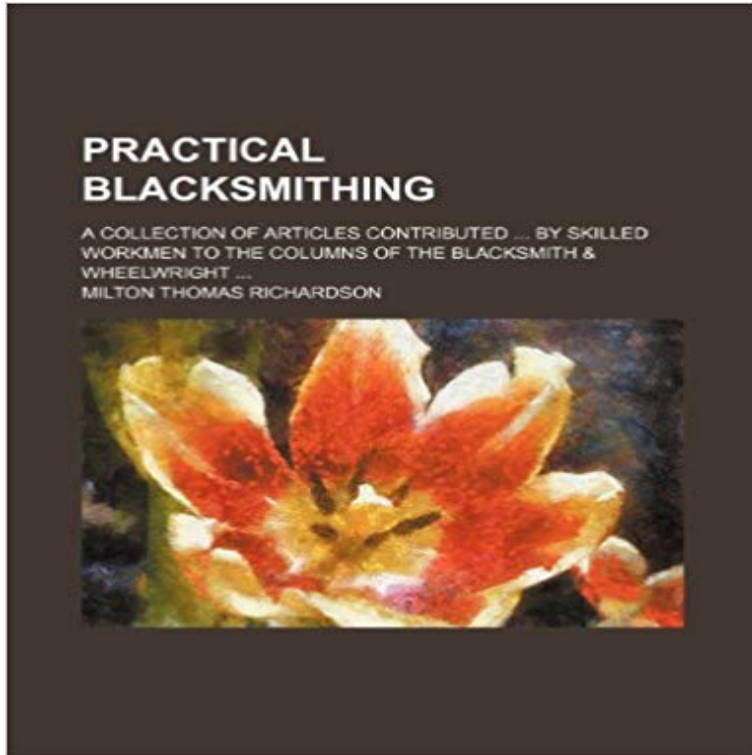


# Practical Blacksmithing; A Collection of Articles Contributed by Skilled Workmen to the Columns of the Blacksmith & Wheelwright



This historic book may have numerous typos and missing text. Purchasers can download a free scanned copy of the original book (without typos) from the publisher. Not indexed. Not illustrated. 1900 Excerpt: ... cut in it, leaving several small points which are liable to fly off as soon as they are hardened or when you are drawing the temper. Now, my way to prevent the corners from coming off, and keep the dies straight is this: I heat my die very carefully in a clean charcoal fire, being careful not to get it any hotter than is necessary to have it harden. When the proper heat has been obtained, grasp it with the tongs near one end in such a way that it can be put in the water perpendicularly, and while in the water I turn it to a horizontal position and take it about half-way out, letting it remain until it is cool enough on the face to take out entirely for an instant without permitting the temper to run down. Then I withdraw it and return it to the water several times very quickly until it is cool enough to take out and scour off. The temper can then be drawn to suit, without any danger of the corners flying off. The object in putting it in the water perpendicularly is to keep it straight; and, as it cools off all alike, when you bring the back out of the water the heat rushes up toward the back, and expands it, taking all the strain off the face of the die and preventing it from breaking. By plunging it into the water and withdrawing it very quickly, the face of the die has time to get cool gradually, and the corners are thus prevented from flying off. This process will work well on any dies or tools hardened in this way. I have tried it hundreds of times with the best of success.--By G. B. J. Tempering Small Articles. When tempering cold chisels, or any other steel articles, heat to a very dull red and rub with a piece of hard soap, then finish heating and harden in clear, cool water. The potash of the soap prevents the

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