

CONTENTS

CHAPTER I

GENERAL PROPERTIES OF IRON.....	1
Early use of iron, 1. Sources of iron, 2. Other elements present with iron, 2. Wrought iron, 3. Production, puddling, 4. The puddling furnace, 6. Calculating weights of iron, 8.	

CHAPTER II

THE FORGE.....	11
The forge, 11. Forge tools, 14. The blower, 14. Fuels, 15. The building and care of the fire, 16.	

CHAPTER III

THE BLACKSMITH'S TOOLS.....	18
The anvil, 18. The hand hammer, 20. The sledge hammer, 21. Tongs, 21. Top and bottom fuller, 23. Top and bottom swage, 24. The set hammer, 24. The flatter, 24. Blacksmith punch, 25. The heading tool, 25. Swage block, 26. Measuring and marking tools, 27. The hardie, 28. Chisels, 29. Mandrels, 30. The vise, 31.	

CHAPTER IV

PRACTICE EXERCISES.....	33
General directions, 33.	
<i>Exercise 1.</i> Hammer wedges, 34.	
<i>Exercise 2.</i> Drawing and forming iron, 35.	
<i>Exercise 3.</i> Meat hook, 37.	
<i>Exercise 4.</i> S Hook, 39.	
<i>Exercise 5.</i> Staples, 40.	
<i>Exercise 6.</i> Forging nails, 43.	
Straightening iron, 45. Twisting square and flat iron, 47.	
Twisting iron when hot, 48. Straightening twisted stock, 50.	

CHAPTER V

UPSETTING, OFFSETTING, SHOULDERING, DRAWING, FORMING, AND BENDING.....	52
Hammer blows, 52. Forging operations, 55. Calculating the required length of stock, 56.	
<i>Exercise 7.</i> Gate hook, 58.	
<i>Exercise 8.</i> Hexagonal head bolt, 62.	
<i>Exercise 9.</i> Bending circular curves, 66.	
<i>Exercise 10.</i> Bending a square-cornered angle, 66.	

CHAPTER VI

WELDING.....	75
Definition, 75. Conditions necessary, 75. Welding fluxes, 76. The lap weld, 77. Angle and T weld, 81. The cleft or fork weld, 83. The split weld, 83. The fagot, lump, or pile weld, 84. The jump weld, 85. The butt weld, 87. Welding steel plates to iron, 88. Welding angle iron, 89. Welding with gas flames, 90. Electric welding, 91. Weld- ing by the thermit process, 92.	

CHAPTER VII

FORGING EXERCISES.....	95
<i>Exercise 11.</i> Forged bolt with welded head, 95.	
<i>Exercise 12.</i> Beam anchor, 97.	
<i>Exercise 13.</i> Dogs, 99.	
<i>Exercise 14.</i> Welded flat ring or washer, 100.	
<i>Exercise 15.</i> Flat ring, 102.	
<i>Exercise 16.</i> Flat band, 103.	
<i>Exercise 17.</i> Links of chain, 103.	
<i>Exercise 18.</i> Soldering iron, 106.	
<i>Exercise 19.</i> Straight, square-point soldering iron, 108.	
<i>Exercise 20.</i> Spanner wrench, 109.	
<i>Exercise 21.</i> Chain hook, 114.	
<i>Exercise 22.</i> Chain hook with swivel, 116.	
<i>Exercise 23.</i> Engineer's wrench, 118.	
<i>Exercise 24.</i> Blacksmith's tongs, 120.	

CHAPTER VIII

THE PROPERTIES OF STEEL.....	125
The Bessemer process, 125. The Bessemer converter, 127. The open-hearth process, 128. Tool steel, 129. The manufacture of crucible steel, 131. High-speed steel, 133.	

CHAPTER IX

ANNEALING, HARDENING, AND TEMPERING.....	134
Annealing, 134. Hardening, 134. Tempering, 135. Tempering furnaces, 138. Tempering a punch and die, 140. Tempering a reamer, 141. Tempering large or long tools, 142. Choosing steel for tools, 142. Tempering springs, 144. Case hardening, 144.	

CHAPTER X

TOOL MAKING.....	146
Cutting off tool steel, 146.	
<i>Exercise 25.</i> Center punch, 146.	
<i>Exercise 26.</i> Cold chisel, 148.	
<i>Exercise 27.</i> Cape chisel, 151.	
<i>Exercise 28.</i> Lathe tools, 151. Round-nose tool, 151. Cutting-off tool, 154. Side tool, 156. Diamond point, 156.	
<i>Exercise 29.</i> Boring tool, 158.	
<i>Exercise 30.</i> Hardie or cutting-off tool, 160.	
<i>Exercise 31.</i> Blacksmith punch, 161.	
<i>Exercise 32.</i> Set hammer, 164.	
<i>Exercise 33.</i> Cold chisel, 165.	
<i>Exercise 34.</i> Hot chisel, 165.	
<i>Exercise 35.</i> Riveting hammer, 166.	

CHAPTER XI

ADVANCED FORGING.....	168
<i>Exercise 36.</i> Anvils, 170.	
Heavy forging, 170. Tools used with the power hammer, 172. Finishing allowance, 177. Shrinkage, 178.	
<i>Exercise 37.</i> Connecting rod, 178.	
<i>Exercise 38.</i> Crank shaft, 180.	
<i>Exercise 39.</i> Solid or weldless ring, 181.	
Drop Forging, 181. Bending angle iron, 182. Bending pipes, 183. Welding pipes, 184. Punching round, square and heavy stock, 185.	

CHAPTER XII

ART FORGING.....	190
<i>Exercise 40.</i> Lock plate, 190.	
<i>Exercise 41.</i> Flame ornament, 193.	
<i>Exercise 42.</i> Spirals, 195.	

- Exercise 43.* Spiral ornaments made from the solid, 199.
Form for bending stock, 200. Scrolls, 201.
- Exercise 44.* Forging a scroll, 202.
Welded scrolls, 205.
- Exercise 45.* Forging a welded scroll, 206.
Other forms of scrolls, 208. Leaf forms, 210.
- Exercise 46.* Forging laurel leaves, 211.
Flower table, 213.
- Exercise 47.* Oak leaves, 214.
The use of angle iron in making leaves, 215. Rose branches,
215.
- Exercise 48.* Forging rose branches, 216.
Flowers forged from solid, 219.
- Exercise 49.* Forging a rose from solid stock, 219.
Other forms forged from solid stock, 224. Hammered metal
work, 227.
- Exercise 50.* Making a vase, 230.
Repoussé or embossed work, 232. The acanthus leaf, 233.
Leaf hammering, 234.

APPENDIX

- Bending brass, bronze and copper pipes, 241. Punching and
marking pipes, 242. Twisting band iron, cold, 243.
Straightening sheet metal, 244. Cutting holes for dowels
and expansion bolts, 245. Drilling a square hole, 246.
Forming a tenon on flat stock, 247. Finishing, 248.
Coloring brass and bronze, 249. Cleaning the surfaces of
metals, 250. Brazing, 251. Brazing a band saw, 252.
Soft soldering, 253. Soldering cast iron, 255. Welding
compounds, 255. Welding with the oxy-acetylene torch,
255. Tack welding, 262. Heat distribution, 263. Types of
welded joints, 264. Welding rod, 265. Welding of leaves
and flowers, 265. Welding cast iron, 268. Welding aluminum,
268. Oxy-acetylene cutting, 269. The use of benzole, 270.
Hardening a scribe, 270. Special springs, 270. Making a
countersink, 271. Screw driver, 271. Angle screw drivers,
272. Tables, 273.