



June 2003

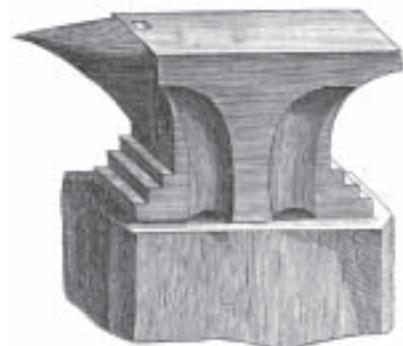
The Florida Clinker Breaker

June 2003 President's Corner by Bob Jacoby

Just some house keeping items this month:

- ◆ Applications for the Walt Anderson Scholarship must be received by Skeeter Prather by Monday June 30th. Please see last month's *Clinker Breaker* for details or contact Skeeter Prather (850.386.9246) for details. This is a great opportunity and I'd encourage anyone who's interested to apply. Take a risk and work to bring your craft to the next level though a formal learning experience.
- ◆ On a related note, Debra Docsa of Wellington (SE Region) was awarded the John C. Campbell one-half-tuition scholarship in April.
- ◆ FABA membership renewals are still streaming into FABA Treasurer, Juan Holbrook. Please check your mailing label to see if it's time for you to renew.
- ◆ FABA Elections will take place in August. The deadline for nominations is June 30th so that we can publish the candidates in the August issue of the *Clinker Breaker* – open positions include: President, Vice President, Program Chair, Secretary and Trustee. We've had strong interest for these positions, but if you're still interested, please contact a board member, or e-mail your interest directly to Karen Wheeler (addresses on the back of this issue).
- ◆ FABA will hold its next Board Meeting on July 12th, in Blountstown. This meeting will include a walk-through of the October Conference Site. This meeting is open to all FABA members, so if you're interested, please plan on attending.
- ◆ Finally, The Clay Spenser Treadle Hammer Workshop, which is being coordinated by Jim Dunmire (jim.dunmire@prodigy.net), now has quite a few people who have expressed interest. While there's room for a few more smiths, we might get to the point where we'll have to start a wait list for any additional people who are interested, but I'll let Jim work out the details. We're still evaluating sites for a shop to host the treadle hammer construction – please contact Jim directly.

Work safe, drink lots of water, and call your FABA buddies.



Upcoming Events

The calendar includes events of interest to the blacksmithing community. Florida Artist Blacksmith Association (FABA) sponsored events are highlighted in bold typeface. The regions have no boundaries - everyone is welcome everywhere. Come to more than one if you can. We hold regular monthly meetings in each region (except that we all try to get together at one Statewide Meeting each quarter) on the following Saturdays of each month: NE-1st, NW-2nd, SE-3rd, SW-last. The actual dates may vary from month to month; check the schedule below.

Our meetings are informal gatherings around the forge. Prospective members are always welcome. Come for all or any part of a meeting, bring your tools, or just watch. Most meetings run from 9AM to 4PM, and you'll need to bring a lunch if you stay all day, unless otherwise noted. If you have any questions about meetings, please contact the Regional Coordinators listed below:

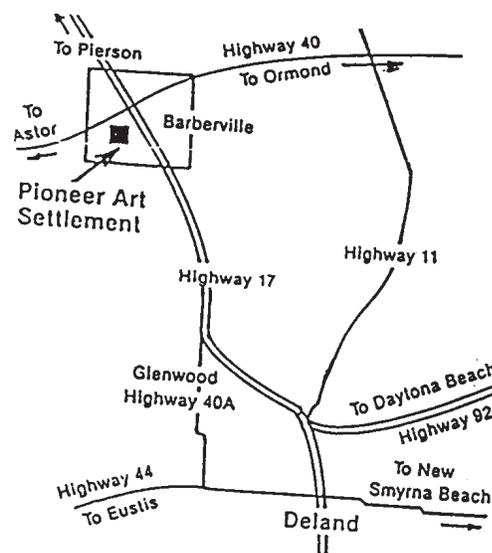
Northeast Region:	Kent & Melanie Owen	352-307-2033	Oak1954@aol.com
Northwest Region:	Billy Christie	850-421-1386	chriswood@talweb.com
	Ed Crane	850-893-3212	NCrane8364@aol.com
Southeast Region:	Lynn Emrich	561-833-0931	lynn@dialup.ws
Southwest Region:	Erik Flett	941-437-3844	-unknown-

June 2003 Meetings

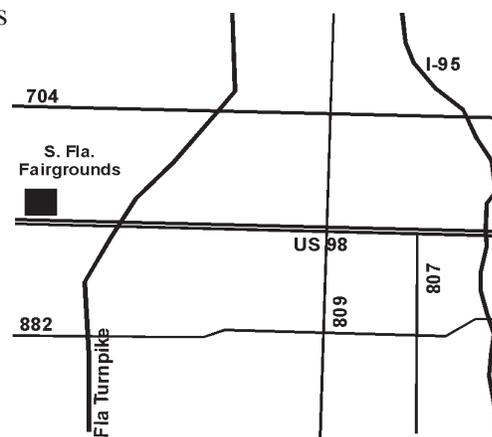
- NE** Jun 07 Pioneer Art Settlement - Barberville
- NW** Jun 14 Joyce and Rick Jay's Shop. Fountain, FL.
He will be demonstrating how he makes his metal deer antlers. Please bring a covered dish.
- SE** Jun 21 Yesteryear Village, West Palm Beach
- SW** Jun 28 to be announced

Extended Forecast

- NE** Jul 05 Pioneer Art Settlement - Barberville
- NW** Jul 12 Panhandle Pioneer Settlement, Blountstown, FL
- NE** Aug 02 Pioneer Art Settlement - Barberville
- NW** Aug 09 Rex and Mary Ellen Anderson, Tallahassee, FL
- NE** Sep 06 Pioneer Art Settlement - Barberville
- NE** Oct 04 Pioneer Art Settlement - Barberville
- NE** Oct 10 - 12th Statewide Conference, Panhandle Pioneer Settlement, Blountstown, FL
- NE** Nov 1-2 Jamboree - Barberville
- NE** Dec 06 Christmas Gathering - Allen and Chloe Hardwick's Shop or Home



NE Region – Jun 7



SE Region – Jun 21



NW Region – Jun 14

“Other News and Goings On”

April Southeast Region Meeting:

On April 19th, the South East Regional Meeting was hosted at John O’Brien and Shirley Brinkman’s shop in Jupiter.



Don Shedlock of Jupiter was the principle demonstrator and showed various techniques for forging steel and aluminum pipe and tubing into bamboo shapes. Don showed his methods for designing, constructing and finishing a “bamboo” chandelier. Don uses a multi-step painting process that gives the steel a very realistic bamboo appearance. The finished product is difficult to tell from the real thing.



The meeting was well attended by current and tentative future members. An “Iron in the hat” drawing was held and a total of \$82.00 was raised for the organization. A special thanks goes to Steve Kane and others for their generous donations.

In the afternoon the ladies gathered in the sewing room and made several small fancy pillows while the “smiths” worked on plant hanger and knife projects at the several forge stations that were set up. Each participant was awarded a hanging flower “Easter” basket of their choice to take along with their hanger. All had a good time, with several staying on for socializing and relaxing, while the forges cooled.

Boy Scouts and Metalwork Merit Badge

Matt McAuliff, Chris Jones, Andrew Bocharski, Matt Graham, and Russell Sandberg all members of Boy Scout Troop 610 in Deland were at the blacksmith shop on May 10, 2003. In the heat, they worked on the blacksmith option of the new Metalwork Merit Badge requirements.

Under the watchful eye of Fred Kingery and Bob Mancuso, they worked on completing their project. Jim Corbet was at the Pioneer Art Settlement as a guide that day and stopped by to help as his other duties allowed. A few of the boys will need to complete their project at another time. A “well done” is given to all five of them for the work at a forge on such a hot day. Some parents present expressed an interest in joining FABA so their sons can learn more about the fun we have at the forge. Hope to see them in June at the Pioneer Art Settlement!

“Other News and Goings On”

News From The Northwest

The Northwest Region of FABA met on Saturday, May 10, 2003, at The Antique Car Museum in Tallahassee. It was a hot May day with clear skies and a nice breeze. We had a pretty good turn out with 31 people signing in.

Our demonstrator was Bill Robertson and his assistant Patty Draper. They were busy demonstrating how to take a piece of flat stock, about 1 1/2" wide by 1/8" thick and 14" long and turning it in to a great looking wall sconce with a gothic flower made into the bottom. The flower was made by cutting 5 or 6 strips about 1/2 of the way across, then heating the strips one at a time and forging each one into a pointed petal. After you have all the petals forged to your satisfaction, you bend them around to make a circle. It's hard to explain, but it looks good. Bill donated this beautiful wall hanging candleholder to the "Iron In The Hat", which sure helped the ticket sales. Bill then demonstrated how to do a butchering technique, for adding a nice decorative element to any item.

The "Iron In The Hat" was next and brought in \$105.00. Clyde Payton was the lucky winner of Bill's wall sconce. Thank you Bill (and Patty) for your generous donation of your wall sconce to the "Iron In The Hat." A BIG thank you to Linda Holbrook for taking care of the drawing and ticket sales.

We had a delicious lunch in the nice, cool Antique Car Museum's Banquet Room. Thank you everyone for bringing the delicious covered dishes.

After lunch most of the members went on a tour of the museum. I saw several vehicles that I would love to take for a spin. It's hard to believe how many nice antiques they have acquired. If you have never been, you should check it out.

NW FABA wants to thank the Antique Car Museum, Tiffany, and Mr. Devoe Moore for letting us hold our meeting at your establishment.

NW Regional Coordinator
Billy Christie

Upcoming Meetings: The June 14th, meeting will be held at Rick and Joyce Jay's shop in Fountain, FL. Rick will be demonstrating how he uses steel to make his realistic looking deer antlers. They are furnishing fried chicken, so please bring a covered dish and your "Iron In The Hat" items. Should be very interesting. 9:00 AM CST.

The July 12th meeting will be at the Panhandle Pioneer Settlement in Blountstown, FL. We have work to do; the October Statewide Conference is coming soon.

Strike while the iron is hot! ☺

“Other News and Goings On”

May Meeting of the Northeast Region - 2003

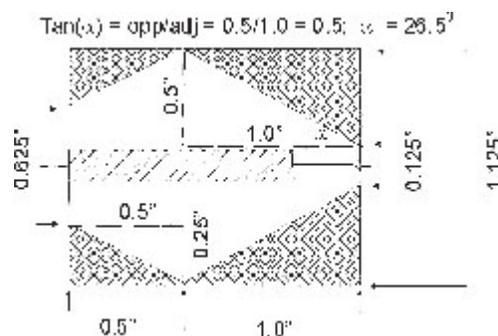
IronFlower Forge (Steve & Kimmy Bloom)

The subject of the meeting was the construction techniques useful in dagger production with emphasis on the utilization of lathes.



We started with the production of a pear-shaped pommel from a 1.5” piece of 1.25” diameter round stock using a Logan metal cutting lathe. The piece had both ends faced and the center marked using a center drill. One end was drilled with a #7 bit and tapped for a 1/4x20 bolt. The piece was then bolted to a ‘handle’ (a 5/8” diameter x 3” piece of round stock with a centered hole through which a 1/4 x 20 bolt could be run) and placed back on the lathe. Given the dimensions (see drawing), the necessary angles for the two cuts were determined and the cross-slide on the lathe was used to make the cuts.

The result was effectively two truncated cones each with 1.125” base sitting base-to-base. Then handle was replaced with a short bolt and the bolt was chucked up in an electric drill. A few minutes work at the belt grinder was sufficient to convert the cones to a pear shape. A few more minutes at the buffer converted it into a high-polish pommel. The technique for producing a wheel-pommel was also discussed.



The same principles can be applied to a guard. Start with a 3/8” piece of square stock 6.5” long. Mark it at the 0.75” and 2.75” from both ends (the 3/4” ends will be held in the lathe chuck or supported by the live center, the center 1” section will be where the tang slides through the guard, and the remaining pair of 2” sections will taper from the center - at 3/8” diameter- to the tips - at 1/4” diameter). As with the pommel, the dimensions and a bit of math result in an angle of 2.5 degrees which the cross-slide and lathe then converts into reality. The addition of a pair of side plates, a bit of free-hand grinding, and the judicious application of heat results in a completed guard.



The next item was the handle. The desired shape was a spindle approximately 5” long, 1” wide at the widest point and tapering in both directions to 5/8” diameter. We started with a square piece of cocobolo 7” long x and 1.25” wide. The ‘corners’ were removed with a radial arm saw to give a rough octagon and the centers on both ends were marked. The piece was placed on a Shopsmith wood lathe and using a crude turning tool made from an old file, the chips were sent flying. The tang cavity was drilled on a drill press using a cross-vise, a dead-center and a key ring laser (to position the chuck directly over the center’s point).

“Other News and Goings On”

The initial hole along the line of rotation was blocked with a sacrificial wood dowel. Two additional holes on either side of the dowel (slanting towards the center) were drilled to accommodate the tang.

We broke for lunch – with the traditional chili / salad / gingerbread & ice cream menu. No one went away hungry. Following the long-standing traditions, we traded junk – err—did a Buck-in-the-Bucket and discussed the upcoming conference(s) and the fact that a lot of you missed a great meeting.



After lunch, John Butler briefed us on the construction of a wood and leather sheath with silver fittings (for a very nice bowie) and there was a brief demonstration of hot bluing. If you want to see the items in color, log on to <http://ironflower.com> -> projects -> dagger fittings, otherwise keep checking the newsletter for the detailed write-up to follow.

“Bits and Pieces”

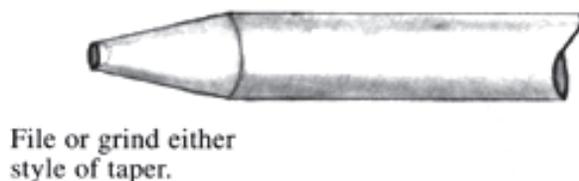
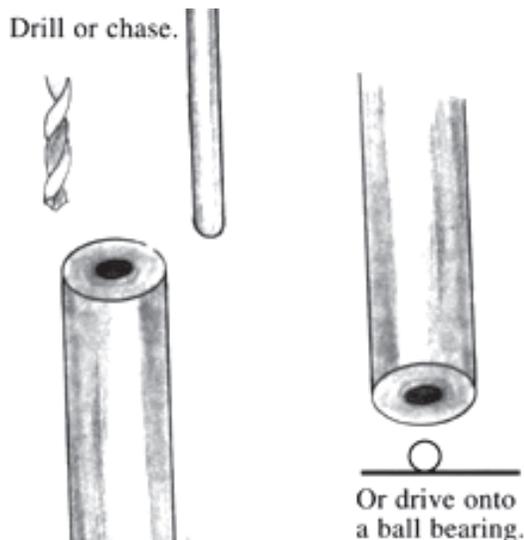
Tool Configurations: Eye Punch

There are at least three approaches to making the simple eye punch. Take a piece of 1/2" diameter tool steel about 5" to 6" long. To form the depression that gives the "raised" eyeball effect, first find the center of one end of the tool steel blank.

Now, either 1) center punch and drill a shallow hole, 2) use a small diameter ball punch and chase the depression into the end of the eye punch blank or 3) drive the eye punch blank down onto a small ball bearing. The last two options are done when the blank is at forging heat.

Once the depression is set into the end of the blank, either file or grind away the excess material. The effect that the eye punch will achieve is partly dependent on the form of the tip around the depression. A longer taper will sink into the hot stock of the dragon head more deeply while a blunter taper will displace more material. Experience will show the differences that can be achieved with varied configurations of eye punches.

Removing the material from the working end of the eye punch after the depression is developed is far easier than trying to set the depression into a tapered blank.



“Scholarship News”

Great News! At the April 12th Board meeting, the John C. Campbell One-half Tuition 2003 Scholarship was awarded to Ms. Debra Docsa of Wellington, SE Region. Hearty congratulations to her!

Walt Anderson Scholarship Still Available

The Walt Anderson Scholarship was established by the FABA Board in honor of the memory of Walt Anderson, one of FABA's charter members. The scholarship's purpose is to further the craft of blacksmithing and is available to any FABA member in good standing.

The Award is limited to actual cost or \$750, whichever is less. The Award may be used for tuition, materials, room and board and transportation (paid at a rate of \$.29 per mile or actual cost of public transportation, whichever is less).

The successful applicant must have convinced the FABA Board, through a written application, that their past experience in blacksmithing is sufficient background upon which additional formal training will enhance the applicant's potential for furtherance of the craft; and the schooling sought is appropriate to that purpose. A formal application blank can be obtained from me, Chair of the Scholarship Committee. However, a simple "Letter of Application" will suffice provided it contains at least the following:

1. Name, address and phone number of application;
2. Brief statement of past experience in blacksmithing;
3. Brief statement as to how the additional schooling will potentiate furtherance of the blacksmithing craft;
4. Brief statement as to how the additional schooling will support the applicant's personal goal in the craft and art of blacksmithing;
5. Name of the school to be attended;
6. Specific course desired and name of instructor;
7. Costs: tuition, materials, room and board, transportation (and means of transportation).

Applications should be send to me by Monday, June 30, 2003:

Skeeter Prather, Chair
Scholarship Committee
Florida Artist Blacksmith Association
2816 Terry Road
Tallahassee, FL 32312

I'll happily respond to phone inquires, of course: (850) 386-9246

The Committee will carefully evaluate each application and recommend three finalists to the Board. The decision of the Board will be final. The successful applicant will be notified promptly.

“Tools and Tips”

TIPS FROM APPLECROSS FORGE SANDING BELT HOLDER



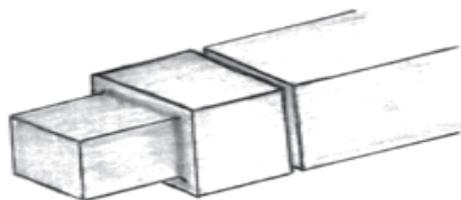
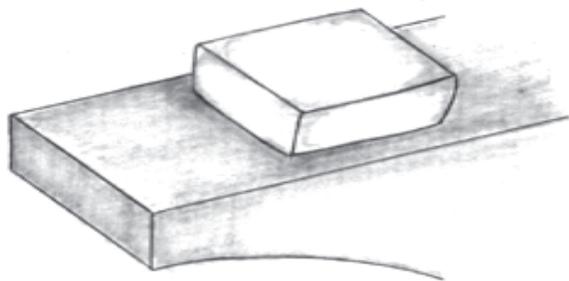
One of the nice things about visiting other peoples' forges is that you always learn something new. While visiting Steve Bloom's shop in Archer, Florida recently, I noticed that he had a creative way of storing his sanding belts. He hangs them on pegs next to each other in ascending order of grit size so that after the numbers wear off of the belts you can still keep them in order. In addition he places a small section of pipe on the bottom of each belt so that they don't curl and tangle, as mine tend to do. Now if I could just find a way to reconnect belts that separate as a result of being left outside in the humidity too long. Does anyone have an answer where to get new tape to connect belts or is this some kind of trade secret?

-Bill Robertson-

Raised Vein Leaf Die:

Stock: 2" x 2" mild or tool steel. 3/8" round mild steel.

Forge a square tenon, sized to fit your hardy hole, on one end of a piece of 2" x 2" bar stock. Cut the bar about 1 1/2" above where the tenon starts.

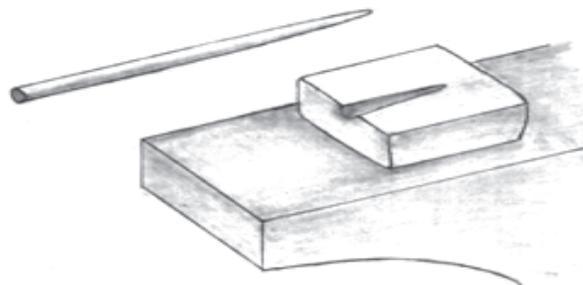


Drop it into the hardy hole at forging (bright yellow) temperature and forge the bar down to about 1" in height above the anvils face. This will seat the tenon as it spreads the face of the 2" square to about 2 1/2" x 2 1/2".

Forge a clean, 2" long taper on a 3/8" round. Make sure that the bar is long enough to hold onto after the taper is done.

Take a forging heat on the tenoned block and drop it back into your hardy hole. Lay the forged taper, cold, down the center of the block so that the two inches of taper stops about 1/2" from one edge as shown. Drive about half of the diameter of the taper down into the hot block. This will form a tapered negative space, half-round in cross-section in the face of your new raised vein leaf die. Be sure that there are no sharp edges around tapered depression that will mar the vein.

If you made this die from tool steel, heat treat it. If it was made from mild steel you can apply a case hardening compound for a longer lasting tool.



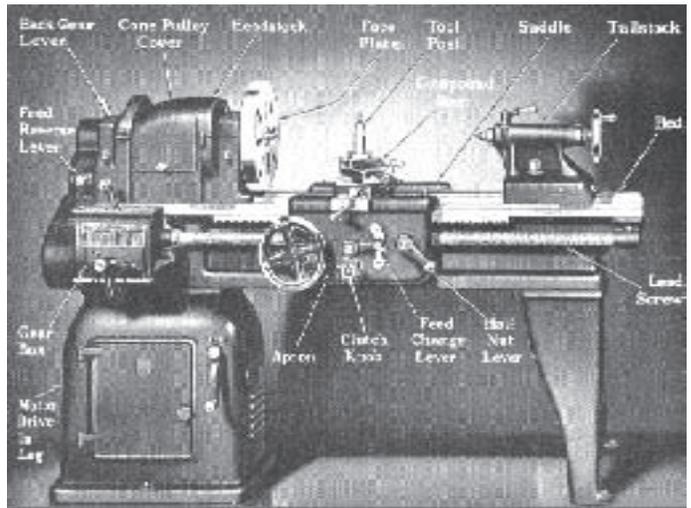
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www.traditionalmetalsmith.com

“Tools and Tips”

Round and Round... by Tom Carboni

Occupying one corner of the blacksmith shop in Barberville, usually hidden under cover, is an old South Bend metalworking lathe. South Bend is a well-known name in machine tools, being founded in South Bend, Indiana in 1906 and still in business today. It's not unusual to see their products still at work after decades of service. Ours was built in March of 1929.

This particular machine was originally bought by the State of Florida's DOT shop in Gainesville in May, 1935. The state later donated this machine to the Pioneer Settlement in Barberville where it sat unused until I decided to restore it. Judging by some of the tooling, it was used for automotive and electrical work i.e. refacing valves, boring cylinders, turning armatures and commutators.



I'll try to explain how a lathe does its thing and what its major parts are. Please refer to the illustration.

A lathe works by rotating a workpiece against a stationary cutting tool. Typically, these machines consist of four key parts: the bedways, headstock, tailstock and carriage. The bed is a large casting that forms the foundation of the machine and holds the headstock, tailstock and carriage in alignment. Bed surfaces that are finely machined, those on which the carriage and tailstock ride, are called the “ways”. Alignment of these critical parts is important to doing accurate work.

The headstock is a large casting or forging that is firmly anchored to the bed. It houses a rotating spindle and its bearings, back gears (reduction gears used for heavy cuts and slow speeds) and a gear train used to drive the lead screw or carriage power shaft. Most lathes have a horizontal spindle that can accept a variety of chucks, tapered centers, faceplates or collets, although some industrial machines have vertical spindles. The maximum workpiece diameter is called swing i.e. a machine that can turn a twelve-inch workpiece is said to have a twelve-inch swing.

The tailstock is another substantial casting housing a screw-driven ram. This ram is usually bored for a Morse taper socket, hence most tailstock tooling needs to have a matching taper shank. A matching taper socket is usually found in the nose of the headstock spindle as well. Some tailstocks have a lever feed instead of a screw, which is very handy for sensitive operations like using very small diameter drills or taps. Most tailstocks are designed to slide along the ways and can be fixed in place by tightening a clamping bolt.

****Note:** A Morse taper is a self-locking taper of about 5/8” per foot used in machine tools. Lathes, for example, will have matching sockets and tapered centers in headstock and tailstock. This calls for taper shank tooling to match these sockets. Many milling machines use an R-8 taper, which is supposedly self-releasing because it uses different angles.

The carriage is a large assembly consisting of a saddle, apron, cross slide and rotating compound slide. The saddle is a sliding casting that rides on the ways. The apron is a vertical flat plate fixed to the front of the saddle that carries a variety of gears and controls for manual feeds, power feeds and screwcutting feeds. Atop the saddle is the cross-slide i.e. a dovetailed slide that runs across the ways. Another dovetailed slide called the compound rests on top of the cross-slide. The compound can rotate through 360 degrees, can be locked in any position and usually has a T-slot that holds the toolpost. Both cross-slide and compound feeds have micrometer dials that permit precise values to be used. These dials are usually graduated in thousandths of an inch.

“Tools and Tips”

These machines are very versatile and capable of many kinds of jobs. A typical lathe can be used for straight turning, taper turning, boring, facing, knurling, drilling, tapping, reaming and cutting screw threads of all kinds. In automotive work, a lathe is used for turning rotors and drums, boring cylinders, finishing pistons, refacing valves and balancing driveshafts. Watchmakers use them to make parts for watch and clock movements. Aircraft plants make extensive use of lathes to build air-cooled engines and propellers, among other things. They can also be used to make milling cutters, threaded fasteners, taps and dies. A lathe is one of few machine tools that can reproduce itself. Generally, lathes and other machine tools are found wherever parts need to be made in almost any manufacturing industry. Although CNC-controlled equipment is common today, the basic function of a lathe hasn't changed much in a hundred years.

With standard high-speed steel tooling, a lathe can turn almost any material except hardened steels. This includes carbon and alloy steel, stainless steel, brass, bronze, copper, aluminum, cast iron, plastic, fiber, hard rubber and wood. I was recently making swages out of 1.25" round stainless steel bar for some of the northeast chapter smiths. One can also use other types of tool bits, like tungsten carbide, Stellite, or carbon steel. With the exception of carbide inserts, a machinist, much like the original blacksmith, is on his own to grind up his tools from blanks. There's some learning curve to this, but it means tooling can be tailored for specific materials and jobs. This allows for great flexibility in the variety of work that can be tackled.

Some minor work to get the Barberville machine running is still ongoing. The care of an older piece of machinery such as this is a labor of love that we can all relate to. The countershaft bearings have needed deburring and adjusting. The drill chuck was mounted on ball bearings as a live chuck for electrical work. It's been disassembled and cleaned up, as well as given a stationary mount. I am still working on the power feed clutch and half-nuts to get the feeds running. One of the parts I am making is a threading dial, as there wasn't one. The micrometer dials on the cross-feed and compound are somewhat damaged and hard to read, so new ones will be made. Some of the oilers have needed cleaning and replacing. The toolpost and rocker have needed some deburring and fitting. None of this is unusual for a seventy-year-old machine, nor hard to fix. If you work on older machines long enough, this somewhat justifies keeping machines of one's own i.e. to make parts for other machines. I find this a handy excuse, anyway.

That aside, the machine runs very well. It will take an eighth-inch cut in very hard stainless steel without straining. I'm continually impressed at its ability to take heavy cuts in tough materials. The builders of the Barberville shop did an excellent job leveling it and setting it up, as it will turn a 18" long piece straight to within .008". That's very accurate, considering its size and age. It's been well cared for and we aim to continue that. With luck, it will be available to FABA for a long time yet.

Many members have become fascinated with the lathe. Some of our older members remember working on one. It has become quite a conversation piece on what it can do for FABA. New ideas are being presented, suggested and requested with a lot of excitement. If you would like some more information on what the lathe is and can do, we invite you to come out to the Northeast Regions monthly meetings on the 1st Saturday of the month. Please check the Clinker Breaker to make sure of the location of each month's meeting. Usually every other month is held at Barberville.

Tom Carboni has been a member of FABA for over a year now. He learned about machinery the old-fashioned way, hands on. He learned from his grandfather who was a model maker and a mechanic. When he saw the lathe unused in the corner, he figured it could add to FABA's capabilities. While Tom says "I don't want to come across as being the final authority when a lot of this information has been around for a long time" he sure has done a great job in my opinion. He has spent many hours working on the lathe and as he says "It does me a power of good" We all appreciate Tom's initiative, talent and hard work with the Northeast Region. Melanie Owen

THE FABA GATE PROJECT

Several years ago, five or six as best I can determine, a project was initiated by Bill Roberts and Tico Rubio. This undertaking consisted of the construction of a decorative gate to be installed at the Pioneer Art Settlement in Barberville. As I understand it, Bill and Tico worked out the design based the gate at the National Metal Museum. Much of the work in was done in Bill's shop.



At the top of the gate is located the FABA "sunburst" logo which was crafted by Rick Jay's artful hand and his plasma cutter. Toward the center of the gate are the initials "PAS" (Pioneer Art Settlement) which were cut from brass by Bill. The remainder of the gate is adorned with graceful scrolls and collars that were done at a NE regional meeting by various members. Space was reserved on the lower portion for 48 3 1/2" diameter steel disks, each to be decorated with a small forging designed and executed by the FABA member who contributed it.



The original optimistic expectation was that more than the needed 48 disks would be submitted, and that the extra disks could be incorporated in some type of ornamental piece to be included in the auction at the annual FABA meeting. Numerous blank disks were distributed, but the results were disappointing. An article by Bill Roberts appeared in the Clinker Breaker several years ago describing the project and its goals, but after all this time, only 30 disks have been submitted, leaving a deficit of 18.



Again, an effort is being made to stimulate the FABA membership to contribute a little enjoyable time and effort to this cooperative project. Each of the FABA regional coordinators has been requested to organize a work session at one or more of their sectional meetings to make additional disks. Blank disks have been cut out by Rick Jay and will be supplied to each region. If more blanks are needed, they can be supplied. Individuals who prefer to make these disks in their own shops can, of course, do so.

The blanks should be 3 1/2" in diam. and 3/32 - 1/8" thick - about 12 gauge. The design is left up to the donor. It is suggested that the decorative piece be made from steel since the completed gate will need sand blasting and painting, and other materials would need to be masked and carefully protected. The range of possible designs is limited only by the constraints of the smith's imagination. Some of the submitted items have included such things as a miniature anvil, tiny tongs, an array of decorative twists in small bars, a wizard head, and an assortment of abstract designs.

Our desire is to have the gate finished in time to show it at the October FABA meeting. This will require prompt action to make and assemble disks, and finish the gate by then. Hopefully, we will not be disappointed again. We urge you to get involved. Make a piece of FABA history!



Welcome New Members!

Welcome New Members!

Kenneth & Louise Burns
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850-878-9643
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352-591-1085
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Submissions to the florida Clinker Breaker

Your FABA friends want to read about you! We are looking for your contributions to future newsletters. Although we cannot promise to use every submission, we want to make this your newsletter. Please email or "snail" mail your articles, want ads, sales ads, tips, pictures and funny stories to k.wendt@att.net or to the address printed on the mailing section. If you include photos of yourself or others please provide names for the captions. Also, if you provide the photo, I assume you have the permission of the people in the photo to publish their picture!

Proposed Treadle Hammer Workshop Update

Progress report on the Treadle Hammer Workshop:

We have about eleven or twelve confirmed, interested parties in the TH workshop. That's about half of what we would "like" to have in order to reduce the price per hammer, but we are making progress.

We are currently evaluating three prospective workshop sites! Thank you to those offering time, assistance and space. This is a big workshop, so we need to find a shop with the capacity, (size) and equipment, welding, burning, machining, grinders, handtools, etc. where we could convene and build the 20 to 25 treadle hammers.

We now have someone interested in coordinating the procurement of the necessary materials and supplies we will need to build the treadle hammer's.

FYI, Clay gets a "free" treadle hammer for allowing us to use his design and for supervising during the workshop weekend. In addition he gets reimbursed for his travel expense and his lodging for the 2 to 3 days of the workshop if he cannot commute from home. In the past, the workshop coordinator, (that's me) gets a "free" TH as does the shop owner who allows us to use his facility and tooling. In this case, since I do not feel adequate to playing the role of the "buyer" of materials, I would give my "free" TH to the person who steps up and performs as the materials coordinator for the workshop.

If there are any other smiths out there interested in participating, please think it over and get back to me with a commitment to the workshop.

With our eleven or so firm volunteers, we will start calculating costs and sharing with you what the progress payments will be and when they will be needed.

- Jim Dunmire

FABA member Jim Dunmire and several others are interested in a treadle hammer workshop to build Clay Spencer's vertical-motion treadle hammer. If you're interested in participating in a the workshop, please contact Jim Dunmire (fax: 407-971-0146; jim.dunmire@prodigy.net) and let him know - email is preferred. Once we have sufficient interest, locate a shop to host the workshop, we will move forward.



The Florida Artist Blacksmith Association (FABA) is a 501(c)3 non-profit educational organization whose purposes are to teach, promote, and preserve the art of blacksmithing. Contributions are tax-deductible to the extent provided by law. FABA publishes the Florida Clinker Breaker monthly and FABA membership includes a subscription. We solicit correspondence and unpaid articles on any subjects related to FABA's purposes. Other not-for-profit blacksmith organization newsletters may reprint non-copyrighted material if it is credited to the author and this newsletter. You need the publisher's permission to reprint copyrighted material unless otherwise noted.

Proposed Treadle Hammer Workshop Update... continued

Treadle Hammer Workshop

by Clay Spencer

Most workshops have been 24 people, lowest about 12, highest 33. The cost depends on number of people, lower usually with more people and depends on material cost. Some groups were able to get significant donations. Range has been from \$325 to around \$450. The material cost for me recently has been about \$260, including anvil stock at \$0.15 per pound. You might get some cost savings by buying in bulk but if you have more work done by outside shops the costs go up.

In most cases, three hammers are overhead: I get one for leading the workshop plus motel (and gas if it is more than a days drive), the shop owner gets one for use of shop and the coordinator gets one. He or she gets the people on a list, gets their money, buys material, schedules work sessions, takes care of all the problems. All the other people split the costs for all the materials and other miscellaneous costs such as drill bits, saw blades, grinding wheels, acetylene/oxygen, etc.

The schedule generally has been to start working Friday morning, work through Saturday and finish mid day on Sunday, drawing a number out of a hat for hammers and start loading Sunday afternoon.

Some work is required to be done ahead of the workshop: cutting and grinding the edges of the half inch thick bases (16" x 32"), can be bought sheared to size cutting the 4", 5", or 6" solid anvils to 36" long and square, cutting the hammer heads to 33" long, one end square (milling machine is nice) cutting the tool holders, 3/4" thick, 4" square with a close 1" square hole through, can be done in several ways: 1.laser cut, 2. torch cut and drifted by hand sledge or big power hammer, 3 . punched with 75 ton press, 4. drilled (1/4" and 1") and filed.

A fairly large space is needed. You need 8' x 10' for the frame assy, about the same for welding the frame, 20 or more 5 gallon buckets for parts, plus space for the bases, anvils, columns, 10' x 10' for hammer head assembly, and space for welding up treadles, turnbuckle assy, guide assy, etc. Each hammer needs 10 square feet while it is being final assembled and checked out. In nice weather, sheds or tarps could be used.

I guess a shop about 40' x 80' with it's equipment would do for a group of 20. I furnish drill jigs and assembly jigs for most parts for the inline design.

Equipment needed:

- band saw(s)
- four drill press
- one up to 5/8" chopsaw welder
- minimum of three, preferably four belt sanders
- air wrenches
- torch set
- power hammer vises
- work tables
- angle grinders
- fish fryer and lead pot/ladle nice to have
- milling machine and lathe hand carts/dollies to handle 500lb.
- nice to have: overhead crane, forklift or tractor front end loader

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If you do not wish to be listed in the printed FABA directory, please check the box to the right []

Send this application and a membership fee of \$20.00 to:

Juan Holbrook, FABA Treasurer
6418 NW 97 Court
Gainesville, FL 32653

Make check out to FABA. Your FABA membership begins when we receive your payment and lasts one year. Membership is for a family. You don't have to be an ABANA member to join FABA, but many FABA members are, and we encourage membership in both organizations.

June 2003

Check your membership
expiration date, get your
dues in on time please!

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