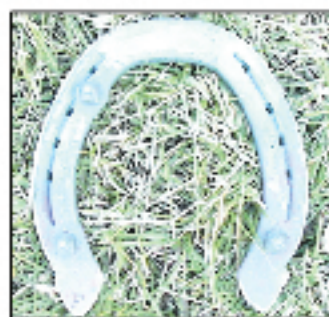


MODIFICATIONS FOR THE JUMPER HIND SHOE

By Dave Farley



LEFT: Typical Jumper hind with studs;
RIGHT: Open Branch to modify heels.

I start with a Kerckhaert SX-8 hind shoe with clips. The shape of this shoe saves valuable time, especially the toe area. I also no longer pull clips as the clips on the Kerckhaert shoes are very strong and well positioned. Because of the extreme torque and stress on the Jumper hind I always use clips.

When shoeing the hind of a Jumper a farrier should be seasoned. For this reason the top professional trainers seek out the most experienced farriers to shoe their horses. Many trainers feel that good farriers are like good horses. By the time both are any good they are both a little long in the tooth. If they are both a little long in the tooth they make less mistakes and make the job look effortless.

When shoeing the Jumper the smallest mistake could be detrimental to the horse and rider. There are many factors to be considered before nailing on a set of shoes. Farriers should consider all the normal issues such as a proper trim, shoe size, nail size and nail placement when shoeing any and all horses. Jumpers require much more. With the Jumper there is little or no room for error. This horse has to be evaluated. A Jumper's conformation, combined with their movement, dictates the type, size, and placement of the shoe and the shoe modifications that will go on that particular horse. In this article we will concentrate on the hind end of the jumper. This shoe will be modified as if it were going on the hind of a horse with normal conformation and a normal gait.

That leaves me with only two modifications to forge on this shoe. The extended heels and the third calk hole. With a little practice you will be able to do both heels with the same heat. After heating the shoe I open the heels. I open the heels so that I can forge each heel without the hammer making contact with the other heel. Holding the shoe with the tongs placed in the toe area, I place about one inch of the heel on the edge of the anvil. I then strike down on the heel until I get the desired angle on the heel. Repeat this on the other branch. The extended heels allow the foot to clean easier and help stabilize the foot and limb. I often put some support on the outside branch with a small hammer modification.

After forging both heels I level the shoe. Using a Bloom steel

LEFT: About 1" over anvil to set angle;
RIGHT: Modify second heel.



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handled center punch I mark the heel area where the calk holes will be placed. These holes should be placed in the center of the branch. This keeps the medial traction device from causing damage to the hoof wall and coronary on the opposite limb. Without a center punch mark it is hard to keep the drill bit exactly where you want the hole to be drilled. These holes need to be placed accurately. The hand held center punch takes a lot of abuse. I place it exactly where I want to mark it and hit it. Quickly get it off the heat. Leaving this or any punch sitting on a hot shoe too long will eventually soften the business end and you will have to do more maintenance to the end.

At this point the shoe will still have some heat in it but I put the shoe back into the fire to heat the area for the third calk hole. Placement of this hole should be determined by the horse's conformation, stance at the jump, and type and depth of the footing. I think it is a mistake to place them all in the same spot on every horse. Position of the third calk hole is usually between the 1st and 2nd nail hole on the outside or lateral nail hole. This gives more traction as the hoof breaks over the toe approaching the jump. If the studs or calks are placed too far back on the shoe, the hoof will slip as the heel lifts and the toe starts to leave the surface of the footing. Studs placed forward of this position require extra effort at the point of break over. Adding extra effort and energy at the point of break over could cause injuries to the tendons and ligaments.

Some trainers also require a fourth calk or stud hole on the medial side opposite the third calk or stud hole.

I start the third calk hole by using a wood handled stud punch. A few years ago I switched to handled tools. I did this for two reasons. A hand held tool required a glove to keep my hand from

LEFT: Clean up heels; **RIGHT:** Extended heels; **BELOW LEFT:** Lateral heel extension; **BELOW RIGHT:** Center punch mark for stud holes.



TOP: Round Punch to make third stud hole; **BOTTOM:** Hole punched from foot surface.

burning. A hand held tool made it difficult for me to see the end of the tool to get the accuracy I am looking for. The calks are often put in and taken out daily. For this reason the third calk hole needs to have material all around the hole so that the calk can be applied easily. Some will simply drill a hole through the crease and tap it. Grooms often find it difficult to get a calk started in holes drilled through the crease and will leave this calk out, causing poor traction.

On this shoe I placed the calk hole between the 1st and 2nd nail hole on the outside branch. Taking a good yellow heat I start the

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hole from the hoof side and drive the tool until it meets resistance. This only takes a few hits. Do not continue to drive the tool after it meets resistance or it will mushroom. I remove the tool quickly and lay it aside to air cool. Never place this tool in water to cool. It would be impossible for me to count how many holes I have punched with this tool and I have never done any maintenance to it. I use it quickly and get it out of the hot shoe. If you like you can flip the shoe over and give it a little time to cool. Then simply place the tool on the mark left by the tool on the ground surface and drive it just enough to remove the slug. Some prefer to wait and drill it from the back after it has cooled and they are drilling the heel holes.

For drilling I use a counter sink 5/16 bit. There are several on the market and usually the more expensive, the better the bit. Be careful not to countersink too much. About 1/16 of an inch is all that is needed. There are a couple of reasons to counter sink the holes. It keeps the threads in the holes from mushrooming in when the calks are removed. A countersunk hole also helps keep the calk locked in the shoe.

Before tapping a shoe make sure that the shoe is securely fastened in a good vise. A sloppy vise that allows movement of the shoe could cause your tap to break off in the shoe. When this happens it causes an immediate negative reaction somewhere on your body. Usually your vocal cords, arms, hands or all the above.

Tapping the holes in the shoe can be done several ways. Tapping guns are expensive and hard to find. A 1/2 inch, variable speed reversible drill is my choice. Or you can use a tapping tool that mounts in your hardy hole or in a vise. Whatever you choose be sure to use some type of tapping solution. You can usually find this solution at your farrier supply.



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TOP LEFT: From ground surface;
TOP RIGHT: Punch through at black heat;
ROW 2, LEFT: Punched hole ready to tap;
ROW 2, RIGHT: Drilling heels;
ROW 3, LEFT: Tapping solution;
ROW 3, RIGHT: Tap shoe, use vise to hold secure;
BOTTOM: Finished shoe, ready for studs.



I don't make the decisions as to what kind of calks or studs to use. I also don't supply them. I find it is much better for the trainer to make this decision and keep a supply of studs to suit their needs.

As I mentioned in the beginning of the article, it is important to make sure that you have applied a good trim and balance to the foot. The modifications to the shoe are where you can help with traction, support, and other balance issues that can't be addressed by the trim. ■

Forging steel handled punches

By Roy Bloom

The photos below were taken at a hands-on clinic hosted by Jim Smith in New Hampshire. Making a hand held punch involves much the same process but you don't have the complicated process of welding and heat treating that is involved in the steel handle tool. If you decide to make some steel handled punches keep in mind that these basic forging steps are only the beginning. The most critical steps are the welding and heat treatment steps. In a future article I will discuss some of those steps.

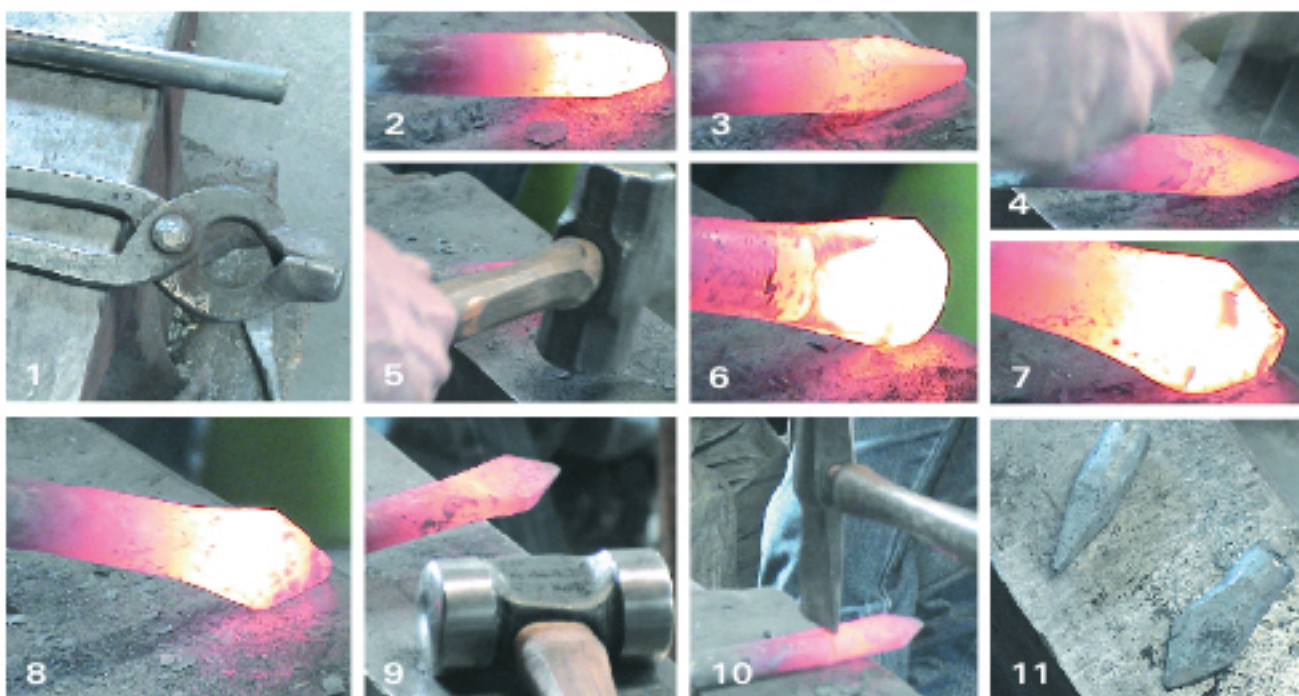
I like to use S-7 for most of my punches. This is a personal preference but I find S-7 to be a good steel for punches. I use 5/8" round stock for most punches, but would suggest 3/4" for punches used for heavier work, like gaited or draft shoes.

The photos show the steps. I strongly recommend the use of a heavy hammer when beginning the forging of the punch. This allows you to get the work done - maximizing your results and reducing the number of heats. You have to be cautious about the heats. Don't work tool steel once the color has gone to red. You also need to make sure you are using tongs that allow you a good hold on the steel - without having to squeeze the reins. Round tongs may be best but there are other types of tongs that are designed to hold round stock. The important thing is to control the material. You can also see that most of the work is done at the edge of the anvil- this will help you avoid damage to the face of the anvil.

You need to keep the work balanced - work both sides and angles so that you keep the tool in a good ratio. If you work it above the 1:3 ratio (width x thickness) you can develop cracks in the material.

S-7 is also an air cool material. Don't quench it in water!

You can forge the tools to the dimensions you are looking for. Check the dimensions as you get close to the end by using some kind of template. Don't leave forepunches with a flat tip. Put a diamond tip on so that you will reduce the resistance when working the tools. Final adjustments to the punch can be made on a belt sander using a 100-120 grit belt. ■



(1) Round tongs and 5/8" stock. (2-4) Forging steps of E-Head. (5) Heavy forging hammer. (6-8) Forging steps on City Head. (9) Final forging with lighter hammer. (10) Cutting head with hot cut. (11) Forged heads, ready for cleanup and welding.

Education Goes Hand in Hand with Experience

One of the most common comments from farriers that have been in the business for many years is the change in the availability of information. Prior to the emergence of local associations and national groups like the American Farrier's Association there were no forums for discussion of ideas and techniques. What a dramatic change has taken place.

The American Farrier's Association and its many chapters provide large venue programs as well as countless hands-on opportunities, lectures, or just local hammer-ins or get-togethers. If you haven't participated in any of these events you should check them out. There are a wide variety of topics. It's not all forging competition shoes, though this has proven to be a tremendous learning experience for those that participate. Many clinics are geared to the basics of everyday work. Trim and balance, fit of shoes, discussion of lameness problems and even business topics.

Supplementing the work of the associations, a number of companies and suppliers put on events. The Natural Angle clinic

series is one that has received high praise for the down to earth approach of the clinicians and the format of the clinics. Most of the clinicians in these clinics are



ROY BLOOM MAKING BAR SHOE AT ASSOCIATION CLINIC.

farriers certified by the AFA and have benefited themselves from participation in clinics and competitions.

There are opportunities for continuing education and development of your skills all over the country. As horse owners and

trainers are confronted with increasing costs of the equine industry they are expecting more and more from the farriers. The best way to handle the additional pressure to perform is to increase your knowledge and skills. That's what clinics are designed for and why so many people who believe in the industry give their time to put these events together.

Aside from the technical and mechanical advantages you will also find the camaraderie and sharing of common experiences to be rewarding and enlightening. The time when a farrier would put away his tools when another one came into his barn is long gone - today's farrier industry thrives because people share ideas, discuss their problems and work to improve their skills.

For more information on clinics and events check with your supplier or visit these websites. www.farrierproducts.com or www.americanfarriers.org. Also check with your local associations to see how you can get involved.

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