

July 2009



The Florida

Clinker Breaker

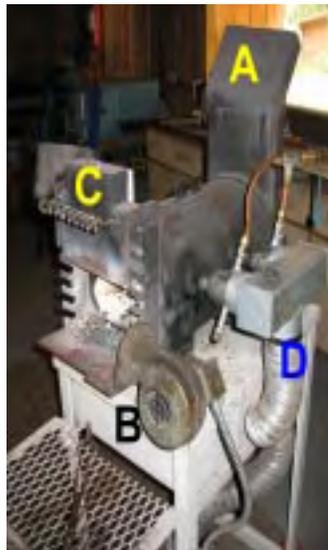
Florida Artist Blacksmith Association - Established May 18, 1985

Editorial Musings

Steve Bloom

As I warned you, if you don't send me stuff, you get to hear about what I've been doing. I hosted a workshop oriented to Damascus production and full-tang blades this weekend. We started early on Saturday and finished about 7:00 PM Sunday. The two smiths who participated walked out (ok, stumbled out) each with a sweet full tang knife (pics next time) and enough steel to make 3 to 5 more blades. By the time we were done, both guys were thoroughly checked out on a 50 lb Little Giant, my new Damascus gas forge, and the wonderful experience of losing 10 lbs of weight in an afternoon (nothing like welding leathers, 95 F temperatures and a roaring gas forge to promote a healthy sweat).

In the interests of promoting wisdom (defined as learning from someone else's mistakes rather than from personal experience), I'll describe the new forge - some times the magic works, some times it doesn't. The rear vent (A) combined with the burners that are placed at 25% & 60% of the length (relative to the door) decreased the 'Dragon Breath' problem as did the auxiliary fan (B) that blows the escaping blast laterally rather than just cooking your hands. I used the same burners and the same blower (D) from my old forge but decreased the volume of the unit by 25%. Turns out that there's such a thing as too much blower. The excess air was sufficient to locally cool the steel (you



could see a dark spot on the wall opposite the rear burner). That, in turn, made welding a tall stack problematical. An air gate will be the next modification.

On the other hand, the new door design worked great. It is basically a box with refractory bricks and "staples" on the sides (see the pic below). The opening is flanked by angle iron milled into a series of angled slots. The door is moved from slot to slot and gravity helps hold it tight to the opening. I also discovered that castable refractory has a shelf life. My 5-year old stuff just doesn't resist the heat like it did when it was fresh.

With an air gate, the new unit will work acceptably but I won't be making too many 2" wide billets in it (besides, I'm just about out of 2" x 1/4" O1 stock anyway).

On-Line Blacksmithing Newsletters

The following is a list of most of the blacksmithing groups that have a Web site that offers a "Current" Free Newsletter whether it is monthly, bi-monthly, four times a year or twice a year, that can be downloaded without having to join the group.

1. Balcones Forge www.balconesforge.org
2. BA of Missouri www.bamsite.org
3. Blacksmith's Guild of the Potomac www.bgop.org
4. Central States Metal Artisans <http://gpba.abana-chapter.com/>
5. FABA www.blacksmithing.org
6. Kentucky BA <http://ky.abana-chapter.com/>
7. New Jersey BA <http://njba.abana-chapter.com/>
8. Northeast BA www.northeastblacksmiths.org/
9. Old Dominion BA www.odbsa.com
10. Southwest Artist-BA www.swaba-abana-chapter.org
11. Tidewater Blacksmith's Guild www.tidewaterblacksmiths.com
12. Western Reserve Artist BA www.wraba.com
13. Vancouver Island BA www.viblacksmiths.com

*BA=Blacksmith's Association

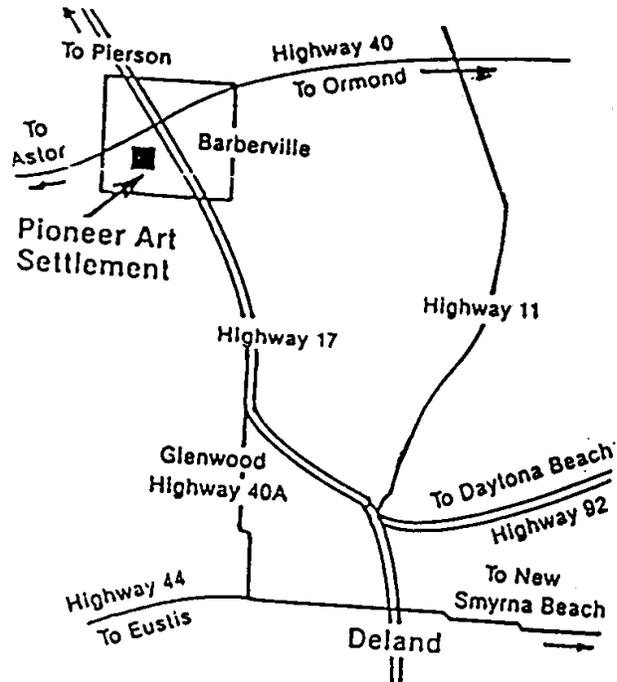
Upcoming Events

The calendar includes events of interest to the blacksmithing community. The regions have no boundaries - everyone is welcome everywhere. Come to more than one if you can. We hold regular meetings in each region on the following Saturdays of each month: NE-1st, NW-2nd, SE-3rd, SW-4th except for quarterly Statewide meetings. The actual dates vary so 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 lunch if not otherwise noted. If you have any questions about meetings, please contact the Regional Coordinators:

Northeast Region	Mitch Widham	386-673-0174	mwidham@cfl.rr.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southeast Region	--needs a volunteer - what about you?		
Southwest Region	Jerry Wolfe	941-355-5615	wolfforge@hotmail.com

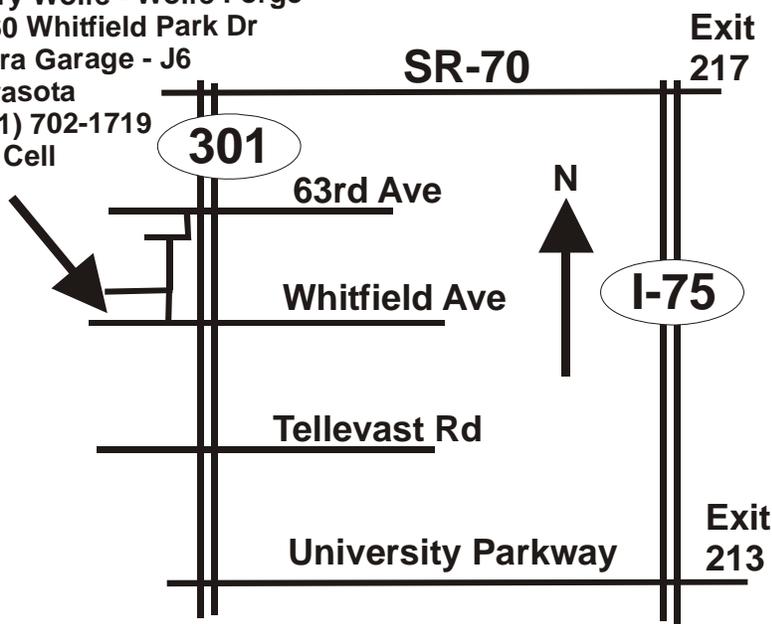
July 2009

- NE 04** Barberville - open forges
- NW 11** Rob & Valynda Nichols's Forge at 3007 Old Lloyd Rd. Monticello, FL. (850) 997-5050. As usual, please bring a covered dish to share & your "Iron in the Hat" items (5 free tickets for hand forged items)
- SE 18** Until further notice-Tanah Keeta
- SW 25** July 25 at Wolfe Forge: Demo by Paddy Falvey - Making a horse shoe - Every blacksmith should know how to do this; also we will attempt to finish the FABA table and if time permits we will make scrolls or finials from channel iron. Demonstration starts at 10AM, come for informal hammering starting at 9AM. We will have our normal Iron in the Hat and a pot luck dinner - Bring a dish to share.



NE Region

Jerry Wolfe - Wolfe Forge
 2260 Whitfield Park Dr
 Extra Garage - J6
 Sarasota
 (941) 702-1719
 Cell



SW Region

SE Region

Boy Scout Camp: from I-95 exit go east onto Indiantown Rd, go north (left) onto Island Way (1st traffic light). Stay on it until it ends at Country Club Dr. Go left—it ends at the entrance to Boy Scout Camp.

Future Events

NW Aug 08 - Marty and Pat's, Shimansky Specialty Machining, Inc., 4972-B Woodville Hwy. (You have to turn onto Marpan Lane in order to get to the machine shop.) I can't wait to see the waterjet cutter

Aug 15-16 The Pioneer Settlement is hosting an Outdoor Extravaganza -many vendors and demonstrators, on hunting, archery and related activities,

Report from the Northwest *John Watson and Billy Christie*

The May 9th meeting was held at Rex Anderson's in Monticello, FL. Demonstrator, Butch Patterson, who is from Starke, FL, put on the show. He is excellent in his ability to show the techniques and steps used in dragon head making. Two points that he brought out often were care and placement of heat along with light hammer use.

In this demonstration Butch used 1/2" square stock and started with the two horns. He then did nostrils, eyes, and nose. When these were completed he fashioned the two front whiskers.

When Butch completed the dragon head, there was no question that he had fashioned one mean dragon head and the statement is made with not one of us ever seeing a dragon in person!

We are thankful to Rex and his wife, Mary Ellen, for opening their fine facility to us for the May meeting. Also, a BIG thank you to Butch for passing along techniques to each of us.

As a footnote: If you have any questions about bee's and honey, well, Butch is the person to ask!
Happy Hammering!

Report from the Southwest *Jerry Wolfe*

The May 23rd meeting at Phil Pauley's Forge was attended by 12 including Phil's brother from NC and nephew from Tampa. One of the demonstrations

was "how to make bends and twists in hollow tubing. With a hollow pipe or square tube, the thin wall will "crimp or kink" and give a distortion rather than a smooth



Top filled, Bottom empty

bend. By filling the tubing or pipe with sand (very dry sand) and welding the ends shut; the pipe will bend without kinks. The square tubing can even be twisted like a solid square bar. Also tapering a hollow member can be tricky but can be accomplished a couple ways, one by filling with sand; the other by using the step of the anvil with gives a three sides forging operation. See pictures for proof.



Left empty; Right filled

Another demo by Jerry Wolfe was how to make an owl and making the eye punches to accomplish a realistic appearance. Eye punches were made by taking 5/8" stock of S-7; driving the heated stock onto a "bearing ball" of 1/2 inch or 1/4 inch creating a rounded depression in the stock.



Tapered filled tube



Owl forging



Then the outer portion of the punch is ground away to give a punch with a "thin edge" (approximately 1/16" or less) around the ball impression. Since S-7 is air hardening, it is ready to go. The owl eye sockets are made using a ball peen hammer and the feathery body appearance is created by overlapping ball peen indentations.

Training sessions were experienced by Bob Lillis and Colt Pauley, Phil's nephew. The training involved some basic tapering and pointing of square stock. We had some "good vittles" and a good day learning from each other.



Cole working;



Cole and Martin Pauley

Report from the Northeast

Mitch Widham

Saturday June 6th at Barberville was a wet one; thankfully the shop is big enough to shelter all in attendance. Thanks to everyone that brought old horseshoes and items to donate to the store. Lots of interesting items were made out of the shoes, and we now have a large stockpile for future projects. Lester Hollenbeck brought out a complete miniature horseshoing shop that he recently completed, including the small building, anvil, forge, vise and tooling, unfortunately, I didn't get any photo's before the rain came, but I will get some for the next issue. Buck in the Bucket was successful again raising \$90.00 for the cause, from those in attendance, and that was followed by a taco lunch, in the Smithy. The July 4th meeting at Barberville, will feature Allen Hardwicke demonstrating; Sharpening of Drill Bits. Allen says to bring your old dull bits, and he will get you cutting again. Also Melanie Owen will lead a group in the making of Dream Catchers utilizing horseshoes for the border, if you have any small feathers or beads please bring some. The Pioneer Settlement is hosting an Outdoor Extravaganza Aug 15 & 16th, which is going to have many vendors and demonstrators, on hunting, archery and related activities, you can check out their website at <http://www.pioneersettlement.org/> if you are interested.

Notices, For Sales & Want-Ads

BLACKSMITH COAL

\$35 per 100 lb bag (Pickup only) & details - Pioneer Settlement, contact the Settlement at 386-749-2959 or 386-749-2087 or mail your order with payment to PSCA/COAL, P.O. Box 6, Barberville, FL 32105. Accepted forms of payment: cash, money orders, checks, MasterCard and Visa.

Need wrought iron?

We have the real thing... and it's all on sale through July 4! Rods up to 14' long

We are dismantling the 1887 Globe Elevator, on the edge of the Duluth-Superior Harbor, and reclaiming its old-growth pine. Among its other treasures are several tons of Real Wrought Iron rods ranging from 5/8" to 1-1/2" in diameter. We also have millions of square-cut wrought iron nails. Prices start at \$2 per pound. Call to check current inventory. Special on 5/8" rods - back by popular demand!

We have revived our 10 lb. special: You can have 10 one-foot-long pieces of 5/8" rod (a total of 10 lbs.) delivered to your door for only \$59, including shipping and handling.

<http://www.readyshare.com/Users/jperes@aol-com/bin%20rods%200014%20small.jpg>

Forward this email to your colleagues. If they make a purchase, you will receive a 15% off coupon for each new customer you refer.

Wisconsin Woodchuck LLC; P.O. Box 97 * Superior, WI 54880-0097; Phone: 715.392.5110 * Fax: 715.392.5112
Email: judy@wisconsinwoodchuck.net; Web site: <http://www.wisconsinwoodchuck.net>

Armour Exhibit

Museum of Arts & Sciences, Daytona Beach
<http://moas.org/index.cfm>:

The Armory - Opening August 15, 2008 - on long term display
Mary Louise Marzullo Gallery

Antique firearms, weapons and armor from the collections donated to MOAS by Kenneth Worcester Dow and Mary Mohan Dow in 1998, these spectacular artifacts have never been exhibited before.



This includes the artistry of some of the most famous gunsmiths and weapon makers from the medieval period to the 19th century illustrated through a wide range of finely designed and decorated muskets, rifles and pistols, lions-head daggers, war axes, knives, sabers and straight-edge swords together with a rare late 17th century inlaid German crossbow.

(Contributed by Greg Cumbaa)

Report from the Madison Conference Clyde Payton

Hello Fellow FABAs Members: You will be happy to learn that the Southern Blacksmith Association's special Auction Project for their 2009 biennial conference sold for \$600.00. The high bidder was Mr. Robert Witt of Rossville, Georgia. This project consisted of the seven association logos - one from each member of the Southern Association. The SBA logo was mounted at the top of the arrangement. When mounted and fitted up it was very beautiful. I hope someone took a picture of it for our newsletter.

(Editor - Clyde buttonholed everyone with a camera to do just this. See the website [Events][Southeast Regional Conference 2009] for lots of pictures and Page 6 for what Clyde wanted.)

Preliminary Look at the Annual Conference Mark Stone

The conference this year, October 9 - 11, 2009, is shaping up nicely. Our two main demonstrators have been secured and are Jim Batson as our Bladesmith and Daniel Miller (<http://millermetalsmith.com/gallery/main.php>) as our Traditional demonstrator. So far we have Steve Bloom and Steve Estenson teaching two Intermediate classes each, with Steve E. teaching the making of tongs. Keith Ivey will be teaching two Beginner Classes (Fri PM and Sat PM). If you are interested in teaching the other two (Sat AM and Sun AM) Beginner classes,

let me know. Our Family Programs so far include Broom Tying w/ Jeff Mohr and Lisa Ann Conner teaching Bead and Wire Jewelry. Tim Ryan will be our featured entertainment Saturday Night as he humors us while auctioning the many wonderful, hand-forged items,



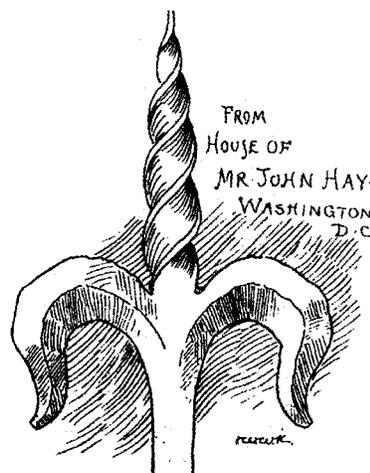
Intermediate Subjects: Meat forks & the "Moo" - utensil hanger

tools, jewelry, etc. We already have a few donated items including forged items from Luis Riggelman's demonstration at last year's conference. If you have any suggestions, feel free to contact me at markham62@comcast.net.

If you want to take the intermediate class, you have the ability to affect the subject matter, i.e., ASK!. Right now, it looks like forks and the 'Moo' utensil hanger but chest hardware/hinges/candle holders are all possible. WHAT do you want? - drop me a line! - Steve Bloom

Angle Cuts on Horizontal/Vertical Bandsaws Steve Bloom

While the usual Harbor Freight bandsaws have the ability to adjust the angle of the clamping mechanism to the blade, there are usually issues of stock slipping, precision of the adjustment, and (most importantly) convenience. A real simple way to make an angle cut is shown here -- grab a rectangle of scrap wood (say 4.5" x 6.8") and cut it diagonally to the required angle. Plop the wood pieces on the saw and capture the stock between them. Screw down the clamp system and start cutting. This trick allows repeated cuts and allows you to make normal as well as angled cuts one after another





SBA LogoProject - 2009 Madison Conference

ABANA Conference News
Site set for Memphis AgriCenter International
June 2009 - Vol. 1 Issue 1

The ABANA 2010 conference will be at the AgriCenter International in Memphis, Tennessee. Located at 7777 Walnut Grove Road, from I-240, on the east side of Memphis, take Exit 13 and drive east on Walnut Grove Road approximately 4.2 miles to Farm Road and turn south, go .1 mile.

Opening ceremonies will be on Wednesday, June 2, 2010. Thursday through Saturday will be full days of forging demo's and excitement ABANA style. Saturday will conclude with a pay as you go Memphis BBQ banquet and the conference auction.

The theme of the conference is to be "ABANA's Greatest Hits" in keeping with Memphis' musical heritage. The ticket price will turn the clock back at least 8 years... The site www.agricenter.org is within a few miles of thousands of reasonably priced hotel rooms. Camping and RV hook-ups will be available on site. Stay tuned for additional announcements.

Log on to the ABANA website and sign-up for our Constant Contact emails, find the box at the very bottom of the home page, enter your email address and click on "Get ABANA Email". You will receive periodic ABANA 2010 Conference announcements.

Gallery Open to Public
"Green Coal" Forges
Memphis Style Banquet
Top Demonstrators
Tailgate Heaven
Vendors for the Craft
Lectures & Workshops

"We will preserve a meaningful bond with the past. We will serve the needs of the present, and we will forge a bridge to the future. Function and creativity is our purpose. Our task is great and so is our joy."

Dimitri Gerakaris, 1973



AgriCenter
International

Memphis
Tennessee

June 2-5 2010

Lance Davis, Co-Chair for the 2010 Conference said, "We are excited to be putting on the ABANA 2010 Conference at AgriCenter International because the site has ample room to spread out the demonstration areas, it has a great area for the "Tailgaters", supports a large attendance, has hot showers for campers and RV hook-ups, plus the great on-site parking arrangements.

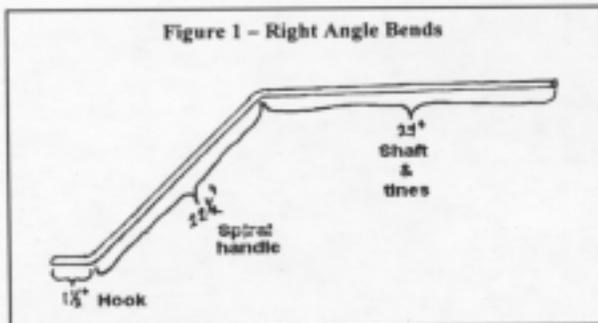
Most of all, by hosting the conference on the grounds of AgriCenter we support our members by making the conference less expensive to attend. We are planning a conference focused on blacksmithing education while not forgetting the many groups that come together to be ABANA."

The Conference will open on Wednesday, June 2 and close on Saturday, June 5 with the Auction. See you in Memphis!

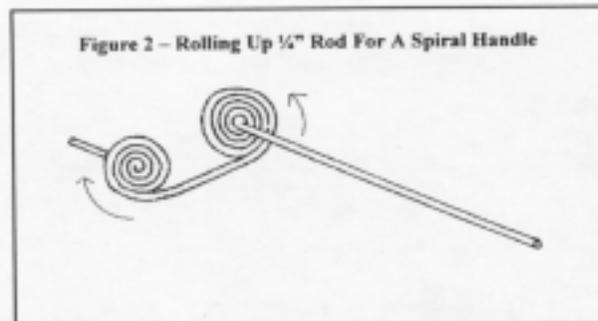
Toasting Fork

By Mike Meyer, OKI Forgers

This project is perfect for a weekend afternoon, being relatively quick and easy to make and yet producing a nice looking toasting fork that can be used around the campfire or the grill. It is also a good project for a beginner since it gives experience in some basic forging techniques. My finished fork is a long one meant for use around a campfire, and measured about 30 inches long. If you want to make a smaller fork, adjust the measurements given below to suit your needs.



To begin with start out with 48 inches of 1/4 inch rod and mark it at 1 1/2 inches from one end and 24 inches from the other end. The 1 1/2 inch portion will be used to make a hook at one end, the 24 inch portion will be used to the shaft and tines of the fork at the other end, and the 22 1/2 inches in the middle will be used to make a spiral handle. Heat the rod at the marks and make sharp 90 degree bends in opposite directions at each mark. This should leave you with something similar to a lopsided "Z", as shown in Figure 1:

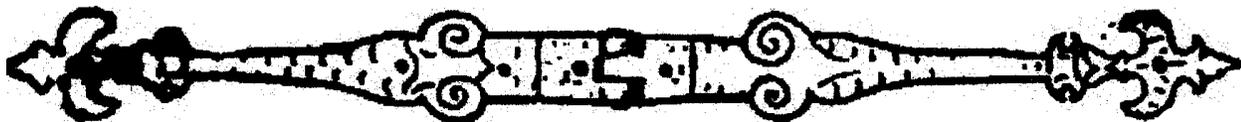


Once the two 90 degree bends have been made, the next step is to make the spiral handle. To do this, heat just to the inside of one of the right angles and when it is hot enough to easily bend then start rolling the handle portion of the rod up into a disc, as shown in Figure 2.

Continue wrapping the rod around the disc until you've used up about half of the rod for the handle. Once this has been done, repeat the procedure at the other bend until all of the remaining 22 1/2 inches of rod has been rolled into a second disc. The two discs should be back to back, similar to the drawing in Figure 3.

Once the discs have been rolled up your next step in forming the handle is to heat the discs evenly and then pull at each end of the rod until the coils of the spiral are drawn out into a handle, as illustrated in Figure 4.

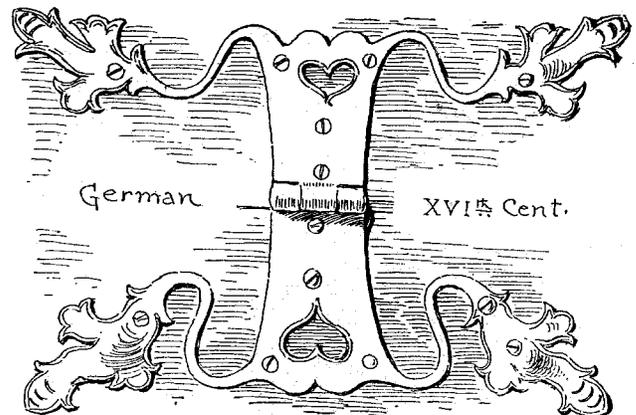
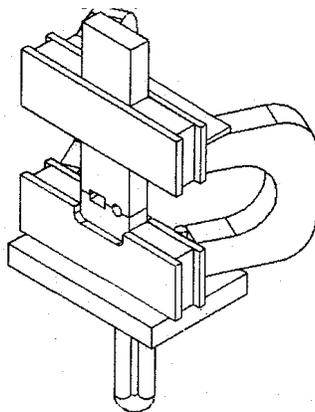
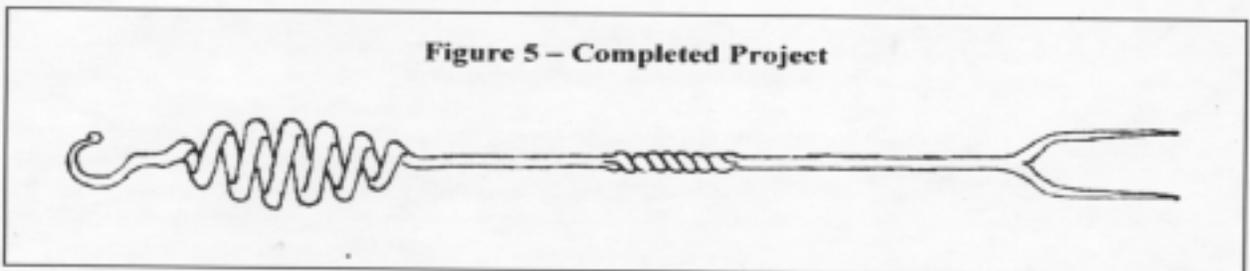
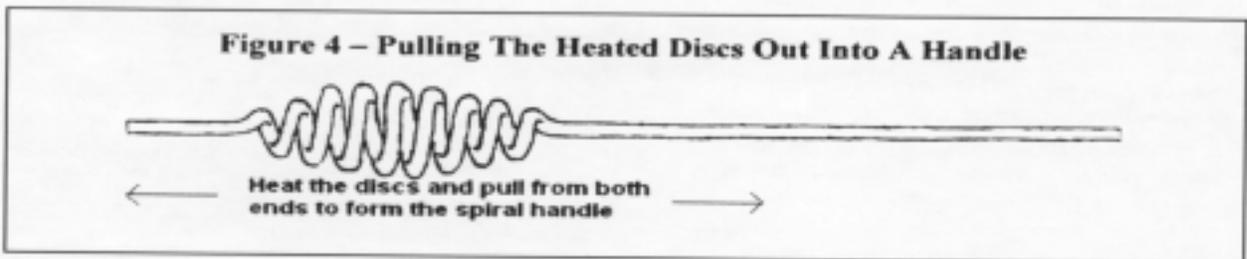
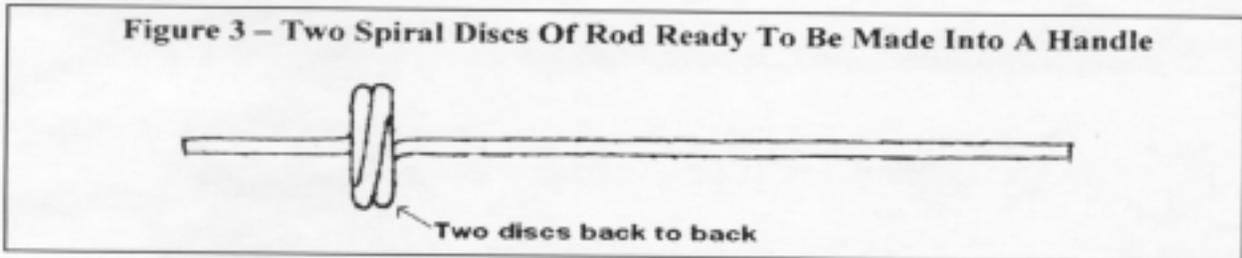
Even heating of the discs is important to produce as nice looking a handle as possible. However, it is unlikely that the handle will draw out 100% perfect. If this is the case, there are



several ways you can improve the look of the handle. To adjust the spacing of the coils, you can pour water on areas of the coil as you spread it to cool selected areas of the metal and make them harder to spread. You can also adjust the spacing of the coils by inserting one or two screwdrivers into the coils and prying them apart. If the diameter of the coils is too large, you can decrease it by squeezing the coils with a pair of channel locks or by hammering on them. When compressing handle diameter, it is very important to not overdo it. It is easy to make the coils smaller but much more difficult to make them larger.

Once the handle is formed to your satisfaction, you have

completed the hardest part of the project. The only remaining steps are to form the hook at the handle end and the tines of the fork at the other end. To make the hook, you just draw down the 1 1/2 inch of rod at the end of the handle into a taper of the proper length and bend it into a hook. To make the tines of the fork you flatten out about 1 1/2 inches of the shaft and either split or saw it. You then spread the two halves out to form the fork tines and either draw or file their ends to sharpen them and give them a pleasing appearance. Also, if you want to add a littler more flair, you can square up the middles of the shaft and put in a twist for decoration (as in Figure 5). Once these final tasks are completed, you're ready to get out a bag of marshmallows and try your fork out.



The Florida Artist Blacksmith Association (FABA) is a 501(c)(3) nonprofit 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. ABANA chapter 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.

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FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, Inc.
 Founding member Southern Blacksmith Association.
 Date _____ New Renewal

Name _____
 Address _____

 City State Zip
 Phone: Home _____ Work: _____
 E-Mail _____
 Spouse's Name: _____

Send application & a membership fee of \$25.00 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.

Don't list me in the directory []



July 2009

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 FLORIDA ARTIST BLACKSMITH ASSOCIATION
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 Gainesville, FL 32653