

# THE SPECIMEN ROADSTER

**10 Steps** to a Consistent Hind Caulkin and Wedge

Roadster Shoe • BY SCOTT DAVIDSON, CJF WITH BILLY CROTHERS, AWCF



## Jumping the Toe

**Step 1**

(picture 1)  
Cool the toe off centre (how much off centre depends on the specimen shoe you are copying). It is good technique to use 2 pairs of tongs to achieve the correct toe heat.

(picture 2)  
When jumping the toe, you are trying to create thickness but not necessarily width. Look at the bottom of the steel, (not where you are hitting) and think of hitting through the steel with firm solid blows.

(picture 3)  
Toe is thicker on the outside and thinner on the inside. This is to enable an easier, smoother, toe bend.

[1]



[2]



[3]

PHOTOGRAPHS BY SCOTT DAVIDSON, CJF

We all have different styles and many different methods of making a roadster.

It is important to be versatile enough to change styles when needed in order to adapt to the many different specimen roadsters that you may encounter in competition situations. Why anyone would want to make a hind roadster caulk and wedge I have no idea! It involves a fair bit of sweat and, as one gets older, a little bit of pain. For some reason it just keeps popping up in a lot of International competitions. It used to be a two man shoe, but over the years it has developed into a one man shoe out of gas (are we getting crazier!).

In August 2006, I was lucky enough to be asked to judge the Montana State Championships. So, while I was at Scott's, we thought it might be a good idea to do a bit of forging. Along with this article, we put together a DVD on the very subject of "Hind Roadster Shoe Making." Like any shoe you have ever made, it is important to break the process down into stages to allow you to understand what it should look like during, and at the end of, each heat as well as the method needed to achieve each stage. When shoe making, it is very important to develop a system, or procedure, that you can repeat. Try to develop a style or method that suits your physique and ability level. Recognise what each stage should look like as it is formed and complete each stage before you move on to the next.

When practising or training for a competition, it is important that you make sure that your practice sessions are constructive. You can reduce your practice time by preparing well before you start. The shoes should be made in your head before you even pick up your hammer and tongs. If the quality of your shoe is not improving with each practice session, take a step back and analyse the form of your shoe and your method and technique throughout each stage.

A poor practice usually derives from lack of preparation. No practice at all is better than a bad practice session!

Have fun making the roadster.

# Turning the Toe

## and Starting the Inside Branch

(picture 4) Toe and inside branch is taken to a dripping white heat. Form a smooth toe bend, bearing in mind that this is a hind toe clip shoe. The toe needs to be narrow, but at this stage be careful not to over narrow the toe or you will be restricted as you come to draw down each branch.

(picture 5) Start drawing the inside branch on the bick of the anvil.

(picture 6) Set down the start of the wedge. How much will depend on the size of the wedge on the specimen shoe you are copying (approx.  $\frac{3}{4}$  - 1").

(picture 7) Continue the drawing on the heel of the anvil and start to forge the wedge.

(picture 8) Knock the wedge back into itself to create height. Make sure that your shoe is held fairly flat on the anvil face.

(picture 9) End of step 2. Toe bend complete and majority of wedge formed and inside branch drawn down.

### Step 2



[4]



[5]



[6]



[7]



[8]



[9]

### Step 3

# Form Square Block for Caulkin



[10]



[11]



[12]



[13]



[14]



[15]

(picture 10) After starting on the bick at the toe, draw down the outside branch on the heel of the anvil.

(picture 11) Turn up about 1 1/2" for the caulkin (depending on the size of the caulkin of the specimen that you are copying).

(picture 12) Forge down and start to make square block.

(picture 13) Do not allow the front of the caulkin to fold over or mushroom.

(picture 14) The angle of the square block at this stage should be 85°.

(picture 15) End of step 3. Some of outside branch is draw down. A square block is formed with no set down ready to be turned into a caulkin.

## Completing the Outside Branch

### and Shaping the Caulkin

Use four simple steps to shape the caulkin.

**MOVE 1:** With the shoe flat on the anvil, forge the check onto the caulkin. This will put the caulkin immediately to 90°. (picture 16)

**MOVE 2:** Set the shoe at an angle on the face of the anvil and forge the end of the caulkin square to the anvil. (picture 17)

**MOVE 3:** Set down. (picture 18)

**MOVE 4:** Forge down height of caulkin. (picture 19)

(picture 20)  
Back to Move 1. Forge up the inside web. Stop at the corner of the check.

(picture 21)  
Check off. Then back to move 2, 3 and 4. Keep repeating until caulkin of desired shape is formed.

(picture 22)  
End of step 4. Outside branch drawn down. Caulkin forged into shape.

## Step 4



[16]



[17]



[18]



[19]



[20]



[21]



[22]



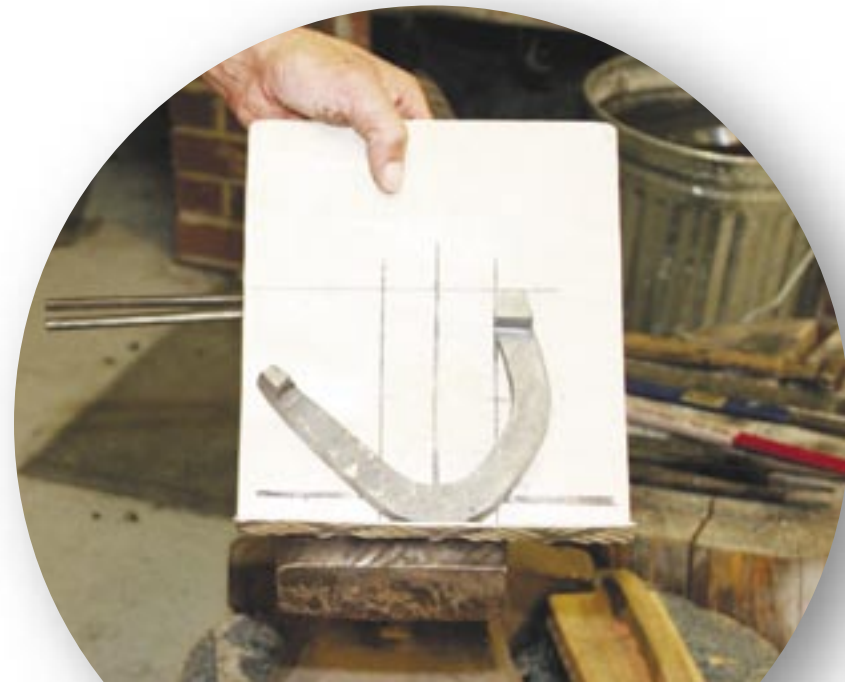
[23]



[24]



[25]



[26]

## Step 5

## Turning the Outside Branch

### and Rasp Caulkin

(picture 23)  
Working on the top of the bick, turn the outside branch. Make sure your hammer and tongs work together. The tong hand is the key; with the hammer hitting in the same spot, move the tong hand under the bick. This is the key to a smooth quarter bend.

(picture 24)  
Take the twists out and level.

(picture 25)  
Rasp and file caulkin.

(picture 26)  
End of step 5. Outside branch drawn and turned. Caulkin formed and rasped. Start to form a rectangle inside the shoe, i.e., Heel check in line with position of toe nail.

## Finish Drawing the Inside Branch

### Form, Rasp and File Wedge

(picture 27) Shape the wedge with the hammer at a slight angle so that the wedge leans in very slightly.

(picture 28) Re-define the set down.

(picture 29) Continue to re-define, bearing in mind the style of the wedge you are copying, i.e., if the front of the wedge is upright, keep the shoe flat to the anvil. If the front of the wedge is sloping, raise your tong hand so that the shoe is off the face of the anvil.

(picture 30) Rasp and file the wedge before the inside branch is turned. It will be very difficult to get to the front of the wedge if you turn the shoe first.

(picture 31) End of step 6. Inside branch is drawn down — wedge complete..

## Step 6



[27]



[28]



[29]



[30]



[31]



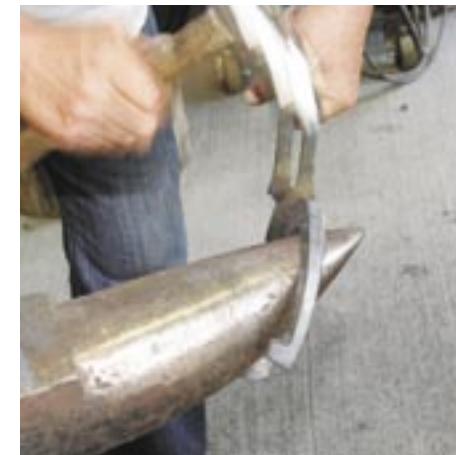
[32]



[34]



[33]



[35]



[36]

## Steps 7&8

## Turn the Inside Branch,

### Mark Position and Stamp Nail Holes

(picture 32) Again, working on top of the bick, let the hammer fall in the same spot with your tong hand moving under the bick.

(picture 33) Set up nail hole position and mark. Toe nails in line with the back edge of the width of stock. Heel nails at the widest point and middle nail half way between the two. How coarse or how fine the nail holes are punched will depend on the specimen shoe that you are copying or the foot that you are shoeing.

End of step 7. General shoe shape complete. Heels formed and rasped. Nail holes marked.

### STAMP NAIL HOLES

(picture 34) Make sure that your stamps and pritchels are set up for the job they are required to do. Be aware of the size of nail you are required to use.

(picture 35) Forge branches and blend in lumps and bumps.

(picture 36) End of step 8. Center mark the position of the clip.

# Clipping

## Step 9

(picture 37) Start the clip hole with firm accurate blows. Forge enough material to enable easy drawing of a strong clip. In this particular shoe I have used a ball pein hammer. Remember to copy the clip style of the specimen.

(picture 38) When starting to draw the clip, secure the location of the shoe position on the anvil with the first few blows coming down at a slight angle.

(picture 39) Use flat blows next to develop the material.

(picture 40) Draw the height and shape of the clip by dropping the heel of your hammer, making sure that your knuckles are lower than the anvil face!

End of step 9. The shoe is complete. Just 1 final heat required to add definition.



[37]



[38]



[39]



[40]



[41]



[42]

## Step 10

# Finishing Touch

## Heat to Shape, Rasp and File

(picture 41) Rasp and file toe.

(picture 42) Shoe complete after checking five important elements:

- Shape
- Heels
- Nail holes
- Clip
- Level

Try to make time to add definition to your shoe in the final stages. Crisp lines, good proportions, as few hammer marks as possible, smooth edges, snug nail fit and definition of the shoe's main characteristics; i.e., with the roadster caulkin and wedge it is important to make the heels in the same style as the shoe you are copying and nail holes in the same position with the same depth and pitch. All this will only come together at the end if you have done the correct preparation at each stage.

This is not an easy shoe to make and no doubt you will have good and bad days when you are learning how to make it. Persevere, because when you have made a roadster that is half decent, it is very self-satisfying. [TPF]