

Rivendell Bicycle Works



Twenty-four Month Lug Calendar

2000-2001

Why Lugs?

If you hang up a calendar featuring cars, puppies, sun-worshippers, kittens, pop stars, cheerleaders, quarterbacks, volley ball players, linemen, the other kind of linemen, the moon's surface, scenes from early '60s sitcoms, the Titanic, the work of famous deceased artists, Siegfried and Roy, mountains, waterfalls, swamps, or sailboats, nobody will ask *what's that?*

But hang up this calendar, and somebody will ask, because most people don't look twice at bikes, and those who do don't see many lugs these days. To make matters worse, calendarwise, these lugs are off the bike, so they're even more peculiar.

Some lugs have simple, flowing curves that blend beautifully; some are more medieval, some are angular. Some blend a mix of styles. As you look at more lugs, and spend more time looking at them (in a healthy way), your tastes may narrow or broaden. But, as B.J. Thomas sang so melodiously in his '70s masterpiece, *any kind of lug is better than no lug at all.*

Lugs affect a frame's strength, repairability, and appearance, but not how a bike rides.

Brazing bicycle frame tubes together with lugs used to be considered the only acceptable way to make a good frame, and all reputable makers offered at least their better models with lugs. But now, in the year 2000, the builders who use lugs tend to be tiny, one-to-four man shops who ignore market trends, dig in their heels and tell their concerned significant others that someday there might be a renaissance. The unpopularity of lugged framebuilding has nothing to do with results, and everything to do with process. It takes more time—the very best lugged steel frames take anywhere from 12 to 24 hours to build, not counting paint. Even semi-budget ones take between 5 and 10 hours. Big companies who necessarily have to watch the bottom line don't tolerate that. 'Good enough for the least cost' rules out lugs.

Lugs are unlikely to make a powerful comeback, and new riders may go their entire lives not having ridden or owned a fine lugged bicycle. But if this calendar has a purpose beyond being a tribute to lugs past and present, it's to get you thinking about lugs, and looking at them more carefully.

About the text

This is not the definitive work on lugs, it's just a calendar with a few facts, observations, opinions, and conjectures, with a good guess or two thrown in just to keep the armchair experts hopping. Richard Sachs and Roland Della Santa supplied many of the older lugs, and volunteered facts and recollections on the lugs I knew little or nothing about. — *Grant*

Rivendell Bicycle Works

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The Photos

***The photographs were taken by Marc Elliot, of Color Services, Inc.
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In case you are interested, Marc used a 4x5 Wista DX II with a Schneider APO-Symmar 150mm lens. Most of the shots were taken at 1/60 at F45, using two Broncolor strobes. The lugs were held in position with beeswax (the photographer's friend) and/or rare earth magnets.

Color Services is a full-service lab specializing in professional photographic services ranging from E-6 processing to large format digital graphics. Color and black-and-white.

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Dubois Model 32

January 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
						1 <i>International All Fool's Panic Day</i>
2 <i>Get On With Life Day</i>	3 <i>Bank Holiday in the U.K.</i>	4	5	6	7	8 <i>(Eid) al Fitr</i>
9	10	11	12	13	14 <i>Full Moon, but that's no excuse.</i>	15
16	17	18	19	20	21	22
23	24	25	26 <i>Australia Day</i>	27	28	29
30	31					

Rivendell Bicycle Works

← Ever Since 1994 →

It isn't clear whether Dubois was a model name or the name of the lug maker. But, at some point, Etablissements Aime Dubois sold this lug type and Nervex brand lugs. This set, the Model 32, was available with or without cut-outs, and in a variety of angles. Tommassini, Paletti, Masi, Richard Sachs, Peugeot, and DeRosa all used it. Say "doob-bwah."



Heron

February 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
		1	2 <i>Groundhog Day</i>	3	4	5
6 <i>Waitangi Day in N.Z.</i>	7	8	9	10	11	12
13	14 <i>Valentine's Day</i>	15	16	17	18	19 <i>Full Moon</i>
20	21 <i>President's Day (U.S.)</i>	22 <i>Washington's Birthday</i>	23	24	25	26
27	28	29				

Rivendell Bicycle Works
 ← Ever Since 1994 →

Designed by Waterford Precision Cycles, with some Rivendell input. The radiused lower head lug (left) eliminates a point in the stressed area. The seat lug includes seat stay plugs. The thick waists and scallops look strong, warlike, and a little fancy. Investment cast.



Bocama



March 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
			1	2	3	4
5	6	7	8	9	10	11
12	13 <i>Commonwealth Day (U.K.)</i>	14	15	16	17 <i>St. Patrick's Day</i>	18
19	20 <i>Spring Starts; and there's a Full Moon</i>	21	22	23	24	25
26	27	28	29	30	31	

Rivendell Bicycle Works
 ↳ Ever Since 1994 ⚙️

Among the producers of lugs and fittings through their demise in the '80s, Bocama offered the largest selection of styles, sizes, and prices. These particular ones were top of the line, and came on Flandria, Mercier, Austro-Daimler, Gitane, and many frames from small U.S. builders. Notice the beautiful, round spoons on the underside—typical of French lugs.



Henry James (road)

April 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
						1
2 <i>Daylight Savings Time Begins, except in Arizona</i>	3	4	5	6	7	8
9	10	11	12	13	14	15
16	17	18	19	20	21	22
23	24	25	26	27	28	<i>Earth Day</i> 29
30						

Rivendell Bicycle Works

← Ever Since 1994 →

Designed by Hank ("Henry") Folsom. His middle name is James. These lugs are made somewhere in America, and are the most widely available and popular lugs around, used by more builders than any other. Simple, classical, and available in stainless or regular steel.



Paramount/Match



May 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
	1 <i>May Day, Labor Day in Mexico, and it's a bank holiday in England</i>	2	3	4	5	6
7 <i>Mother's Day</i>	8	9	10	11	12	13
14	15	16	17	18 <i>Full Moon</i>	19	20
1	22	23	24	25	26	27
28	29 <i>Yet another bank holi- day in England</i>	30	31			

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

Designed at Match by Tim Isaac for Schwinn's 1998 model Paramount. As a nod to the Paramount's past, this lug set combines elements of Nervex Professional lugs, and takes advantage of the best investment casting technology. Compact, and light, it adds strength and classic styling to the latest Paramounts. The top head lug weights just 17 grams.



Richard Moon

June 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
				1	2	3
4	5	6	7	8	9	10
11	12	13	14	15	16	17
					<i>Full Moon</i>	
18	19	20	21	22	23	24
<i>Father's Day</i>						
25	26	27	28	29	30	

Rivendell Bicycle Works
 ← Ever Since 1994 →

Richard M. uses a felt-tip pen to draw a pattern on store-bought lugs, then drills holes in various places, as starting points for his jeweler's saw. He finishes the edges using small files. Each lug in a set takes four to five hours. His designs evolve as he goes, and influence future designs. All have moons!



Anonymous. The most intriguing lugs in the whole calendar, because they're the oldest, the crudest, as beautiful as any (in their own way), and we don't know much about them. We know: They're sand-cast, an ancient process still employed today in many industries, in which molten metal is poured into molds formed by various combinations of sand and rice hulls. They're from the 1930s. We think: They're from England, in which case they're likely a Chater-Lea or B.S.A. model—a frame fitting powerhouse from the early 1900s to the 1950s. Most of the top British

July 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
						1 <i>Canada Day in Canada, eh?</i>
2	3	4 <i>The 4th of July</i>	5	6	7	8
9	10	11	12	13	14	15
16 <i>Full Moon</i>	17	18	19	20	21	22
23	24	25	26	27	28	29
30	31					

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

builders during this time used fine cast British lugs from these firms, or the even finer ones from the superb Belgian maker, Ekla. These could be Eklas. Interestingly (maybe), the Nervex lugs followed in the mid to late '50s, and the keen snoots regarded them as cheap, stamped, mass-produced fake art for the "ignorant British club cyclist." The only person we know of who might be able to identify this set of lugs is Dick Swann.



Masi ('60s)



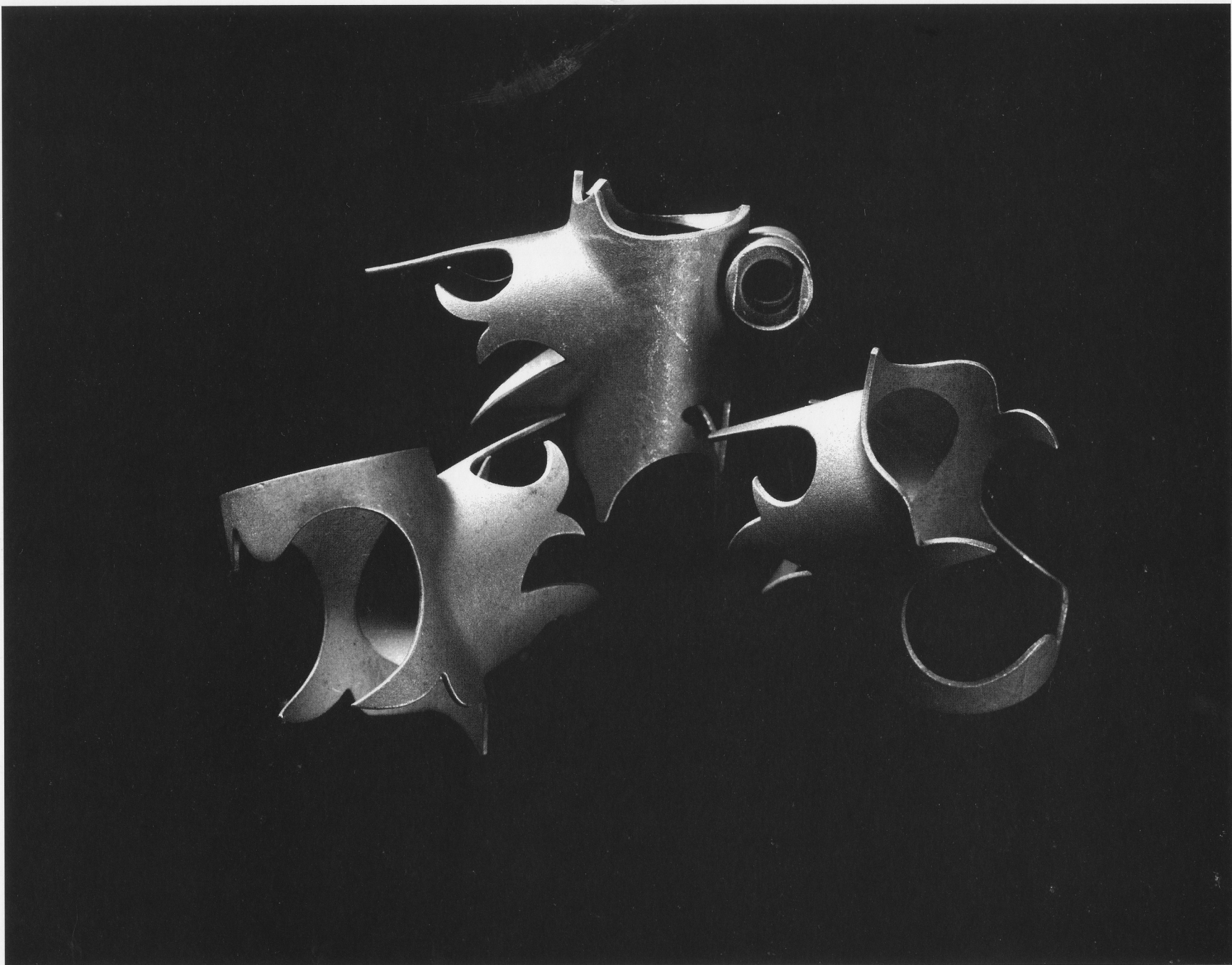
August 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
		1	2	3	4	5
6	7 <i>Civic Holiday in Canada</i>	8	9	10	11	12
13	14	15	16	17	18	19
20	21	22	23	24	25	26
27	28 <i>Bank Holiday in England</i>	29	30	31		

Rivendell Bicycle Works

← Ever Since 1994 →

This is a rare set of lugs from the early 1960s, used by Masi before they switched to Nervex Pros, and after that, the renowned Dubois Model 32 (January 2000). The latter wasn't made in January 2000, but is the lug of the month in this calendar for that month. The seat lug was used on some older Bianchi frames. From the collection of Roland Della Santa.



Rivendell RS Original (road)

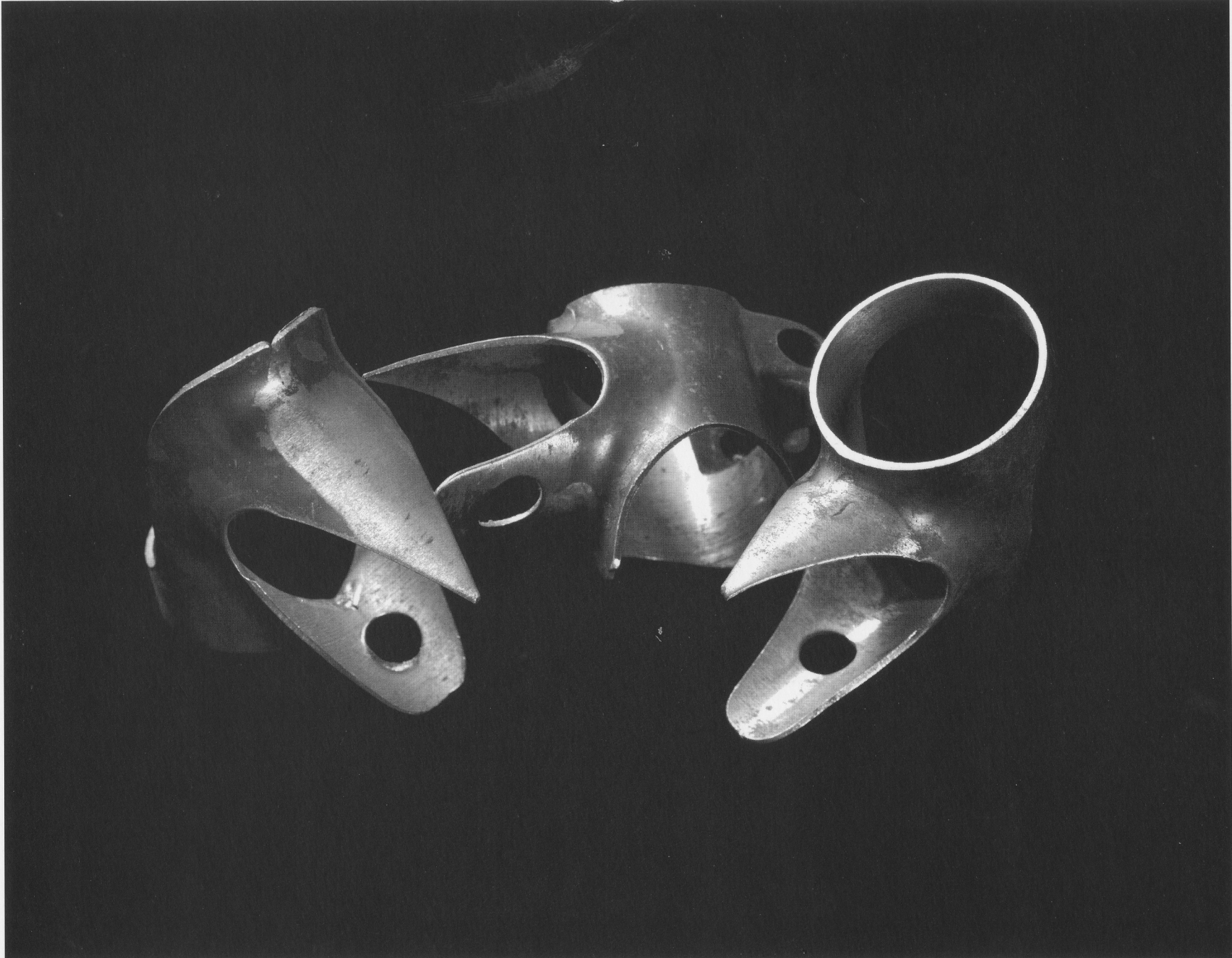


September 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
					1	2
3	4	5	6	7	8	9
10	11	12	13	14	15	16
			<i>Full Moon</i>			<i>Mexico's Independence Day</i>
17	18	19	20	21	22	23
					<i>Autumn begins</i>	
24	25	26	27	28	29	30
					<i>Rosh Hashanah</i>	

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

Our first road lugs, designed by Richard Sachs. We wanted and got something swirly, ornate, with classical styling. The seat lug has large, triangular windows on its backside, both to aid brazing and as something to paint in a contrasting color, to give whoever's riding behind you something to look at. Investment cast steel.



Cinelli



October 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
1	2	3	4	5	6	7
8	9 <i>1. Yom Kippur 2. Colón Day 3. Thanksgiving in Canada</i>	10	11	12	13 <i>Full Moon</i>	14
15	16	17	18	19	20	21
22	23	24	25	26	27	28
29 <i>End of Daylight Saving Time</i>	30	31 <i>Offer to let your chil- dren keep their 10 favorite pieces, and trade them a toy for the rest of them.</i>				

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

Cino Cinelli made his reputation with racing frames, handlebars, stems, and saddles. In the early '70s, Cinelli sold framebuilding parts, too. A variation on the well-known and popular Cinelli 'Super Corsa' style, the stamped steel lugs shown here were used by many builders in Europe and the U.S. The rounded spoons and circle cut-outs were distinctive. Still are!



Guinticiclo

November 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
			1	2	3	4
5	6	7 <i>Write in the candidate of your choice.</i>	8	9	10	11 <i>Full Moon Veteran's Day Remembrance Day in Canada</i>
12	13	14	15	16	17	18
19	20	21	22	23	24	25
26	27 <i>Ramadan, 1</i>	28	29	30		

Rivendell Bicycle Works

← Ever Since 1994 →

***Guinticiclo** was an Italian firm which made a variety of stamped lugs and fittings. This set was among the most popular with Italian racing bike makers Ciocc, Guerciotti, Gianni Motta, Liotton and others. These lugs were offered with a variety of cut-outs and engraving.*



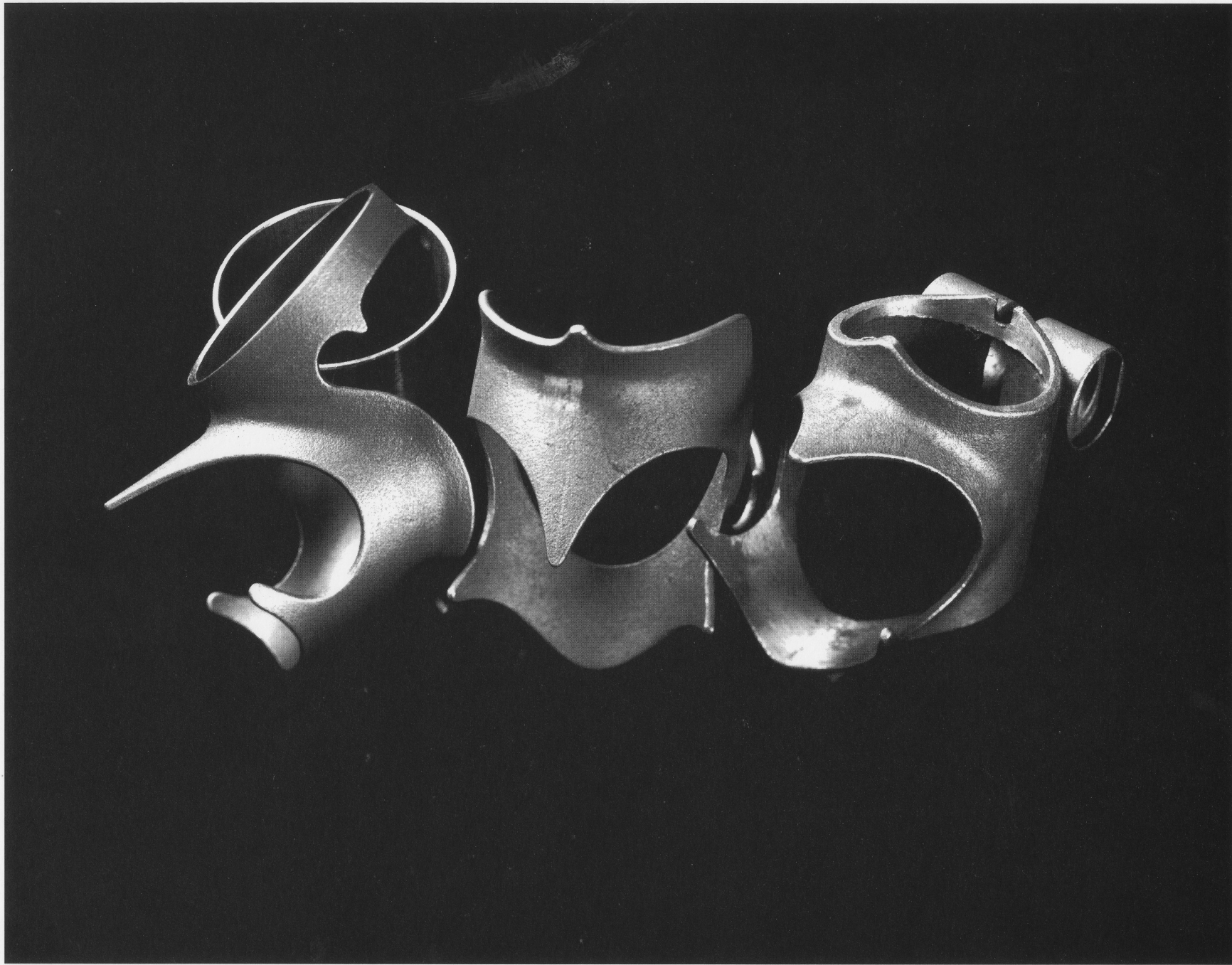
Serotta 1986 Tour de France

December 2000

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
					1	2
3	4	5	6	7	8	9
10	11 <i>Full Moon</i>	12	13	14	15	16
17	18	19	20	21 <i>Winter Begins</i>	22 <i>Hanukkah</i>	23
24 31	25 <i>Christmas</i>	26 <i>Kwansaa begins, and it's Boxing Day in Australia, New Zealand, England, and Canada.</i>	27	28 <i>(Eid) al Fitr</i>	29	30

Rivendell Bicycle Works
 ← Ever Since 1994 →

The 7-11 Tour de France team used Serotta frames built with these, carved from Henry James lugs and made to be as light as possible. The goal was a frame that would last a month of Tour racing, after which they were retired. As spartan as they are, there's no doubt that those same frames could go another several Tours. Serotta recently introduced replica frames.



Rivendell All-Rounder and Oversized Road (original)



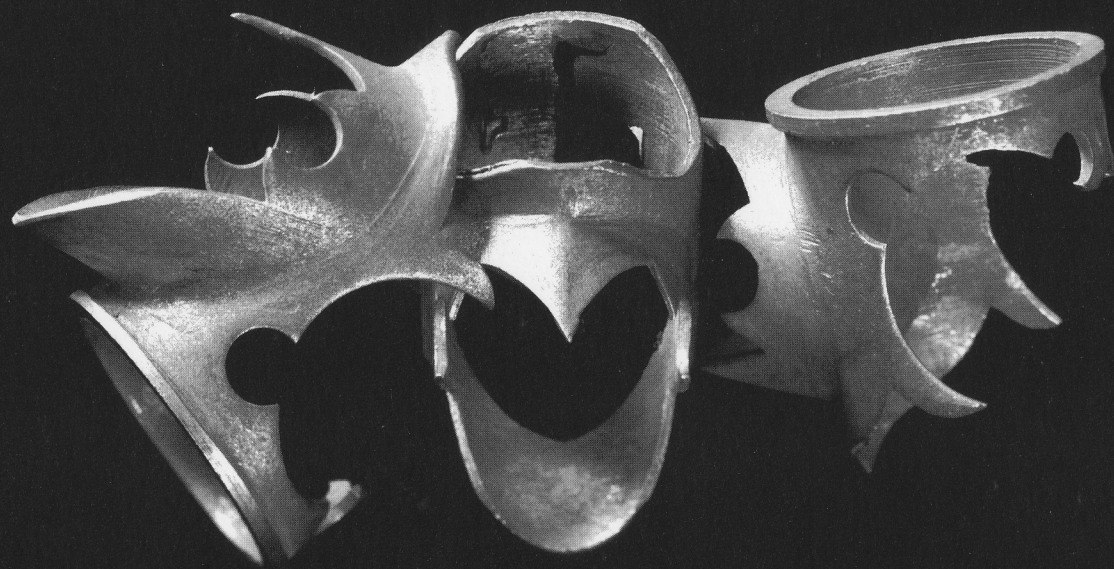
January 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
	1	2 <i>International "Now What Are You Going To Do With All That Canned Food?" Day</i>	3	4	5	6
7	8	9	10	11	12	13
14	15	16	17	18	19	20
21	22 <i>1854: The Flying Cloud left NY on what would be its record/fastest trip to SF</i>	23 <i>Ricky Damele's Birthday</i>	24	25	26	27
28	29	30	31			

Rivendell Bicycle Works

↔ Ever Since 1994 ↔

Co-designed by Waterford and Rivendell, with heavy influence from Haden "Polaris" lugs from the '70s. Used for the first several hundred Rivendell All-Rounders and big road frames. The underside "points" are rounded to distribute stress, and there's enough fanciness to shout a little, but they're still simple enough for people who don't like 'em fancy. Investment cast steel.



Nervex Professional



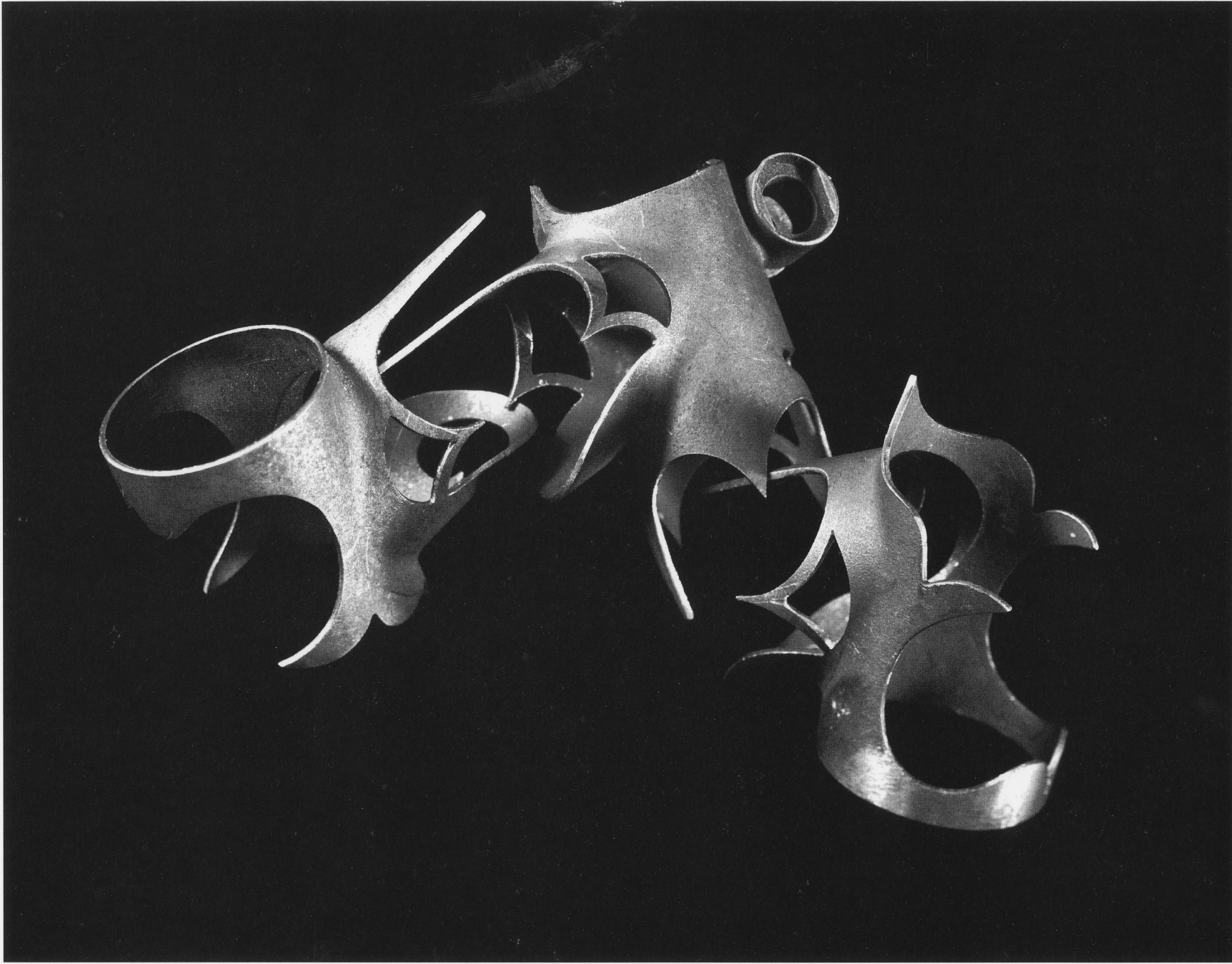
February 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
				1	2	3
	5	6	7	8	9	10
11	12	13	14	15	16	17
18	19	20	21	22	23	24
1855: The Flying Cloud left NY on its last trip to San Francisco.						
25	26	27	28			

Rivendell Bicycle Works

⚙️ Ever Since 1994 ⚙️

The most famous lug in the world, with circles, spurs, flukes, parrotbeaks, and spoons. It's the French at their best. But when it was first issued, it was seen as cheap art by cyclists accustomed to English and Belgian lugs, hand-cut from sand-castings. It is the most widely used of the fancies, having hit the big-time on high-volume bikes from Raleigh, Schwinn, Peugeot, and Mondial. Stamped steel. Born in the late '50s, popular for 20 years. Stamped and welded.



Richard Sachs 25th Anniversary

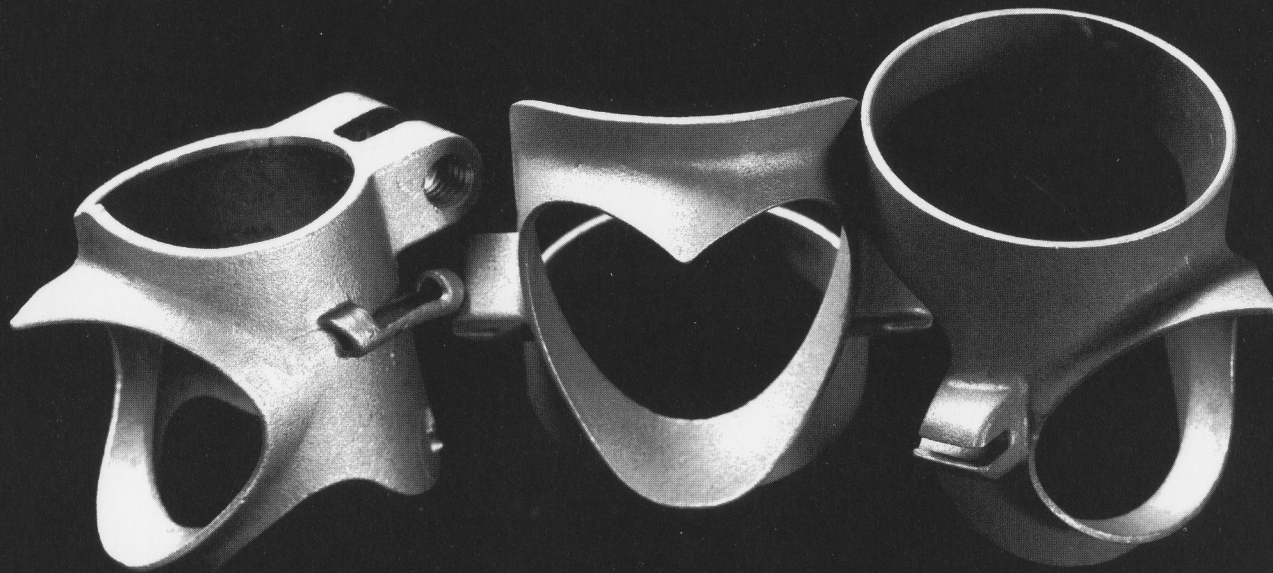


March 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
				1	2	3
4	5	6	7	8	9	10
11	12	13	14	15	16	17
18	19	20	21	22	23	24
25	26	27	28	29	30	31

Rivendell Bicycle Works
← Ever Since 1994 →

In an effort to keep the Rivendell RS originals exclusive to Rivendells, Richard chopped and channeled the design, added some side-specific cut-outs, and developed these, used on his 25th Anniversary frames and replicas. In an exclusive arrangement and as thanks for his design work, we supply Richard with the lugs, and he carves them up.



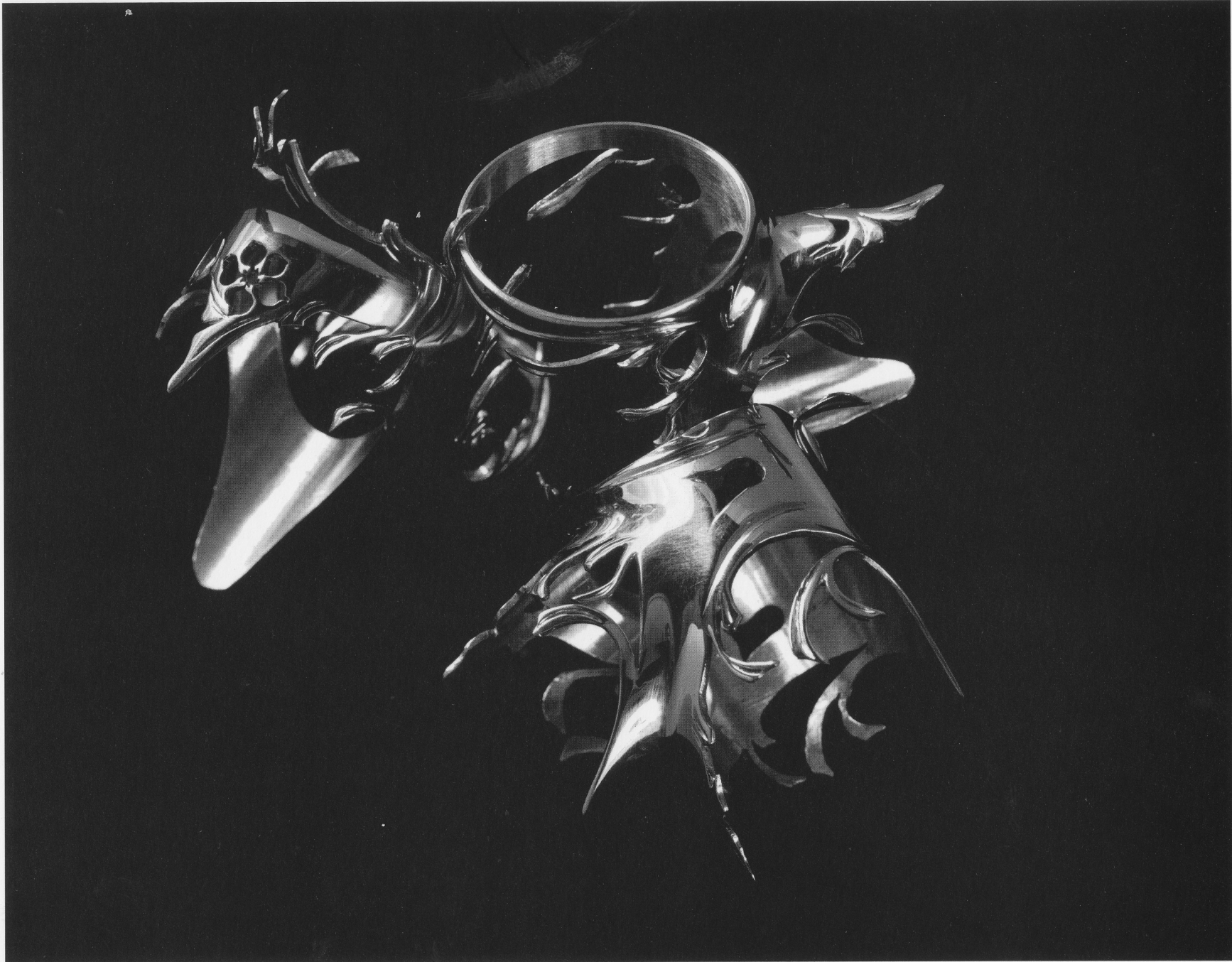
Waterford Road (Oversize)

April 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
1 <i>April Fool's Day</i>	2	3	4	5	6	7
8	9	10	11	12	13	14
15	16	17	18	19	20 <i>On 1/22/1854, The Flying Cloud left NY. Arrived today, 89d 8h later—a clipper ship record!</i>	21
22	23 <i>1853: The Flying Cloud left NY for SF. Will arrive 8/12, with a so-so time of 105d.</i>	24	25	26	27	28
29	30					

Rivendell Bicycle Works
 ← Ever Since 1994 →

Designed by Waterford Precision Cycles for its fine line of Waterford road frames. The cast-in cable stops on the lower head lug are a unique and clever nod to modern shifters, and eliminate the need to braze them on. With thin waists that almost touch the tube miters, this is one of the lightest lugsets ever, and helps Waterford build superlight lugged steel road frames.



Columbine

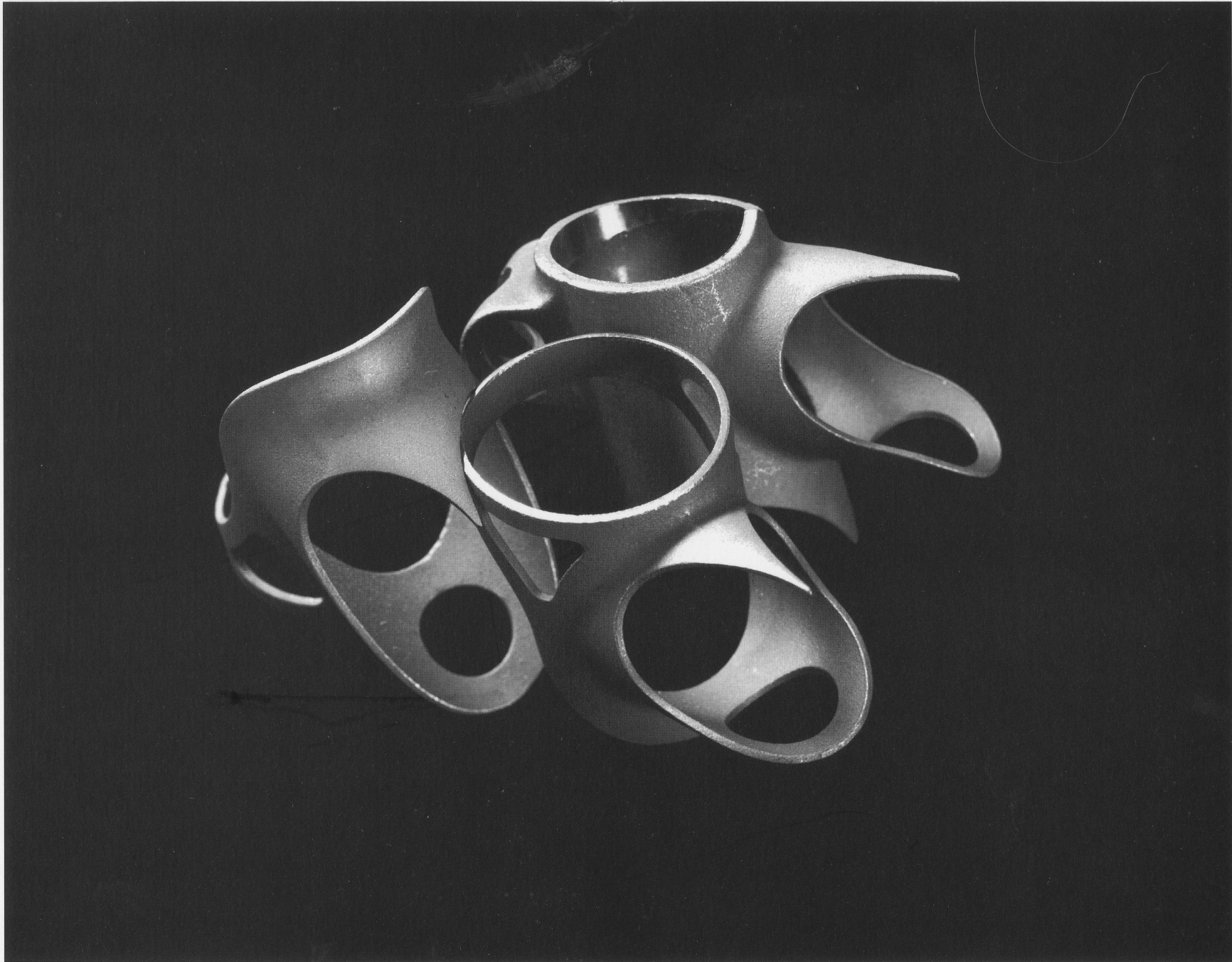


May 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
		1 <i>May Day</i>	2	3	4	5
6	7	8	9	10	11	12
13 <i>Mother's Day</i>	14	15	16	17	18	19
20	21	22	23	24	25	26
27	28	29	30	31		

Rivendell Bicycle Works
— Ever Since 1994 —

John Murphy (who is Columbine) usually starts with stainless steel Henry James lugs, then carves them with a jeweler's saw (for every half inch of cut he needs a new blade), and specialty tools he makes himself. A whole frame's worth of lugs like these here takes 20 to 24 hours to carve, and he's been doing this for about 17 years.



San Rensho NSL



June 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
					1	2
3 <i>The Flying Cloud's maiden voyage: NY to SE. Will arrive 89d 21h later, on 8/31.</i>	4	5	6 <i>The Flying Cloud arrives in SF for its final time. Left NY 2/18. 108d.</i>	7	8	9
10	11	12	13	14	15	16
17	18	19	20	21	22	23
24	25	26	27	28	29	30

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

The original version of these were bulge-formed (blown up a steel tube like a balloon) and then cut with laser beams, by Nikko of Japan. This current version is investment cast in Taiwan, by Long Shen. The Cinelli-like Os, the windows, and the way the side waists curve into the French-like spoons on the undersides combine in this infuriatingly beautiful design.



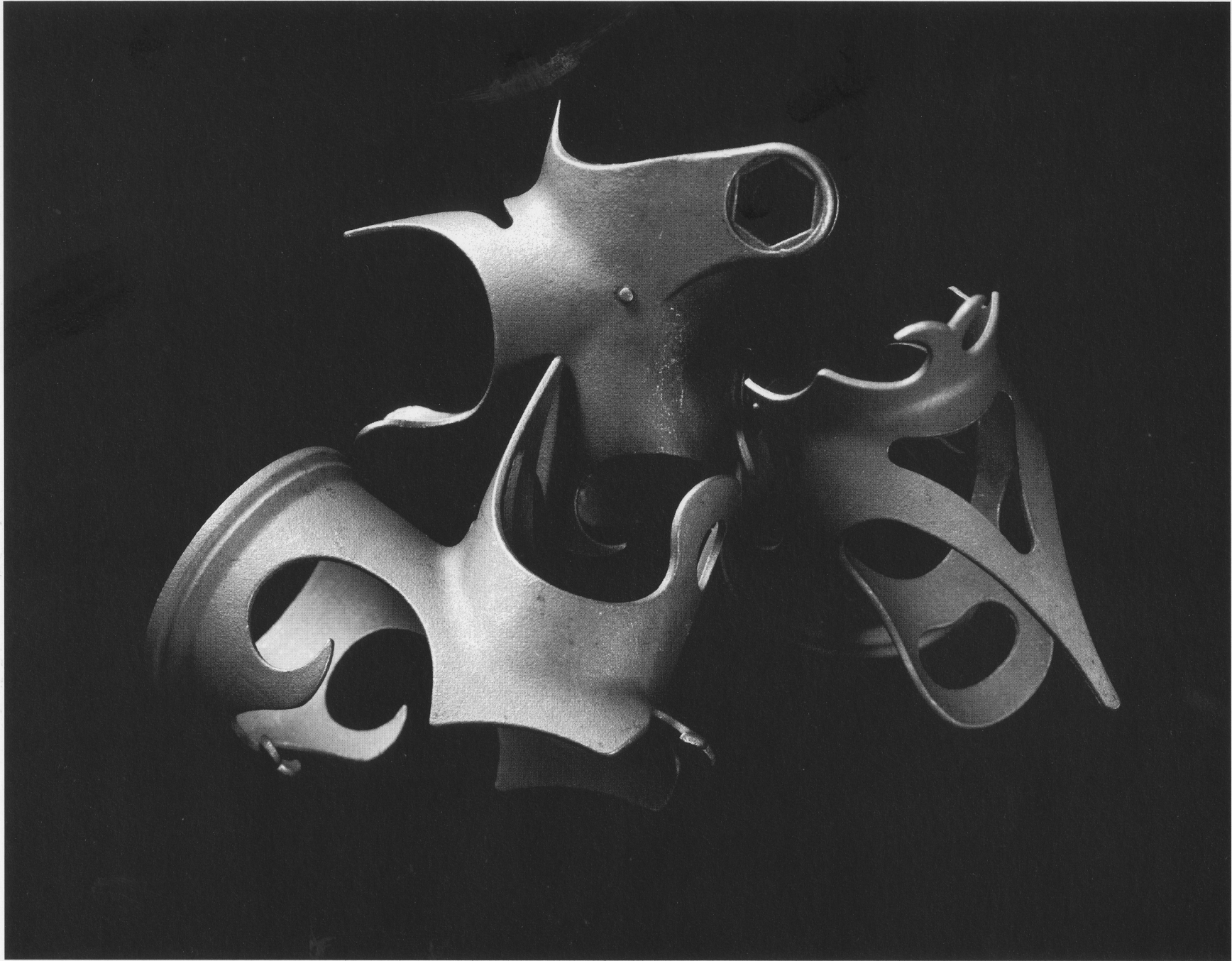
Emilio Bozzi

July 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
1	2	3 <i>The Third of July</i>	4 <i>The _____ of July, and S. Beaudet's B'day.</i>	5 <i>The Fifth of July</i>	6	7
8	9	10	11	12	13	14 <i>Batille Day</i>
15	16	17	18	19	20	21
22	23	24	25	26	27	28
29 <i>X.E.'s birthday</i>	30	31				

Rivendell Bicycle Works
 ↳ Ever Since 1994 ↳

Emilio Bozzi was the firm which produced Frejus and, later, Legnano bicycles. These were among the most popular brands for racers during the 1950s. Available models included the Roma Olympiade, Professional, Tour de France, and the Grand Premio; and at some point. The integrated seat stay spigots both simplified and complicated seat stay attachment.



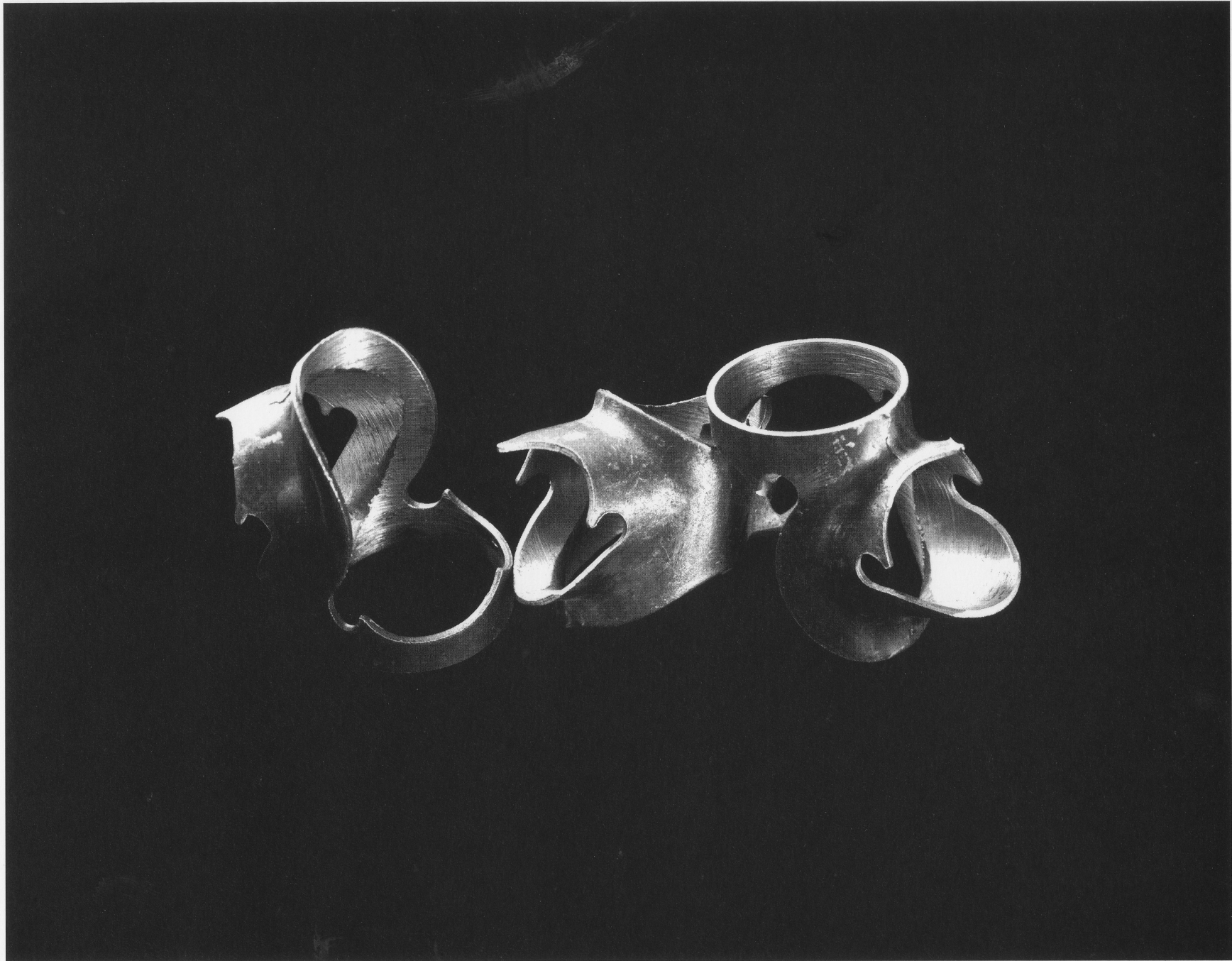
Papilio Robustus (Rivendell)

August 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
			1	2	3	4
5	6	7	8	9	10	11
12 <i>1853: The Flying Cloud arrives in SF 105d after leaving NY on 4/28.</i>	13	14	15	16	17	18
19	20	21	22	23	24	25
26	27	28	29	30	31 <i>1851: The Flying Cloud arrives in SF for the first time, in the astounding time of 89d 21h. (From NY)</i>	

Rivendell Bicycle Works
 ← Ever Since 1994 →

The Latin name is part description ("strong butterfly," referring to a silhouette visible in them from certain angles), and part Hetchins, who also gave lugs Latin names. These mix familiar classical elements with fine tolerances for good brazing, and smart structural details, and an extended top lug for higher handlebars, more comfort. Investment cast by Long Shen.



Prugnat (Model 62)

September 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
						1
2	3	4	5	6	7	8
9	10	11	12	13	14	15
16	17	18	19	20	21	22
23	24	25	26	27	28	29
30						

Rivendell Bicycle Works
← Ever Since 1994 →

Prugnat (prune-yat), a French firm, was a major lug supplier thru the middle '80s. The lugs came in a wide range of styles—with or without windows, short or long point, and so forth. Most Prugnats were generic, but they had four or five especially good-looking models, and this is probably about no. 4 among those.



Haden Concorde

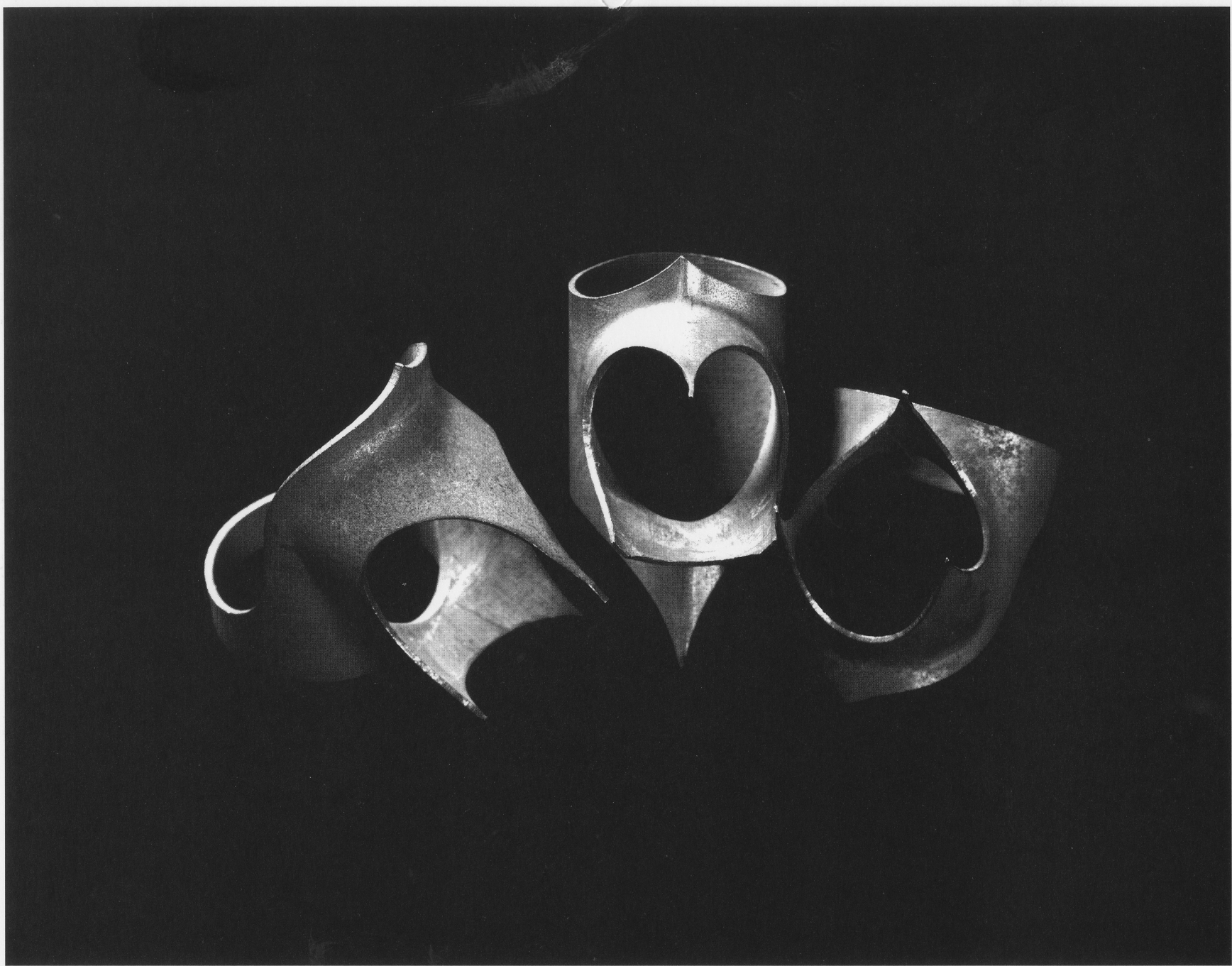


October 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
	1	2	3	4	5	6
7	8	9	10	11	12	13
14	15	16	17	18	19	20
21	22	23	24	25	26	27
<i>End of Daylight Saving Time</i>						
28	29	30	31			

Rivendell Bicycle Works
— Ever Since 1994 —

Stamped and welded by Haden (England). Introduced in the middle '70s. There were several variants, each with different cut-outs. Common belief: Haden introduced this radical style to keep step with newer Reynolds tubesets. On the same catalogue page is an illustration of a Concorde jet, which may have influenced its style. Or was it the other way around?



San Rensho



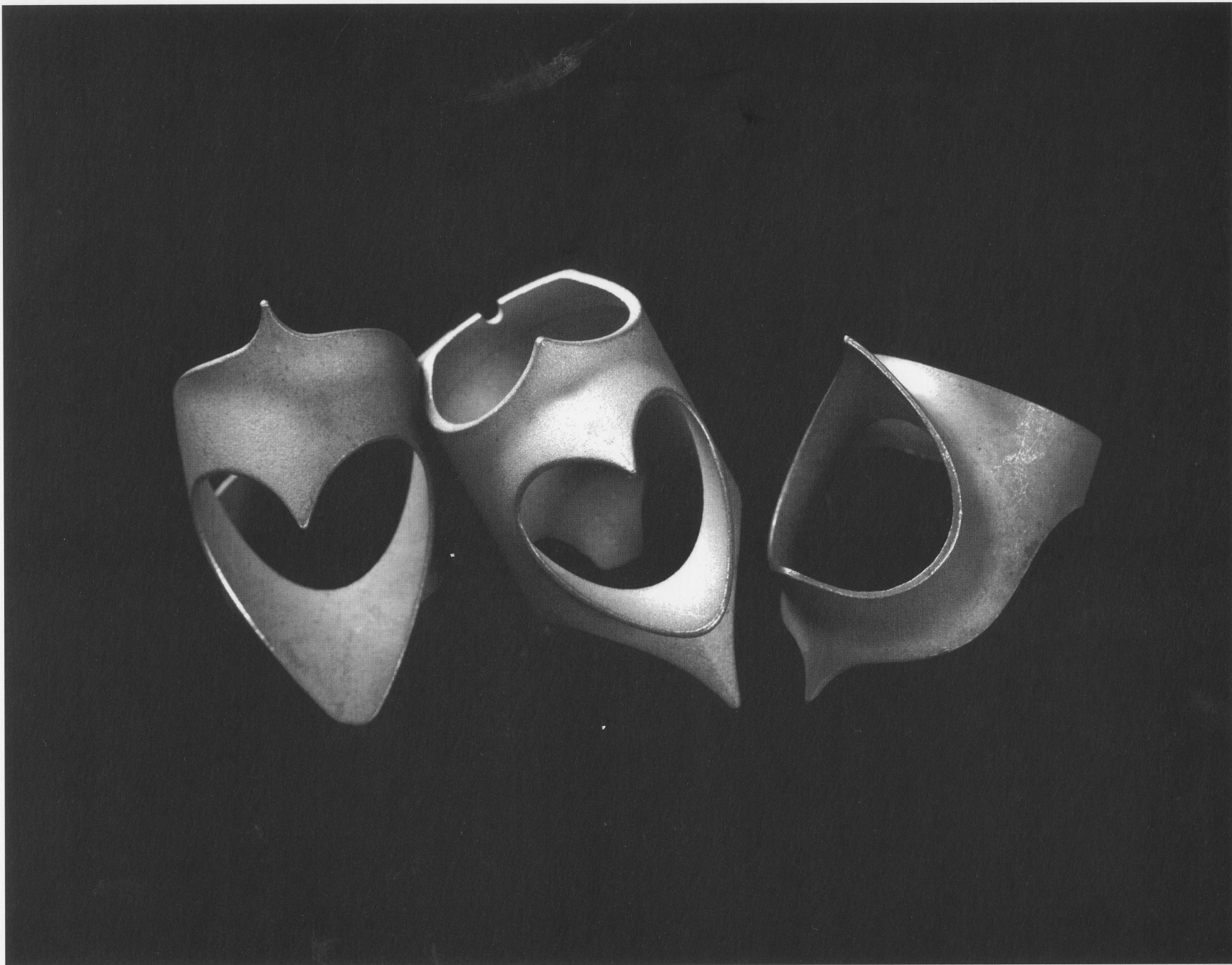
November 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
				1	2	3
4	5	6	7	8	9	10
11	12	13	14	15	16	17
18	19	20	21	22	23	24
25	26	27	28	29	30	

Rivendell Bicycle Works

← Ever Since 1994 →

Laser-cut from expanded steel tubes into an unusual, if not unique side-point design. San Rensho, usually seen as 3Rensho (3=san in Japanese), was Yoshi Konno's company until he recently retired. He was a superb designer with a keen eye for style. These particular lugs were and still are available commercially, although they're rarely seen outside of Japan.



Takabashi/Sachs



December 2001

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
						1
2	3	4 <i>Gary Combs' Birthday</i>	5	6	7	8
9	10	11	12 <i>Tommy Suczek's Birthday</i>	13	14	15
16	17	18	19	20	21	22
23	24	25	26	27	28	29
30	31					

Rivendell Bicycle Works
 ← Ever Since 1994 →

At the request of Takahashi's Mr. Kikuchi, Richard Sachs sent to Japan a set of his reworked and handfiled Dubois model 32s to copy and investment cast. A letter dated April 1983 stated that a meeting with frame makers of the Kanto area took place and the conclusion was that the supplied lugs would be the model for the new molds. Sachsabashi?

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