

Their Royal Majesties

Lars Wolfblut III & Mary of Carrigart III

(Michael Luthner) trh@northshield.org, (612)845-8229.

(Kate Luthner) trh@northshield.org, (651)341-4332 Call between 5 & 10 p.m. CST to talk to a real person.

Chamberlain/Chief of Staff Wu Yun (reign36chamberlain@gmail.com)



Their Royal Highnesses

TBD

The Stallari Qouncil of Northshield



Kingdom Seneschal seneschal@northshield.org Sorcha Bhuidhe (Sarah Oldenburg Garcia)

(715)497-9767



Kingdom Polaris Herald herald@northshield.org Ysolt Pais de cuer (Laura Knappenberger) (414)761-9603 (*Please call before 9:30pm*)



Kingdom Exchequer exchequer@northshield.org Æsa Gilsdottir (Angie Gilmore) (608)825-6768



Kingdom Chronicler chronicler@northshield.org Arnbjørn Karlsson (B Wesley Adams II) (414)326-5197



Kingdom Minister of Arts and Sciences moas@northshield.org Farolfus filius Richardi (Sebastian Renfield)



Kingdom Earl Marshal kem@northshield.org Siegfried von Kulmbach (Chris Kalmbach) (608)301-5566



Landed Barons and Baronesses

Barony of Caer Anterth Mawr



Abelard die Elster (Paul Knappenberger) baron@caeranterth.org; (414)761-9603 (No calls after 10pm)

Ysolt Pais de cuer (Laura Knappenberger) baroness@caeranterth.org; (414)761-9603 (*No calls after 9:30pm*)



Barony of Castel Rouge

Gabriel De Lion (Michael DeLine) dj_archangel@hotmail.com; (204)979-0550 (*No calls after 9pm*)

Nadrah al-Zahara (Amy Pickard) nadrahsca@gmail.com

Barony of Jararvellir

Athelyna de Chestre (Ty Patterson) athelyna@jararvellir.org; (715)781-3833

Jois Corbet (Deena Patterson) baroness@jararvellir.org; (608)628-5059 (No calls before 9am or after 10pm, unless emergency)



Barony of Nordskogen Gabriel Kjotvason (Patrick Anderson)

baron@nordskogen.org; (952)412-4112

Caoilfhionn inghen Cheallaigh uí Mhórdha (Kellie Hultgren) baroness@nordskogen.org; (612)804-1159



Barony of Candhaven Hamish de Nisbet of the Clan Nisbet hamish2@hotmail.com; (920)284-7807

Markéta Barfussin (Melissa Heenan) mgaywont@gmail.com; (920)265-4023 (Please call between 9am & 10pm)

The Northwatch – June 2023

Northshield Svent Galendar

NOTICE: All events are subject to being canceled if, at the time the event is to be held, modern civil authorities have issued restrictive orders related to public gatherings pursuant to their COVID-19 mitigation efforts.

Although the SCA complies with all applicable laws to ensure the health and safety of our event participants, we cannot eliminate the risk of exposure to infectious diseases during in-person events. By participating in the in-person events of the SCA, you acknowledge and accept the potential risks. You agree to take any additional steps to protect your own health and safety and those under your control as you believe to be necessary.

May 2023 (AS LVIII)

- 13Northshield Spring Crown Tournament, Shire of Darkstone (Ashland, WI) 🖄 🖄
- 20Deadline for July 2023 Northwatch (Welcome!)
- 26-28.....Raid the Brewery, Shire of Rivenwood Tower (Mankato, MN) 🖄
- **26-29.....Feathers and Steel**, Shire of Schattentor (Piedmont, SD)

26-29.....War Practice Weekend at the Roost, Barony of Caer Anterth Mawr (Mukwanago, WI) **June 2023 (AS LVIII)**

- 3.....Castle Fever, Shire of Silfren Mere (Oronoco, MN) 🖄 🖄
- 9-17.....Lilies War, Kingdom of Calontir (Smithville, MO)
- 10Skirmish at the Border, Barony of Jararvellir (Stoughton, WI) 🖄 🖄
- 20Deadline for August 2023 Northwatch (Home Goods)
- 23-25.....Midsummer's Eve: Academy of Arts & Sciences, Shire of Tremont (Wessington Springs, SD)
- 23-25.....Known World Heraldic & Scribal Symposium, Barony of Caer Anterth Mawr (Milwaukee, WI) 堂
- July 2023 (AS LVIII)
- 13-16.....Warriors & Warlords 28, Barony of Jararvellir (Tomah, WI) 🖄 🖄
- 20Deadline for Septembor 2023 Northwatch (Youth)

28-Aug 13 .Pennsic War 50, Kingdom of Æthelmearc (Slippery Rock, PA) 🖄 № August 2023 (AS LVIII)

- 18-20.....BYOM (Bring Your Own Marshal), Shire of Vilku Urvas (Deer River, MN)
- 18-20.....Poor Man's Pennsic, Shire of Falcon's Keep (Wisconsin Rapids, WI)
- 20Deadline for August 2023 Northwatch (TBD)
- 26Crispin's Archery Thing, Barony of Nordskogen (Otsego, MN) 🖄 🖄



Sovereign will attend ≌ Sovereign's Consort will attend ≝ Royal Heir will attend ≌ Royal Heir's Consort will attend
Laurel Meeting @ Pelican Meeting
Defense Meeting
Chivalry Meeting ★ Stallari Meeting

Listing your event on the calendar does not place an ad in the *Northwatch*. To submit your event advertisement for publication in the *Northwatch*, submit the required information to the Event Information Officer (calendar@northshield.org) before the 15th of the month before the month of publication (i.e., May 15th for the July issue). To contact the Northshield Event Information Officer, send a message to calendar@northshield.org.

QUARTERLY BOARD MEETINGS

All meetings start at 10:00 am. Note: Attendees are asked to wear modern clothing to Board meetings. (Agenda deadlines are first of month of meeting.) **Meetings are tentatively scheduled for the following locations; however, depending on "safer-in-place" regulations in effect, meetings may be handled by VoIP. July 2023 meeting: TBD. October 2023 meeting: TBD. January 2024 meeting: TBD.

SQA Contacts

Society Seneschal

Lis Schraer (Elasait ingen Diarmata) (314)941-0831; seneschal@sca.org

Northshield Ombudsman Jennifer Krochmal (Duchess Kalisa Aleksandrovna) jkrochmal@director.sca.org

Society Registrar (Memberships/Insurance) Louise du Cray (800)789-7486 x202; louise@sca.org

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proofreading this issue.

For more information about the Society for Creative Anachronism and the Kingdom of Northshield, please visit our websites:

Northshield: www.northshield.org

SCA: www.sca.org

This is the June 2023 issue of the Northwatch, the official newsletter of the Kingdom of Northshield. Northshield is a branch of the Society for Creative Anachronism, Inc., and the Northwatch is published as a service to the SCA's membership. Subscriptions are available only to members. Memberships are available from the Member Services Office, SCA, Inc., P.O. Box 360789, Milpitas, CA 95036-0789. Online version of the newsletter can be found at enewsletter.sca.org. All changes of address or questions about subscriptions should be sent to the Corporate Office. Membership information and a subscription form are included in the Northwatch as possible.

Advertising rates: \$50 for 1/2 page, \$30 for 1/4 page, \$25 for 1/8 page. All advertising is on a pre-paid space-available basis. Checks should be payable to "SCA, Inc. – Kingdom of Northshield."

For details, contact the *Northwatch* Editor at northwatch@northshield.org or visit http:// northshield.org/Posts/Display.aspx?ID=2477.

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Their Royal Majesties

No missive this month.

Lars & Mary

Their Royal Highnesses



Be kind to one another.



Ysolt



Greetings, Exchequers!

Not a whole lot for me to say this month. PayPal and updated Kingdom financial policies are still not approved as of this writing, so the published versions are the most recent.

Enjoy this all-too-brief summer!

In service,



No missive this month.



The Virtual A&S Display is available here: https://sites.google.com/view/northshieldkasf-2023/virtual-as-display

Farolfus

V Kingdom Chronicler

Greetings unto the populace of Northshield,

Summer has arrived in Northshield (as I doubtfully write this missive in chilly April). Congratulations to our new heirs. The royal succession is secure.

Speaking of successions, this month marks the beginning of my second year as Kingdom Chronicler. Come December, the office will be officially open for letters of intent, for my successor to step up in June AS 58. I mention it now, to encourage people to begin thinking about applying. As a great office of state, the office has a voice and the responsibilities of being a member of the Stallari Council. It is largely an administrative position, overseeing the more specialized deputies and making sure those positions are filled. One of my favorite duties is submitting nominations for the William Blackfox Awards, the Society chronicler awards. While experience as a chronicler, webminister, and/or social media officer can be helpful, it is not required. If you have questions about the Kingdom Chronicler position, or would like to be a Deputy Kingdom Chronicler, to get a feel for the office, please let me know. I am working to make sure all the infrastructure for the office is in place for my successor.

Speaking of infrastructure, work on the new kingdom website is proceeding well. A solid foundation has been laid and we are nearing the building stage. This is where the kingdom needs your help. There are four positions the website development team needs volunteers for the following:

Special Deputy: Web Service Developer

This is a limited-term role under the Webminister. This individual will assist in the creation of the new Northshield website. Desired skills or knowledge includes MySQL, PHP, JSON, and Git Experience.

Special Deputy: Web Plug-In Developer

This is a limited-term role under the Webminister. This individual will assist in the creation of the new Northshield website. Desired skills or knowledge includes programming for WordPress. Plug-In Maintainers and Database Programmers with knowledge of WordPress Security Architecture, Object Oriented PHP, JSON, JQuery, MySQL and Git experience are also desired.

Special Deputy: Web Front End Developer

This is a limited-term role under the Webminister. This individual will assist in

thecreation of the new Northshield website. Desired skills or knowledge includes WordPress theme design/development (Website designer, GUI designer, PHP programmer, all in one),JSON, AJAX, and Git experience. Javascript knowledge a plus.

Special Deputy: Web Administrator

This is a limited-term role under the Webminister. This individual will assist in the creation of the new Northshield website. Desired skills or knowledge includes DNS administration, website backup administration, general administrative tasks, and Git experience.

All positions are open until filled. Applications should be sent to the Kingdom Chronicler (chronicler@northshield.org) and Kingdom Webminister (webminister@ northshield.org).

Now, for my monthly pitch for volunteers. We have a number of kingdom deputy offices open. Open offices include:

- Emergency Deputy Kingdom Chronicler
- Kingdom Archivist/Historian
- Media Relations Deputy
- Deputy Northwatch Editor
- Western, Central, and Eastern Regional Deputy SMO
- TikTok Deputy SMO

Many hands make light work. If anyone is interested in learning more about the Chronicler's office, and/or is interested in becoming either a local group chronicler or a Deputy Kingdom Chronicler, please let me know. I will be very glad to talk to you about it.

Saving the Best For Last, after eleven years, the *Well-Versed Northwatch* returns! The WVN is the songbook of the kingdom. We are looking for songs, poems, short stories, and cover and interior artwork. Submissions are due by June 6, 2023. Email them to northwatch@northshield.org. Please use "Well-Versed Northwatch" in the subject line, to make it easier for the *Northwatch* editor to sort the submissions. Submissions need to include SCA Creative Work Copyright Assignment/Grant of Use Form.

Ever in service to Crown, Kingdom, and you,

Arnbjørn



Cén scéal? What's the news?

Our upcoming newsletter themes are as follows, but please submit art and articles on any topic for the edification of the kingdom.

- May 20 Welcome! How can we help make Northshield a welcoming place to all our newcomers in all their diversity? Share your thoughts and messages of welcome; advice for newbies in your art, craft, or martial endeavour; and pictures of your own beginnings in the SCA.
- June 20 Homely Goods What physical items make your table, camp, or presence space more homey? What (e.g., dishes, furniture, or lighting) do you have that is period-appropriate for you and where did you get it or how did you make it? What period items would you like to have (practical/realistic or not)?
- July 20 Youth of the Kingdom The (parents/guardians/teachers of) children and teens of Northshield are encouraged to send in our youngest members' A&S projects, fighting kit or garb photos, stories, or any other spiffiness they would like to show off. Let's celebrate the future of Northshield!

Please send all questions or submissions to northwatch@northshield.org.



No missive this month.

Siegfried



SCA CORPORATE ANNOUNCEMENTS

POSITION AVAILABLE – MARSHAL OF THE SOCIETY (SOCIETY MARSHAL)

The Marshal of the Society's area of authority is all martial and related activities practiced in the Society, both those described by the handbooks approved for the office and proposed as additions to those handbooks (experimental activities). The Marshal will work to encourage the participation of all in the Society's martial activities, and strive to expand and improve those activities for the benefit of the Society and its members.

The duties of the office include:

- Directing the Earl Marshals of the Kingdoms in matters concerning the supervision of martial and related activities at Society events
- Overseeing the manner and conduct of duties of all marshals throughout the Society
- Working to promote and improve the safety of the Society's martial activities
- Working with the Minister of Arts and Sciences to encourage research in armor, weapons, and the practice of historical martial arts

Day-to-day work of the position entails administering the marshallate activities of the Society and coordinating the activities of the Kingdom Earl Marshals, and of all Deputy Society Marshals for the individual disciplines. Reports are required to be filed quarterly to the Board summarizing the martial activities of the Society. The Society Marshal is also responsible for maintaining communications with the Kingdom Earl Marshals. These activities specifically include:

- Warranting (with the Crown) Earl Marshals for twenty kingdoms
- Warranting (with the Board) Deputy Society Marshals for Armored, Rapier, and Youth Combat, Combat Archery, Siege Weapons, Equestrian, Rebated Steel, and Target Archery and Thrown Weapons, and other deputies as needed
- Supporting the Earl Marshals when they have questions, and advising them as necessary
- Resolving disputes among marshals, and between marshals and the Crown
- Serving as the point of appeal for sanctions applied by the Earl Marshals
- Encouraging the expansion of martial activities in the Society by the wise revision of the marshallate's documents and by conducting experiments with new materials and activities

The successful candidate must be well versed in administrative techniques, problem solving, and interpersonal communications. The successful candidate will possess:

- Knowledge of marshallate policy, rules, and procedures
- Knowledge of the traditions of the Society
- Extensive negotiation skills and experience in resolving differences

- The ability to set aside all preferences and biases for the betterment of all
- Patience in the face of emotion, advocacy and provocation
- Expertise in the use of modern communications media, messaging, e-mail and telephone
- The ability and availability to travel as necessary

Interested applicants should send a letter of interest, together with modern and SCA qualifications, hardcopy to:

Louise Du Cray, P.O. Box 611928 San Jose, CA 95161

with courtesy copies to resumes@sca.org.

The deadline for applications is June 15, 2023 and is open to members of SCA Inc and all affiliates.

ACCIDENTAL RELEASE OF BUSINESS-IN-CONFIDENCE INFORMATION

On January 29th, 2023, SCA Inc. Information Technology was notified by concerned members that the archives of the SCA-Comments list serve were accessible to the public. Although it is not the designated reporting channel, the comments email address has, at times, been used as a harassment and discrimination reporting vehicle. Subsequently, the breach had the potential to jeopardize a victim's right to privacy and SCA Inc's responsibility of protection for them. Upon receipt of this information, my team immediately acted to shut down the breach. However, data had been exposed long enough that several search engines had crawled and archived the data. The extent of this security breach was emails sent to along side of comments@lists.sca.org/SCA-Comments@ lists.sca.org between March 2020 and January of 2023.

The initial exposure was contained within a few hours of notification. Over the next couple of days other avenues of exposure to the same and similar data were found and locked down. My team began the process of getting the search engines to remove their archives of the information. At this point, we believe all access to that data has been removed and we feel that publishing this information will not cause further risk to any individuals concerned or the organisation.

The root cause of the breach was a misconfigured archive setting when the email address for comments was changed last year. To prevent further similar occurrences, SCAcomments has been moved entirely off the list serve system. The correct email address for comments is "SCA-comments@sca.org" (although the 'lists.sca.org' address will still work for now). This has been active for some time.

SCA Inc. Information Technology apologizes for any alarm or inconvenience anyone may have suffered because of this breach. Particular thanks go to Matthew Simon Ryan Cavalletto (Mathghamhain Ua Ruadháin) for initially alerting us to and helping assess the scope of the issue.

Anyone wishing to further discuss this matter should contact me (it@sca.org) and John Fulton, SCA Inc. President (president@sca.org).

Sam Davis, Manager, Information Technology

Correction: The announcement originally incorrectly noted the breach as occurring between April of 2022 and January of 2023. Thanks to Kevin Rhodes (Cormac Mór) for alerting us to the error.

MEMBERSHIP CARD UPDATE

I am pleased to announce that Membership Cards are back! If you've renewed your membership during the past quarter and elected to receive a paper membership card, keep an eye on your mailbox. The files are at the printer and all cards will go out via USPS beginning Wednesday, April 19. Going forward, membership cards will be printed and mailed twice a month to ensure that people who select the physical card option will receive it in a timely fashion.

A new fully-digital option for your SCA Membership Card will shortly be available. Proof of membership details will also continue to be accessible through the Membership Portal.

Transferring from our old system to a completely new type of CRM certainly presented some unique challenges from a data import perspective, but I am happy to report that nearly all issues affecting member profiles have been resolved. Thank you to everyone who has patiently assisted us with discovering and resolving these bugs so far.

As you may know, this significant systems upgrade coincided with some extremely severe winter weather in the San Francisco Bay Area, where the Corporate Office is located, and our small staff is now working through a significant backlog of requests and communications. We have temporarily taken on additional resources to address this, and it is anticipated that membership processing will return to a more regular cadence from late April onward. The need to find new software also presented us with the opportunity to reduce related costs. Our new member software represents an 83% annual savings compared to our previous system. This is part of our ongoing drive to find appropriate corporate savings wherever possible.

Thank you once again to everyone for their kindness and patience during this time. I continue to investigate opportunities to improve the portal experience based on your feedback and can be contacted at membership@sca.org. Please note that due to the high volume of correspondence we have received there may be some delays in response time.

Yours in Service,

Louise Du Cray

Vice President for Corporate Operations & Member Services

FEE INCREASE FOR INSURANCE CERTIFICATES

As of May 1, 2023, there will be an increase in fees for insurance certificates. The new rates for groups will be \$75 for non-equestrian insurance certificates and \$200 for equestrian certificates.

This change affects requests received on or after May 1. If you've already got an insurance request in process, even for an event taking place after May 1, there is no fee increase and no further action is needed.

Certificate Rates as of May 1, 2023

- General Liability with Additional Insured \$75.00
- General Liability, no Additional Insured \$0.00
- Host Liquor \$75.00
- Golf Carts \$75.00
- Equestrian \$200.00

This price rise is driven by an ongoing increase in insurance costs overall, in addition to a significant increase in the SCA's equestrian insurance coverage in particular. In comparison to 2019 (the last full year of SCA activities prior to the pandemic), the SCA's insurance premiums for 2023 increased by 16.9% and the premium for equestrian insurance increased by approximately 275%. The organization was looking at an even higher increase but were able to negotiate a small discount.

The majority of the SCA's insurance costs are covered by membership income. SCA Inc. uses this income to subsidize the cost on individual certificates at a current rate of 62% for event certificates and 69% for equestrian certificates.

Insurance certificates can be requested by emailing insurance@sca.org. Please note we are in the process of updating and digitizing the insurance certificate ordering process.



See the Kingdom website at http:// northshield.org/Posts/Display. aspx?ID=5722 or email the contact below for complete descriptions of the following positions; see email addresses on page 2.

- Lakes Regional Deputy Seneschal: Inquiries and applications should be sent to the Kingdom Seneschal. Open until filled.
- Woodlands A&S Regional Deputy: Inquiries and applications should be sent to the Kingdom Minister of Arts and Sciences. Open until filled.
- **Kingdom Youth Officer:** Inquiries and applications should be sent to the Kingdom Seneschal. Open until filled.
- **Regalia Minister:** Inquiries and applications should be sent to the Kingdom Exchequer. The anticipated changeover is ASAP.
- Emergency Deputy Kingdom Chronicler: Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- Kingdom Archivist/Historian: Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- **Media Relations Deputy:** Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- **Deputy** *Northwatch* Editor: Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- Western Regional Deputy, Central Regional Deputy, and EasternRegional Deputy SMOs: Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- TikTok Deputy SMO: Inquiries and applications should be sent to the Kingdom Chronicler. Open until filled.
- See Kingdom Directory for other current vacancies.













Courts of TRM Lars III & Mary III

KINGDOM ARTS & SCIENCES

A report from the court of Lars and Mary, held April 22, AS 57, in the Barony of Nordskogen at Kingdom Arts & Sciences.

Herald of Record: Abelard die Elster; Signet: Katerinka Lvovicha; Seneschal: Bazyli Bolesław z Krakowa.

RECIPIENT	HONOR	SCRIBES	
Hedwyg	Award of the Black Flame	Geirráðr hersir Kolbeinsson	
Gospatric de Reynes	Award of the Black Flame	Judith of Northwode	
David of Silfren Mere	Award of the Black Flame	Geirráðr hersir Kolbeinsson	



















DEAR ABBESS: I recently purchased a long and beautiful horn that I was led to believe was a unicorn horn, but I now fear I was hoodwinked and wish to confront the seller to demand a refund. I have heard scattered tales of a sea-creature with a single horn,

and I have reason to believe that my horn came from such an animal, not from a unicorn. But when I have attempted to learn more from books, the illustrations all seem to disagree on precisely what the creature looks like. Is the creature a fish? Or more like a sea-goat? How can I discern what sort of horn this is and prove that the merchant who sold it to me is a deceiver?

—On the Horn of a Dilemma

Dear On the Horn,

I believe what you are describing is known as the monocheros. As Thomas of Cantimpré wrote in his *Liber de natura rerum*, the monocheros is a one-horned beast with a most dangerous single horn on the front of its head and capable of wreaking destruction on ships and sailors, but it swims slowly enough that most ships can simply outrun it. Visual depictions do appear to vary, and it seems as though some show a large fish with a horn, as does Cantimpré, while Jacob van Maerlant shows a fish with a goat-like head and single horn in his *Der naturen bloeme*. Either way, this is a wholly different creature than the sea-goat, which possesses the front legs of a goat as well and is usually shown with a pair of curving horns. And, more to the point (see what I did there?), I predict you will

have a very difficult time trying to get a refund from an unscrupulous or ignorant merchant. Caveat Emptor. So I suggest you simply enjoy your purchase – one mythical beast's horn is likely as good as any other, don't you think? –ABBESS

For more information on the monocheros, see Bibliothèque Municipale de Valenciennes, MS 320 (*Liber de Natura Rerum*), f.117r https://patrimoine-numerique.ville-valenciennes. fr/ark:/29755/B_596066101_MS_0320/v0235.simple. selected Tab=thumbnail

KB Nationale Bibliotheek van Nederland KB KA 16 f.107v https://galerij.kb.nl/kb.html#/nl/dernaturenbloeme/ page/109/200m/4/lat/23.32208001137843/lng/-43.76953125

Do you have Medieval Problems? Ask Dear Abbess by writing to Northwatch@northshield.org, putting "Dear Abbess" in the subject.



File-Making

By Peter Joynar <peter@matrixrunner.net>

Introduction



I became interested in making a "common file." It's something that today we can get, machinemade, for a couple of dollars, but for a long time had to be made by hand. I was fascinated by

a YouTube creator "Clickspring." In a couple of videos, he made files [7] and case hardened them [8] in his efforts to recreate the Antikythera mechanism. One of the statements that he made was that mild steel makes a good stand-in for wrought iron because there is not enough carbon to harden the steel. He then proceeded to carburize the steel to increase its carbon percentage and ended up with workable files. I tried to replicate his methods, but used wrought iron, and concluded that he is wrong, and mild steel is not a good stand-in.

File number #3 is the "final" output of the process.

Examples of the tools in use:



Knife Maker 1524, Die Hausbücher der Nürnberger Zwölfbrüderstiftungen [10]

The Knifemaker

He is filing away at a dagger pommel using some form of a bench hook or attachment to resist the file pressure. There is also an additional file on the bench in the "ready to use" position.

Der Schmidt.



Book of Trades Blacksmith [2]

The Blacksmith

There are two files hanging off the side of the anvil stump. I'm not sure about the illustrated smith, but I can speculate from personal experience that the tools near the anvil like that are regularly used. I would suspect they are for hot work, not bench work.



Materials

- 1. High carbon steel (1090), teeth cut, hardened, tempered.
- 2. Mild steel, teeth cut, carburized, hardened, tempered.
- 3. Wrought iron, carburized, teeth cut, hardened, tempered.
- 4. Wrought iron, teeth cut, carburized, hardened, tempered.

Included are also a test mild steel piece and a wrought iron practice blank.

Notes from each sample:

1. 1090 plain high carbon steel. Likely steel of this quality would not have been readily available. At the time it is what I had available. The teeth were hard to cut into the steel. This was likely because my forging of the tang had air-hardened the steel. This file works as expected; the shallow teeth make the file not cut very aggressively. The teeth are well-formed and it will file wrought iron.

File-Making, Cont.

- 2. Mild steel. The teeth cut very nicely, but my attempt at carburizing was a little less successful. Overall, the process ends up with a file that does cut. It works better on softer materials like copper alloys (brass) and pewter, but did cut wrought iron. I think that it would dull fairly quickly, but had the case-hardening gone better the durability would be increased.
- 3. Wrought iron, carburized, then the teeth cut, hardened and tempered. The teeth were very hard to cut in, almost as hard as the high carbon steel. After carburizing the wrought iron, an annealing step would have made the teeth easier to cut. The end result was a file with reasonably well-formed teeth that does cut both softer metals and wrought iron.
- 4. Plain wrought iron. It was easy to cut the teeth, but they are not well-formed. There is tearing along the edges that, once carburized and hardened, resulted in a poorly-performing file.

From my test pieces I came to the conclusion that if carburization was used, the process needed to be applied to the blank before cutting the teeth. I think they more likely used a lower quality all-steel blank, or a forge-welded steel and wrought iron blank. Without at least some carbon, the teeth are too poorly-formed to be useful.

Process

Making a file requires a number of steps. None are difficult or require a lot of teaching to learn, but practice got me more consistency and better results. I followed these steps no matter what the material of the file was.

- 1. Forge the raw bar stock into a rough file shape with a tang. Tools required to perform this operation are
 - a. The forge Mine is a modern tool. I work in my backyard in a city and am not comfortable using charcoal in close proximity to neighbors and my house. The benefit that the propane forge brings is better heat control with less effort. In period, there would likely have been an apprentice or a child that looked after the fire.
 - b. Cross peen hammer I use a modern 1000 gram engineers' hammer with the faces rounded for forging. The hammers that I make are too light to move as much metal as I needed to with this project. My goal is to replace my modern hammer. The modern hammers are all steel, as opposed to wrought iron with steel faces; in the modern world steel is much cheaper to manufacture.
 - c. Anvil I used a modern London pattern anvil (Peter Wright roughly 1900-1930). From examples, I have seen in *Ironwork in Medieval Britain*[1] and the *Book of Trades*[2], the main difference is the physical size of the anvil. I did all of the drawing out on the face and the corners of the anvil rather than using the horn.
 - d. Large Tongs Modern manufacture-forged steel tongs, ½", for controlling the %" bar stock for rough shaping and welding. The period tongs are of similar construction, except they would have been wrought iron, not steel.
- 2. Refine the blank using a file. This step eliminates the hammer marks and forge scale, and gets the blank as flat as possible. Also this step puts blunt points on either end of the file.
 - a. A vice A modern bench vice, used to hold the blank while filing. I could have used some form of a bench hook. The vice is a little easier on my eyes and back.

- b. A file This step could have also used a grindstone for the same effect.
- 3. Strip the blank. This turns out to be a critical step as shown by Ken[6]. The blank is put into a stripping frame and then drawfiled. With the ends pointed, the blank can rock back and forth slightly. That eliminates the slight crown on the blank from the filing or grinding in the previous step.
 - a. Stripping frame I made this tool out of pine, nailed together with my forged nails. The splits in the holding surface do not affect the operation of the tool. Should I decide to make more files, this tool needs to be made out of a better wood with more care. For making the 6 or so blanks I prepared, it worked just fine.
 - b. File This step needs a single cut file. Depending on how well the previous step went, either more or less time was required.
- 4. Cut the teeth. The term for this a little deceptive, as the process is really punching the teeth. The tool is not sharp and there is a small flat on the tip.
 - a. Small anvil I used a modern eight-pound anvil from Harbor Freight, but a block of metal would have worked.
 - b. Soft metal spacer To protect the file teeth when cutting teeth on the opposite side of the blank, lead is recommended by Ken[6]. I used lead-free pewter cast into a long thin block.
 - c. Hold down strap I used modern rope for this; leather would have been better, but paracord was what I had on hand.
 - d. File-cutting tool I made one with a wrought iron body and forge-welded steel working surface. Were I to make more files, I would make the whole tool out of steel and make it more triangular and much smaller so that it would be easier to control.
 - e. Large hammer I tried a variety of sizes from small to sledge hammers and settled on a cheap engineers' hammer that is roughly 5 lbs. Larger is better, but a short handle is needed, as you're lifting and striking with the weight of the hammer.
 - f. Bench I used my saw bench to support the anvil and allow me to sit and hammer down on the file cutting tool.

Handles

I do not have any period sources for the handles for the files, so I used a very basic octagonal shape out of a soft wood. These are all pine with a linseed oil finish.

Tools:

- Wood bench plane Mine is an 1850's era single iron plane. I suspect in the past the handle would have been shaped with a knife. The plane is really a specialist tool for joiners.
- Bench knife Modern high carbon, low carbon steel knife. From the other examples that I have seen, the blade seems a little thin compared to the ones from finds in England[1].

Carburization – Case hardening

This is a speculative process that I attempted based off of the research and assumptions made by Chris from "Clickspring" [8]. I feel his logic is sound, in that all of the materials were available and the process is not really all that complicated, but to come up with the process you need to understand the chemistry, something that would not exist until very recently. The sealed crucible used by the smith in "Secrets of the Viking Sword" [9] I think is more plausible as a way to get carbon in the wrought iron. It produces billets, not surface carburization.

The short summary of the process used:

- 1. Crush up charcoal using a mortar and pestle.
- 2. Add to that a ratio of 6 parts charcoal, 4 parts salt, 3 parts wheat flour.
- 3. To that dry mixture, add enough water to make it into a cookiedough consistency.
- 4. Completely cover the files, and let dry completely.
- 5. Roll out a high fire clay into a thin flat sheet.
- 6. Wrap the clay around the charcoal cigars, and let everything dry.
- 7. Fire up the forge and get the files up to a welding temperature.
- 8. Let the process soak for about 40 minutes.
- 9. Break apart the clay and scrape off the bits down to the files.
- 10. Bring back up to non-magnetic and quench.
- 11. Clean off a section and temper to a pale straw.

The purpose of the clay is to seal from air and allow the carbon in gas form to get into the iron. Because of timing, the amount of fuel, and it being winter, I did all of the samples at once. I could see that I ended up with cracks in the clay and at least one of the vessels was actively burning the charcoal. Unfortunately, the worst of these was the wrought iron file number 4. The end of that file was burned and melted off.

Sources:

[1]I. H. Goodall, *Ironwork in Medieval Britain : an archaeological study*. Leeds: Maney, 2011.

A reliable secondary source, where the images and descriptions have been collected writings of the extent objects. The book is a catalog of items made from iron found in England from roughly 1100 to 1600. I find it useful for comparing lots of items from across time, for example comparing the shape of spoon bits across time.

[2]Jost Amman, H. Sachs, and B. A. Rifkin, *The book of trades = [Ständebuch]*. New York: Dover Publ, 1973.

A reprint of the the illustrated book of professions from 1568 that contains one of the few good examples of tools that I have found. Most trades require tools and they tend to surround the people performing the work.

[3]P. N. Hasluck, *Metalworking: old-fashioned tools, materials, and processes for the handyman.* New York, Ny: Skyhorse Pub, 2011.

A reprint of a 1907 work on the blacksmith trade, written in a time when the skills and techniques had been used in recent memory. Takes time to study, but in the absence of someone to ask, it can be a good stand-in.

[5]D. Frechette, "Blacksmithing Project - How To Hand Cut Files 2," www.youtube.com, 28-Jun-2017. [Online]. Available: https://youtu.be/QzkuIElUlQM. [Accessed: 26-Feb-2020].

DF in the Shop second video on making files, with many links and a good close-up on the file-cutting process. He did the best job of explaining how the process works. His first attempt had lots of comments, making the second video much better.

[6]K. Hawley, "Making Files by Hand," www.youtube.com, 08-Jun-

2016. [Online]. Available: https://youtu.be/FB58hkncznI. [Accessed: 26-Feb-2020].

An older gentleman describing the process of cutting files used up until the 1960s in England. I modeled my file cutting set-up off of his stump, anvil, and strap.

[7]C. Clickspring, "Antikythera Fragment #3 - Ancient Tool Technology - Hand Cut Precision Files," www.youtube.com, 09-Jul-2017. [Online]. Available: https://youtu.be/SOw9WqMOHjA. [Accessed: 26-Feb-2020].

Clickspring showing the carburization process he used to harden mild steel. He commented that mild steel is a good proxy for wrought iron. See other notes: I think he is wrong, but the process he used worked for me to get hardened steel.

[8]C. Clickspring, "Antikythera Fragment #4 - Ancient Tool Technology - The First Hardened Steel," www.youtube.com, 09-Jul-2017. [Online]. Available: https://youtu.be/V_Mp1fNzIT8. [Accessed: 26-Feb-2020].

Clickspring cutting files. This video convinced me that I could do it. His research seems to be solid and his practical explanations and experimental approach seem sound to me.

[9] Secrets of the Viking Sword. Nova PBS, 2012.

An hour-long Nova show on smithing, from iron ore to a completed sword with what seemed to be to be credible sources and methods.

[10]B. S. Library, "Die Hausbücher der Nürnberger Zwölfbrüderstiftungen," hausbuecher.nuernberg.de, 1542. [Online]. Available: https://hausbuecher.nuernberg.de/75-Amb-2-279-30-r/ data. [Accessed: 28-Feb-2020].

A set of images taken from period manuscripts that memorialize various tradesmen. The scans are very high quality and the amount of text that goes with them seems good. I used Google Translate to go from German to English.

Additional Images:

The wooden stripping frame.



On the following page, see close ups to show what I learned during the process:

 The file blank must be stripped. Filing flat in a vice is not good enough. The half moonshaped teeth show this process compared to these results:



This was done in a stripping frame. To use a stripping frame, you need to point both ends of the file so that it can rotate freely.

2. If you look at the steel in the previous figure, you can see a set of "ripples" in the material where the wrought iron was pushed out of the way during the cutting process. The mild steel (.05%-.30% carbon) in the image below does not have the same ripples. The wrought iron that I carburized, then cut teeth in, did not have this pattern. The teeth are much crisper.



Questions When Event Planning

By Grainne Dhonn <kyria.thalia@gmail.com>

- What's the restroom situation?
- a. How far will they be from the main action and what kind of accessibility options do we have planned? Do we need to rent accessible porta-potties to make sure people with mobility issues don't have too far to trek?
- b. Will there be changing facilities for infants?
- c. Will there be non-gendered restrooms available?
- Will people have free, easy access to water or will we need to provide it?
- Can the noisiest activities be located at one end of the event so that there are quieter areas for people who need them?
- Can we provide a separate quiet/calm space, if that's not feasible?
- Are there limitations on parking that will affect people with mobility issues?
- Is there seating available or will we need to arrange for benches/picnic tables, etc.?
- a. Can we make sure that some of these are along sidewalks/accessible paths?
- b. Is there shade available for the seating areas or will people need to bring/provide their own?
- Can we provide maps at the natural entry points to the event of what can be found where: restrooms, water, cooling station, etc.?
- Can we provide large schedules of events near the maps?
- What jargon are we using to advertise? Is this going to be comprehensible to people who have never attended this event before?
- Are there things that happen at [EVENT] that Everyone Knows About? Everyone doesn't know. Can we make sure that these things are mentioned/explained in the advertising and event booklet (if any)?

Thank you for considering these questions for the comfort and health of your fellow SCAdians!



The Northwatch – June 2023

JUNE 3, 2023

SHIRE OF SILFREN MERE

Castle Fever



Oronoco Community Center 15 2nd St NW Oronoco, WI 55960 USA Site opens 9am. Site closes 8pm.

Fees: Adult (18+) \$15 Adult member \$10 Youth (12-18) \$5

Under 12 free Family cap \$40

Checks payable to SCA WI Inc-Shire of Silfren Mere.

Planned Activities: Armored Combat, A&S Display, Rapier Combat, Thrown Weapons. Populace/presence space available. Site is ADA accessible.

Although the SCA complies with all applicable laws to try to ensure the health and safety of our event participants, we cannot eliminate the risk of exposure to infectious diseases during in-person events. By participating in the in-person events of the SCA, you acknowledge and accept the potential risks. You agree to take any additional steps to protect your own health and safety and those under your control as you believe to be necessary.

Event Steward Celestria de Clare ; nlheinz@live.com;

Kajsa Mulikka Metsasta (Millie Webb); millmow@outlook.com

https://castlefever.silfrenmere.org/



Event Steward Beatrice Domenici della Campana(Katherine Finegan) kfinegan@gmail.com Margaret Malise de Kyrkyntolaghe (Melissa Vigil) melissa.vigil@marquette.edu https://www.caeranterth.org/kwhss2023 JUNE 10, 2023

BARONY OF JARARVELLIR

Skirmish at the Border





Fees:Adult (18+) \$15Student member w/ID \$5Adult member \$10Youth (5-17) \$5Student w/ID \$10Under 5 free

Checks payable to SCA WI Inc-Barony of Jararvellir.

Planned Activities: Armored Combat, Bardic Activities, Classes, Rapier Combat, Youth Boffer Combat, Cut & Thrust Combat. Populace/presence space available. Site is ADA accessible.

Although the SCA complies with all applicable laws to try to ensure the health and safety of our event participants, we cannot eliminate the risk of exposure to infectious diseases during in-person events. By participating in the in-person events of the SCA, you acknowledge and accept the potential risks. You agree to take any additional steps to protect your own health and safety and those under your control as you believe to be necessary.

Event Steward Evelein Jantz (Storm Bird) aneira612@gmail.com

https://kristyanapplegate.wixsite.com/skirmishattheborder



Planned Activities: A&S Display, Bardic Activities, Classes. Rough hilly terrain in park. Some level sidewalks around site. Building is accessible. Populace/presence space available. Merchant space available. Saturday brunch and Saturday potluck feast planned.

Although the SCA complies with all applicable laws to try to ensure the health and safety of our event participants, we cannot eliminate the risk of exposure to infectious diseases during in-person events. By participating in the in-person events of the SCA, you acknowledge and accept the potential risks. You agree to take any additional steps to protect your own health and safety and those under your control as you believe to be necessary.

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https://sites.google.com/view/trewint/events/midsummers-eve

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The Northwatch - June 2023

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To report a change of officer or contact info

(address, phone, etc.), please contact your kingdom

superior - the Change of Officer form on the website is

only for new, incoming officers. New seneschals must

also send the appropriate paperwork to the Kingdom

Seneschal to be listed.

Parallax by Duchess Kaylah the Cheerful

