

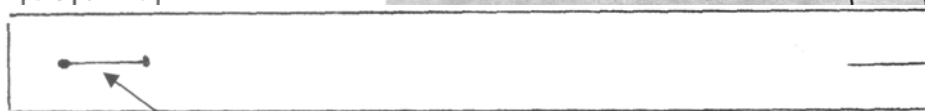
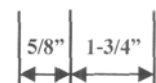
# New Jersey Blacksmiths Newsletter

## Blacksmith Double Calipers

By Steve Anderson,  
a MABA member

**Handle:**

**Stock-** 1/8" x 1" x 20"

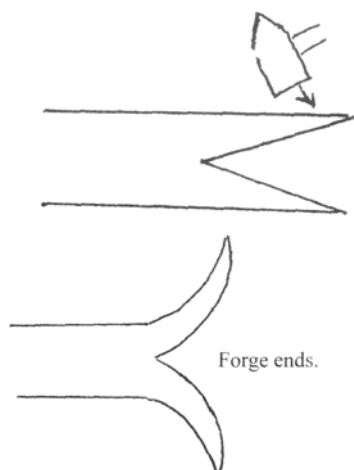


Slit eye.

Saw or hot cut.

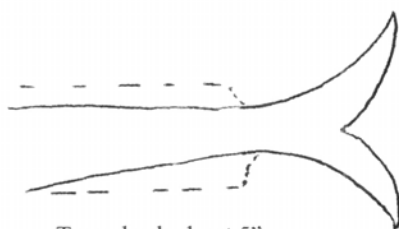
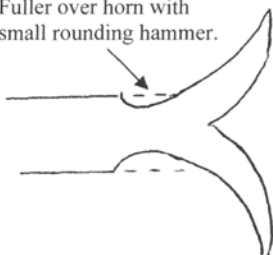
Bend one side up and  
one side down, then  
forge short tapers.

Hammer on the outside  
of the split only.



Forge ends.

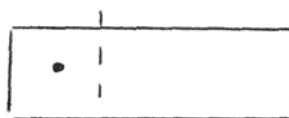
Fuller over horn with  
small rounding hammer.



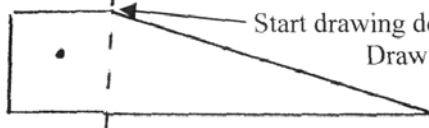
Taper back about 5"

**Claws:**

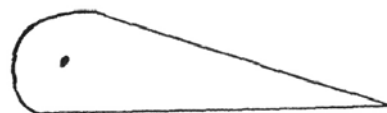
**Stock-** 2 pieces, 1/8" x 1" x 6-3/8"



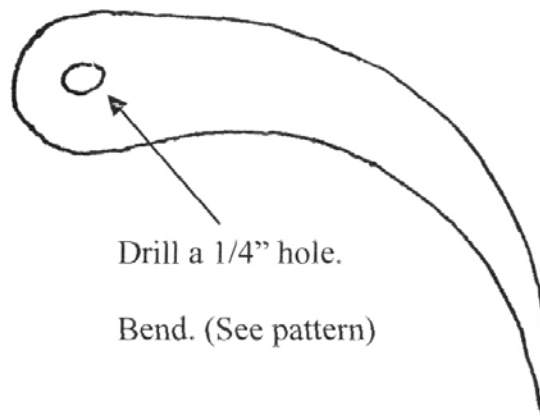
Center punch the center  
of the 1" x 1" square.



Start drawing down here.  
Draw out to 8-3/4".



Round the end.



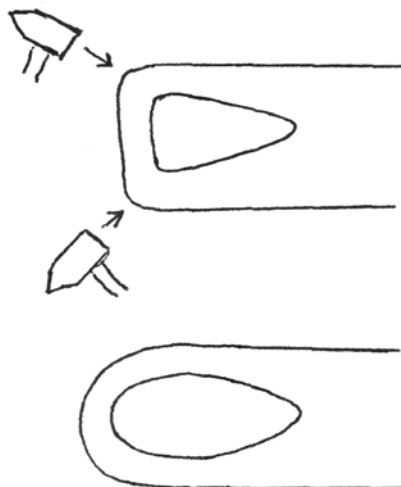
Drill a 1/4" hole.

Bend. (See pattern)

# New Jersey Blacksmiths Newsletter

## Eye:

Spread the eye and forge it open over the end of the horn, hitting only on the corners.



## Washers:

**Stock- 2 pieces 1/8" x 1" x 1"**

Trace the washers onto the stock. Drill a 1/4" hole in the center of each. Rough cut and grind to the approximate shape. Place a washer on a 1/4" bolt and secure with a lock washer and nut. Chuck in a drill and turn against a running belt sander to round and bevel the outer edge of each.

Counter sink one to accommodate a 1/4" rivet head and then counter sink the other washer, but not as much for the rivet upset.

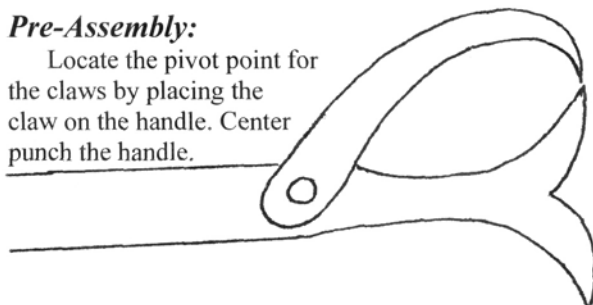
## Final Assembly:

Fuller over the horn using a small rounding hammer.

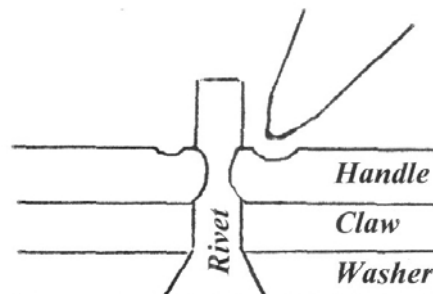
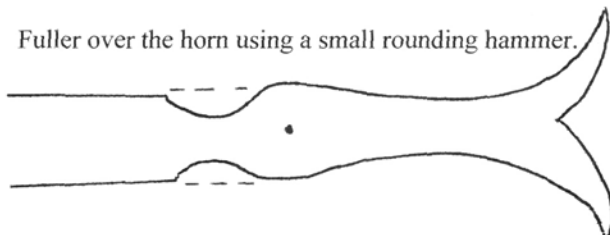


## Pre-Assembly:

Locate the pivot point for the claws by placing the claw on the handle. Center punch the handle.

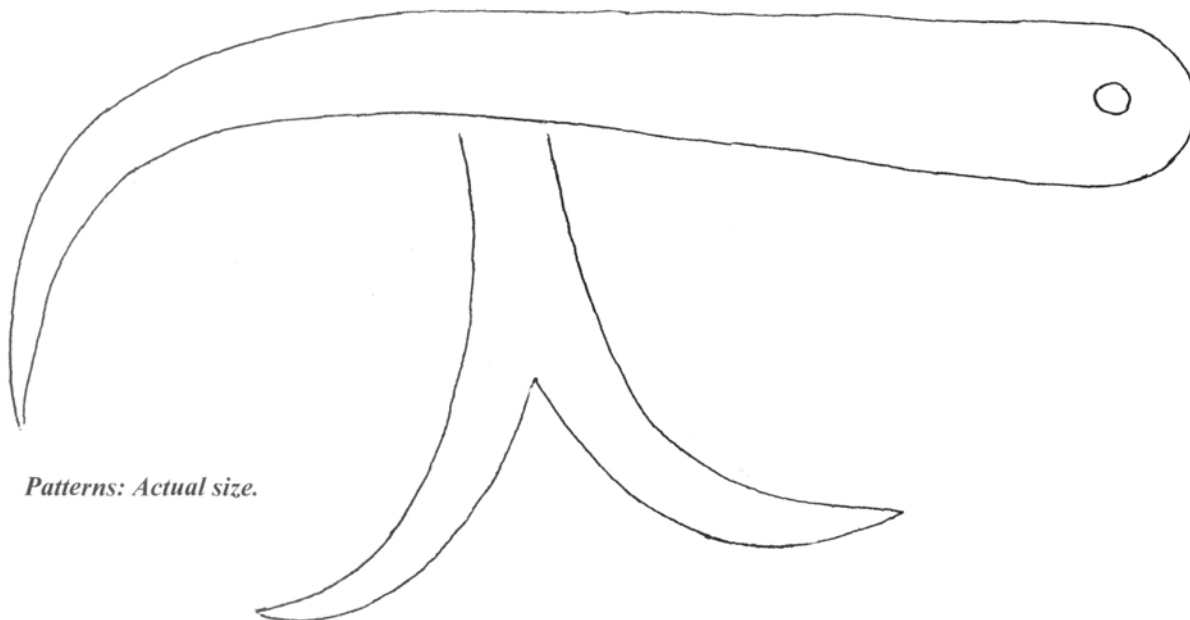


Fuller over the horn using a small rounding hammer.



- File and finish the parts.
- Place rivet in bottom washer, attach the bottom claw, then attach the handle. Mark rivet where the handle will sit.
- Dismantle and file grooves on opposite sides of the rivet at the handle position, then use a blunt center punch to force the handle material into the grooves on the rivet. (The rivet must be attached to the handle to allow the claws to move independently: this could also be welded or brazed.)
- File to remove any upset material on handle surface.
- Attach the upper claw and washer. Place index cards between surfaces then rivet (not too tightly at first).
- Adjust the contact of the claws if necessary.
- Manipulate to free the claws (note: if the holes in the claws are slightly larger they will rotate easier.)

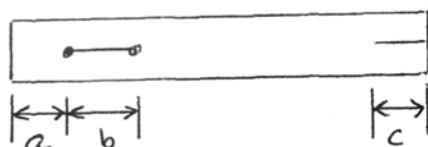
# New Jersey Blacksmiths Newsletter



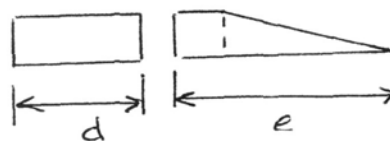
*Patterns: Actual size.*

*Additional Sizes:*

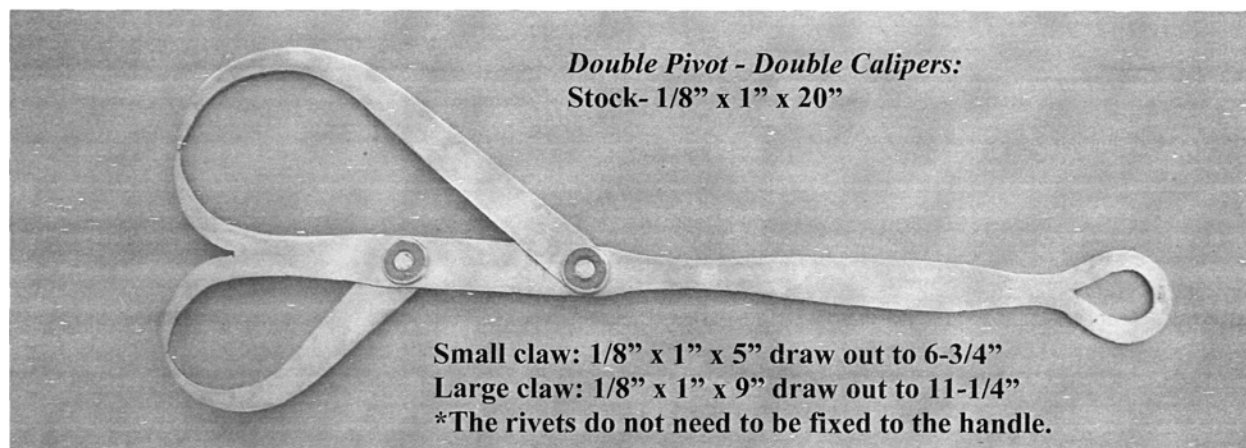
*Handle Stock*



*Claw Stock*



|                   | a    | b      | c                                  | R<br>I<br>V<br>E<br>T | d        | e       |
|-------------------|------|--------|------------------------------------|-----------------------|----------|---------|
| 1/8" x 1" x 20"   | 5/8" | 1-3/4" | 1-3/4"                             | 1/4"                  | 6-3/8" → | 8-3/4"  |
| 1/8" x 3/4" x 15" | 1/2" | 1-1/4" | 1-5/16"                            | 1/4"                  | 4-3/4" → | 6-9/16" |
| 1/8" x 1/2" x 10" | 3/8" | 7/8"   | 7/8" ***<br>upset before splitting | 3/16"                 | 3-1/4" → | 4-3/4"  |



*Double Pivot - Double Calipers:  
Stock- 1/8" x 1" x 20"*

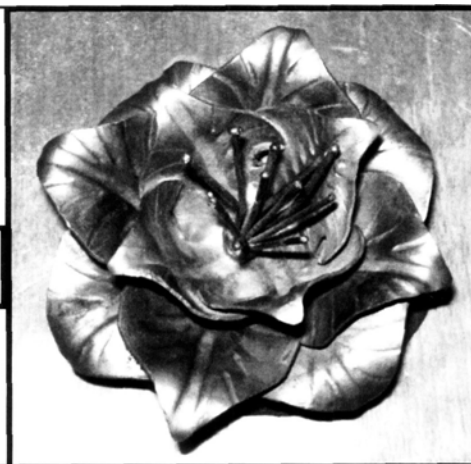
Small claw: 1/8" x 1" x 5" draw out to 6-3/4"  
Large claw: 1/8" x 1" x 9" draw out to 11-1/4"  
\*The rivets do not need to be fixed to the handle.

# New Jersey Blacksmiths Newsletter

From The Bituminous Bits, Alabama Forge Council Mar. Apr 2011

Flower pattern by Paul Rice of Elwood, IN  
(by way of Don Neuenschwander)

From the Don Neuenschwander  
collection of metal work



① LAYOUT PATTERN 4 EACH

② CUT OUT AND REMOVE BURRS

③ FULLER LINES

④ SINK IN CUP

SPLIT  
COPPER  
TUBE



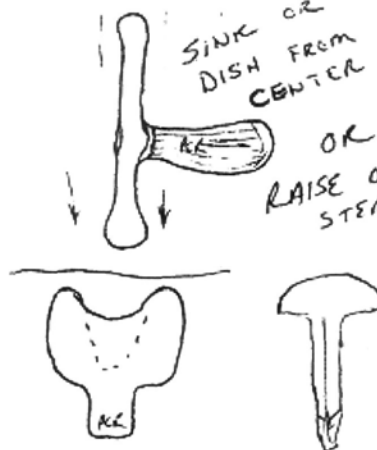
X REMOVE



FULLER  
LINES



SINK OR  
DISH FROM  
CENTER OUT  
OR  
RAISE OVER  
STEAK



MAKE (4) FOUR EACH.

(3) THREE TOP (1) ONE BOTTOM  
NEST TOGETHER



CENTER PUNCH TOP OF  
CARRIAGE BOLT. PUNCH OR  
DRILL PETALS. BOLT TOGETHER

⑤ NEST 3 TOGETHER

⑥ DRILL OR PUNCH CENTER

⑦ PLACE ON BOTTOM

⑧ FASTEN TOGETHER

← RIVET END  
OVER FLOWER  
TENNON OR ROD  
BOLT  
RIVET  
SOLDER

# New Jersey Blacksmiths Newsletter

Patented Sept. 21, 1926.

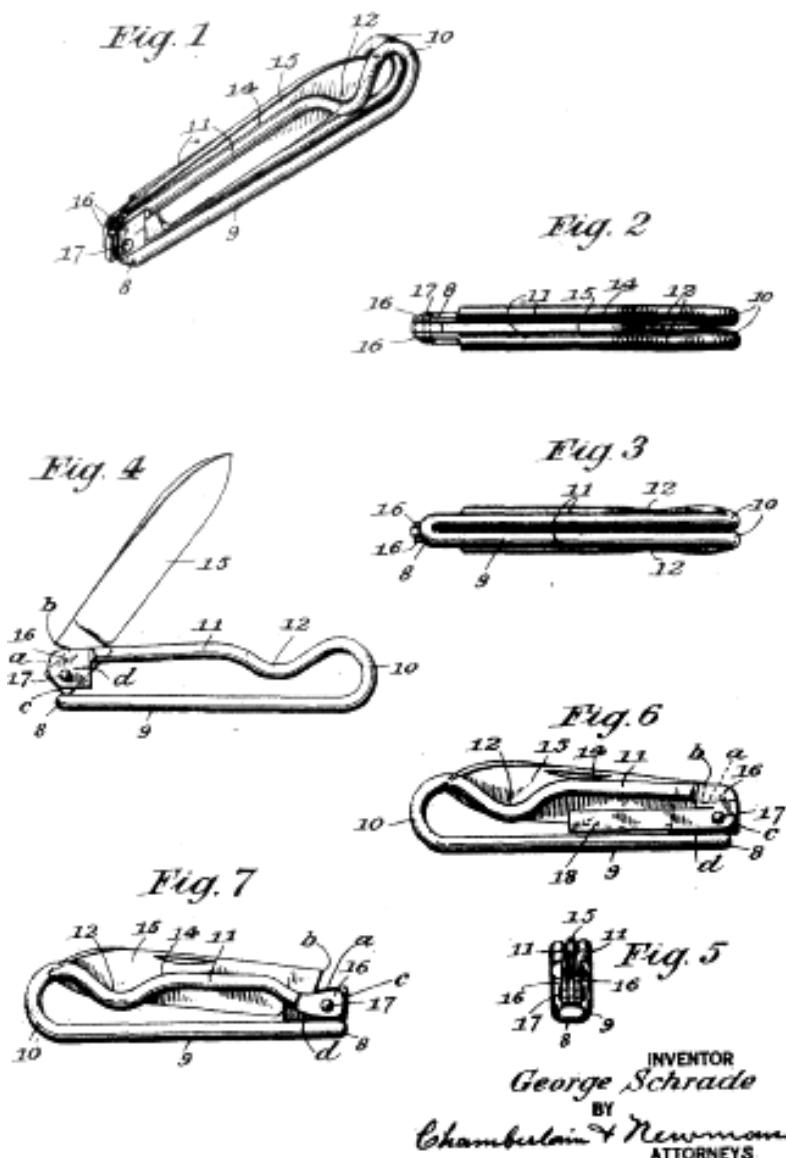
1,600,602

## UNITED STATES PATENT OFFICE.

GEORGE SCHRADER, OF BRIDGEPORT, CONNECTICUT.

POCKETKNIFE.

Application filed October 6, 1906. Serial No. 60731.



Editors Note: The entire patent can be seen on the US Patent website: [www.uspto.gov](http://www.uspto.gov) -search by patent number.

Excerpts from the patent text.

Fig. 1; shows a perspective view of my improved form of pocket knife;

Fig. 2; is an edge view of the same;

Fig. 3; is a back view as seen from the opposite side of that shown in Fig. 2

Fig. 4; shows a side view of the same knife with the blade in open position;

Fig. 5; shows an end view as seen from the near end of Fig. 1;

Fig 6; shows a side view of the knife illustrating a slight modified form of wire handle, and Fig. 7; Shows a further side view of knife including a simplified feed form of handle.

As before suggested the handle is formed throughout of a single piece of heavy wire, that is bent and shaped to form a handle.

Finding the U.S. Patent reminded me of this small pocket knife that was made by Brent Cole, a MABA member- The blade is made of L-6 (a band saw blade) and 5160 for the spring handle.

Photo and text by Steven Sporre

THE UPSETTER  
NEWSLETTER OF THE MICHIGAN  
ARTIST BLACKSMITH'S ASSOCIATION  
NOV/DEC 2008

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Website; [www.abana.org](http://www.abana.org) Email; [centraloffice@abana.org](mailto:centraloffice@abana.org)

EXPIRATION DATE \_\_\_\_\_

## **Join ABANA or Check out other area chapters!**

### **Northeast Blacksmiths Association**

Northeast Blacksmiths holds its meets  
twice a year at the Ashokan Field Campus  
in New York State.

The Ashokan campus is located in  
Olivebridge, N.Y., several miles west of  
Kingston, N.Y. The meets are held the  
first weekend in May and in the first  
weekend in October every year. The main  
demonstration is in the blacksmith shop  
and there is a "Hands On" workshop for  
beginners. A main demonstrator is  
brought in for each meet, food and bunk-  
house style lodging are provided as part of  
the cost of the weekend long meet.

**Contact : Tim Neu**

to register for hammer-ins

or subscribe to the newsletter;

Tim Neu, The Ashokan Center,

447 Beaverkill Rd.

Olivebridge, N.Y. 12461 [914]657-8333

For more info check out the web site;

<http://www.northeastblacksmiths.org/>

### **Join The Pennsylvania Blacksmiths Association!**

Name \_\_\_\_\_

Address \_\_\_\_\_

City, State, Zip code \_\_\_\_\_

Home / work Phone # \_\_\_\_\_

E-mail (optional) \_\_\_\_\_

New Member \_\_\_ Renewal \_\_\_

Do you have any particular skills (welder, accountant, carpenter,  
doctor) that may be helpful to the group or membership?

Suggestions for PABA demonstrations \_\_\_\_\_

What is your skill level?

☐ Beginner ☐ Intermediate ☐ Advanced ☐ Professional

Membership paid by \_\_\_ Cash \_\_\_ Check # \_\_\_\_\_

Send your completed application with \$ 25 ( one year dues) to;  
PABA, Jeff McComsey, Treasurer

124 W Franklin St

Strasburg, PA 17579

(make Checks payable to PABA)

### **PABA Membership Application**

Membership is from Jan. 1 — Dec. 31

**New Jersey Blacksmiths Association**  
**Attn: Larry Brown, Editor**  
**90 William Avenue**  
**Staten Island, New York 10308**



Index For NJBA  
Volume 17, #2  
09/02/12  
Meets and Reports  
Pages 1–5;  
Ad Page 6,  
Art Nouveau 7—11,  
Caliper 12 — 14,  
Rose — 15,  
Knife 16  
NJBA Renewal form  
and Ballot—back page

## **How to Join or Renew your Membership in NJBA:**

**NJBA Dues are \$20 per year.**

**NJBA Business Dues are \$40 per year**

**Please make your check out to: "NJBA"**

**Please mail checks to:**

**NJBA, P.O. Box 224, Farmingdale, NJ 07727-9998**

Please include payment with the information listed below. You will receive a postcard confirmation of your membership, and will receive a newsletter within a month.

NJBA's "year" runs from June to June. If you join mid-year, the postcard will offer a prorated dues option which will then allow you to extend your membership till the following June. The following information will be listed in a roster available to other members.

Name \_\_\_\_\_ Home Phone \_\_\_\_\_  
Address \_\_\_\_\_ Day Phone \_\_\_\_\_  
City \_\_\_\_\_  
State \_\_\_\_\_ Zip \_\_\_\_\_  
E-Mail \_\_\_\_\_ Skill Level (optional) \_\_\_\_\_  
Comments \_\_\_\_\_

## **TEAR THIS PAGE OFF!!!**

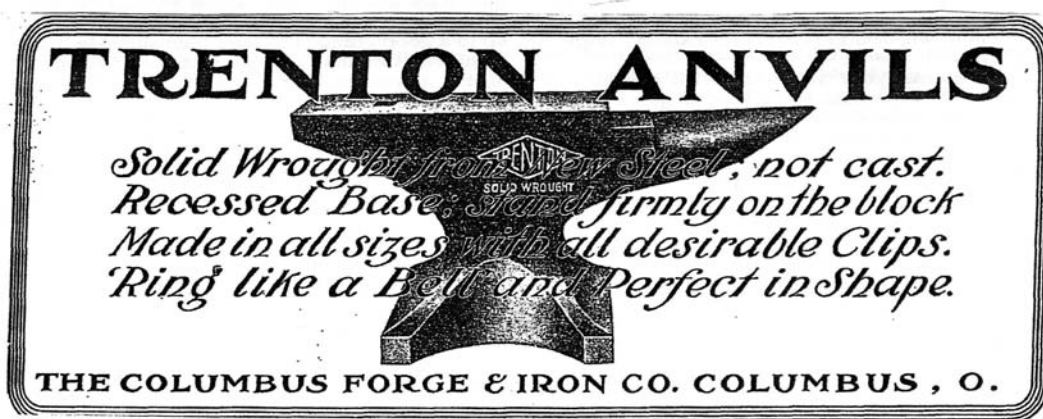
### **NJBA Board of Directors Election and Membership Renewal Page**

The NJBA bylaws were recently amended to provide for a mail-in ballot for electing NJBA directors. On the other side of this page, you will find your ballot and renewal notice. Please fill out your ballot and return it with your 2012-2013 membership dues. (Note that NJBA elections are not, nor ever have been, by secret vote. Your name is on your ballot so the board can confirm you are a member in good standing and that your vote should be counted – which you can insure by returning your ballot with your dues.) Ballots will be counted 30 days after this newsletter is mailed, so please be prompt in your response.

The NJBA Renewal and Board of Directors Ballot is on the next page. Please fill this out and send in as soon as you can.

The date of your last renewal is on the mailing label!!!

If your date is **2011** or older this is your last newsletter!!!





# NJBA Ballot and Renewal

## Renewal

Name\_\_\_\_\_

Address\_\_\_\_\_

City, State, Zip

\_\_\_\_\_

Phone Number (s)

Home\_\_\_\_\_ Cell \_\_\_\_\_

Email address \_\_\_\_\_

[ ☐ ] My check is enclosed for **\$20** (membership) or **\$40** (business membership).

## Ballot

Please check a box for each nominee.

You should vote on all nominees.

### Nominee

### Nominee

|               | For                          | Against                      |                | For                          | Against                      |
|---------------|------------------------------|------------------------------|----------------|------------------------------|------------------------------|
| Marshall      |                              |                              |                |                              |                              |
| Bienstock     | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | David Macauley | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |
| Larry Brown   | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | Tom Majewski   | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |
| Eric Cuper    | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | Mark Morrow    | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |
| Dave Ennis    | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | Dan O'Sullivan | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |
| Bruce Freeman | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | Bruce Ringier  | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |
| Bruce Hay     | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] | Eric Von Arx   | [ <input type="checkbox"/> ] | [ <input type="checkbox"/> ] |

**Send To:**

**NJBA, P.O. Box 224, Farmingdale, NJ 07727-9998**