

# NEWS FOR FARRIERS

## Kerckhaert Aluminum Century Support in Size 4 Now Available

The Kerckhaert Aluminum Century Support shoe is now available in a size 4. The additional width in the heels of the Century Support size 4 has been requested by farriers that are using aluminum for bigger footed warmblood type horses. Available in a front shape with quarter clips only.



## New Items from FootPro™

**The FootPro™ Tool Roll** features 4 knife pockets in addition to the pockets for files and rasps, perfect for organization on the go.



**The FootPro™ Welders Apron** is made with light leather and has two chest pockets. This is ideal for crafters and where welding or grinding processes are common.



## JUST A REMINDER

### Bloom Forge Signature Series Hammers

The full range of Bloom Forge Signature Series

Hammers and are now available. This new tool range includes rounding hammers in 1.75, 2, 2.5 and 3 lb. weights; a 2 lb. Cross Pein; a 2 lb. Clipping Hammer; and a 20 degree angled 2 lb. Cross Pein in a right and left hand option. Farriers and competitors will find hammer head design and change in handle beneficial. All hammers are made in Wisconsin.



## Kerckhaert Heavy Full Swedges

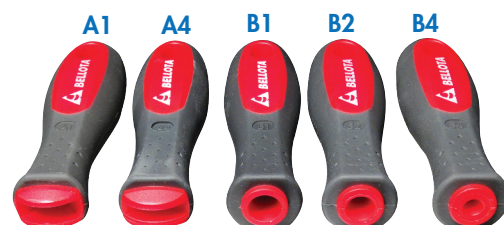
Kerckhaert has produced two sizes (3 & 4) of Heavy Full Swedges to expand the Standardbred racing line. It is slightly wider and thicker than the regular Full Swedge and is available unclipped only. Kerckhaert has become the primary brand in the Standardbred Racing market. Ask your FPD Dealer about these new shoes.



## Bellota Ergonomic Handles

Bellota now offers a full line of ergonomic file handles, best fit for Bellota files.

A1 fits 14" Files and Rasps. The B1 fits the 12" Triangle file, B2 fits the 12" Round file and 6" Flat File. The B4 fits the 8" Round (chainsaw) file and the A4 fits the 8" Flat File.



# The Tool Corner

## PROPER USE OF THE FOREPUNCH

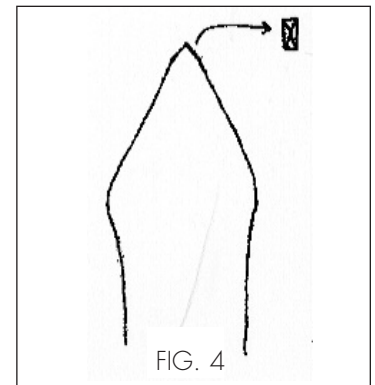
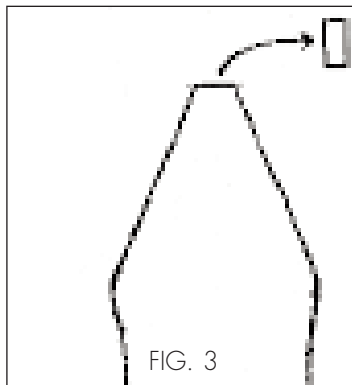
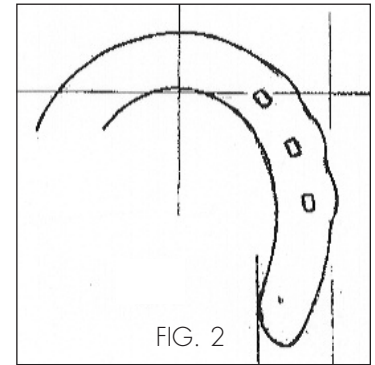
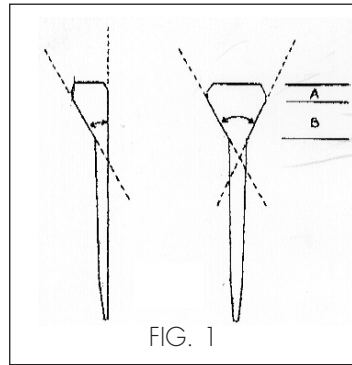
BY ROY BLOOM

THE FOREPUNCH IS USED TO CREATE AN IMPRESSION OF THE NAIL HEAD. THERE ARE FOUR QUESTIONS THAT SHOULD BE DISCUSSED BEFORE USING THE FOREPUNCH.

**1. What size nail are you using?** The common nail heads are city, regular or e-head (European). In Figure 1 the dotted lines show nail head angles; front and side. These angles are the same for all sizes of city head nails. Likewise, the angles of a regular head are the same for all sizes and the angles of the e-head are the same for all sizes. The length of the head, labeled B, is the variable for each size. The important thing to remember is your punch end must match the two angles of the nail you are punching for.

**2. What size stock are you punching?** The nail size used is directly related to the stock size. A 6 city or regular would not be used in 1/4 inch stock. You would be more likely to use a 4-1/2 city or 5 race. The most common stock size used in manufactured or hand-made shoes is 5/16 x 3/4. The most common nail would be the 5 City. I'll use these common sizes for this discussion. In Figure 1, area A is the portion of the nail that will be projecting above the ground surface of the shoe. Area B is the focus of our attention. This is the area the punch is used for. It is also the area with the trademark on it. The length of this area on a 5 City is 3/16 of an inch. That is the maximum depth the punch should penetrate to create an impression for this nail.

**3. What happens to the material when we drive the punch into it?** The punch does not remove material, it displaces it. This material must go somewhere, hence, "frog eyes." If every hole is punched exactly in the center of the stock there will be minimal distortion. However, most shoes are punched to the outside of center. The closer to the edge, the bigger the frog eye (Figure 2). The displacement always takes the path of least resistance. Figure 2 shows the toe nail, punched



more to the center, has less distortion than the heel nail. There is also a change in the thickness of the shoe between the hole and the edge. It is now thinner. If you simply grind off the frog eyes the thinned area still remains. When you tap the frog eye back the nail hole is distorted and you have to re-punch. If the initial punching produced an impression the size of the nail head then you will find the impression is too big for the nail after addressing the frog eyes and re-punching. The tapping in of the frog eyes actually draws the hole longer. Therefore, it is important to only penetrate about 2/3 of the desired depth with the initial punch run, address the frog eyes and then reopen to finish size.

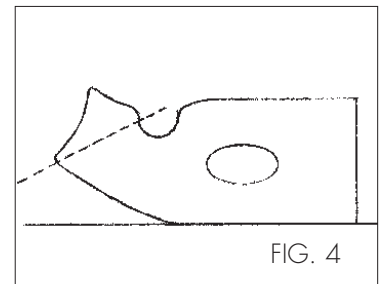
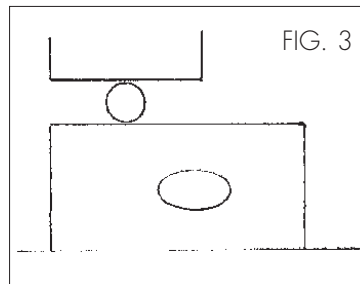
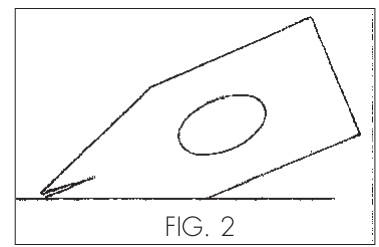
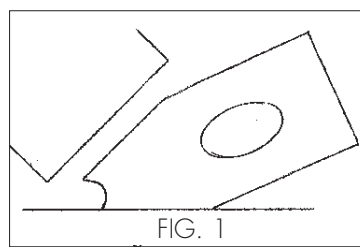
**4. What type of tip should your forepunch have?** The forepunch should have a sharp, diamond shape tip on it for two reasons:

a. Suppose your punch tip is flat (Figure 3). The steel comes out to be punched at a yellow heat. The surface is slippery from this heat. When you place the punch on the hot steel and raise your hammer the punch will often slip. After the hammer makes contact and you see where the hole is punched you can't understand why your nail holes are out of place! A flat end on your forepunch will cause this every time. By putting a sharp point on the end (Figure 4) you can stick it into the stock with no movement.

b. When the punch end is flat you create a resistance area. The tip is a lot smaller than the stock and the stock is hot. **Resistance + Small Dimension + Heat = Upsetting.** The longer you dwell in the material, the hotter the tip gets and the more danger you have of upsetting the end of your forepunch. You may have started with a city head punch but ended with a regular head. The sharp tip allows the punch to enter, displace the material and exit with the least amount of resistance.

#### To Recap:

1. The end of your forepunch should match the angles of the nail style you are punching for.
2. The nail size should work for the stock size.
3. The punch should be driven in 2/3 of the way, frog eyes addressed and then the final punching done to finish the hole.
4. The tip of the forepunch should be sharpened (with a diamond shape).



#### FARRIER'S QUESTIONS

"Why the cut out below the handle eye?" Tim isn't alone when he asks this. I've been asked this same question at every clinic. The answer simply is, the cut or notch appears during the forging of the creaser.

Let me try to explain this. I'll refer to figure 1. When an attempt is made to forge the taper of the creaser, the result is a cup or pocket at the end of the piece. If the forging continues, it will result in a fold and a cold-shut or crack (figure 2) rendering the point useless. It is nearly impossible to forge this large a piece without this result. There is an easier way which requires less work with better results. This is where the notch comes in.

If a round is placed just off the eye and forced into the material (figure 3) the bottom edge lifts and becomes the point (figure 4). The only thing left to do is cut off the excess as the dotted line shows in figure 4.

So, the notch accomplishes two things; an easier more accurate method of producing the working edge and a tool with a little something extra to catch the eye.

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