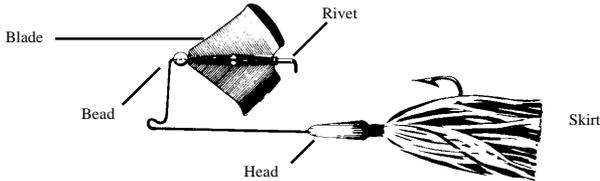
- ③ Now the last set is rather easy. Simply slide the skirt of your choice onto the shoulder of the molded body. That's it.



Note: Colorado blades will give your spinnerbait more lift and therefore can be retrieved shallower and more slowly. Willow leaf blades on the other hand will let you retrieve more quickly and deeper.

BUZZ BAITS

Buzz baits are just as easy to make as are spinnerbaits. These weedless lures are fished on the surface. The blades are sold in the same sizes as the heads. For example if you are making a 1/4oz buzz bait use a 1/4oz size buzz blade. Use a hollow metal bead in front of your buzz blade and a rivet after the blade.

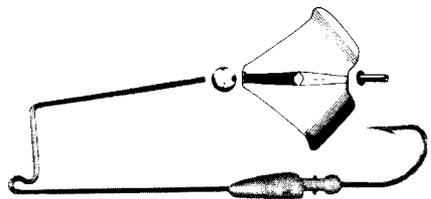
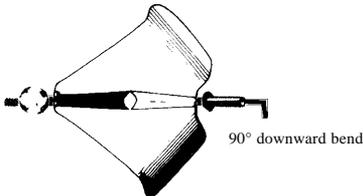


Buzz Bait Component Chart				
	1/8oz	1/4oz.	3/8oz.	1/2oz.
Blade Size	1/8oz	1/4oz.	3/8oz.	1/2oz.
Rivet Size	1	1	1	1
Bead Size	1/8"	5/32"	5/32"	5/32"
Skirt Length	3" to 4"	4"	5"	5"
If You Plan To Mold Your Own Heads Use:				
Wire Diameter		0.035"	0.045"	0.050"
Hook Size	1/0	2/0	3/0 or 4/0	4/0

PUTTING THE BUZZ BAIT TOGETHER

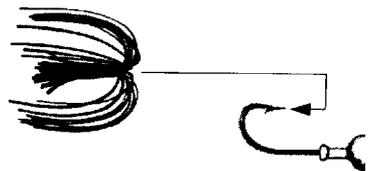
Follow these three quick steps to making your own Buzz Baits. Have a pair of needle nose pliers ready.

- Slide on the hollow metal bead onto the buzz bait arm. It will prevent the blade from getting hung up on the wire arm. Now slide on the buzz blade followed by the rivet.



- Make a 90° downward bend on the shaft after the rivet. Leave enough room so the blade can spin freely on the shaft.

- Now the last set is rather easy. Simply slide the skirt of your choice onto the shoulder of the molded body. That's it.



MOLDING LEAD

Molding your own lead heads is quick and easy. Serious luremakers invest in a few inexpensive lure molds and some melting equipment! Not only can you mold spinnerbait and buzz bait heads but also many types of jig and sinkers.



While the required tools are inexpensive, you should consider a quality lead melting pot. The pot along with a ladle works well and is a good investment for beginners. The melting pots are available in several capacities (sizes).

TIPS FOR MOLDING WITH LEAD

First, always use eye protection, gloves and long sleeves when melting lead. Avoid loose clothing. Using the proper melting equipment will save time and frustration later on.

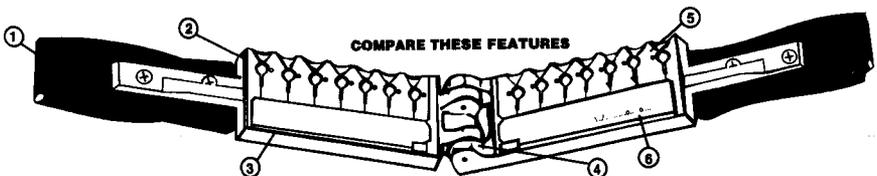
Pure lead is soft, melts at a low temperature 621°F (327°C) and pours well. Pure lead is ideal for beginners. It also produces nice a head without air pockets. When using recycled or scrap lead remember it may not be pure. It may contain other soft metals.

LEAD SOURCES

Lead has many industrial applications and is readily available from scrap metal dealers. You may also be able to collect used tire weights from tire dealers in your local area.

THE MOLDS

The Do-It Company, in my opinion, have the finest lure molds in the business. They have many features not available on other molds.



1. Wooden handles
2. The mold is cast with a hard, warp resistant aluminium alloy.
3. The mold faces are machined smooth and flat.
4. The hinges are machined to fit and then tightly pinned to assure precision line up.
5. Each mold is individually checked

- for proper hook and insert size.
6. The style and sizes of hooks and other inserts is listed on each mold.

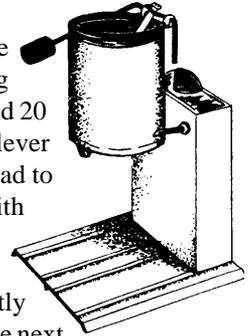
BEFORE YOU BEGIN

- You must have a sturdy work surface
- You must work in a well ventilated area
- Before you turn on the heat of your lead melting pot or camp stove make sure the pot you are using is sturdy. A wobbly work surface can be dangerous.
- When finished casting your heads let the mold stand to cool.

Never place the mold or any hot item in water to cool.

MELTING LEAD

Commercial lead furnaces are available which aid the lure maker. These lead melting pot are convenient when casting large quantities of jigs or sinkers. They hold between 10 and 20 pounds of lead. Most commercial lead furnaces have lever controlled spouts which allows just the right amount of lead to pour into the mold. Almost all are electric powered with thermostats to keep the lead at the right temperature.

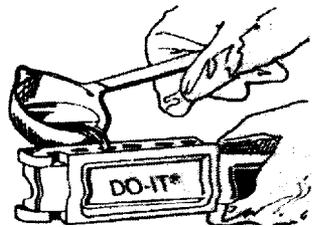


You fill the mold by placing mold under the spout and gently release the lever and fill the mold cavity then repeat over the next cavity.

No commercial furnace, don't worry. You can use a propane camp stove to melt lead in a cast iron pot. Lead melts at 621°F (327°C) so you require a heat source that will generate enough heat quickly. Pour the lead into the mold using a ladle. There are two ladle sizes, a 1½ lb and 2 oz. Use the 2 oz. for small tear drop jigs and smaller sinkers.

CASTING LEAD

The first step to casting lead is to preheat the mold. You can do so by casting heads without hooks. If you do not preheat the mold your castings may have rippled surfaces. Don't forget to preheat the ladle as well. A cold ladle will often cool the molten lead enough to cause problems before you can even pour the lead into the mold.



Smoking the mold with a candle will often help make casting easier. To smoke your mold simply light a candle and hold the open mold above the flame and allow mold cavities to become black with soot. Now you should try to remove the soot from around the cavities. I recommend smoking molds with small cavities.

When you cast spinnerbaits or buzz baits you must use a ladle. There just isn't

enough room above the molds because the wire forms extend above the mold to use a commercial lead furnace. Use extreme caution when pouring lead into any mold with large wires or hooks extending above the mold.

You should only pour lead outdoors or in a well ventilated garage or room.

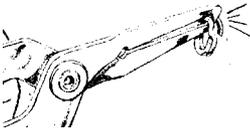
After the heads are cast you must allow the heads to cool before removing the spruce. After removing the spruce file away any flash along the joint of the head. Now the castings (jigs etc.) are ready for finishing.

I recommend that, if you will be painting the castings, you apply a white (primer) coat of paint on the castings within a few hours or store them in a sealed plastic bag. This will prevent the castings from tarnishing.

SPOONS

Spoons are extremely popular with all anglers. They work well, come in many different sizes and weights. Assuming you do not make your own spoon blanks the only tools you need are a pair of split ring pliers and a sharp knife. You probably already have everything you need to get going.

- ① Before you begin assembling the spoon. Attach any lure tape to the blank or paint the blade first if you are going to paint it.



- ② Using a pair of split ring pliers, open the split ring and attach to the rear hole in the spoon blank. Attach a second split ring to the front hole. Now attach a crane swivel if you like to the front split ring.

- ③ Attach the hook to the rear split ring. That's it!



SPOON DOCTORING

There are many adjustments you can do to your spoons to change their action. Try these on your spoons and you just might be amazed the change will have on the fish catching ability of your spoons. These tricks work on both casting and trolling spoons.

1. Reverse the spoon. Put the hook on the front of the spoon and run the spoon backwards. It may not work on all spoons but it often changes the action (wobble) of the spoon considerably which is just what you need to get that fish to strike.
2. Attach a small spinner blade to the split ring holding the hook. The blade will add extra flash to the spoon and will create a strike zone for the fish.
3. Replace the treble hook with a siwash hook if you are losing fish. The siwash hook will penetrate deeper and holds better.
4. Replace the treble hook with a treble dressed with a buck or calf tail. The spoon will run shallower and the extra bulk of the tail makes the spoon look larger. It will also give the fish a strike target.
5. Remove the treble hook and slide a piece of coloured latex tubing onto the hook shank. It will give the fish a strike target.
6. Make a spoon weedless by replacing the treble hook with a worm hook. Texas rig a plastic worm or plastic twister tail onto the hook. Now you can cast it into the weeds or work the bottom without the risk of losing your spoons.

SPINNER HARNESSES

Making your own spinner harnesses is extremely quick and easy. They require few tools and can be made virtually anywhere. I clearly understand why most walleye anglers today make their own spinner harness rigs.

Harnesses can be made on monofilament line or nylon coated stainless steel wire. As a general rule walleye harnesses are made with monofilament and pike harnesses are made with nylon coated stainless steel wire. Always use the lightest line practical to avoid spooking fish.

There is an endless number of spinner harness designs. Think about the many different styles of spinner blades, sizes, colours and finishes. Generally, that alone is enough to create confusion. So I will concentrate on the most popular types of harnesses. There are two main types of harnesses, the long spinner harness type (36" to 48" long) and short harness type (6" to 17" long). Each uses the same style of blades: Colorado, Indiana, and Willowleaf. Look over the section on spinner blades on pages 14 thru 17 and the chart below to help you decide which blades are best for your water conditions. Both harnesses and casting-harness anglers should follow the same general rule on blade choices.

Blade Size Chart Guide			
	Colorado	Indiana	Willow
Cold Clear Water	00,0,1	00,0,1	0,1,2
Cold Stained Water	2,3,3½	2,3,4	2,3
Warm Clear Water	1,2,3	1,2,3	1,2,3
Warm Stained Water	2,3,3½,4,5	3,4,5,6	3,3½,4,5

Blade Colour Chart Guide			
	Colorado	Indiana	Willow
Cold Clear Water	Nickel/Brass	Nickel/Brass	Nickel/Brass
Cold Stained Water	Red/Chart./Orange	Red/Chart./Orange	Red/Chart./Orange
Warm Clear Water	Nickel/Green/Blue	Nickel/Green/Blue	Nickel/Green/Blue
Warm Stained Water	Red/Chart./Orange	Red/Chart./Orange	Red/Chart./Orange

White is an excellent all around colour. Chart. is chartreuse.

SELECTING HOOKS

Selecting the proper hook is almost as important as the blade itself. Before you actually decide what type of hook to use, consider the bait you will be using with each spinner. There are several types of hooks which work well and have high hooking percentages on harnesses.

Most commercial harnesses use the live bait hook. It is the most popular hook used on harness construction in the United States. It is somewhat less popular with Canadian tackle manufactures. In Canada, the long-shank Aberdeen (style 214), bait holder (style 181) and sproat (style 80 and style 84) are popular.

When you make your own you can choose between live bait, bait holder, Aberdeen, and even treble hooks. Use the style in which you have the most confidence in. The live bait hook is great for use with minnows and night crawlers. The Aberdeen hook is popular on some commercial harnesses and the bait holder is popular amongst northern walleye anglers. Use small trebles (size 12 or 10) as the rear hook on minnow harnesses. Regardless of the style you choose, the hook should be no larger than needed for the bait.

Walleye Harness Hook Selection Guide			
Blade Size	Aberdeen⁽¹⁾	Bait holder⁽²⁾	Livebait⁽³⁾
Colorado - 00,0,1	8,6, or 4	8 or 6	6
Colorado - 2,3,3½	6 or 4	6 or 4	4
Colorado - 4,5,6	4 to 2/0	4 or 2	2
Indiana - 00,0,1	8,6, or 4	8 or 6	6
Indiana - 2,3,3½	6 or 4	6 or 4	4
Indiana - 4,5,6	4 to 3/0	4 or 2	2
Willow - 00,0,1	8,6, or 4	8 or 6	6
Willow - 2,3,3½	6 or 4	6 or 4	4
Willow - 4,5,6	4 to 3/0	2	2

- (1) Aberdeen hooks are often used with very small bladed harnesses or on harnesses designed for use with minnows. The long shank permits the hook to go into the minnow's mouth and pass out through the gills and then back into the rear of the minnow.

The Aberdeen hook with it's straight eye design will not pull straight if the hook is snelled to the harness.

- (2) Bait holder hooks are generally used when only a single hook is being used. It is more popular on casting harnesses when used with worms as bait.

Hooks like the sproat (style 80) with similar down turned eye can be used if a bait holder hook is not wanted. Eagle Claw style 80 is the same as the bait holder except the hook does not have the bait holder barbs on the shank of the hook.

- (3) Live bait hooks are used for both worms, minnows, and leech harnesses. They can easily be snelled in pairs, two live bait hooks or even with a treble behind the first live bait hook as shown below. There are several styles of live bait hooks in use. The most popular is Eagle Claw 183 hook but VMC Vanadium 7356 and Eagle Claw L757 hooks are becoming more popular.

HARNNESS HOOK SAMPLES



Live Bait Hook Up
Turned Eye



Bait Holder Hook
Down Turn Eye



Aberdeen Hook
Straight Eye



VMC Sure Set Hook
Up Turned Eye



Sproat Hook Down
Turn Eye



Sproat Straight Eye
Hook*

* The Sproat Straight eye (Eagle Claw 84) hook is generally used on harnesses when they are assembled with nylon coated wire and a connection sleeve is used to make the connection.



Standard Treble
Eagle Claw 374



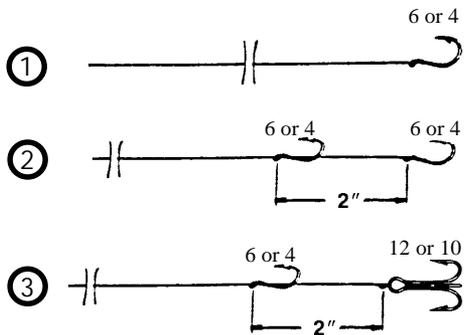
Wide Bend Thin
Wire Treble
VMC 9649



Wide Bend Short
Shank Treble
Eagle Claw 954

Shown on the right are a few possible combinations of hooks.

- (1) Ideal for leeches and minnows. Use a size 6 with leeches.
- (2) Ideal for night crawlers. You may also add a third hook for light strikes.
- (3) The deluxe method for minnows.

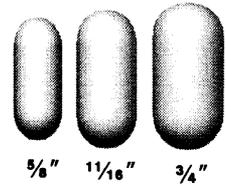


BEADS

No discussion of harnesses would be complete without at least the mention of beads. Beads are available in so many different colours, sizes and finishes that it would be impossible to discuss the best colours or sizes. So rather than talk colour lets talk size. Sizes 4, 5, and 6 are by far the most popular sizes on most harnesses but many anglers swear by size 8. Beads serve three main purposes. First, beads add attraction, so size and colour play an important part in the overall effectiveness of the spinner. Secondly, beads act as good separators, use beads to separate the different components of the spinner (blades, floats etc.). Thirdly, beads act as bearings for the clevis and blade.

RIG FLOATS

Rig floats are great at keeping your rigs off the bottom and away from obstructions as well as keeping your rig in the strike zone. They are available in three sizes and several colours. These floats are made of styrofoam and then painted in a number of fluorescent colours, each has a centre hole through its length. If you want to keep your harness off the bottom, thread on a rig float while making your harness.

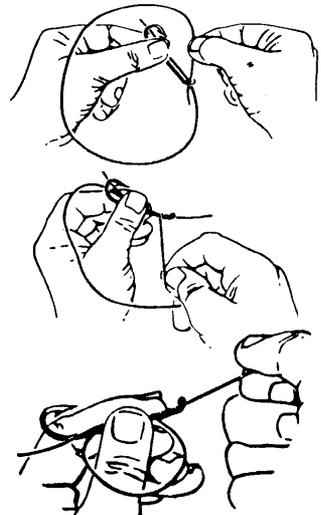


KNOTS

Just when you thought you were over the tuff stuff we get to the knots. Every angler can easily tie on a hook using an improved clinch knot but many still have problems snelling a hook. You must learn to properly snell a hook if you want to rig a harness with multiple hooks. Remember strong knots hold your rigs together. You will quickly learn, while on the water, if your knots fail.

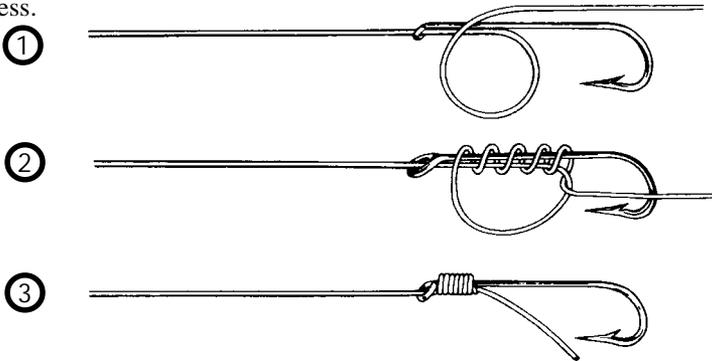
AN EASY SNELL

- ① Cut your line approximately one foot longer than the finished rig will be. Now insert one end of the line through the eye of hook just past the barb. Pass the other end through eye in opposite direction, leaving a large loop hanging down.
- ② While holding both lines along hook shank. Use line hanging from eye to wind tight coils around shank and both lines from eye towards barb. Make 5 to 10 coils.
- ③ Move fingers to hold coils tightly in place. Pull leader line extending from eye until entire loop has passed under coils.
- ④ With coils snuggled up neatly, use pliers to pull tag end, cinching up snell. Clip off tag end of rear hook. Repeat steps 1 to 4 for second hook.



THE UNI-SNELL

Here is another easy way to tie snell knot. The uni-knot has many uses such as snells, joining lines, and tying bobber stops. The major disadvantage with the unit snell is that it is rather difficult to use if you want to gang two or more hooks on a harness.



1. Thread the line through the hook eye about 8 inches. Hold the line against the hook shank and form a small loop.
2. Make 5 to 8 turns through the small loop (around the hook shank and line) Close the knot by pulling the tag end.
3. Now tighten the knot by pulling the main line in the opposite direction of the hook. Trim tag end.

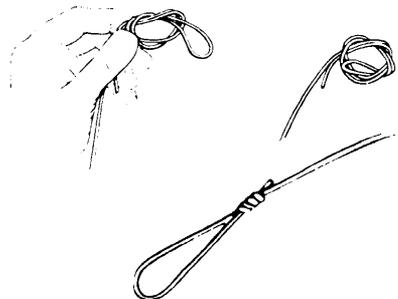
SURGEON'S LOOP

You will have to tie a loop knot at the other end of your line but only after the spinner components have been slid onto the rig.

There are a number of strong easy to tie loop knots around. The rapala loop knot is popular but for some reason some anglers have difficulty tying it. The Surgeon's End Loop is easier to tie and just as strong (about 80% line strength).

SURGEON'S END LOOP

- ① Double end of line to form loop and tie over hand knot at base of double line.
- ② Leave loop open in knot and bring doubled line through once more.
- ③ Holding standing line and tag end and pull loop to tighten knot. Size of loop can be determined by pulling loose knot to desired position and holding it while knot is tightened. Trim tag end.



ASSEMBLING YOUR SPINNER RIG

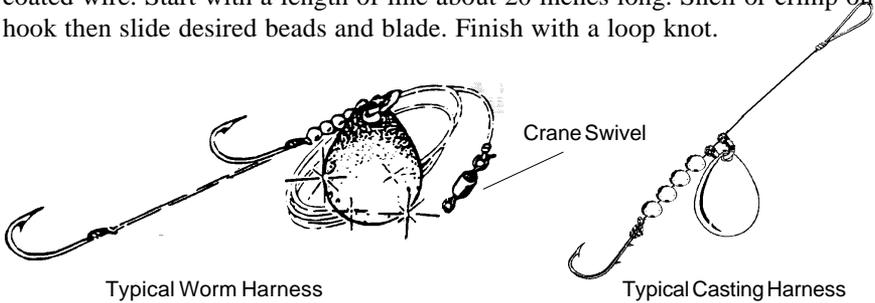
Now for the fun stuff. First decide which hook(s), blades, and beads you will be using and whether you will be using nylon coated wire or monofilament. If you will be using wire you may prefer to use connection sleeves instead of tying the knots. If using monofilament it is recommended that you use the lightest line as is practical.

WALLEYE HARNESSES

Harnesses are generally tied onto a length of monofilament of three to six feet long. Cut a length of monofilament line and snell on the hook(s). Slide on beads, float(s) and blade(s) and tie end loop. Many anglers will use a crane swivel instead of a loop knot.

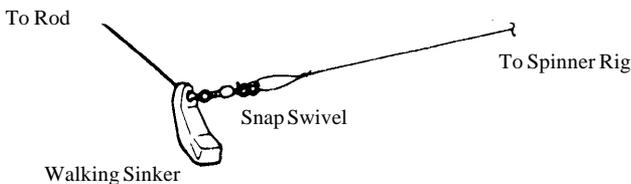
CASTING-HARNESSES

Casting Harnesses are generally much shorter than trolling harnesses. There are often six to ten inches long when complete and tied on monofilament or nylon coated wire. Start with a length of line about 20 inches long. Snell or crimp on hook then slide desired beads and blade. Finish with a loop knot.



USING YOUR RIGS

Harnesses are usually fished by trolling or drifting. To get the rig down to the strike zone you will have to use a weight system. Popular weight systems include the use of walking sinkers, bottom bouncers, and three way swivels with a dropper line attached to a bell sinker or split shot (also known as a *wolf river rig*).



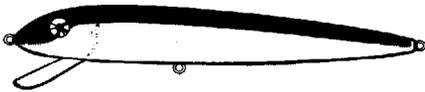
PLASTIC CRANKBAITS

For now I will assume you are starting with Real Pro's Crankbait bodies. These are unpainted crankbait bodies which only require to be painted and the attachment of hooks. See the chart below for the appropriate hook and split ring size for each crankbait.

Crankbait Hook and Split Ring Chart		
Crankbait	Hook Size	Split Ring Size
2" Diver	8	3 or 4
3" Diver	6	3 or 4
4" Diver	4	3 or 4
5" Diver	4 or 2	4 or 5
3" Shad	6 or 4	3 or 4
4¼" Shad	4 or 2	4 or 5
3" Minnow	8 or 6	2 or 3
4" Minnow	6 or 4	3 or 4
5" Minnow	2	4 or 5



Diving Crankbaits Bodies



Minnow Bodies



Shad Body

Painting these crankbait bodies may be done by dipping, air brushing or hand brushing. Please see next section on making and finishing wooden crankbaits for details.

MAKING WOODEN CRANKBAITS

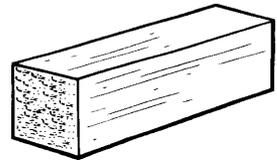
Making your own CRANKBAITS from scratch or painting Real Pro's CRANKBAIT BODIES is much easier than most anglers think. Requires few tools, just follow these simple instructions and you'll be well on your way to becoming a much better angler. Follow the painting instructions for both wood and plastic crankbaits.

WOOD SELECTION

Each wood has a unique action. Softer woods tend to give the finished lure a more darting (faster) action when retrieved. Softwoods are more buoyant and thus may dive less than a similar lure made from a hardwood. Hard woods give the lure a slower, tighter action when retrieved. Hardwood is also less buoyant, almost neutral in many cases. Many hardwoods lures will often remain suspended and tend to glide longer on their own momentum. All woods will catch fish. The type of wood you decide to use is an exciting variable. Identical lures made from different types of wood may end up having a completely different action. The best advice is to experiment and get the feel of several types of wood. Begin using soft fine grain woods to get the hang of shaping and sanding. Then move to progressively harder woods.

Softwoods: Balsa, Pine, Cedar, and Basswood

Hardwoods: Maple, Oak, Ash, and Walnut

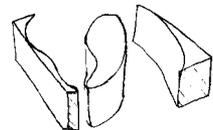
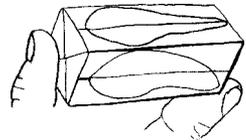


CUTTING THE ROUGH SHAPE OF THE LURE

Begin by selecting a clear knot free block of wood, some what larger than the finished lure will be. Many round shaped top water lures have the same pattern on all four sides and thus may be turned on a wood lathe or cut by hand. Most other lures have irregular shapes and require separate top and side patterns and therefore must be cut by hand. The figures shown in these instructions show a bass diver style plug. The process is similar regardless of the style or shape of plug you are building.

SHAPING YOUR LURE.

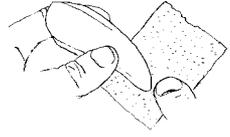
1. After selecting an appropriate block of wood. Draw centre lines on the top, sides and both ends of the block.
2. Using a template pattern, trace the outline of the lure on top and side of your block. Use top pattern on top and side pattern on side of block. Use the centre lines to carefully position the pattern in the centre of the block.
3. Using a scroll saw or small band saw carefully cut along the side plane of the block. Keep the cut-outs as a base to rest your plug when cutting the top plane. Now cut the top plane.



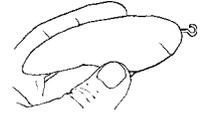
(Safety Tip: Use a drop of wood glue and glue the top and bottom cut-outs back onto the block. Use a rubber band to hold the block together for about one minute. Then remove the rubber band and cut the top plane. The glue will help keep the block from coming apart or rocking while you're cutting the top plane. Now, before the glue has completely dried pull the top and bottom from the plug.)

4. You should now have a rough cut plug. Use a sharp wood carving knife or jack knife and cut the edges to bring the plug to a rough round shape.

5. Now use 60 grit sandpaper to sand the plug to the final shape. Once satisfied with the shape change to 80 grit sand paper then 120 grit, then 320 grit and finally 400 grit.

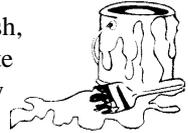


6. Mark locations of screws for hooks, diving lips and line attachments. Drill small pilot holes for line tie and hook eye screws. The small screws used with the hook hangers and metal diving lips are self tapping and do not require pilot holes in softwood. Before attaching screws or diving lips permanently follow the painting instructions below to paint your lure



PAINTING YOUR CRANKBAITS

There are several methods of painting crankbaits. You can brush, dip, spray or air brush (for super fine detail) your plugs. (Note small open eye screw in tip of above plug. This is a temporary screw used to hang the plug for drying.)



First, paint all lures with a coat of white paint or primer or clear sealer to seal the lure. White is necessary if your will be painting the lure a bright fluorescent or translucent colour(s). If the paint has been thinned the lure may require a second, third or fourth coat of white paint. Let the lure dry completely before applying another coat of paint.

After the base coat of white paint, paint the lure the desired colour(s). Always begin with the lighter colours first. After the paint has dried seal the lure with a quality water proof clear coat to protect the finish. You may wish to apply several coats of clear coat.

TIPS FOR BRUSHING

Brushing is by far easiest method and requires the least preparation. Use a small 1/4" brush. Always use several thin coats instead of one heavy coat. Paint very carefully and avoid overlapping strokes.

TIPS FOR DIPPING

Always thin the paint you are using to prevent drips from drying on the lure. If drips develop on the lure thin the paint a little more. Dip the lure several times, letting it dry before each dip. Tip: After the white base coat dip 2/3's of the lure in bright red, orange or chartreuse for a great looking lure.

TIPS FOR SPRAYING

Small cans of spray paint are a great way to add dashes of colour to any lure. Use a small piece of screen or nylon mesh and tape it on the lure. Spray over mesh to create a fish scale effect.

PAINTS FOR CRANKBAITS

When choosing the type of paint to use remember to use compatible types. Don't, for example, use a latex paint for the base white coat with alkaline paint as they may not adhere properly. Many lacquer paints contain strong solvents and are often not compatible with enamel or other mineral spirits-thinned house paints. So the basic rule of thumb when it comes to choosing the paint to use is to use similar paints for all coats and colours. Remember the final clear-coat must also be compatible with all other coats and be "waterproof". So use an exterior grade clear-coat.

THINNING PAINTS

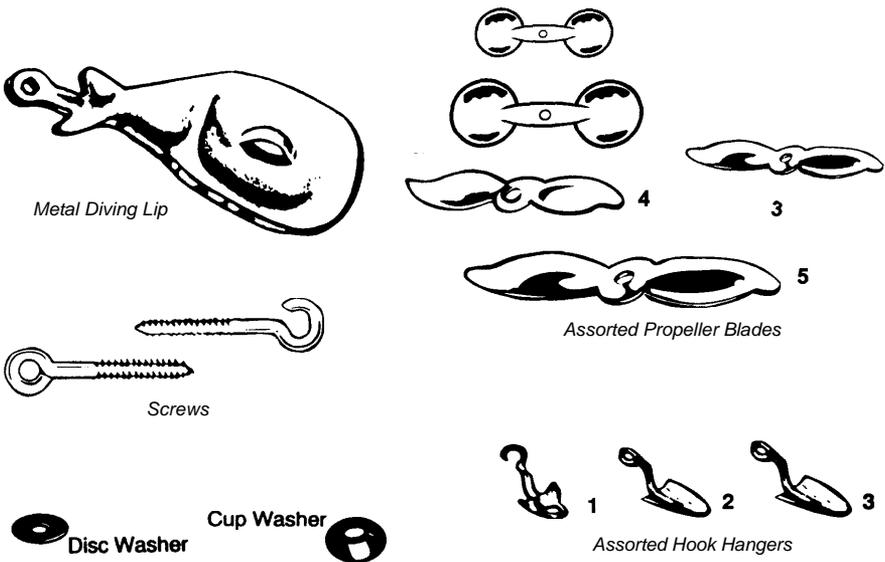
- Use a lacquer thinner to lacquer paints. Do not use mineral spirits.
- Use mineral spirits to thin enamel and alkaloid paints.
- Use water to thin water based paints.

Follow the manufacturer's instructions for proper thinning ratios or use this general guide. For *brushing* no thinning required. If *spraying*, thin paint four parts paint to one part thinner. If *dipping*, thin paint three parts paint to one part thinner.

ATTACH HOOKS

Now attach any hook hangers, eye screws, diving lips and line attachment screws. Clear holes and partially screw eyes into lure then using a pair of pliers twist the eyes the rest of the way in. For large plugs set screws in two part epoxy.

CRANKBAIT ACCESSORIES



MAKING LEADERS & SNAP SWIVELS

Making your own leaders and high quality snap swivels is a straight forward and simple task. Leaders are made up of three parts. A swivel on one end, a snap on the other end with a length of wire or line between the two ends. Making your own leaders is the only way you can end up with a leader that will exactly meet your needs. Forget about using commercial wire leaders.

SINGLE STRAND LEADERS

First, decide what length of leader you will need and the strength you will require. Expert anglers almost always make their own leaders using single-strand wire over the nylon coated wire because it has a smaller diameter for its strength. Experts generally use single-strand stainless steel wire (0.012" to 0.020" or about 32lb. to 124lb. test), a quality swivel and a duo-lock snap. The small diameter of the wire makes it almost invisible to the fish and the duo-lock is extremely strong for its size. Match the crane swivel size to the snap size.

Just cut a length of wire about six inches longer than the finished leader will be. Then attach the crane and duo-lock snap with haywire twists. Now you make a professional leader in about a minute.

The Haywire Twist



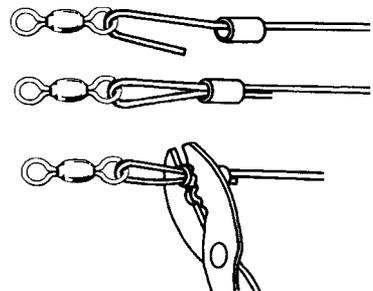
For maximum strength make $3\frac{1}{2}$ to 4 twists of the loop, then wind several tight wraps. Bend the tag end into shape of handle and crank the handle back and forth several times until the wire breaks off.

NYLON COATED WIRE LEADERS

Using desired strength nylon coated wire, connection sleeves, duo-lock snaps and matching swivels you can easily make your own leaders. Use one of the methods below to crimp the snap and swivel to the nylon coated wire. Remember to match the size of the connection sleeve to the size of the nylon coated wire.

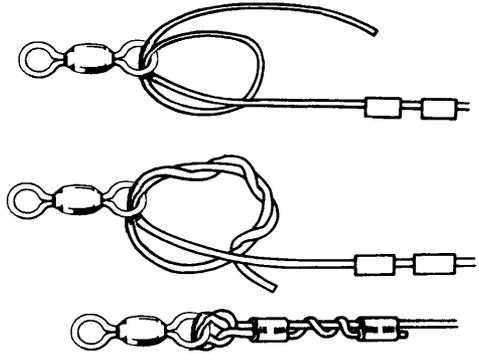
Standard Crimp Method

1. Pass the wire through the eye of the swivel.
2. Bring the end back through the connection sleeve. There should not be any excess wire sticking out of the sleeve.
3. Using the crimping tool crimp down hard on one end of the connection sleeve, Now repeat at the other end of the connection sleeve.



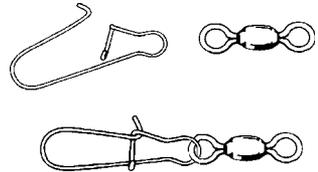
Heavy Duty Crimping Method

1. Slide two connection sleeves onto the wire, then pass the wire through the swivel eye twice.
2. Pass the wire through the loop two or three times.
3. Snug the loop, now pass the wire through the two connection sleeves as shown and crimp the connection sleeves.



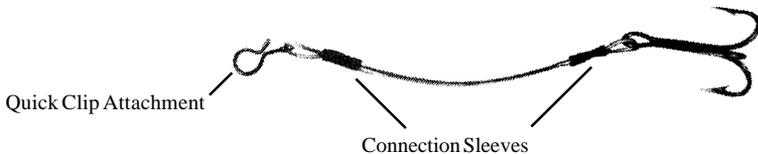
SNAP SWIVELS

Making your own snap swivels by opening a duo-lock and slipping it into a deluxe crane swivel. Now reclose the duo-lock snap and it's complete.



MAKING STINGER RIGS

Stinger rigs are a great way of catching those short striking fish. Use stingers with jigs and other baits. Make your own using a short length of nylon coated wire, monofilament or even a length of single strand 0.012" wire and attach to a *quick clip attachment* and *treble hook*.



Look over the Standard Crimping Method to review how to connect the treble and quick clip attachment to the wire. I recommend that you use a small treble size 10 or 12. If fishing for very large fish use a size 8 or 6 treble. A short shank, wide bend treble will perform better than a regular treble.

TYING DRESSED TREBLES & BUCKTAIL JIGS

LARGE BUCKTAIL TREBLES

Large pike and musky spinners are not much without a large bucktail dressed treble on the end of the spinner. These large dressed hooks add much bulkiness and colour to the spinner. Tying large bucktail dressed trebles is a little tricky and requires a little practice.

SMALLER SQUIRREL & CALF TAIL TREBLES

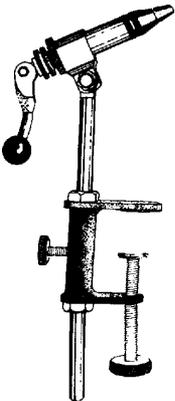
Likewise small dresses trebles dressed with calftail add a degree of attractive powers to both the angler and the fish. You probably already realize that most commercial spinners which have a dressed treble sell at a large premium over plain spinners. The cost of purchasing a dressed treble is close to or more than the cost of all components going into the spinner. So the advantages of tying your own dressed trebles is sure to help your wallet.

BUCKTAIL JIGS

Tying bucktail jigs is very similar to tying bucktail trebles. Use a jig without barbs. If your jigs have barbs simply remove the barb by cutting it off. Most anglers paint the jig head before tying while others prefer to dip the jig head and thread wrapping into the paint because the thread wrappings become coated with a layer of paint.

REQUIREMENTS

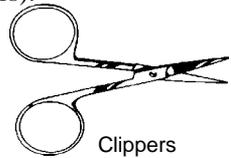
Before you begin tying trebles you will need a few basic tools. You will require a hook vise, a bobbin and a small pair of clippers (scissors).



Hook Vise



Bobbin

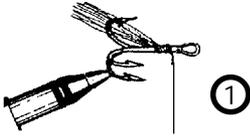


Clippers
Scissors

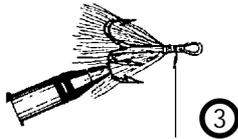
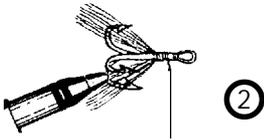


Thread

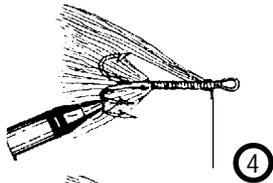
Tying bucktail, squirrel tail, calftail trebles or jigs is somewhat similar. The major difference is to create a fuller bucktail you may wish to tie two collars of bucktail on larger trebles. Follow this simple guide and illustrations below.



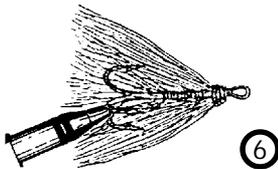
- (1)** Cover the hook shank with tread and head cement to form a bed for the hair. Tie on small bunches of hair letting them slip around the shank. Work plenty of head cement into each small bunch of hair after it has been tied on.



- (2)&(3)** Tie on additional bunches of hair until you have a complete collar of hair around the hook shank.

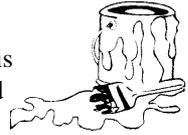


- (4)&(5)** For a larger and heavier bucktail add a second collar ahead of the first collar.



- (6)** Work plenty of head cement over the thread winding, let dry and repeat.

PAINTING YOUR COMPONENTS



You can easily paint most of your components by following this simple guide. Remember to always paint in a well ventilated area. Many paints produce strong odours and vapours which may cause serious injury.

TIPS FOR BRUSHING

Brushing is by far easiest method and requires the least preparation. Use a small 1/4" brush. Always use several thin coats instead of one heavy coat. Paint very carefully and avoid overlapping strokes.

TIPS FOR DIPPING

Always thin the paint you are using to prevent drips from drying on the lure. If drips develop on the lure thin the paint a little more. Dip the lure several times, letting it dry before each dip. Tip: After the white base coat dip 2/3's of the lure in bright red, orange or chartreuse for a great looking lure.

TIPS FOR SPRAYING

Small cans of spray paint are a great way to add dashes of colour to any lure. Use a small piece of screen or nylon mesh and tape it on the lure. Spray over mesh to create a fish scale effect.

DRYING RACK

Most components will dry more evenly if they are hung too dry. Make a simple drying rack with a few scrap pieces of wood, an old window frame, or cardboard box. Hang a length of bathtub bead chain or small link chain to serve as lure / component holders. The chain prevents the components from sliding together.

PAINTING EYES

Painting eyes is a simple affair. Use several sizes of nails with different sized heads. Simply dip the nail head into the paint and then touch the lure lightly. With a little practice you will be painting eyes and pupils.

BLADES, SPOON, BRASS SPINNER BODIES

It is recommended that you use lacquer paints, also called car paint. Many colours are available through automotive departments in spray cans. Enamel paint may also be used but they dry very slowly.

BLADE PREPARATION

Before you actually paint any brass or nickel plated metal, it should be etched.

Etching will clean the blade and allow the paint to adhere very well. If you decide not to etch the blade the paint may chip and peel more easily. Simply dip your blade or body into the etching solution, available at painting supply stores, and allow to dry completely.

APPLY SPRAY PAINT

Now hang the blade or lay them out for painting. First, spray each component with a high quality “white” metal primer. After the primer is dry you may apply the final coat of paint in the desired colour. Always use a white primer, because all fluorescent colours require a white undercoat first. It is the white undercoat which creates the fluorescent brilliance to the colour.

Applying paint with a spray can is easy but does require a little practice so practice on a few spare blades first. To add patterns such as scales or other patterns spray paint through nylon netting material. Try nettings of different sizes and patterns you may surprise yourself.

SPINNER BODIES

Many anglers like to paint the small groves found on many of our brass spinner bodies. A simple method to paint these groves is to use a small rag and dip a corner of the rag into the paint then gently rub the spinner body on the rag until the groves are filled with paint then wipe excess paint from the remainder of the body.

PAINTING LEAD HEADS

You can use a variety of paints to paint lead but remember some paints will react with soft plastics such as plastic twister tails, plastic worms etc. So if you will be using the head with a soft plastic test the paint you want to use before hand or stick to epoxy or vinyl paints.

Epoxy paints are the most durable of all paints. They come two in two parts which must be mixed. Mix equal parts of epoxy and hardener, add the colour pigment of your choice and mix. Vinyl paint can be used as it comes. Both epoxy and vinyl paints may be dipped or brushed.

LEAD HEAD PREPARATION

If the heads have just been molded no further cleaning is required if you are careful not to handle them with your hands. If they must be cleaned simply soak them in regular vinegar for a few minutes. Let them dry fully before painting.

Apply the paint by dipping the head in the paint or brush on the paint with a small hobby brush.

For a more resistant finish, clear coat the paint with Real Pro's epoxy top coat.