

# Billetts & Blades

Mark Hazen takes Best Fighter category



## Events of the 2003 SouthEastern Custom Knife Show



Tony Kelly and the Paramedics take center stage at the Awards Banquet



John Poythress wins Best Utility / Hunter



The Bowie Symposium highlights Friday's activities



Peggy Jones and sons, Phillip and Barry receive the Tommy McNabb Award



## The Official Publication of The North Carolina Custom Knifemaker's Guild

# Billets & Blades

NORTH  
CAROLINA  
CUSTOM  
KNIFEMAKER'S  
GUILD

## Guild Officers and Directors

Billets and Blades is the official publication of the North Carolina Custom Knifemaker's Guild. It is compiled and published in four issues annually with two additional special publication dates possible each year. Compiled, published, and distributed by The Knifemaker's Guild.

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The North Carolina Custom Knifemaker's Guild was formed to meet the needs of a growing body of custom knifemakers in the southeastern United States. The purpose of this newsletter is to serve as a medium of exchange for the members of the NCCKG.

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## Letter From The President

The 2003 Southeast Custom Knife is now in the history books. By most accounts, it was another successful show. There were lots of knives sold and ordered and many reservations booked for next year. There were many compliments on the hospitality suite from our table holders and I want to extend a special 'Thank You' to all of our great bakers and to the ladies who made sure that it was well organized. I also want to take this opportunity to thank those who donated our auction items and door prizes. The auction was a great success and everyone enjoyed the banquet. It is this combination of great support from our members and those that support our show that continue to make our show one of the best in the country.

Plans have already begun for next year. This will be a very special show because it will be our Tenth Anniversary Show and we are going to do all we can to make it a memorable event. I welcome any ideas and suggestions you might have, so please let me know your thoughts on this matter.

Our Guild meeting in April will be another 'Special Event'. It will be held at the Montgomery Community College. However, we have reserved a lodge by the lake that is equipped with a swimming pool, boats and lots of things to do. We will have a special cookout. *This event is open to all Guild members and non-Guild members.* So, mark your calendars for the weekend of April 24<sup>th</sup> and 25<sup>th</sup>. This should be a lot of fun and a great opportunity to be among friends.

One last, but very important item; for those of you who attended the banquet, you heard Jack detail the events that occurred in the Atlanta Airport with the U.S. Customs people regarding Nico Bernard of the South African Handle Supplies Company. Nico is a long time supporter of our Guild and a supplier to many knife makers and other craftsman. The NCKKG fully supports Nico and will have much more to say about this in the newsletter and to various officials in our government. We encourage you to keep Nico in your thoughts and to support him in his efforts to clear his name and to right the injustice that befell him in Atlanta.

## NCKKG Meeting

November 08, 2003

Home of Bill and Brenda Pate

Directions to the November 8 Meeting at 1611 Oakley Road: Castle Hayne is just north of Wilmington on US 117/133.

Entering Wilmington on I-40 East, take Exit 414 at Castle Hayne, travel US 117/133 south 5 miles to the Kangaroo Gas Station at Oakley Road, then follow the anvils.

Entering Wilmington from the north on US 17 South, turn onto Hwy. 210 at Hampstead, travel west to the intersection of I-40 (at Exit 414), travel US 117/133 south 5 miles to the Kangaroo Gas Station at Oakley Road, then follow the anvils.

Entering Wilmington from the south or west on US 74-76 East or US 17 North or 421 South travel north on US 117/133, 5 miles to the Kangaroo Gas Station at Oakley Road, then follow the anvils.

If you're approaching Wilmington from the east, dock your boat at Wrightsville Beach and call us!

### Wilmington Motels

#### College Road (at the end of I-40):

Comfort Inn	Fairfield
\$80-90	\$69-109
910-791-4841	910-392-6767

Marriott Courtyard	Holiday Inn Express
\$69-119	\$62-99
910-395-8224	910-392-3227

#### Market Street/Hwy 17 (near College Road overpass)

Comfort Suites	Fairfield
\$80-90	\$69-96
910-793-9300	910-791-8850

Ramada	Holiday Inn
910-799-1730	\$66-104
	910-392-1101

Days Inn	Hampton Inn
\$43-53	\$75-85
910-799-6300	910-395-5045

Sleep Inn	Wingate
\$60-80	\$80-90
910-313-6665	910-395-7011



### SECK Show Winners

- Best Art Knife ——— Doug Casteel
- Best Hunter ——— John Poythress
- Best Damascus Pattern ——— Shann McIntyre
- Best Miniature ——— Robert Washburn
- Best Fixed Blade ——— Ken Durham
- Best Fantasy ——— Dianna Casteel
- Best New Maker ——— Stacy Apelt
- Best Folder ——— Murray Sterling
- Best Forged Knife ——— Shann McIntyre
- Best Fighter ——— Mark Hazen
- Best Scrimshaw ——— Dusty Moulton
- Best Engraved Knife ——— Jody Muller
- Best of Show ——— Ken Durham



The judges for the SECKS had a tough job

### GEORGE HERRON awarded 2003 Folk Heritage Award

George Herron received the 2003 Folk Heritage Award. The article was in the July—September issue of "Artifacts", published by SC Arts Commission. He was also recognized by the SC legislature !!!! He is politely referred to as the "grand-daddy" of SC knifemakers and a standard bearer among knifemakers.



### The Bowie Symposium



The Bowie Symposium is always an anticipated event of the SouthEastern Custom Knife Show. This year's even was no differ-

ent. We were honored to have Dr. James Batson, Master Bladesmith and authority on early bowie knives; Mark Zalesky, Editor of Knife World; and Dr. James Lucie, an accomplished bladesmith and leading authority on the life and work of W.W. Scagel as our speakers.



Well, it finally happened Sunday, April 07, about 8:00 pm. NCKKG member, Thomas Clegg, became an official member of the Grandparent club. His claim to this position was granted with the arrival of Emma Summer Belcher. She weighted 8 lbs. 15 oz. and is 23" long. Mother and daughter are both fine and dandy; Grandpa is only a little worse for the wear after a knife show all weekend and then taking off to greet his new granddaughter. Congratulations Thomas!

On October 4 & 5, 2003, The Ocmulgee Blacksmiths Guild will sponsor the 9th Annual Terry Ellerbee Bladesmithing Hammer In, At Shadyrest Forge in Macon GA. The object of this Hammer In is to demonstrate the art of hand forging a blade to the finished knife. There is no admission for this two day event. There will also be free camping on the site. Every one is welcome. For more information contact Buster Grubbs 478-7434244 or Ed Halligan 770-251-7720.

Classified Ads found in newspapers:  
 Gas cloud clears out Taco Bell.  
 Lawyer says client not that guilty.  
 83 Toyota Hunchback \$2000.



## SouthEastern Custom Knife Show Sights



There is always more that you can actually take in at the show. Saturday was very brisk with

lots of customers and knife enthusiast coming through the door.



All of the table-holders enjoy the goodies supplied by the

Guild and also appreciate the helpfulness of the show staff with "table sitting" and taking lunch orders.



The Awards Banquet was a lot of fun. Everyone enjoyed a great meal and Tony Kelly gave us "quite the show" with his visit by the Paramedics. The auction was spirited and bidding was intense. I do believe a good time was had by all.



I'm not sure who is most tuckered out after the first day of the show, Koji Hara or Gumbo.

Gumbo is a "working" dog trained to assist his owner with balance.



Peggy Jones and her sons, Phillip and Barry, received the Tommy McNabb Award. This is given for "Outstanding Contributions to Knifemaking and our North Carolina Custom Knifemaker's Guild. With Respect, Admiration And Deepest Appreciation For Your Contributions To Our Association." Mrs. Jones is not shown above, but you can see her on the cover of this issue.



Can we take any guy seriously after spending the day sitting under a flock of pink flamingos? The ladies in the Hospitality Suite out did themselves this year!



Below is a letter I received from Chuck Staples on the classes sponsored by the Guild and Montgomery Community College. Chuck writes:

“I wanted to let you all know about the knifemaking classes at Montgomery Community College. Most of you have probably attended one before but for those who haven’t, they are well worth the time and money. You can’t beat hands-on instructions, and with the small group of students in each class, you get a lot of one-on-one help. In both of the classes I was in, Tommy McNabb was there to help out. Tommy is as qualified as anyone I know on knifemaking, be it forging or stock removal.

My first class was the forged bladesmithing class taught by Jim Batson. He was very thorough and we took a lot of notes. We were kept busy every day, making two blades each. The first was from a coil spring which was hammered into a full tang blade. The next was a Moran Fighter. Both blades were heat-treated in class. We had students in the class that had never made a knife and they did a great job on their blades. I have forged many blades but I learned new methods that are saving me time and grinding.

My second class was the Forged Tomahawk class taught by Wayne Whitley. I just may have learned more in this class than any I have attended. Wayne, in my opinion, is an outstanding knife-maker. This class was fun, maybe because it was a little different than making a knife. It was my first time forge welding and I must have been lucky because I succeeded on my first attempt. Each student made a complete hawk; from welding the head to heat-treating to finishing the handle. We also got a start on a railroad spike head to finish at home.

In both classes I made new friends, finding that several live very close to me. Saturday night the school treated us to supper at a local steak house, and we received a hat or a shirt. Some of us went back to the motel after supper and sat around talking and solving most of the world’s problems.

If you are interested in knifemaking, you should plan to attend a class. The classes help keep the art of knifemaking alive.”



Ron Newton taught a Mosaic Damascus class the past summer at the college. John and I did not attend this class but we did get the opportunity to “peek-in” on it. It was quite interesting to me to see

what is involved in making mosaic Damascus.

(This could be for the Damascus, then again it could be highly classified state secrets. )



I enjoy seeing people forge. I also enjoy seeing the cutting and grinding. I could easily be a fire bug because this holds a special beauty to me. And just in case people think forging is a man thing, just take a look at one of our newest Guild members, Stacey Holt.

Stacey is beginning her journey as a ‘metal maker’. She thoroughly enjoyed Ron’s class and getting to know other Guild members.



## Powder Mosaic Damascus

Ron Newton, Instructor

Article by Bill Bisher

Part 1

“This past August I had the privilege of taking the Powder Mosaic Damascus class under Master Bladesmith Ron Newton. The NC Knife Guild and Montgomery Community College sponsored the class. I hope to pass on some of this information to you in the article.” (Bill Bisher)

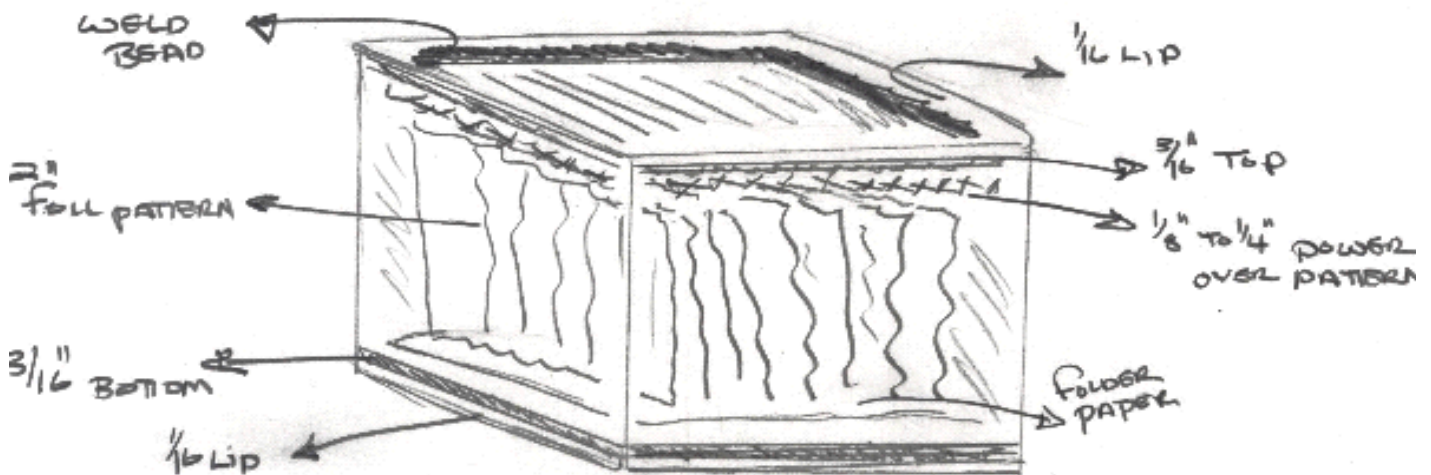
Ron started the class explaining the technique he uses and the type of material needed:

1. Powder Metals
  - 1084 high carbon steel
  - 1018 low carbon Steel
  - 4600 or 4800 nickel alloy
  - 8% pure nickel powder
2. Square Steel Tubing and Flat Stock
  - 3” squares with 3/16 thick wall
  - 3” heavy gauge exhaust pipes
  - 3/16” thick flat stock for bottoms and lips on tubing

3. Nickel Shim Stock or Sheets
  - Thickness can vary-it is your choice  
(THIS IS NOT German Silver/Nickel Silver!)  
Most knife supply houses carry pure nickel in stock.
4. Heavy Paper Stock; Folders work good  
Super glue and narrow masking tape
5. Iron Stock For Handles
6. A Good Imagination!  
Forge Welding Knowledge

A hydraulic press is real handy in forging this type of work, as it does not distort your pattern as bad as a hammer would.

The first step is to build a box from the square tubing or exhaust pipe. Ron favored the exhaust pipe because it seems not to distort the pattern as bad as the tubing under the press. The box should be about 3” - 4” long. The length has to do with the width of the nickel shim stock. If the nickel is 2” wide the box height would be 2 3/4” to 3”.



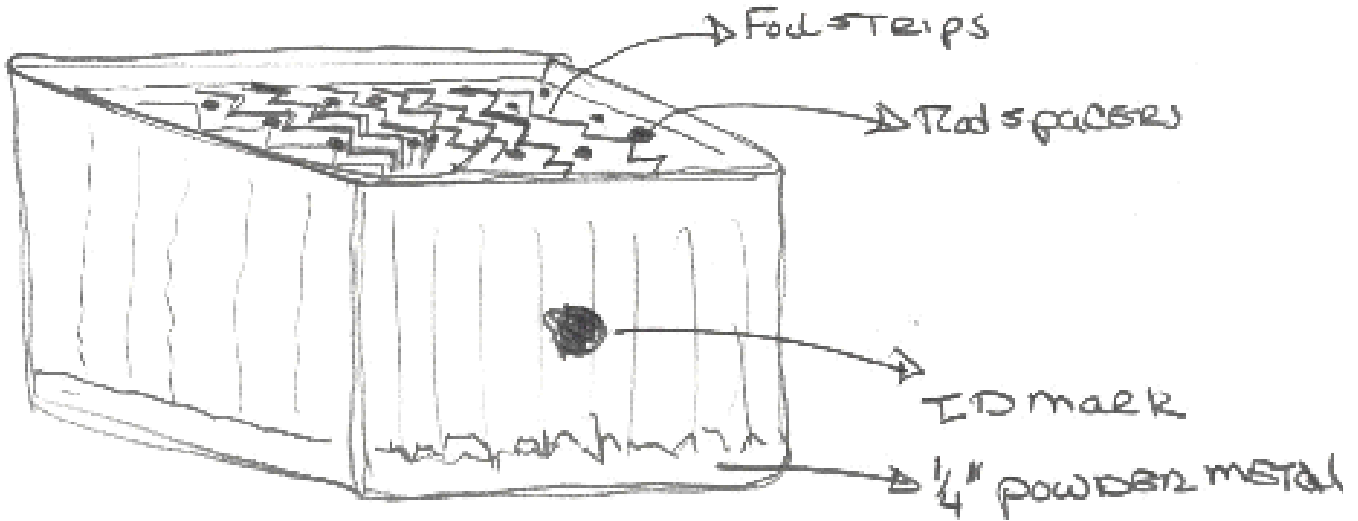
To construct the box, take the 3” tubing and cut two pieces of flat stock to fit snugly in each end of the box. The better the fit—the better the seal. Recess the bottom about 1/16” and weld in place. Set to the side to cool. (Make sure there are no holes in the weld) As the box is cooling the pattern can be made.

Ron started with a “W” pattern. He had purchased a crimping iron with a “W” shaped heating surface from a beauty supply shop. By placing the nickel foil in the iron and pressing it together, he was able to form sheets of “W’s”.

**Note:** Cut the foil into pieces so when formed into W’s, they will fit into the box and match up.



Welding rods can be used as spacers between each piece of foil. It is best to place about 1/4" of powder (1084) in the bottom of the box to help hold the foil in place. Place foil strip / rod spacer / foil strip / rod / etc.....After all the pattern strips and spacers are in place—pour in powder metal (1084) to about 1/4" above the pattern



Tap sides of box lightly to settle the powder. There should be enough room left to place the 3/16" lid and have a 1/16" lip for welding.

**Note:** Before putting on lid mark the box to identify direction of pattern

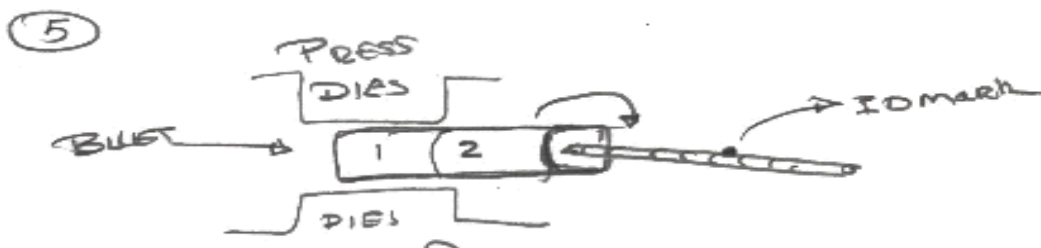


Weld lid in place. Weld on handle to bottom and make ID mark on handle to match box.

Now it is time to forge weld.

Place the box into the gas forge and bring up to welding heat. Be sure to flux (Borax) as box starts to get red. Once up to welding heat, flux again and let set for a minute or two in forge to ensure you have a good soaking heat.

Put in press and do two light presses on each side and place back into forge and bring back up to welding heat—flux—and repeat the same pressing process.

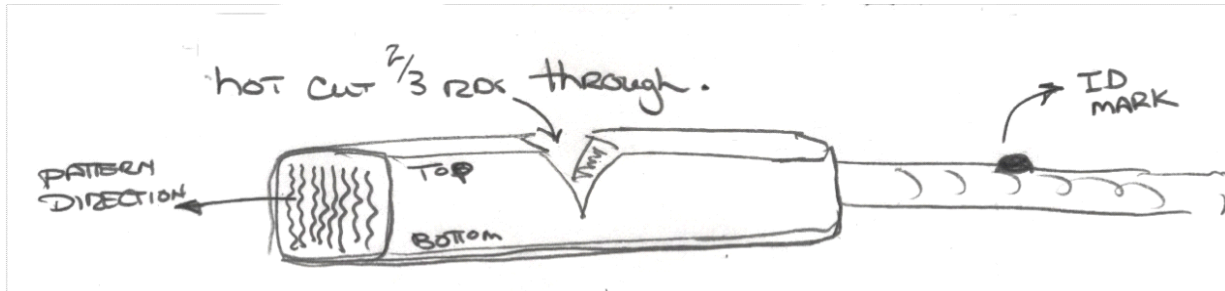


For the first two or three heats, press box lightly so not to distort pattern. When billet feels firm, you can

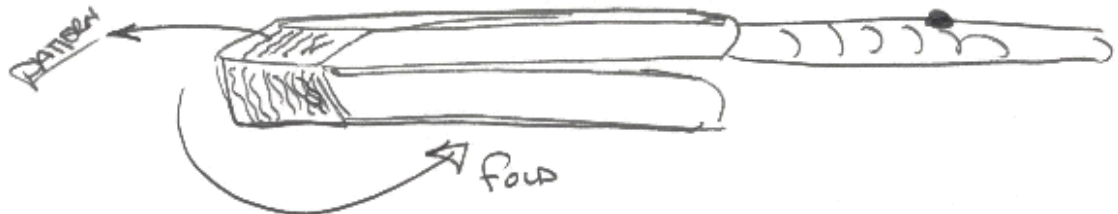


apply more pressure. Once the box is stretched long enough, the number of presses per side will increase. Keep presses even so box (billet) will remain square.

Forge billet out to about 1" square. Mark center of billet and take a good forge heat and hot cut 2/3rds of the way through.



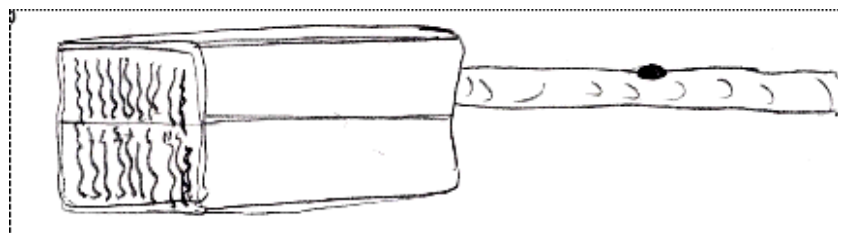
Grind away the skin of the tube from both sides of the billet. (top and bottom) If billet has enough heat, flux the sanded sides. Put back into forge and heat billet / flux again. When up to welding heat fold billet over.



Put folded billet into forge and bring up to heat / flux again—Put back into forge and get a good welding heat. Take out and weld fold together. This will take a couple of heats to make sure you have a good solid weld.

**Note:** Do not do any forging on the sides of the billet unless it is at a good welding heat.

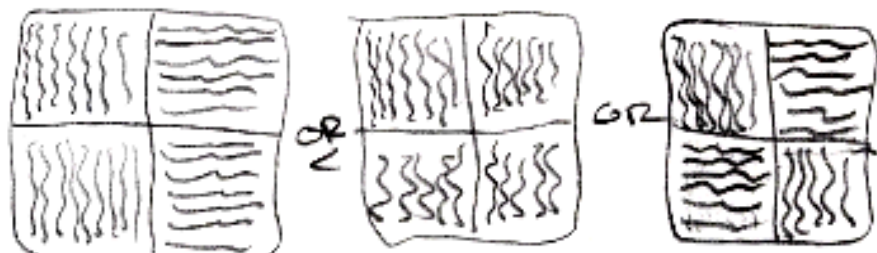
Now you have a billet with a double "W" Pattern



You can forge this out to a 1" square or whatever size you need for bolsters / cut off slaps or tiles as needed. Note: Anneal billet to make it easier to work.

If you wanted to you could draw out the billet cut in 1/2" pieces, weld back together to get a 4 panel billet for bolsters.

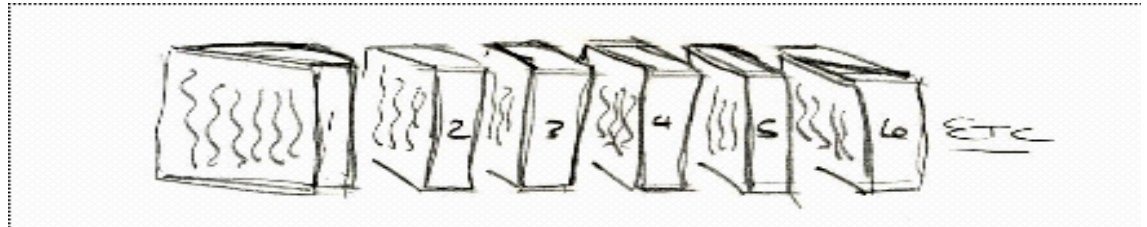
**Note:** Before welding the four together, grind the sides clean or you will have lighter lines between squares



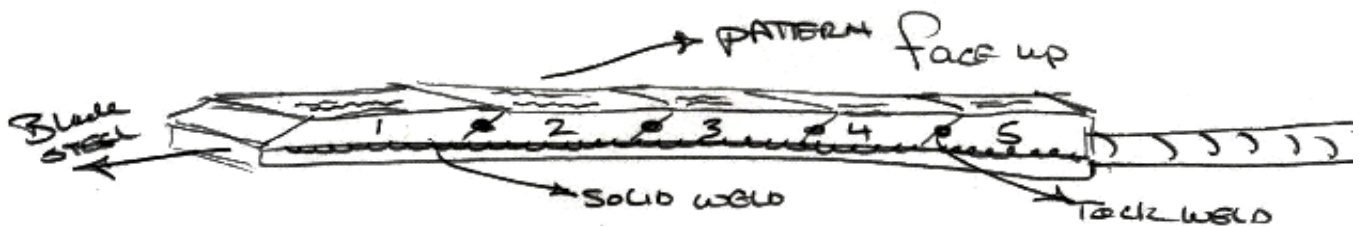
## Using Your Mosaic Billet For A Knife Blade

If you want to use the billet for a blade pattern, Ron demonstrated a couple of ways to do this.

Ron Demonstrated two ways to use the billet for a knife blade. The first was to cut the square billet into 1/4" tiles. Number each tile. Cut the first end pieces at a 45 degree angle. (notice piece one is cut in a wedge shape)



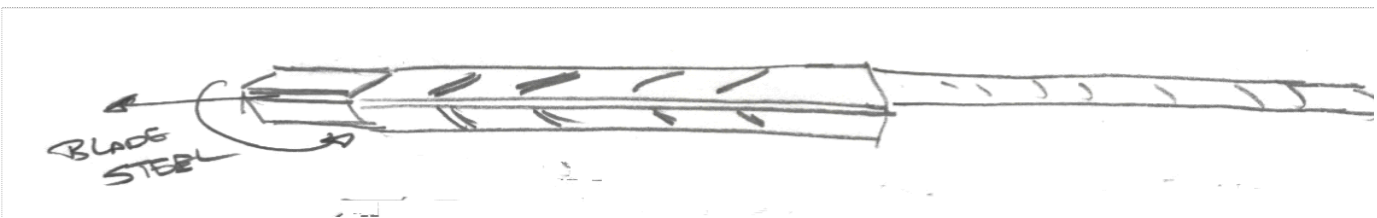
Then lay the tiles on a strip of blade steel such as L6 or 15N20.



Tack weld the tiles together and solid weld them to the blade steel (both sides). Weld on a handle to the square end / heat / flux / re-heat and forge weld together.

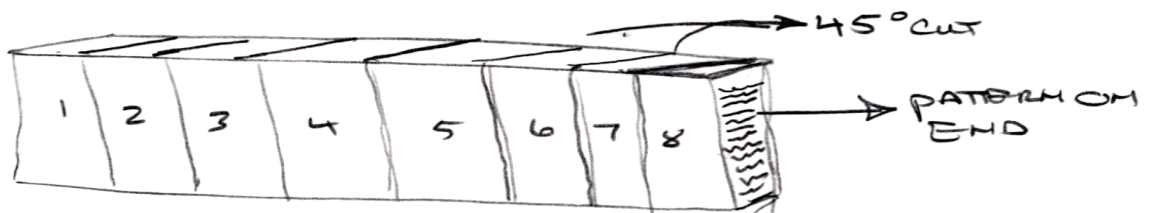
**Note:** Start forge weld from end away from the handle)

Draw out / mark and hot cut in middle so blade steel will be together and tiles will be to the outside. Fold and forge Weld. Draw out billet and forge into a blade blank. You will have a pattern on both sides and a L6 cutting edge in between.

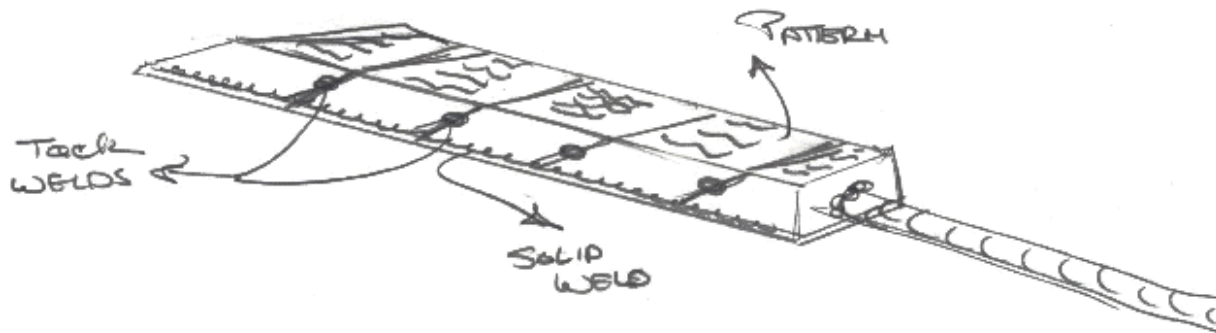


The second method was about the same technique except for the way the billet was forged out and the tiles cut.

The billet was forged into a rectangle and set on edge, the tiles were cut at a 45 degree angle and numbered.



Lay tiles on a piece of blade steel (L6 or 15N20) and tack weld together and tack weld to blade steel as before.



Again weld on handle and forge weld up billet as described with other billet.

**Note:** Again start with angled end of billet

Mark center / cut & fold / forge weld and forge blade.

There is another part to the instructions on Mosaic Damascus that we will have as soon as Bill gets through transcribing his notes. Please be sure and thank him. He is great to have as a note taker at a demo and outstanding for writing up the demo. His notes are very precise and he is always willing to share with us for the newsletter. Thanks very much Bill. And thanks to Ron Newton for his willingness to share the talent and knowledge he has been gifted with.

### Demonstration Schedule

**November 8, 2003**  
**Bill Pate's Shop**  
**Castle Hayne, NC**

**Saturday:**

- 9:00am Board Meeting
- 9:30am Guild Meeting
- 10:00am Mokume – Phillip Jones and Bill Pate (Demo may require additional time in afternoon session)
- 12:30pm Lunch
- 1:30pm Iron In The Hat
- 2:00 pm Heat Treating with a Fire Brick Forge – Dave Vail
- 3:00pm Basic Engraving Techniques – John and Joan Poythress
- (Time allowing there will be a round table discussion on Knife Shows – The Good and The Bad)
- 5:00pm Departure

A saleswoman is driving toward home in Northern Arizona when she sees a Native American woman hitchhiking. Because the trip had been long and quiet, she stops the car and the Indian woman gets in.

After a bit of small talk, the Indian woman notices a brown bag on the front seat. "What's in the bag?" she asks.

"It's a bottle of wine. I got it for my husband," says the saleswoman.

The Indian woman is silent for a while, nods several times, and then says, "Good trade."



North Carolina Palm Pilot



## Calendar of Events

### October 2003

**Forged Tomahawks Class:** Oct. 10-12, Wayne Whitley, Instructor, Montgomery Community College, Troy, NC

### November 2003

**NCCKG Meeting:** Nov. 08, Bill Pate's Shop, Castle Hayne, NC

### January 2004

**NCCKG Meeting:** January 24, 2004 Montgomery Community College, Troy, NC

### April 2004

**NCCKG Meeting:** April 24-25, 2004 Montgomery Community College, Troy, NC

### June 2004

**The Blade Show:** June 4-6, 2004, Cobb Galleria, Atlanta, GA

### July 2004

**NCCKG Meeting:** July 17 & 18, 2004, Norm Gervais' Shop, Hardy, VA

### September 2004

**10th Annual SouthEastern Custom Knife Show:** Sept 11-12, Benton Convention Center, Winston-Salem, NC

*\*\*Tentative Dates and Details.*

Complete details on classes at the guild website at [www.ncknifeguild.org](http://www.ncknifeguild.org)

(Directions and meeting details will be sent in the Newsletter preceding each meeting)

(Register for classes at Montgomery Community College; located in Troy, NC. Lodging is available close by.)

## MEMBERSHIP APPLICATION FORM

Date:		
Name:		
Address:		
City:	State:	Zip
Phone:		
Email:		
Website:		
Choose One:	New Member:	Renewal:
Choose One Membership Category:	Collector:	Student

Membership / Renewal fees are: \$50.00 per year

Collector membership fees are \$25.00 per year

Student memberships are \$10.00 per year

Please send this form with a check or money order to:

NC Custom Knifemaker's Guild

Attn: Tony Kelly

348 Bell Road

Kinston, NC 28504

<http://www.ncknifeguild.org>