

Billetts & Blades



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

December 2004

Dedicated to the Art & Craft of Custom Knifemaking

Billets & Blades

NORTH
CAROLINA
CUSTOM
KNIFEMAKER'S
GUILD

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.

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 NCKKG.

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President's Letter

For those of you who have not yet heard, I have the unhappy responsibility of informing you of the cancellation of the 2005 SouthEastern Custom Knife Show. As you may already be aware, the new management of the Adam's Mark hotel and convention center chose to break verbal commitments and a nine year relationship with our show this past September to pursue another potentially more profitable client. Failing to do so they then sent contracts that did not stand by previously agreed to details not the least of which was the loss of our hospitality room. For the past few months alternate venues for our show have been broadly explored. Unfortunately another site was not found and exhibitor refunds needed to be sent.

With the bad news aside, it has been encouraging to witness the indomitable spirit of Guild Members as they offered their help in efforts to rectify the situation with the Adam's Mark, and in exploring other sites for the show. There has already been much talk about finding a new home for our show. Thank you one and all.

Fortunately for all of us the North Carolina Custom Knifemakers Guilds is much more than an annual show. Phillip and Barry Jones have generously taken on responsibility for the knife making classes at Montgomery Community College. Phillip indicates that he has five classes planned with subjects such as tomahawk making, blade forging, folder making, and two classes covering general knife construction. The class schedule is on page 7.

Our book and video lending library continues to grow with a steady stream of donations. Thank you to those who have contributed materials for all to use. Members are already taking advantage of the libraries titles, so don't miss out on this free resource. As you all know a knife making tip here and there saves months of trial and error. This thought brings me to our next meeting.

Our next meeting will be held on January 15, 2005 at Montgomery Community College located in Troy, NC. Bill Pate has put together another good line-up of demonstrations. Don't forget to bring a

knife and a friend. We hope to see you all there!

Andrew McLurkin
President
North Carolina Custom Knifemakers Guild

At the fall meeting of the NCCCKG in Chocowinity we had knifemaker Bob Ham become a voting member of the NCCCKG. To become a voting member, you have to be general member for a year and then bring three knives for inspection by the Board of Directors.

Welcome Bob and Laura!!

If you have ever been concerned about what the laws are in your state, or a state you are traveling to, on the internet do a Yahoo search on "state law on knives". Then click on the link: [KNIFE LAWS of the 50 STATES - Introduction and LINKS](#). At that point just pick your state. There are many links from this site that knifemakers and collectors will find interesting.

Our best wishes for a speedy recovery goes out to Wayne Bernauer. Wayne had back surgery the week of our last meeting and was not able to attend.

The Board of Directors of the NCCCKG wish each of you a very Merry Christmas and a prosperous, safe, and happy New Year.

Have you smiled today?



All About Buffing

At the fall meeting of the NCCCKG, Travis Daniel did a presentation on. Below is a small fragment of the information Travis gave out to everyone.

Wheels

1. Muslin—woven cotton range from light, soft, and fine to heavy, fabric. Usually 64-68 threads per inch. It is a very versatile wheel and can be used with almost any compound successfully.
2. Flannel—soft twilled woolen—fine nap
3. Felt—made by processing or rolling wool hair—was imported from Spain; now from India.
4. Sisal—strong fiber used for twine cordage. From the leaves of “Agave Sisalana” in Java, East Africa, Mexico; mostly from Yucatan, Mexico

These come sewn, loose, bias cloth, soft, medium, hard, extra hard, and treated. There are actually 16 types total when you include all the subdivisions.

Compounds

Two categories:

1. Greaseless: there are three types.
 - a. Solid: sausage-like, wrapped plastic tubes. It usually comes in a 2 pound tube, 80 to 300 grit Aluminum Oxide.
 - b. Brush on paste: Cuts faster lasts longer (3-4 hrs). Dry overnight; 150 to 800 grit Aluminum Oxide.
 - c. Glue on grit “powder”: these work well on muslin and felt. Coat the wheel in glue and role in powder.
Same grit as paste.
2. Grease based: comes in 1/4 to 2 pound bars. It is easy to apply and will not dry out. Cover the wheel and it is a ready. Be sure and keep the bar in a zip-lock bag to prevent contamination. It comes in over 60 different compounds.

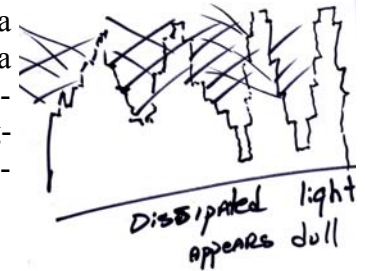
There are nine different places these items can be found: Sheffield Knife Supply, Jantz, Texas Knifemakers’ Supply, K&G, Brownells, Sealwell-Filterco, Bayland Products, Koval Knife Supply, and Pop’s Knife and Supply. Travis recommends

Pop’s Knife and Supply for your buffing compounds and supplies.

Buffing and Polishing

Somewhat like using wet or dry sandpaper, only much faster than using “elbow grease”. We use the power and speed of an electric motor. The face of the wheel is the sanding block which carries a thin layer of compound which is the sandpaper. Compounds are made from a wax substance (kersoene) which has the abrasive powders added. The block is applied to the wheel, heat from friction melts the wax and both wax and abrasive are then added to the wheel.

The object is to make a rough surface into a smooth surface. Magnified it looks like jagged mountains and valleys.



By repeated abrasions, the wheel wears down into “old soft rolling hills” which will not dissipate light but reflects light thus making it appear shiny.

Travis took us through four different ways to achieve a mirror finish. This information was gathered by talking to different people who sell or manufacture the different types buffing compounds and by talking with other knifemakers.

The first of the four ways involves 8 steps to achieve a mirror finish. Beginning with a felt wheel you start with 80 grit compound then go to 120 grit, then 150 grit. After that you move to a sewn muslin wheel beginning with 240 grit compound, then to 300 grit, then to 400 grit. Next you would use a sisal wheel and use Cut & Color Compound. The final buff is done with a loose muslin wheel and Lea 555 compound.

With the 2nd of the four ways you would grind your blade with a 60 grit belt, then do clean up on a

120 grit belt. After that you would heat treat the steel. Once heat treating is complete you thin and clean up the blade using a 120 grit belt again. To get your grind lines where you want them, you would use a 220 grit belt. You would proceed on to a 320 or 400 grit belt up to the 800 grit and then to the 15 micron. If you are using a Trizact you would use an A16 or A6. Next comes buffing using matchless green compound, following up with Pink No Scratch compound.

The third of the four different ways to achieve a mirror finish begins with a rough grind on your blade using a 36, 50, or 60 grit belt. Then move up to an 80 grit belt and after that you would step up to a 100 or 120 grit belt. You then finish all grind and flat lines with 160 to 220 grit belt. Be sure and leave your edge about 1/16 of an inch thick to heat treat. After heat treating clean up the blade with a 220 grit belt, then move up to a 320 or 400 grit belt. Next you go to an 800 grit or 15 micron. After that you buff using matchless green compound and follow up with Pink No Scratch.

The last way is Travis' way. At this point Travis stressed that **PREPARATION** is the key to getting a good mirror finish on a blade. He begins with a 60 grit or 100 micron belt. Next he heat treats his steel. Then he uses 100 micron, moves on to a 60 micron and then to a 30 micron. After that he buffs and polishes the flats first using matchless green and then matchless white.

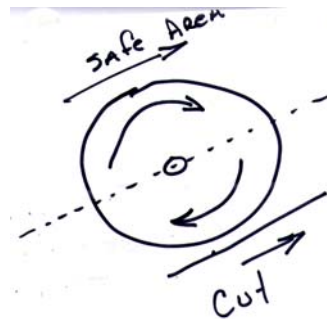
Never use the same buffing wheel or belt for more than one compound, especially from coarser to finer. It just won't work. Once the grit has been applied, it is almost impossible to remove it. You could end up with unexplained deep scratches all over your work and will have to backtrack a couple grits to start afresh and having to purchase a new wheel replacement for the finer grit. This could be most expensive if it was a hard felt wheel. Mark your polishing wheels and belts with the permanent ink marker with the grit applied to it.

Travis was very quick to stress **SAFETY FIRST!** He gave several accounts of people he knows (himself included) who has been injured by the buffing wheel. There is no amount of first aid

equal to being alert and wearing adequate eye protection.

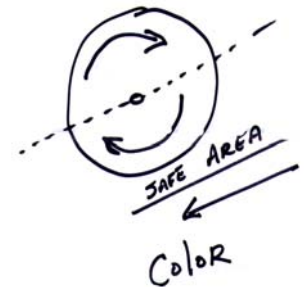
On display he had a couple of wheel rakes showing us one he made himself. The purpose of the wheel rake is to fluff the wheel and remove debris. It does not take long to do this maintenance but is a good step to help prevent problems from arising. Be sure and keep your wheel and your compound in a zip-lock bag to keep it from becoming contaminated.

The best speed for the buffer is 1700—1800 rpm. Travis says anything in the 3600 rpm is just asking for trouble.



This shows the safe area when you are "cutting" steel away.

And this is the a diagram of the safe area when you are polishing.



There are also specific safe areas for any spectators that might accumulate in your shop.

If you have any questions on buffing and getting that mirror finish Travis said to feel free to contact him.

I received these on e-mail. Thought you might find these interesting. I haven't tried the Quaker Oats cure so if it works let me know.

Rainy day cure for dog odor... Next time your dog comes in from the rain, simply wipe down the animal with Bounce or any dryer sheet, instantly making your dog smell springtime fresh.

Quaker Oats for fast pain relief... It's not for breakfast anymore! Mix 2 cups of Quaker Oats and 1 cup of water in a bowl and warm in the microwave for 1 minute, cool slightly, and apply the mixture to your hands for soothing relief from arthritis pain.



The fall meeting of the NCCCKG was held in Chocowinity at the homes/shops of Travis Daniel and Wayne Whitley. There was a good group of knifemakers on hand to participate in the meeting.

Travis began the day by taking the group through the process of obtaining a mirror finish on a knife.



Travis also took some time to show what is needed to do a good job dying bone.



Alan Folts explained the steps taken to construct a Kydex sheath.



John, Wayne, and Travis are deep in conversation. I'm sure they are discussing some astoundingly deep topic like "what's for lunch".

Phillip "seems to be" showing off his muscles. Are you carrying something on your shoulder there strong man?



This little puppy is really excited to see the visitor that came to see him. I have never seen one little fellow invest such time in trying to make sure his visitor had a good time.



Later in the day, Wayne took us thru forging a blade. Wayne is a great instructor and made sure there was time for others to try their hand at the anvil and the forge.

Bob Ham, our newest voting member tries his hand at using fire and the hammer to fashion a knife.



Tim is always willing to give a helping hand to those who want to try their hand at the anvil.

Nelson Simmons, under the guidance of Wayne and Tim walked away with this nice blade



After the meeting those who could stayed for supper. The fun thing about the NCCCKG is that you never know who you might end up at supper with.



NCCKG Classes

Course: Custom Folding Knives

Instructor: Ed Van Hoy

Dates: May 12-15, 2005

Cost: \$315.00

Description: This class will teach students how to make a custom folding knife. Students will learn how to design, grind parts and make handles for the folding knife that they will finish in class.

Course: Basic Knife Making

Instructor: Tommy McNabb

Dates: May 19-22, 2004

Cost: \$315.00

Description: In this course the students will learn knife making by designing and making a knife themselves under the guidance of the instructor. Each student will grind, heat treat and finish a knife using the stock removal method. This class is for beginners to intermediates that want to perfect their knifemaking talents.

Course: Forged Blades

Instructor: Mark Sentz ABS MS

Dates: September 15-18, 2005

Cost: \$315.00

Description: American Bladesmith Society Master Smith Mark Sentz will teach students the fundamentals of blade forging ranging from steel selection, heat treating, forging and finishing the blade and handle.

Course: Grinding Knife Blades

Instructor: Geno Denning

Dates: September 29-October 02, 2005

Cost: \$315.00

Description: Students will learn fixed blade design, how to hollow grind knife blades, heat treating, making guards and handle finishing.

Course: Forged Tomahawks

Instructor: Wayne Whitley

Dates: October 28-30, 2005

Cost: \$240.00

Description: Forge and finish an early American tomahawk, including forging, grinding, heat treating and finishing the blade and handle.
Student supplies: Wayne Whitley will furnish all the supplies for the students to purchase and make a tomahawk.

Show Memories

From Bob Cumming, CUMMING KNIVES

Cedar Crest, New Mexico

Although I cannot participate in this year's SE Custom Knife Show, I will miss my annual visit to Winston-Salem with much regret. This particular show, unlike any other in which I participate, wins an Olympic Gold Medal for its friendliness especially the welcome extended to newcomers. The cohesiveness of the members of the NCCKG and, in particular, the family-like character of the event, the result of dedicated spouses who are fully committed to and supportive of knife makers and collectors, underscores the importance of the team and genuine hard work toward a common cause. From my very first participation in this stellar event five years ago, I have considered myself not only fortunate, but truly honored to be associated with a very, very fine organization.

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From Tim Britton, Britton Knives
 Winston-Salem, NC

Tommy McNabb called me about 12 years ago.... wanted to talk about starting a NC Custom Knifemaker's Guild. I suggested that he take up watching paint dry or ballet....the idea was not needed at this time and would likely be a giant failure. Thank God that some of us have been blessed with vision, to be able to dream and then make it come true. Our NC Guild survived an awful show in Durham, NC, and a trial by fire in New Bern, NC. Does anybody remember the animal calls and the dogs running around the show? How about the clown? Our guild has since become the model for other state guilds throughout the USA. Our first class school at Montgomery CC in Troy, NC and our world class show in Winston-Salem every September has set the standard for other guilds. Lots of time and energy on everybody's part is bearing fruit. My guess is that the future of our shows and organizations relies heavily on regional activities. I'm very likely one of NC knifemaking's senior citizens and remember way back when. I'm proud to be a member of our guild and am deeply indebted to all of you who have helped turn our dreams into reality.

**Guild Demonstration Schedule
January 15, 2005
Montgomery Community College**

Saturday:

8:30 am	Board meeting
9:30 am	Guild meeting
10:00 am	John Poythress Spiral Handle Dagger
11:30 pm	Iron in the Hat Bring some of your spare goodies
12:00 pm	Lunch, on your own-Zeno's or BBQ are both good choices
1:30 pm	Andrew McLurkin Photographing Your Knife Bring one of your own knives to experiment with
3:00 pm	Barry & Phillip Jones Flat Grinding, Hands-On Demo. Bring a blade blank to try your hand at the grinder
5:00 pm	Departure

**Directions to Montgomery Community
College**

From Winston-Salem:

Take Hwy. 52 South to Lexington; then take Hwy.64 East to Ashboro; from Ashboro take 220 South to Bisco Exit; turn right & go approximately 9 miles until you see Montgomery Community College sign on the right; turn right at the sign, and go approximately ½ mile to the college entrance. Look for marked parking.

From Fayetteville:

Take Hwy. 24 & 27 West through Bisco, go approximately 9 miles until you see Montgomery .

Community College sign on the right; turn right at the sign, and go approximately ½ mile to the college entrance. Look for marked parking

From Charlotte:

Take Hwy 24 & 27 East through Troy, go approximately 2 miles until you see the Montgomery Community College sign. Turn left and go approximately ½ mile to the college entrance. Look for marked parking.

Area Hotel Accommodations

Days Inn Biscoe, NC 910-428-2525	Comfort Inn Albemarle, NC 704-983-6990
Holiday Inn Express Albemarle, NC 904-986-2100	Sleep Inn Albemarle, NC 704-983-2770
Uwharrie Mountain Lodge Troy, NC	

At the fall meeting Norm and Marge Gervais were not able to attend because Norm was in the hospital. Norm, you and Marge both were missed at the last meeting! John and I have talked with Norm and Marge and he is now home and on the mend and just in time for all the good home cooking that comes with this time of year. We will keep you in our prayers and look forward to seeing you at the January 2005 meeting.

Since our fall meeting I have also found out that Bill Bisher's wife has had a stroke. We wish her a speedy recovery and hope she will be on the mend real soon.

On The Cover

Forged copper overlays highlight this knife and tomahawk set. Both blades are a damascus blend of 1095 and L-6. Ferrules of damascus and copper feature a sunburst pattern. The knife handle is an elk antler crown. Curly maple was used for the spike tomahawk. The craftsman of this beautiful set is Daniel Winkler.

HOW TO STAY YOUNG

Remember, there is no way you can look as bad as that person on your drivers license.

1. Throw out nonessential numbers. This includes age, weight and height. Let the doctors worry about them. That is why you pay them.
2. Keep only cheerful friends. The grouches pull you down.
3. Keep learning. Learn more about the computer, crafts, gardening, whatever. Never let the brain idle. "An idle mind is the devil's workshop." And the devil's name is Alzheimer's.
4. Enjoy the simple things.
5. Laugh often, long and loud. Laugh until you gasp for breath.
6. The tears happen. Endure, grieve, and move on. The only person who is with us our entire life, is yourselves. Be ALIVE while you are alive.
7. Surround yourself with what you love, whether it's family, pets, keepsakes, music, plants, hobbies, whatever. Your home is your refuge.
8. Cherish your health: If it is good, preserve it. If it is unstable, improve it. If it is beyond what you can improve, get help.
9. Don't take guilt trips. Take a trip to the mall, to the next county, to a foreign country, but NOT to where the guilt is.
10. Tell the people you love that you love them, at every opportunity.
11. Don't sweat the petty things and don't pet the sweaty things.

Zero Gravity:

When NASA first started sending up astronauts, they quickly discovered that ball-point pens would not work in zero gravity.

To combat this problem, NASA scientists spent a decade and \$12 billion developing a pen that writes in zero gravity, upside-down, on almost any surface including glass and at temperatures ranging from below freezing to over 300 C. The Russians used a pencil. Your taxes are due again soon--enjoy paying them.

Signs Across America

Better be careful who you choose for a best friend.



No comment can help this one.

Think I'll keep shopping at Bi-lo



Do some things need to be said?

Is there any other way?



**North Carolina Custom Knifemakers' Guild
Membership List 2005**

Member	Member Category
Alan Folts	Maker
Andrew McLurkin	Maker
Barry & Philip Jones	Maker
Bill Moran	<i>Honorary</i>
Bill Pate	Maker
BR Hughes	<i>Honorary</i>
Bruce Ryan	Maker
Bruce Turner	<i>Honorary</i>
Charles F. Fogarty	Maker
Charles Ostendorf	<i>Judge</i>
Chuck Staples	Maker
Dan Johnson	<i>Supplier</i>
Daniel Winkler	Maker
Danks Seel	Maker
Darrel Ralph	Instructor
Dave McKeithan	Maker
Dave Vail	Maker
Dexter Ewing	<i>Judge</i>
Dr. James Batson	<i>Judge</i>
Dr. Jim Lucie	<i>Honorary</i>
E. Gene Calloway	Maker
Ed Halligan	<i>Instructor</i>
Frank Joyce	Collector
Gary W. Cunningham	Maker
Geno Denning	Maker
George Herron	<i>Honorary</i>
Goguen Knives	Maker
Harland Simmons	Maker
Howard Peacock	<i>Instructor</i>
J. Wayne Short	Maker
Jack Hyer	Maker
Jacob Kelly	Student
James A. Williams	Maker
Jesse Houser, Jr.	Maker
Jim A. Decoster	Maker
Jim L Gardner	Maker
Joe Corbin	Maker
John (Jack) Busfield	Maker
John W. Poythress	Maker
Johnny Sorrell	Maker
Ken Simmons	Maker
Koji Hara	<i>Instructor</i>
L.E. Wilson	Maker
Lester "Red" Banks	Maker
Mark Gottesman	Maker

Member	Member Category
Mark R. Henry	Maker
Nelson Gimbert	<i>Judge</i>
Norman A. Gervais	Maker
Phillip L. Gaddy	Maker
Pop's Knife & Supply	Supplier
Rob Wotzak	Maker
Robert Davis	Student
Robert E. Barber	Maker
Robert Ham	Maker
Robert J. Cumming	Maker
Robert Knight	Maker
Ron Newton	<i>Honorary</i>
Russ Sutton	Maker
Sterling Custom Knives	Maker
Steve Sallee	Maker
Terrill Hoffman	<i>Show Photographer</i>
Tim Britton	Maker
Tim Scholl	Maker
Tommy Johnson	Maker
Tommy McNabb	Maker
Tony Kelly	Maker
Travis Daniel	Maker
Victor L. Odom	Maker
Wayne Bernauer	<i>Instructor</i>
Wayne Whitley	Maker
William B. Roberson	Maker
William M. Bisher	Maker

NCCKG Lending Library

During the past year, the NCCKG began a Lending Library. What started out as just an idea has grown to a resource of 13 tapes this year. It is due to the generosity of the NCCKG membership, and your willingness to share your knowledge that makes a venture like this a success.

In the last month, Charles (Hillbilly Chuck) Fogarty donated nine videos to the library. I know that many of the videos donated have already be requested to be borrowed by several members. Thank you Chuck for contributing the videos to the library.

Be sure and look over the list of videos on the lending form on page 11. If you see one that you would like to borrow, fill out the form, placing a check mark by the title, and mail the form to Barry Jones at the address shown.



The North Carolina Custom Knifemakers' Guild Video / DVD Library

Check Here	Title	Check Here	Title
	GRS Engraving Methods & Techniques Tapes I & II		Kydex Sheathmaking - Blade Cutlery (Allen Blade)
	Intermediate & Advanced Engraving Lynton McKenzie		Hollowing Grinding - Blade Cutlery (Allen Blade)
	Focused Listening Skills		Flat Grinding - Blade Cutlery (Allen Blade)
	The Woodsmaster Vol. 9—Primitive Knifemaking		
	Take Your Time and Enjoy Your Forging Dr. James Batson		
	An Introduction To Knifemaking		
	Forging Damascus - Jim Hrisoulas		
	Carbon Steel Heat-treating - Blade Cutlery (Allen Blade)		
	Knifemaking (actual title unknown) - Ron Newton		
	Knifemaking (actual title unknown) - Gene Osborne		

Videos and DVD's must be returned within 3 weeks of checkout time (Date noted below).

There will be a penalty of \$40.00 per item incurred for loss or damages sustained during the checkout period. The person or persons check out the videos or DVD's is responsible for said loss or damages.

Name

Check out Date

Address

Due Date

Phone

E-Mail

Signature

Return Videos / DVD's to:

**Barry Jones
221 North Avenue
Danville, Virginia 24540
(434) 793-5822
Jknives@gamewood.net**

Calendar of Events

January 2005

NCKKG Meeting: Jan. 15, Montgomery Community College, Troy, NC

April 2005

NCKKG Meeting: April 23 - 24, Montgomery Community College, Troy, NC

May 2005

**** Date TBA Trackrock Hammer-In:** Trackrock Camp Grounds, 4887 Trackrock Campgrounds Rd., Blairsville, GA
Custom Folding Knives: Montgomery Community College, Troy, NC Instructor: Ed Van Hoy
Basic Knifemaking: Montgomery Community College, Troy, NC, Instructor: Tommy McNabb

June 2005

The Blade Show: June 03-05 , 2005, Cobb Galleria, Atlanta, GA

July 2005

*****Date & Location TBA NCKKG Meeting:**

September 2005

Forged Blades: Montgomery Community College, Troy, NC Instructor: Mark Sentz, Mastersmith
Grinding Knife Blades: Montgomery Community College, Troy, NC, Instructor: Geno Denning

October 2005

*****Date & Location TBA NCKKG Meeting:**

Forged Tomahawks: October 28-30, 2005, Montgomery Community College, Troy, NC Instructor: Wayne Whitley

****Tentative Dates**

Complete details on classes at the guild website at 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>