

# The Natural Angle

VOLUME 16: ISSUE 3

## Forging a Plain Stamped Shoe

Roy Bloom, APF CJF

Roy Bloom, APF CJF provided us with an opportunity to get some good step by step shots of him forging a plain stamped shoe using 5/16"x3/4" flat stock. Notice that Roy, right-handed, works with his struck tools in line with his center-right side and is not trying to cross-over the shoe. This allows much more controlled use of the tools and allows you to strike the center of the tool in a balanced position. You are likely to get better results in the shoe and also avoid damaging your tool with off balance impact. You can see Roy talking about tool maintenance and forging in videos we have posted on our YouTube channel - [youtube.com/farrierproducts](https://www.youtube.com/farrierproducts).



*Start your toe bend working on the face or horn, making your first blow just off center.*



*Working with round side of hammer, establish first one side of bend then the other.*



*Keep stock in line and flat as you put toe in.*

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*You can eyeball it or use a Bloom t-square tool to mark your toe nail.*



*Working on face and at opposite edge of anvil, form your heels and heel check.*



*Turn branch over horn, striking the shoe just past the center of the horn to make the bend.*



*Use hammer to position forepunch to minimize heat build-up in tip. Establish your nail position and punch almost to finish depth.*

**BLOOM FORGE** **BELLOTA** **FootPro**

## The heat is on

When competition season heats up, be ready with **Bloom Forge, Bellota and FootPro™** tools for winning results.



*Work branch to clean up frog eyes.*

# **BELLOTA** **RAZOR Plus**

**LONGER LIFE – ENHANCED PERFORMANCE**



*Bellota rasp handle not included.*



Bellota is now producing the *RAZOR Plus*. Using a high grade material for the *RAZOR Plus*, it has proven in farrier testing to have a longer life. In addition, the tooth design is more aggressive and requires only a very light stroke in the early stages of using the rasp. **HERE IS WHAT PROFESSIONAL FARRIERS ARE SAYING ABOUT THEIR EXPERIENCE WITH THE NEW BELLOTA RAZOR PLUS:**

*“The RAZOR Plus is the best I’ve used in a long time. I’ve been using the Heller GR8AT and liked them when they first came out, but they are no longer any good. I only get one or two days max out of them. The RAZOR Plus lasted me a week and I shoe 8-12 horses per day with a helper.”*

*Brandon Guillot, Louisiana*

*“This is a pretty dang good rasp! I liked it very much. The file side is sharp and the rasp side is good, and didn’t scar the horses’ feet. It worked really well. When I used the second one, I found it to be just as good as the first.”*

*Eddie Williams, Kentucky*

*“I have probably worked on over 200 horses (shoeing and trims) with this Razor Plus and it is still working well as a finish rasp. Thanks for letting me test it. I will switch to the Razor Plus when I use up the Save Edge rasps I already have.”*

*George Scott, Oklahoma*

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*Forepunch to final depth, drift and pritchel.*



*After drifting and pritcheling, make your flattening run and any last adjustments to shape.*

# Choosing the Best Tools for Shoe Finish

Many farriers have power finishing equipment for shoe finishing and modifications in their daily work. The Baldor grinding units with expander wheels, attachment arms and various types of other wheels are very efficient choices for this work. However, in farrier competitions you are seldom allowed to use power equipment. You might also be at a stage in your career where power equipment available for a rig doesn't fit your budget yet, but getting a nice finish on your work is still important. FPD has developed a solid range of Bellota files and FootPro™ Sandbox tools (designed by Justin Fry) that are being used for shoe finishing as well as hoof wall finish. We've been following the competitions and see how competitors often pick up extra points for shoe and hoof wall finish. We put together some images to give you an idea what kind of "scratch" pattern each tool provides, from the coarsest to a very fine finish. You can see some of these tools in action in various Facebook clips, YouTube clips and still shots we've been posting in recent months. Each file was used for 2-3 strokes to produce the images. The shoe was at a low heat. Sandbox tools with various grits were given a number of strokes to produce an even scratch pattern.



Tools that are commonly used for hand finishing, somewhat in the order of coarse to fine. (left to right) Bellota Top Sharp Rasp, Bellota Top Finish File, Bellota 14" Pipeliner Half-Round, Bellota 14" Half-Round -Bastard Cut, Bellota 14" Half-Round-Double Cut, Bellota 12" Triangle File-Smooth Cut, Bellota 12" Round File-Smooth Cut, FootPro Sandbox Regular Flat with 80grit showing, FootPro Sandbox Half-Round with 40grit showing. FootPro Sandbox Tools designed by Justin Fry.



Using coarse side of Top Sharp



File side of Top Sharp



Top Finish file coarse side



Top Finish smooth side



Pipeliner Half-Round



14" Half-round with Bastard Cut



14" Half-round with Double Cut



12" Triangle File with Smooth Cut



Sandbox Flat with 40 grit



Sandbox Flat with 80 grit



Sandbox with 120 grit



Wire brushed shoe after all steps

We worked the inner web of a classic roller to give you some sense of Half-Round file and sandbox performance.



14" Pipeliner Half-Round



14" Half-Round with Smooth Cut



12" Round with Smooth Cut



Sandbox Half-Round with 80grit

We also ran the Sandbox with an 80grit belt on a clip.



Before Sandbox



After Sandbox run with 80grit belt

## ARE YOU USING THE RIGHT TOOL FOR THE JOB?

FILE	CUT
Bellota Halfround File	Bastard
Bellota Pipeliner File	Single Cut
Bellota Top Finish File	N/A
Bellota 6" File	Smooth
Bellota 8" File	Smooth
Bellota 12" Round File	Smooth
Bellota 12" Triangle	Smooth
Bellota 14" Flat Taper	2nd Cut
Bellota 14"HR Taper File	2nd Cut
Bellota 8" Round File	N/A

### TOOTH PATTERN [REMOVAL RATE]



Single Cut  
Gradual

Light removal and sharpening



Double Cut  
Moderate

Faster removal than single cut



Rasp Cut  
Rapid

Rapid shaping of soft materials

### COARSENESS [SPACING OF TEETH]



Bastard Cut  
Coarse

General purpose. Deburring and sharpening.



Second Cut  
Medium

Sharpening and smoothing.



Smooth Cut  
Fine

Sharpening and smoothing.

# What You See and Do Makes the Difference

*Images and comments from Dave Farley, APF CF*

It is our obligation as farriers to do as much as possible to improve the feet of the horses we work on. The images we see as we go through our daily work should help direct our choices in how we trim and fit shoes, considering all the variables such as conformation, discipline and environmental conditions. It is truly "all in the details" so be sure you are training your eye and mind to note and consider them. Shoe wear is one of our best guides to how the shoeing job is working for the horse. You also have to ask how the horse is going and understand the conditions the horse is in.

*We want to get your feedback and comments on these images - email us at [footpro@farrierproducts.com](mailto:footpro@farrierproducts.com).*



These are four shoes off the same horse. The shoes fit to the trim when applied. Question is, are there improvements that should be made? This horse is on a 4 week schedule.



The left hind shoe indicates wear and load is more on the medial side of the shoe. Trim issue?



## Designed for Versatility

**These generic pattern styles are easily shaped to fit the front or hind foot and are an excellent choice for various modifications.**



Unclipped  
Sizes 00 - 3

**DURA PLAIN**



**STANDARD RIM**

Unclipped  
Sizes 0 - 2



Unclipped  
Sizes 00 - 3

**STANDARD EXTRA**



Introducing the new Liberty Cu Hybrid. Combining the best features of the most popular horseshoe nails, by Liberty - this nail is a great option for those using Mustad Concave nails.

Liberty Cu Hybrid available in size

# THE NATURAL ANGLE



Left front shoe. Notice the wear is at and perhaps over the outer edge of the shoe from the clips back. Did the fit need to be this tight for the environment and use of the horse?



Load and wear again appears to indicate a tight fit. What conditions justify this fit?



Front shoes showing the wear in the heel area. Even with the lateral modification the heel is sitting to the outside of the web.



The hind shoe shows a breakover wear pattern that is clear to see. If you try to move the breakover to center, will you be helping this horse? The toe wear is one of the most important details to notice.



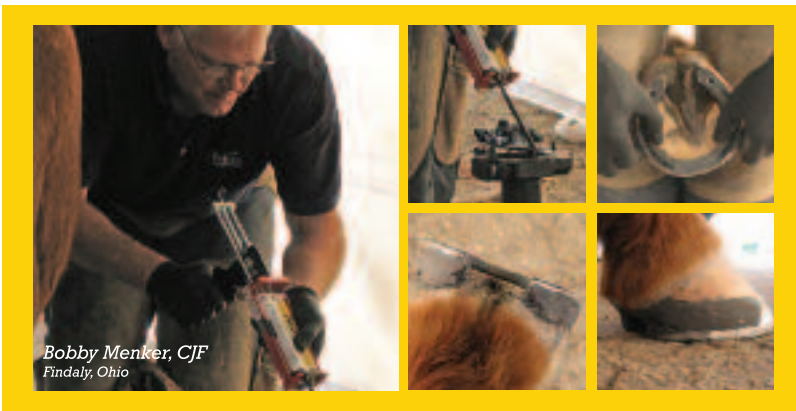
A new DF Select hind shoe placed and slightly beveled to help with direction of breakover.



The right hind fit will give the lateral support I'm looking for, keeping the heel in the center of the web.



This left hind shoe allows room for the foot to expand without going over the shoe. The additional length of the DF Select will provide support as the foot grows forward.



Bobby Menker, CJF  
Findaly, Ohio

THE NATURAL ANGLE is published to provide you with new and useful information about the industry. It is published through a cooperative effort of Vector and Liberty Horseshoe Nails, Bloom Forge, FPD, Kerckhaert Shoes, Vettec, Bellota, Mercury and your supplier.

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"I've used Vettec's Adhere product for gluing on shoes for years with great success."



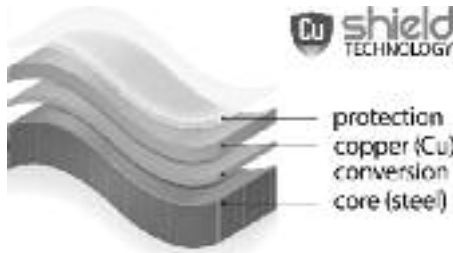
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# Liberty Cu Horseshoe Nails with Copper (Cu) Shield Technology



In addition to all of the same great features of the regular Liberty nail Liberty Cu horseshoe nails include Copper (Cu) Shield Technology. This technology provides much more protection than traditional horseshoe nails. Hoof wall, white line and sole are stronger and healthier when Liberty Cu nails are used on a daily basis. The Copper (Cu) Shield Technology is unique to Kerckhaert and Liberty Cu horseshoe nails. *Ask us about the full line of Liberty Cu Nails: 5 City, 5 Slim, 5 Combo Slim, E-2 Slim through E-7 Slim, LX-50, LX-55, LX-60, LX-65, LX-70 and new Hybrid 3, Hybrid 4 and Hybrid 5.*



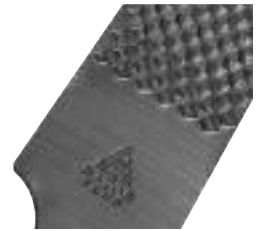
# Kerckhaert SX-8 Horseshoes – Unclipped and Clipped

The Kerckhaert SX-8 horseshoe was designed to meet demand for shoes punched for City head nails. The SX-8 is a 5/16" thick shoe with graduated widths. These shoes are popular for trail, jumping, dressage and ranch work. The clipped version of the SX-8 provides a strong clip from top to bottom; quarter clip fronts, side clips behind. Because the clip is not drawn from the web of the shoe, the integrity of the nail holes and shoe strength is protected. Toe area is slightly wider to provide strength and wear. Punched for 5 City, 5 Slim or 5 Combo. The Kerckhaert SX-8 horseshoes are symmetrical and have sole relief on fronts.



# Bellota RAZOR Plus Rasp

Using a higher grade material for the Bellota RAZOR Plus, this rasp has proven in farrier testing to have a longer life. In addition, the tooth design is more aggressive and requires only a very light stroke in the early stages of use.



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