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**Spalding Precision Forging Assures
Quality Club Heads**

By **JAMES M. LONG**
Assistant Manager, Golf Club Dept.
A. G. Spalding & Bros.

The head is the most important part of the club and the secret of making good iron heads is to start with a forged head which is as accurate as possible.

It is not the general practice in the forge industry to work as close as we



Bill Duncan, one of the skilled craftsmen who do the important work of making master models and special order irons, is checking a head with a precision gauge.

do in our drop forge and many experienced forge shop owners, who visit our plant, are amazed that we have made a "watch factory out of a drop forge". If we had to use the general run of the mill forging, instead of our own precision forged heads, we wouldn't be able to work as close as we do now in making our finished matched sets. We insist that our forgings do not



Machinist Robert Champigny is operating a huge machine called a Hydro-tel used in making forging dies in Spalding's machine shop. Instrument at the left cuts out exact pattern of the model at right. Dies cut on this machine from the master model are accurate to 8/1000 of an inch.

vary more than 5/1000 from the master model in size and shape or a fraction of an ounce in weight. Because of this high precision forging we can maintain closer tolerances for size, shape, and weight.

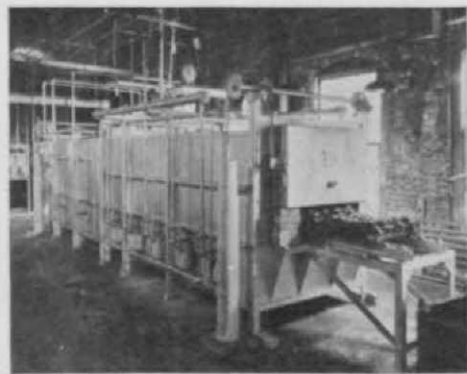
To illustrate briefly I will mention the six major operations following forging and the features of the forged head that are the most important to each of these processes: **broaching**—head that has a straight face and is accurate for size; **centerless grinding** and **drilling**—heads



Three stages in the forging of a head. (Right) The bar after it has been bent. (Middle) After two blows in the blocking impression. (Left) Forging about to be cut off from bar of steel.

with perfectly round hosels; **face scoring** and **stamping**—heads that have a maximum of face scoring and are tops in appearance; and **polishing**—one of the most important and skillful steps.

The first important step in making an iron club is producing a master model of the iron to be made. This has to be hand forged from a steel bar. Naturally



After heads have been forged they are put through this large annealing furnace where they are heated and then allowed to cool off slowly under carefully controlled conditions. This process softens the steel and gives the head the same "feel" as mild steel.

February, 1950



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MURDOCK



much of the work on this master model is dependent on the trained eye of the skilled craftsman, however, he checks his own work with high precision gauges and fixtures to measure lie, loft, hook, slice, face progression, blade length, blade outline, top line, and sole line thickness. From this master model the forge die is made.

We not only make the forge dies but also the hot strike dies, trimmer punches and dies, broaching fixtures and cutters, drilling fixtures, stamping fixtures and face scoring fixtures and dies. Precision tools are necessary to produce dies from

Use

WEEDANOL

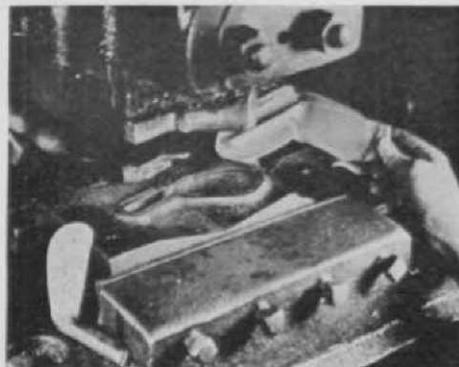
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"Flash", the excess metal around the head proper is trimmed off in this punch press.

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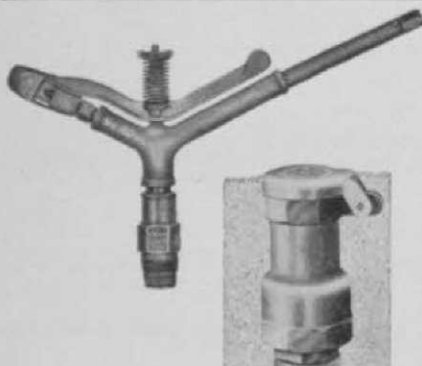
132 Church Street

New York 8, N. Y.

which finely matched precision sets of clubs are made.

It takes between 80 and 100 hours to make one set of dies, time that could be spent otherwise if we didn't know that the forging of our own heads was so important in the production of the finest matched clubs.

Forging is a very interesting and difficult work. We use a very tough stainless steel alloy, made to our own specifications, and we heat the bars in a furnace where the temperature is regulated, by control equipment, to a heat that is as



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free from scaling as possible and yet gives the proper forging heat.

After the solid round bar is heated it is forged into a club head by an average of six blows from the drop forge hammer. First the operator bends the straight piece of metal so that it has the rough angle or shape of an iron head. Next he strikes it with two blows in the blocking impression of the forge die, and then two more in the finishing die, to complete the forging cycle. After the forging is hot trimmed it is re-struck in a single impression finishing die. This hot striking process gives a super finish perfect head. The final operation in the drop forge is to



A section of the grinding and polishing room where a large group of experienced operators hand-grind the heads to their final shape and size.

pass the forgings through the annealing furnace to soften the steel and make it 'feel' the same as mild steel.

After the heads have left the drop forge they are carefully sorted in sets, correct shafts are selected for each set,

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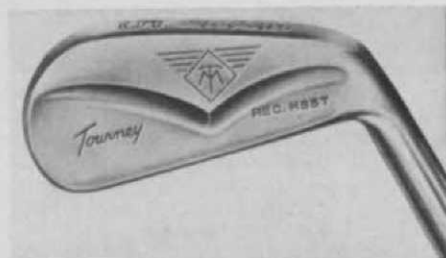
Ed C. Goeckel, 8811 S. Laflin, Chicago, has been appointed special sales representative by Rhee Elastic Thread Co., Warren, R.I. Ed, for many years in charge of Wilson's field and laboratory golf ball research and factory operations, is highly qualified for the golf ball thread phase of the Rhee production.

JACOBSEN SERVICE SCHOOL



A representative of the Service Department, Jacobsen Manufacturing Co., Racine, Wis., discusses the finer points in the construction of a Jacobsen Lawn Queen. The company is conducting a series of mid-winter classes on the servicing of power mowers. Dealers and servicemen from all parts of the country attend the three-day courses.

MacGREGOR'S "MT" TOURNEY BLADE



The "MT" Tourney blade shown above is gaining a fine reception for the company's new line of clubs, according to officials of the MacGregor Golf Co. Main features of the blade are compactness and scientific placement of weight at the heart of the club. The new club is sold through professionals only.



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