



NEWSLETTER IN A KNUTSHELL



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Our international membership is happily involved with "Anything that goes 'cut'!"

March 2017

Farriers' "Paring" Knives

Martin Drivdahl

O.K. so they're not paring knives, but the function and use of farriers' knives is much the same as that of using a paring knife for peeling. What I knew about horse shoeing and the purpose and use of a farrier's knife could have been written in bold print

on the head of a pin; so I arranged to have coffee with a professional farrier from the Helena Valley and pick his brain for information. As I now understand it, a farrier's knife is used to clean away, and trim off, excess buildup of sole material located on each side of the v-shaped frog area and within the perimeter of the hooves of a horse's foot. Farriers' knives are not used to trim the hooves or for removing pebbles from a horse's foot. Nippers are used for hoof trimming, and a hoof pick is used for removing stones or other objects.

Farriers' knives are made with a curved blade that is sabre ground on one side only, such as a wood chisel or planer blade. The blade tip is curved around tightly to make a 180 degree bend. The purpose for this bend is to form a rounded tip that won't allow the blade tip to penetrate into the fragile parts of the horse's foot within the frog. Some of the older farriers' knives have a very narrow blade tapered to a fine tip. These are classified as "searchers" and, from what I've learned, were made to search out and lance abscesses which sometimes occur in a horse's foot beneath the tough sole layer.

The blades of farriers' knives of older manufacture are attached to handles made from one piece of antler, bone, wood, or horn by slitting the handle and installing steel pins through both side of the handle and blade tang. One manufacturer made and patented a perforated cast iron handle. Farriers' knives were made early on by some of the well established cutlery companies and by a few which were apparently more

specialized. Since horses are still very plentiful in America and elsewhere, the work of farriers is also yet in high demand and farriers' knives are still being made.

Shown in the accompanying photo are four antique farriers' knives. Knife #1 is tang stamped HELLER, with a quite detailed horse image beneath. This knife has an antler handle that is about 1" in diameter and 4-1/2" long, and the blade extends out 3-3/4". It was made by Heller Brothers Co. of Newark NJ between 1900 and 1930, during which time that company was in business. Knife #2 is blade stamped WOSTENHOLM & SON/WASHINGTON WORKS/SHEFFIELD, ENGLAND and is also stamped I*XL on the tang. This knife has a 4-1/4" dark colored



antler handle and has a 4" blade extension. According to my reference material, the WASHINGTON WORKS stamping was used from 1848 to the 1870s; but with the country of origin included, the knife may date as late as the 1890s. Knife #3 is tang stamped SHEFFIELD/ENGLAND and has a 4-1/2" handle made from a dense, dark colored horn tip which I believe could be African buffalo. It has a very narrow 3-1/2" long blade which perhaps would suggest it to have been made as a "searcher." Knives #1, #2 and #3 all have blades which vary in thickness, being thickest at the front end of the tang and decreasing in thickness into a tapered slit in the handles, also decreasing in metal thickness toward the curled tips of the blades - definitely hand forged. Knife #4 is blade stamped HARRINGTON CUTLERY CO. (in an arc)/ DEXTER/SOUTHBRIDGE, MASS. Stamping identical to this was used on pre-WWII era professional kitchen cutlery, trademarked thus by Dexter Harrington, the son of Henry Harrington. Henry was one of the first American manufacturers of cutlery and worked in his trade from 1818 to 1876. This knife has a 3-5/8" wooden handle and a short 2-3/8" blade.

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The Kukri Notebook: The Kukri Blade Itself

Ted Fitzwater

The blade may be flat-sided, hollow ground, or fluted, depending on the quality of the blade. If the blade is hollow ground, it reduces the weight without lessening the strength of the blade (Picture 1). I had talked to Wayne Goddard about this a few years back, he told me that doing a good job of hollow grinding, or fluting, a blade takes a good amount of skill on the part of the knifemaker.

In the collection I have, most of the military are flat sided, I would say ninety percent; but at least fifty percent of the native are hollow ground.

Older blades commonly have a single flute or *chirra*, as they are called in Nepal. Two flutes are less common, and three are rare (Picture 2). Now, with modern *kukris* being made in Nepal, I have seen as many as five flutes that are done by electrical hand grinders.

1) *Chirra* or Flute

The intent of the *chirra* or flute is to reduce the weight but still maintain the strength. This is the same as hollow grinding of the blade. There is also a secondary purpose which is decoration; it shows the skill of the maker.

Note: In Nepalese terms for numbers of flutes, *dui* means two and *tin* means three.

Example:

A single *chirra* or single flute



A two *chirra* because of the scallop to the edge.



Dui chirra or two flute



Tin chirra or three flute



A *tin chirra* due to the scalloped edge



2) Spine

The spine consists of the upper and

lower back side. It may be up to a half inch wide on the upper spine next to the handle on some vintage *kukris* (Picture 3). The spine angle of the blade may proceed gradually or abruptly to the point, depending on the design (Picture 4). Place your finger on the upper spine and run it down to the point; you can feel where it changes angle point. Note that in most instances this can be easily seen. The spine may be flat, rounded, or peaked, again depending on the maker (Picture 5).

When I look at a *kukri* one thing I enjoy looking for is whether it has done work or been used. You can tell this by looking at the spine rather than the edge. If it has done work, it will normally have strike marks on the lower spine; it has been used to split wood, possibly for making a fire. The spine has been struck with a hard object and made strike marks. These marks really stir my imagination. (Picture 6.)

3) *Aunlo Bal*

This is the fuller just below the upper spine. It has a religious overtone, as it may be called the sword of Shiva. It may also be more commonly called a blood groove, but for the most part it is strictly decoration and has no functional purpose (Picture 7). The fuller may be forged, engraved, or in modern times machined into the blade. You may see scrolling rather than the fuller. It is found in a variety of designs and may also have some religious meaning. (Picture 8).

4) Belly

The widest section of the cutting edge of the blade. You measure the width of the belly by measuring from the spine to the widest section of the blade.

The wide belly has somewhat fallen out of favor in modern times. You can find vintage ones with belly widths of 2-1/2" to 2-3/4". More modern ones may be 1-1/2" to 2" from spine to widest point of cutting edge (Picture 9).

5) Blade Length

I sat down with a catalog and found that the majority in the collection ran in the

11" to 13" range. The longer blades are out there but not nearly as common. In my collection the longest blade is 17-1/2". I have seen some longer blades over 20". I looked at a very large one that had been sold at the 2015 Show, but it was junk. It was big, maybe in the 25" range, but of poor quality. The larger blades have been used for animal sacrifice in Nepal. These rarely come to the collector's market. (Picture 10).

6) Styles

Some have secondary names. In this section we will look at a few that are in my collection.

Special note: there are military ones that are given official Mark designation such as Mk.1, Mk.4 and so on. But we will go over them at a later date. (Picture 11.)

The first style is called a *budhume* which I do not have in my collection. It is also called a *Big Belly*. It is one of the oldest and largest styles. If you look at Pictures 3 and 4, it is similar in appearance but has a much bigger and wider belly than either of these. I have only seen pictures, I have never held one; they are rare.

(1) *Lambendh* if my spelling is correct. At one time it was also called a *hanshee*, but this was found to be incorrect. It is identified by the handle which is long and narrow; the pommel is very minimal. The blade is usually not very wide; it may be curved as shown, to almost straight. It is very rare and very desirable.

(2) *Sirupate* - I have a number that fall into this category. I have a very good description of this style:

a) has a slender blade

b) the belly is difficult to define (not too clear as to the widest part of the blade)

c) not too strong of a curve in the spine and not too strong a curve in the blade as well. Rather straight than curved appearance

d) shoulder or spine (the point where the blade changes directions) is more to

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Two tables at the Gun Show

On March 18 - 19 the Willamette Valley Arms will hold its annual Gun Show at the Lane County Events Center. It will be located in the Performance Hall, which is the room north of the room in which the OKCA Show is held. It is a new and bigger venue for them; and, to show our support, the OKCA will have two tables. Your OKCA membership will get you in at no charge, and there will be no cost to an OKCA member to use part of the tables. Please contact us if you are interested to sell or display on the tables. So come sell or show or promote our Organization. I would like to see as many of our members show up to support this two day Show. We will have display cases in which you can place items if you like.

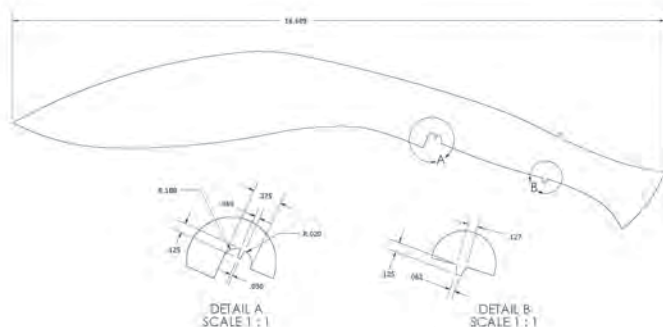
The Congress Whittler

Our 2017 offering of a Great Eastern Congress Pattern Whittler will be another one-of-a kind offering by the OKCA. I thought it was just another neat whittler, but closer inspection proved me wrong. This is one neat knife offered as per the specs of **Roy Humenick**. The knife is 3.71" closed, with a split back spring and has laser engraved artwork on the bone scale. But the thing that caught my attention was the congress pattern. How many whittlers have you seen with a congress pattern? Well, it isn't the six blade congress pattern that Lincoln had in his pocket while at the theater; but this knife will do perfectly in my accumulation of really neat knives. Just a slight few knives are left at this writing so get your application form on our website.

2018 Display Awards

Before the 2017 Show even starts we are gearing up for the display awards for 2018. Gene Martin will have blanks to hand out at the 2017 Show. The project will be the *kukri*. These are Gene's comments:

My thoughts are that this is just a great project. The kukri is a well known, battle tested and wonderful knife. It also serves as a kitchen knife in Nepal, where it is held between the feet, edge



up, and used to slice meat. There is probably as much legend to the kukri as there is to the bowie. When the English army met the Gurkha, they initially got their butts handed to them. They regrouped and did it right, but each side earned tremendous respect with the other. They joined forces and gave the world the Gurkha Regiments. And this is just a cool project.

Custom Competition at the Show

Entry of knives for custom competition will happen on Friday, April 07, at 1PM and end at 2PM. Rules for this competition can be found on our website.

The paring knifemakers...

A custom made paring knife will be awarded to the displays that have been judged Best Of Show. The makers who have volunteered to finish these blade blanks are: **John Coleman** - Citrus Heights CA - **Jose Diaz** - Ellensburg WA - **Theo Eichorn** - Grants Pass OR - **Gary Griffin** - Bend OR - **Cameron House** - Salem OR - **Jim Jordan** - Junction City OR - **David Kurt** - Molalla OR - **Gene Martin** - Williams OR - **Jeff Murrison** - North Plains OR - **Bernard Ortiz** -

Brookings OR - **Sterling Radda** - Grants Pass OR - **Jeremy Spake** - Portland OR - **Blair Todd** - Gresham OR - **Bryan Wages** - Eugene OR



Articles this month....

are from **Martin Drivdahl, Michael Faber, Ted Fitzwater, Auggie Schmirtz, Roger Worley and Little Orphan Annie**. There is some great reading this month that is truly educational. I must remind our membership that all our *Knewsletters* are available on line, and that the Google bots pick up on these articles. That makes these words available worldwide. So it isn't just this *Knewsletter*, but issues going back to April 2001 which are available for research and education.

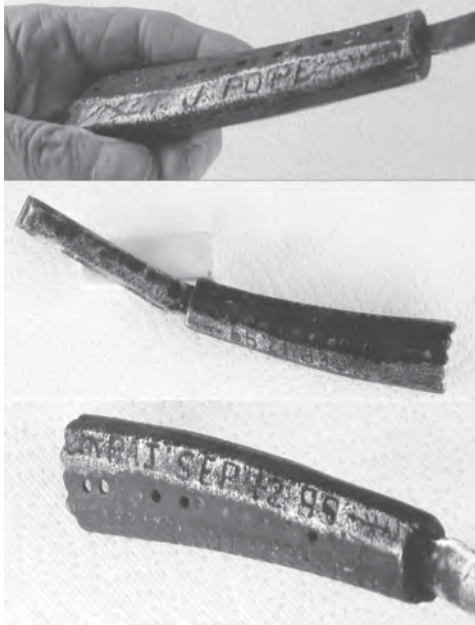
Todo's....

Get ready for the April Show - Attend the OKCA Wednesday meeting if near by - Get your paring knife blank completed - Knifemakers get that custom knife started for the competition at the 2017 Show - Make a paring knife - Make a chef knife.

The Sizzler...

Don't forget our monthly meeting at the Sizzler Restaurant. It is the third Wednesday of the month which makes it **March 15, 2017**. I always look forward to this gathering, so mark your calendar and come be with us. Come smile with us with your latest purchase. It is always nice to see my fellow knife enthusiasts that are a cut above.

Looking for a place to stay while in town for the Show? We have again arranged with the Valley River Inn to provide a reduced rate for our visitors. You might also look in to airbnb. Also if you have an RV you can camp in the Center's parking areas. See our website for more info. ↘



The accompany three-part photo shows details of a farrier's knife with a cast iron handle. The handle is 4-1/4" long, is hollow with a flattened octagonal shape tapering outward to the back end and has cast-in cross hatching. From an on-line search (done by my wife), we determined that the manufacturer and patent holder was Tjerck J. Pope, a resident of Sauquoit in the county of Onida NY (state). The patent was filed on June 24, 1899 and issued as Pat #632,846 on September 12, 1899. The patent has to do with the two-piece cast iron handle which allows for replacing the blade and adjusting the extended blade length by removing two screws which extend through the handle sides and blade tang. The patent also involves the non-slip gripping features of the handle construction.

To supplement this article, I've included a photo taken from a 1910 Keen Kutter wholesale catalog showing five farriers' knives that were then offered. The top knife is Keen Kutter's own #K10 equipped with a bone handle and a 5/8" wide crucible steel blade. The next two down shown, #7834 and 7834/s, were made by Wostenholm and are also fitted with bone handles. The bottom two knives are Pope's knives with detachable, pierced cast-iron handles. Note that the very narrow bladed versions of these examples are termed "searchers." The wholesale price shown for these knives is \$6.50

or \$7.00 per dozen, equating to a price of \$.54 or \$.58 each; so they probably retailed at that time for somewhat under \$1.00 per knife.

In contrast, a handmade farrier's knife currently in very high demand is being produced by Frank Ringel of Florence, Montana, and retails for around \$100.00. One of these knives is shown in the accompanying photo. It is fitted with beautifully



contoured and perfectly fitted hardwood handles that are attached to a full length blade tang with four pins. The blade is hand forged and heat treated. Note that the proportions of this farrier's knife are quite different than seen in the examples of older knives. This knife configuration, having a longer handle and much shorter blade, is apparently more suited for the tasks in which it is used, and is therefore preferred by the commercial farriers of today.

FARRIERS' KNIVES.

KEEN KUTTER*



No. K10—Solid Bone Handle; Highest Grade Crucible Steel Blade 5/8 in. Wide, Uniformly Tempered, Highly Polished. CARE-FULLY GROUND AND SHARPENED, READY FOR USE. Per Dozen, **\$6.50**



Solid Bone Handle; Extra Quality Crucible Steel Blades, Highly Tempered, Glazed Finish.

Per Dozen

No. 7834—WOSTENHOLM'S: Assorted 5/8 and 3/4 in. Blades **\$7.00**

No. 7834L—WOSTENHOLM'S: 5/8 in. Blade; LEFT HAND **7.00**



Solid Bone Handle; Extra Quality Crucible Steel Blades, Highly Tempered, Glazed Finish.

No. 7834/S—WOSTENHOLM'S SEARCHERS; 1/4 in. Wide at Point. Per Dozen, **\$7.00**
Weight per Dozen about 3 lbs.



Japanned Iron Pierced Handle; First Quality Crucible Steel Detachable Blades, Highly Tempered, Glazed Finish.

POPE'S.

Nos.			
Width. in.	1 1/2	1 5/8	1 3/4
Per Dozen.	6.50	6.50	6.50



Japanned Iron Pierced Handle; First Quality Crucible Steel Detachable Blades, Highly Tempered, Glazed Finish.

No. 3—POPE'S SEARCHERS; 3/8 in. Wide at Point. **\$7.00**
Weight per Dozen about 4 lbs.



P.W. Ostwald

Roger Worley

In 1983, OKCA member, Jerry Melton was the first that I knew to collect P.W. Ostwald - Baker OR and F. Warren - Baker OR pocketknives. Jerry collected cattle pattern and stockman knives, and most of these Oregon makers' knives were of these patterns.



Remington blades that had been removed to be replaced; and that later, during shop cleaning, they were finally thrown into the trash. After a couple of years Remington found out what they were doing and refused to sell them any more. Both men also re-bladed various brands of used knives, as they

handled the general machine work and never became involved in the cutlery business. The majority of Paul's knives were sold to ranchers and farmers in the Northwest and probably pretty much used up. Although hundreds of these knives were issued in our own area, they are relatively scarce.

In 1964, the King Ranch of Texas, at that time the largest privately owned cattle ranch in America, somehow heard about Ostwald's knives and asked to see a sample of his three bladed stockman. A sample was sent; and in due time, an order was received for four dozen knives, purchased for issue to their cowboys. For the next six years, until Paul retired, he filled annual orders for four dozen knives from King Ranch. The last group was shipped in 1970 at a price of \$60.00 a dozen. Paul Ostwald was then 90 years old.

were able to obtain them.



Frank Warren continued to be listed as a cutler until his death in 1933. Paul struggled through the depression and turned mainly to saw sharpening and general machine work. I have not been able to determine exactly when Paul began to make his own knives from scratch, but I believe it may have been right after the War. If you are familiar with Ostwald made pocketknives, they are mostly all pretty much alike. Two or three blade, with red plastic scales and brass bolsters. The fit and finish leaves much to be desired. I asked Walter what made them so popular; and he replied, "the steel and the tempering." I know that at least originally Paul used bandsaw steel for his knives. Paul had a unique tempering process that made them easy to sharpen, yet would hold a razor edge. Indeed, the pieces that I have collected are razor sharp.

And so, Paul's knifemaking career came to an end. We'll never know how many he turned out as no production records were ever kept. Walter remembered that one gentleman from California bought six knives that he put away in a safe deposit box for his children and grandchildren. He said, "He wanted them to see what a real old time craftsman turned out."

Paul's obituary in 1973 stated that "He was well known for his skill in making knives."

When I met Walter in 1993, he was in semi-retirement but went to the shop every day filling various needs for the local community. When my article about his father was published in *Knife World*, they sent me a case of copies of which I gave half to him. Over the years my own copies have melted away, so I'm down to a couple. Walter and I became good friends, exchanging letters and cards; and I always stopped in to see him on our way to the Coast. He gave me numerous pictures of the early days and also gave me several knives. When Walter passed away in 2009 at the age of 86, I made it over for his funeral. Later I was contacted by the gentleman in charge of the estate and ended up buying all the cutlery related items. ↘

In 1993 I made a trip over to Baker City to interview Walter Ostwald about the history of his father Paul. Walking into the shop was like stepping back in time. From the vintage belt driven machinery to the hard packed dirt floor, it was much the same as it had been for years. An exception was that all of the knifemaking equipment had been removed after Paul's passing in 1973. Walter had a large box of photographs, which I scanned, as well as many examples of his father's work. Walter related this story:



In 1910, Paul, at the age of 22, arrived in Baker City to visit his uncle. Having a background in sawmill work,

he found a job in this field in Sumpter, Oregon. At that same time Frank Warren was listed on the tax rolls as a cutler in Sumpter. In 1914 Warren relocated to Baker, and Ostwald worked for him as a machinist and began to learn the cutlery trade. By 1917 the Baker City directory listed both Warren and Ostwald as 'cutlers.' It would appear that in the earliest years, the cutlery of both men consisted primarily of butcher knives, cleavers and steels. Both were interested in making folding knives, but originally they both chose to re-blade factory frames with their own forgings. They struck a deal with Remington and for a short time ordered a large quantity of mostly stockman patterns from that factory. Walter said that for years there were numerous boxes of brand new

After Walter was discharged from his WWII service in the navy, he returned to Baker to join his father in the shop. A 1950 listing is "Ostwald Saw and Machine Shop (P.W. and W. A. Ostwald);" and so for the next 25 years, the two occupied the shop using much of the same equipment, but doing different work. Paul returned to primarily making knives while Walter

Internal Pin Bolsters

Michael Faber

Those of us who use straight-through pins ground flush to the surface of our bolsters may have occasionally seen the results of a pin undersized relative to the hole – an unsightly little smile that makes the pins quite obvious. Having seen such a smile on one of my own knives, I took the approach of drilling my holes undersized and reaming to dimension, then using dowel pins that were .0005" undersized – pretty good; but you can still see the pins if you look hard enough.

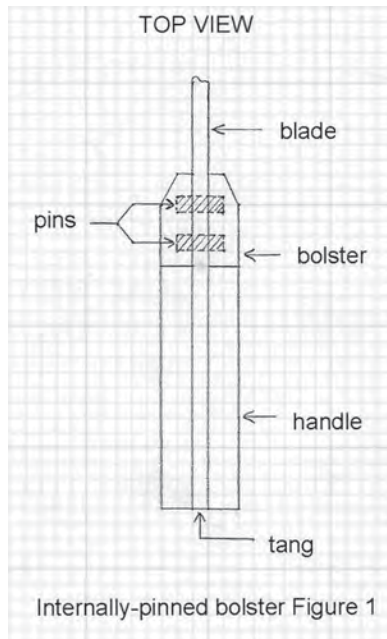
On the quest for "invisible" bolster pins, I did some reading and asked around and kept coming up with the same response: justpeen the ends of the pins; the pin will expand to completely fill the hole, rendering the pin invisible providing you've matched the pin and bolster materials. This advice came with a warning: the expansion effect may only go .010" - .020" deep below the surface of the bolster.

This presented me with a problem; my approach to assembly is to pin and epoxy bolsters and scales to the tang and grind my handle tapers after everything has set up. Most of my handles have a forward taper that means grinding off considerably more than .010" - .020" off of the bolsters in the vicinity of the pins, so the peening method wasn't going to work in an easy, straightforward manner. I thought about making the assembly with try pins and a temporary adhesive on the bolsters, grinding the tapers, then disassembling, cleaning and epoxying everything together again and doing a light finishing grind. When I envisioned peening epoxy-laden pins with clamps in the way, I lost heart.

As I was steeling myself to go through this kind of effort, I finally thought of a mechanical concept that has been around for a long time: internal pins. With internal pins, the pin holes don't go all the way through the bolsters, so there's nothing to see (Figure 1).

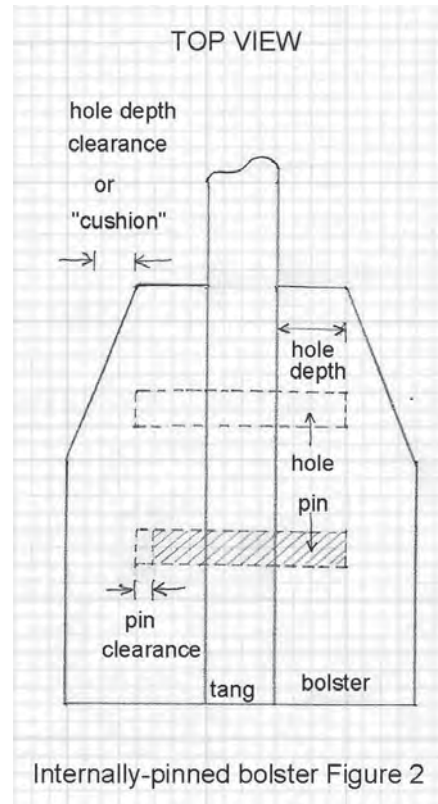
What's presented here is one approach to "invisible" bolster pins. This approach is a little bit meticulous but is oriented toward having things come together tightly and

hole (the hole will be smiling at you, but you won't be smiling back). The pins must be long enough so that when the pin is bottomed out in the hole in one bolster piece there is enough pin protruding through the tang to engage in the hole in the other bolster piece. The pins must also be shorter than the combined hole depth of both bolster pieces plus the thickness of the tang; or when you assemble everything, no matter how hard you pound or clamp, there will be a gap between the bolster and the tang because the too-long pin is acting as a stand-off (Figure 2).



cleanly and to work right the first time and every time thereafter. There are, of course, a number of things you can do differently to suit your own needs and style.

Let's look at the concepts, how to do the calculations and how to do the actual work. The key concepts that make the internal pin approach work are precise spacing between the holes, appropriate hole depth and appropriate pin length. The spacing between the holes in each bolster piece must be precisely the same and must precisely match the spacing between the holes in the tang. If they don't, things won't go together during assembly or may result in a sloppy fit. Hole depth in each bolster piece needs to be deep enough to allow for solid pin engagement, but not so deep that when you grind or sand after assembly you cut into the bottom of the



Calculating nominal target hole depths and pin lengths is pretty straightforward, but it's important to give yourself some leeway; plan your tolerances so that even when you're off at the extreme ends of your ranges, everything will still fit. Let's look at hole depth first. Go to your drawing or a finished knife you will be duplicating and measure the total thickness of both bolster pieces plus the tang. If the bolster is tapered, measure at the thinnest point at

the edge of where the hole will be. Take this total thickness, subtract the tang thickness and divide the result by 2. This will give you the minimum thickness of the bolster piece at the point where the hole will be. Now give yourself a "cushion" – I like to use .040" –and subtract that from the minimum bolster thickness. This gives you your maximum hole depth. To minimize the risk of exposing the hole from the outside of the bolster and to

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save yourself some time, don't make the hole much deeper than you have to. As long as you've got the minimum pin engagement you need, shallower is better than deeper. If you're using .125" diameter pins you don't need more than .110" engagement, and I've had as little as .060" engagement work just fine.

Calculating the nominal pin length is simple – just add together the hole depths on both bolster pieces and the tang thickness, but again you need to give yourself a cushion so the pin will never bottom out on both sides of the bolster at once. I like to give myself .005" pin clearance. Additionally, it's difficult and time-consuming to consistently grind your pins to the same exact length, so allow yourself a little tolerance. I give myself $\pm .005$ " tolerance on the pin length. So, to calculate a target pin length to grind to take the nominal pin length (tang thickness + total hole depths) and subtract the pin clearance, and then subtract the pin length tolerance. If you have a number of different designs you are going to do this for it may be worth your while to set up a simple spreadsheet to do the hole depth and pin length calculations for you. This way you only have to deal with the relationships and the math once.

With calculations out of the way, let's look at an approach to actually making holes and grinding pins. I make all the holes in the tang and the bolsters using a milling machine, which makes precise location and spacing of the holes as well as precise hole depth control very easy.

If you don't have access to a milling machine, don't despair – more on this

later. It's best to drill the tang holes, but the blind holes in the bolsters are best made using a square end mill. A square end mill will produce a hole with a flat bottom that minimizes the depth required to get adequate pin engagement. A drill bit has a point on it, which means you have to drill a deeper hole to get adequate pin engagement unless you grind the ends of your pins at an angle that exactly matches the angle on the tip of your drill bit (not impossible, but a lot more work to get it right). When using an end mill to make a blind hole, feed it very slowly – if you feed too fast you risk breaking the end mill and possibly ruining the hole. If you don't have a digital readout on your quill, use the knee to slowly feed the workpiece into the end mill –that way you'll get accurate control of the depth of your holes. Once you have made your blind holes in the bolsters, check the pin fit – many end mills come with a diameter tolerance of $+ 0, - .0005$ ", and you may need to ream the hole out to get the pin in. If you do, use a reamer that has almost no bevel on the end (you need to ream all the way to the bottom so the pin can seat all the way in). If your reamer has a point on it you can carefully grind the end square until there is only the slightest bevel left.

Once the holes are completed you can grind the pins to length. If you are only grinding a few pins, you can just put a pin in a pin vise, grind one end square and then grind a very slight bevel on the end (just enough to deburr it). Reverse the pin in the vise and keep successively grinding and checking the length until you get to your target length, then grind a tiny bevel on that end, too. If you're going

to make a lot of pins, you might find it worthwhile to make a pin gauge. I

made mine from 1/2" x 1/2" aluminum bar stock and milled holes in it to the required depth for each pin length I need. I made the holes about .003" shallower than the target pin length so I can stop just short of having the gauge face contact the grinding belt. It's a good idea to drill a tiny hole through the bottom of the pin hole in the gauge; it will let air escape when you insert a pin and allow the pin to fully seat in the bottom of the hole. You can also poke a piece of wire through the tiny hole to push the pin out once it's ground to length. Using the gauge, grind one end of the pin square, bevel it, reverse it in the gauge and grind to just short of the gauge face. Check the length to be sure it is within your tolerance and bevel the end. However you grind your pins, the final thing you need to do to them is to grind a slight flat along the entire length of the pin. During final assembly this will allow air and epoxy to escape from the holes as the pins go in and keep the pieces from flying apart again as soon as you let go of them.

If you don't have access to a milling machine, I think it should be possible to make all of your holes using a drill press. (Now it's time for the Big Disclaimer: I have not personally done this on a drill press, but it ought to work!) If you have a compound/cross-slide table for your drill press, precise location of your holes will be just as easy as on a milling machine. Or, if you have a drill press with laser crosshairs, you can probably get close enough. If you have to just eyeball things, mark and locate your holes as carefully as you can; you may need to play around with things a bit and adjust your pins and/or holes. Try the assembly; and if things don't quite go together, identify the hole that is off.

First, try rotating the flat on the pin in the misaligned hole and see if that allows the assembly to go together. If that almost-but-not-quite-works, try making the flat on the pin a little bigger. If that doesn't work, you can try

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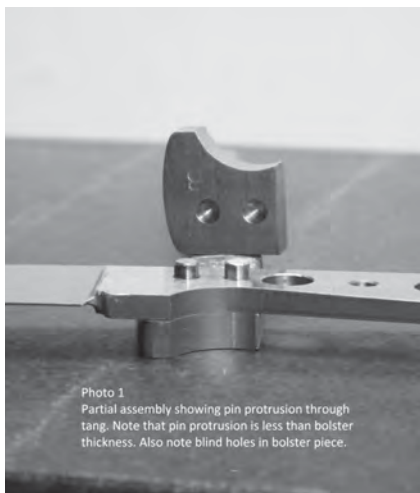


Photo 1
Partial assembly showing pin protrusion through tang. Note that pin protrusion is less than bolster thickness. Also note blind holes in bolster piece.

The Seek-Re-Tary Report

elayne

The February meeting was held at the Sizzler Restaurant on February 15, 2017. There were 36 present.

The Show is sold out. We have a waiting list. However if you are asked, encourage anyone who wants a table to forward payment. The odds are very good we will be able to provide a table with the inevitable cancellations as Showtime nears. If we are unable to provide a table, the table fee will be refunded.

This *Knewsletter* will be mailed to current members of the organization. We mailed the January and February *Knewsletters* to the 2016 members to advise them we would not take renewals of membership on Friday of the Show. You must be a 2017 member or a 2017 table-holder to attend the Show on Friday, table-holder set up and members-only day. Please locate your membership card and contact me if you need another. Your card or table-holder badge (pick up in the west lobby of the Lane Events Center) must be displayed on Friday.

I am forwarding the table-holder badge list to the printer. I need the names that are to be printed on the badges. Each table-holder is allowed two badges. If

you have not advised the name for the second badge, please advise me now. (email elayne@oregonknifeclub.org or call (541)484-5564.) You must have a table-holder badge or a membership card to gain entry on Friday of the Show.

We have two Club knives this year. The Wayne Goddard Tribute knife was a recognition of the contributions to our organization by Wayne. We have one Wayne Goddard knife available for purchase. If you have reserved a knife and have not paid for it, pay now. The guy with the money will bump the guy with no payment. The other knife is the Great Eastern Congress Pattern Whittler. There are a dozen available. We have added a few new memberships, since one must be an OKCA member to purchase the Great Eastern or the Wayne Goddard knives.

We have been receiving Silent Auction donations from companies contacted by **Brian Huegel**. Thank you, Brian, for your efforts on our behalf. Unfortunately Brian will not be attending the Show in 2017; but the donation of his time for our organization is very much appreciated. The Silent Auction is a fund raising event for our organization. It helps keeps our table fees low. Please participate by donating and bidding on the items.

We have two tables at the Willamette Valley Arms Collectors Show this

weekend, March 18-19. If you are interested to sell items on the tables, please contact us. It will be a first-come first-serve reservation. We will also have information regarding the OKCA as well as membership applications. Please promote this Show on our behalf. Your OKCA membership card allows you free entry to the WVACA Show.

Thank you for the contributions by our members to our *Knewsletter*. If you are not able to type or email your articles, write it in longhand or print it; I will type the article for you. No problem. We want to encourage all of our members to contribute with an article. The sharing of our collective knowledge is the purpose for which the Oregon Knife Collectors was founded. Also a thank you to **Lisa Wages** for her contribution to our Facebook page. If you are a Facebook member, check out our page. One of the easiest methods to reach our page is through the link on our website. Also thank you to **Bernard Levine** for his emails to our local members to remind them of the meeting date. His emails are always entertaining and informative.

See you at the Sizzler Restaurant, March 15, 2017 for our dinner meeting. Bring a show-and-tell item (but only one, please). 🐾



Internal Pin Bolsters continued from page 7

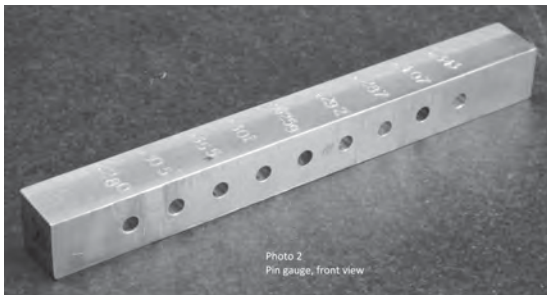


Photo 2
Pin gauge, front view

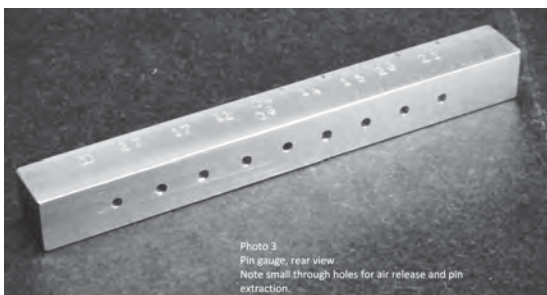


Photo 3
Pin gauge, rear view
Note small through holes for air release and pin extraction.

elongating the hole. Look carefully and mark the side of the hole that needs to be extended, and re-mill it (this does not work with a drill bit, but does work with a square end mill). Many drill press depth stops aren't very accurate, so to get your hole depth right you may need to experiment with a test piece that is exactly the same thickness as your bolster. Make an initial setting on the depth stop and mill the hole (remember to feed slowly!). Check the hole depth and keep adjusting the depth stop until you get your target hole depth. Make several holes in your test piece at the same depth stop setting and measure the depth of each. If you get different

depths, to be safe you may want to shorten your target pin length by the amount of variation you see between your test holes.

Hopefully this overall approach will be of use to you in understanding the concepts and some techniques for implementing them, and that you will be able to apply them to the extent that meets your needs for making bolsters with truly invisible pins. Remember, this is just one approach to making internally pinned bolsters. If you have alternatives or improvements, please share them with us! 🐾

the grip than to the middle of the blade. The *sirupate* is an enduring style in Nepal and still is manufactured. I would guess I have close to 20 that fall into this type; they range in age from 20 years to close to 150 years old.

(3) Longleaf or Broadleaf - The workhorse of the Nepal army around 1900. Some may weigh near three pounds and have an overall length of 19". They are bruits and very cool. This is one of 13,000 that came out of the Royal Armory of Nepal. Currently they are easy to come by. Atlanta Cutlery sells them for \$139.00 plus shipping, including sheath and two small knives. To me that is a buy.

(4) *Bhojpure* sold by Atlanta Cutlery


and others. Of the bulk that came out of the Royal Armory, almost half were of this style. The overall length is around 17". The *Bhojpure* name comes from the Bhojpure valley in Nepal. It still can be obtained from Atlanta for \$129.00 plus shipping.

Special note: Ben Judkins has written an article, *Identifying and Collecting the Nepalese Military Kukri*. It can be accessed online and is an excellent read.

(5) *Chainpure* is recognized by the handle. It has somewhat of a bulbous pommel. The ones in my collection I would classify as weapons, more than tools. They are light in construction and vary in blade styles. The handle again is the key to identification.

(6) What I have heard is this is called a sherpa's *kukri*. It is the workhorse of modern Nepal and is still being made and used. They are very close to the *sirupate* in appearance, with a rough and usually unfinished blade. Handle style will also vary, half tang and rat tail tang. Blade length in my collection are 11-3/4" to 16". The ones I have were probably made in the last 25 years. They will do the job from everyday around the house to self defense.

(7) This falls into the category of most. It has no name beyond it is just a big, old *kukri* and a very lovely one at that.

With my next paper, we will be going over accessories such as sheaths, tinder pouches and the small knives found with the *kukri*. 

PICTURES



#1) A hollow ground blade, both sides of the blade are as you see this right side. I believe I mentioned that 50% of the native ones are hollow ground, military have a much smaller percentage.



#2) (1) quality, commercially made single flute, dates to the 1940s. (2) East India Company two fluted; I think it is a presentation piece. The flutes are much deeper and narrower than any I have seen. The maker of this one,

whoever he was, was very skilled. Dates to pre 1857. (3) A working three flute, it is modern made and the flutes are somewhat shallow. It is relatively modern, maybe 25 years old.



#(3) (1) vintage Nepalese Longleaf military; spine is a 1/2" thick just 1" from the handle. (2) used as a comparison; a little under 1/4" thick and 1" from the handle



#(4) (1) and (2) show two styles with different forward taper styles. (1) World War II Mark 3 has an abrupt change in angle. (2) World War II vintage Mark 2 has gradual change in angle from the handle to the point.



#(5) Different *kukri* spine types (1) flat (2) peaked (3) slightly rounded the peaked is by far the most common spine type.



#6) Both of these *kukris* show heavy use. (1) Nepalese Longleaf dates to pre World War 1 (2) a World War II Mk.2 and the other *kukris* that are in the collection that show similar use; the strike marks are in the same area just beyond the angle changing point.

Continued on page 10



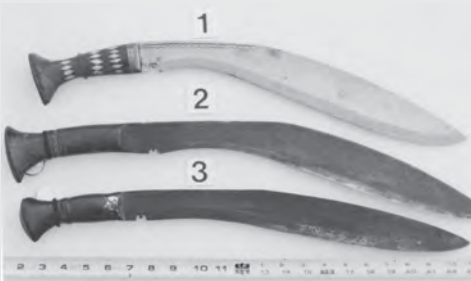
#7) (1) and (3) hand engraved fuller (1) very early (1820s) (3) much later possibly 1950s (2) Nepalese having hand forged fullers



#8) 1) and (2) have decorative scrolling rather than fullers stamped into the upper section of the blade (2) inlaid brass in at least three places on each side of the blade



#9) Darkened areas that are considered the belly and approximate area to measure the width of the belly.



#10) All three over 15" (1) is 16-3/4" (2) 17-34", the longest (3) native half tang, blade length 16-1/2" (2) similar to a ritual animal sacrificial kukri. Weight about 3#, handle a hand and a half. You can get a lot of power

on a forward swing, but there is no way of proving it. There is a old Nepalese saying, "the farther away from town the longer the blade of the kukri."



#11) Shown are the ones that I can put a name to other than just kukri.

Attending the April Show? continued from page 12

RV's are allowed to stay overnight in the Convention Center Parking Lot but see our web site for details.

Saturday will host **Demonstrations and Seminars** with different events happening all day long. There is a schedule of the times listed on the sign outside the Meeting Rooms (south end of room). Sunday there will be a **Non-Denominational Church Service** and also another forging demonstration.

Ivory???? Since this is a controversial subject left up to the judgement of our government evaluators, I would recommend that you be wary if you happen to have this material. Be comfortable with what you think the law is all about. As far as I am concerned, it is all celluloid.

And on the subject of taboos: **Automatic knives** (switch blades) are legal in Oregon,

however the law is specific about crossing borders. We stress that such devices be under direct supervision and not sold to anyone who is under the age of 18. Even to an old man who acts like a kid.

Every year we provide a **steel blank** for makers to enhance to be awarded to the best displays at the Show. **Gene Martin** has been the leader of this project. If you are interested to donate your time and art, see Gene Martin at Table **Q11** during the Show. This year will be way something different. The challenge is out there.

We have two OKCA sponsored knives that will be available on Friday afternoon. The **Wayne Goddard Tribute Knife** will be available for pick up at **Steve Huey's**

Table K06. The Great Eastern Congress pattern whittler can be picked up at the **Great Eastern Table P01**. We want to thank both of these individuals for their help in these projects.

We have patterned our culture for the knife show on Disneyland. This is to be a happy place and all the food has no calories. We do our best to make it a well organized event that can be enjoyed, an educational experience and an opportunity to make and renew

friendships. If your goal is to be a financial success, that is totally up to you. Sales 101.

Remember that a fist bump is a more sterile greeting than a handshake and just as sincere.





OKCA Free Classified Ads

Free classified ads will run up to three issues and then be dropped. Available only to paid members. Write your ad on anything you have handy (except symbolic orange crate covers) and email or snail mail to the OKCA PO Box 2091 Eugene OR 97402. The number and size of ads submitted by a single member will be accepted, or excepted, dependent on available space and the mood of the editors.

Eugene 5160 Club: A Club for knifemakers of all stripes, meeting monthly. Check out our newsletter archive to get a feel for the group: elementalforge.com/5160Club. Sign up for newsletter & meeting reminders by finding us on Facebook at "5160 Club" and click the "Newsletter Signup" tab. Non Facebook users can still find us at: facebook.com/5160Club.

Wanted: Remington scout/ utility knife with pioneer boys or highlander boys shield or heroism shield. Email jpitt306@earthlink.net or phone Jim (562)716-9857

Shelton Pacific – Some of some of the finest curly koa in the world outside of Hawaii. We will be in our usual place at table S06. There are also the ever popular "Shokwood" (hybrid) knife handle blocks and scales. Please come by to see us at the April Show.

For Sale - WHK 2004-2009 (William Henry Knives) including several auto. OKCA knives 2005-2009 (Humenick, Lone Wolf Paul, Ruple, Swauger) and misc production and custom. See Glenda Brown at the April Show. Table M01.

For Sale - **Hardcore grinder 1.5 hp variable speed 8" wheel \$1800.00. Black G10 1/4"x4' x 3' sheet \$480.00** Gary (253)307-8388

For Sale - prices negotiable. : -BADER BIII knifemaker set up, flat platters & wheels. Some belts. - C&M Topline Tumbler, Vibratory stone wash. TLV-25 with fluid system. Electro-Etch for logos. -HiTorque Mini Mill, Solid Column with Air Spring - knives@threesistersforge.com Three Sisters Forge, llc, Bend OR.

For Sale - I am retiring from knifemaking and have a lot of tools for sale. 20" Sherline bench lathe w/collets and 3 and 4 jaw chucks, plus handtools \$350.00. NC gas fired vertical melting furnace \$100.00. Commercial metal cutting vertical bandsaw w/blade welder, made by JET, like new \$750.00. H. H. Frank Newport OR (541)265-8683.

Buying Club knives for personal collections. 1998 Wayne Goddard wood beaver handle and 2010 Lonewolf Paul defender. Contact Jordan Lake (310)386-4928.

For Sale - Recon, turquoise, lapiz and coral. I will trade for knives, Damascus or parts. This material is used by D-alton Holder, Randy Lee, David Yellowhorse and many other famous makers. Perfect for scales, full handles, jewelry and wood inlay.- Elliott Glasser - Hiltary Industries - Scottsdale AZ (602)620-3999

Randall Made Knives. Buy, Sell, Trade. Also a good selection of Case knives, and many custom knives for sale or trade. Jim Schick www.nifeboy.com (209)295-5568.

For Sale - Oregon yearly Club knives, 1979 to 2012. Selling singly, 10% off current pricing. Call Fred (541)285-1894.

Looking for 1902 US Saber marked " 1st. Lt. Robert M. Porter". Please contact Don Hanham at dwhanham@gmail.com.

WANTED : Western Wildlife Series knives produced from about 1978 to 1982 (letters B, C, D, E, F). I'm missing the knives with blade etches of eagle, elk, cougar, hunting dog, antelope and bear. Call Martin at (406)422-7490.

KNIVES FOR SALE: Antique, custom & factory, pocketknives, folders, fixed blades, dirks, daggers, bowies, military, Indian, frontier, primitive & ethnic. Other collectibles also. Current colored catalog - FREE. Northwest Knives & Collectibles (503)362-9045 anytime.

SPYDERCO KNIVES wanted. Entire collections. River Valley Knives (715)557-1688

AL MAR, BENCHMADE, PACIFIC CUTLERY wanted. Entire collections. River Valley Knives (715)557-1688.

Wanted: 2012 Case XX USA medium stockman #6318 PU CV jugged bone w/ punch w/signature of Skip Lawrie. Ralph Nuno Sacramento (916)682-9305.

For Sale: Buck knives. Large consignment. List available from Larry Oden. Typically have Buck standard production, limited edition, BCCI, Buck Custom and Yellowhorse models. Email loden@dka-online.com or call (765) 244-0614 8AM-8PM EST.

For Sale: older knives. Please visit HHknives at www.allaboutpocketknives.com. Thanks for looking.

Mosaic pins and lanyard tubes by Sally. See at www.customknife.com, email at sally@customknife.com. Phone (541)846-6755.

Hot off the press - 2ND edition *The Wonder of Knifemaking* by Wayne Goddard, revised and in color! \$30.00 shipped by priority mail. Get your autographed copy now by calling Steve at (541)870-6811.

Blades and knifemaker supplies. All blades are ground by Gene Martin. I also do custom grinding. See at www.customknife.com, contact Gene at bladesmith@customknife.com or call (541)846-6755.

Useful reference books on blades. Collectible knives, custom knives and knifemaking, military knives, swords, tools, and anything else that has an edge. Email for a list. Quality Blade Books C/O Rick Wagner P O Box 41854 Eugene OR 97404 (541)688-6899. or wagner_r@pacinfo.com.

Knife Laws on-line. Federal, state, local. Bernard Levine (541)484-0294 www.knife-expert.com.

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The Newsletter

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Attending the April Show?

This is a short synopsis of what is happening at the Show. Friday is a members' and table-holders' day. We will **NOT** accept membership renewals or new memberships on Friday. Now is the time to find that membership card you put in a safe place. Table-holders will pick up their Show badges at the Show when they check in (west lobby). **Only two badges per table-holder.** Please do not ask for more. We do ask that any children under the age of 18 who accompany a table-holder have a table-holder badge or membership card to insure that they will be recognized as part of our event where "anything goes cut." You must wear your table-holder badge or your membership card to be in the Showroom on Friday. No exceptions. Your membership card also lets you in without charge the whole weekend.

Friday is a casual day; one can cover or uncover tables as they please. Set up

on Friday is **10AM** after the doors are open and no sooner. Members and table-holders will be allowed entry at that time.

During Saturday's and Sunday's public hours no covering of your tables is allowed. Saturday **8AM to 5PM** - Sunday **9AM to 3PM**. Leaving early is a death threat to your future to participate in our event. Even one minute early puts you at risk.

We were unable to secure a speaker for the Friday morning **Metallurgy Seminar** due to schedule conflicts, therefore this event will not happen this year.

Friday is the day for **Custom/handmade Knife Competition**. Rules are on our website. Entry starts at **1PM** with an one hour window to submit your knives.

Judging will commence at **2PM**. Go to the room in the south of the building. Hopefully we can announce results by **5PM**.



The **Silent Auction** will start on Friday but will gain full swing on Saturday. This is a fund raising project for our organization so please get involved with this event. **Donate** an item and bid on several.

We have renewed our relationship with the **Valley River Inn**; so if you are looking for a place to stay, we would recommend this as a consideration. Information on our website. Going to our site map on the web is an easy way to guide you to answer your questions.

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