



December 2009

*The Florida*

# Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

## Message from President Elect Jerry Wolfe

I really appreciate the "vote of confidence" from all the officers and members of FABA in electing me to the President's office for the next two years. As many previous Presidents have kept our chapter profitable, I will do my utmost to help in continuing our

mission which is to teach, promote, and preserve the art of blacksmithing. I appreciate all the volunteers who have made our organization a success over these many years and will expect many more to give of their time to help our younger generation; as well as some of us who are not so young, learn new things about blacksmithing and the art of using iron and other materials. I look forward to getting better acquainted with each of YOU.



## Sad news: Bob Mancuso

*Mitch Widham*

It is with heavy heart that I inform you of the passing of Bob Mancuso. As most of us know, Bob was diagnosed with cancer recently. He wasn't feeling well and was hospitalized and passed away shortly afterwards.

We know that Bob touched so many of us in his own special way. At some time after Bob was diagnosed with cancer, he told Scoutmaster Jason Johnson that in the event of his demise, he requested that a tree be planted in his memory at (Boy Scout) Camp La No Che in Paisley, Florida.

There will be a tree planting dedication for Mr. Mancuso on Saturday, November 21st at camp with a memorial service to follow. We are trying to plant the tree in the area where Mr. Mancuso would traditionally set up his blacksmith shop. How fitting. All of Mr. Mancuso's friends will be invited, not just scout camporee attendees.

Mr. Mancuso's surviving family opted for a private interment. No other funeral services will be held, except for this service at La No Che on November 21, 2009. It is sure to be moving.

Mr. Johnson has agreed to deliver Bob's eulogy and would be interested in any stories or comments you are willing to share in person that day or in writing via e-mail to him at the above address.

*Due to inherent delays in getting an issue out, those receiving a hard-copy of the newsletter may not see this notice in time to attend the Memorial. For those receiving this via the Internet, please let your fellow smiths know - Editor*

## March Meeting - Payton Forge

Trent Tye from Georgia will be our demonstrator at the March meeting at my shop. I just talked to him and he suggested we watch a video which will be on his web site tonight (Monday Oct. 12) at 9:00 pm. His web site is [www.purgatoryironworks.com](http://www.purgatoryironworks.com). Thought you might be interested in watching his presentation.

## Morningside (Gainesville)

Are you interested in joining our small group of volunteer demonstrators for Living History Days? We are currently seeking individuals who would like to step back in a time when the roosters' crow and the rising sun, not an alarm clock, welcomed a new day! Morningside Nature Center's late nineteenth century Living History Farm comes to life with staff and volunteers interpreting day-to-day north central Florida life. Traditional crafts and trades such as blacksmithing, woodworking, knitting, soap making, spinning, weaving, and period folk music and are important parts of our program as well as more day-to-day activities such as cooking on a wood burn stove and feeding farm animals! Living History Saturdays run from September through May while several events throughout the year offer special opportunities to bring the past to life. Begin your journey back in time by filling out the volunteer application today or write to Nature Volunteering: [Nature Volunteering@cityofgainesville.org](mailto:NatureVolunteering@cityofgainesville.org)!

### Upcoming Events

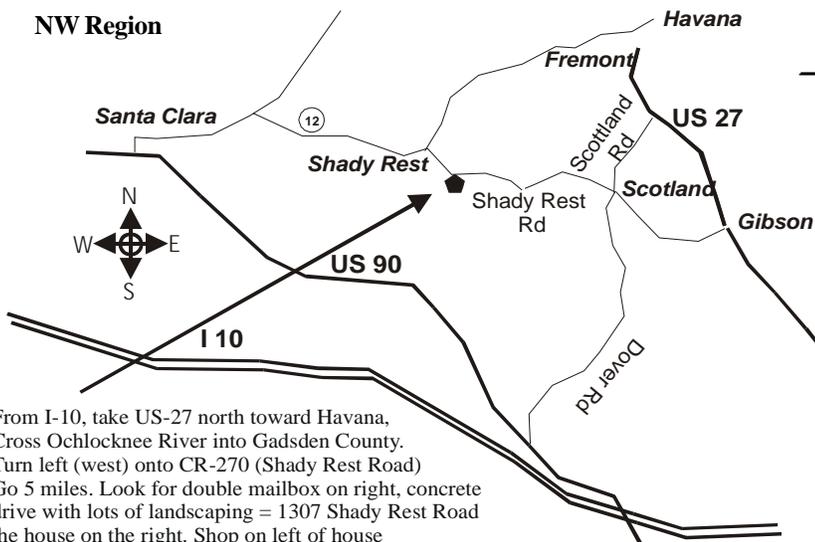
The calendar includes events of interest to the blacksmithing community. The regions have no boundaries - everyone is welcome everywhere. Come to more than one if you can. We hold regular meetings in each region on the following Saturdays of each month: NE-1st, NW-2nd, SE-3rd, SW-4th except for quarterly 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
Southwest Region	Jerry Wolfe	941-355-5615	wolfforge@hotmail.com
Southwest Region	--needs a volunteer - what about you?		

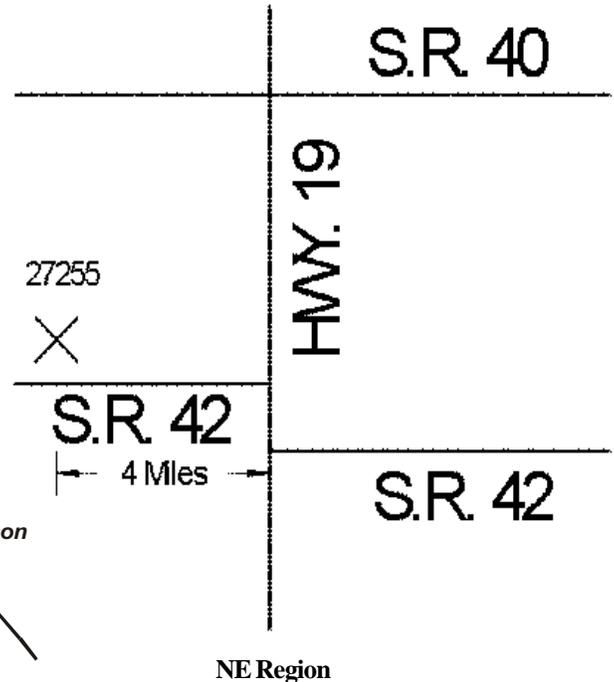
### December 2009

- NE 05 Christmas Gathering at Allen Hardwicke's
- NW 12 Bill Adams "Blind Hog Forge" at 1307 Shady Rest Road, Havana, FL.
- SE 19 Meeting to be held at the Boy Scout Camp.
- SW 12 [NOTE DATE!] - Trez Cole's forge shop-see pg.3

#### Blind Hog Forge - Bill Adams

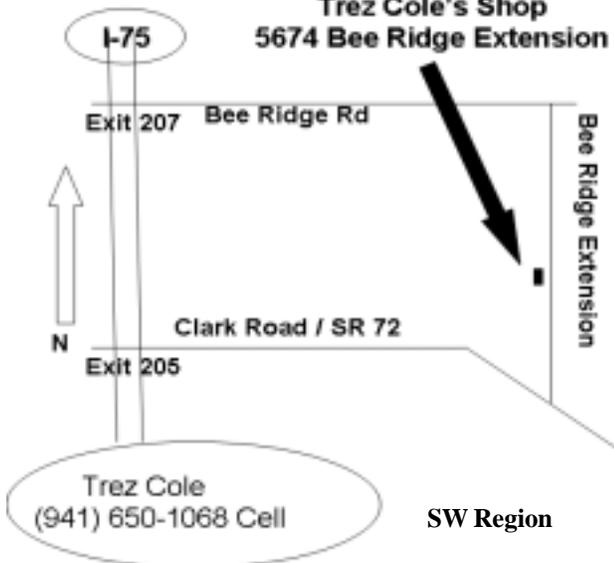


From I-10, take US-27 north toward Havana, Cross Ochlocknee River into Gadsden County. Turn left (west) onto CR-270 (Shady Rest Road) Go 5 miles. Look for double mailbox on right, concrete drive with lots of landscaping = 1307 Shady Rest Road the house on the right. Shop on left of house



NE Region

#### Trez Cole's Shop 5674 Bee Ridge Extension



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.

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### Current Events

**SW Dec 12** [NOTE DATE!] - Trez Cole's forge shop - Candle holders and letter openers.: A number of folks will demonstrate making different styles of candle holders and letter openers. 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.

**NW - Dec 12** Bill Adam's "Blind Hog Forge" Havana, FL. As always please bring a covered dish to share and your "Iron In The Hat" items

### Future Events

**NW Jan 09** Jeff & Brook Mohr's "Mocking Bird Forge" 22 Ironwood Court, Crawfordville, FL.

**SE Jan 16** Meeting to be held at Ray Reynolds' Shop

**NW Feb 13** Juan Holbrook, Gainesville, FL.

**SW Feb 27** Regional meeting -Stay tuned for details.

**NW Mar 13** "Payton Forge" outside of Monticello, FL.

Trenton Tye from Albany, GA demonstrating

**NW - Apr 10** Panhandle Pioneer Settlement in Blountstown, FL. John Watson & Danny Willis Demonstrating. Think Fire!

**NW- May 8, 2010** Rex & Mary Ellen Anderson's Shop outside Monticello, FL.



Cross Demo by J. Wolfe

riveting. Good job Trez.

Another demo by Jerry Wolfe was replicating the cross made by Daniel Miller. The cross uses the tenon-wedge concept to hold the horizontal and vertical members together. The vertical member has a square hole punched and the cross member has a tenon that fits thru the square hole and held in

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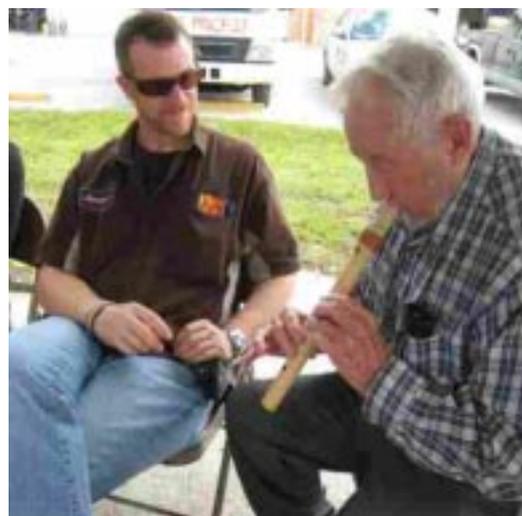
### Report from the Northwest

*Clyde Payton*

The Painted Pony Ranch is near the small town of Lloyd Florida and each year Painted Pony has a special "fun day" for kids. This year FABAs was invited to give a blacksmith demonstration at this function on Sunday, October 25th.

My mission was to advertise/promote FABAs for the purpose of recruiting new members. The most able demonstrators were Rex Anderson, Ron Childers, Rob Nichols, Charles Pate, and Aaron Peck. We also had a very impressive display of blacksmith made items.

This turned out to be quite a Fun Day for us big kids too!



Bud Grieshop & Travis Meeks

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### Report from the

**Southwest**

*Jerry Wolfe*

Our SW region meeting on Oct 24th was attended by 14 who watched two demos. Trez Cole demo was making a pair of pick up tongs. Starting with 1/2" square stock and progressing thru the various steps of making the jaws, pivot and



Trez Cole

place by a wedge. The pictures tell the story. Bud Grieshop made some flutes and gave a detailed lesson on the history and how to play the flute. Also: Three FABAs members demonstrated at the Antioch Days Festival east of Tampa on Nov 7th - Steve Berglund, Hank Kuczwarra & Jerry Wolfe.



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**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.

**FABA Conference 2009**

Bob Brown & Jerry Wolfe generously provided the pictures of the latest conference. I was tied up teaching and didn't get the usual coverage, so you'll just have to live with it. The pictures of the Gallery and Auction items will appear in a future episode once the post-production is completed but what we have is isn't half bad -- classes going on (during a pounding rain storm / Florida sauna), the anvil shoot, Tim Ryan (and other friends) and sharing the knowledge with younger smiths (kind of sad when you begin to realize that virtually everyone is a "younger" smith...).





## The Smithy at The Mission San Luis Dr. Skeeter Prather

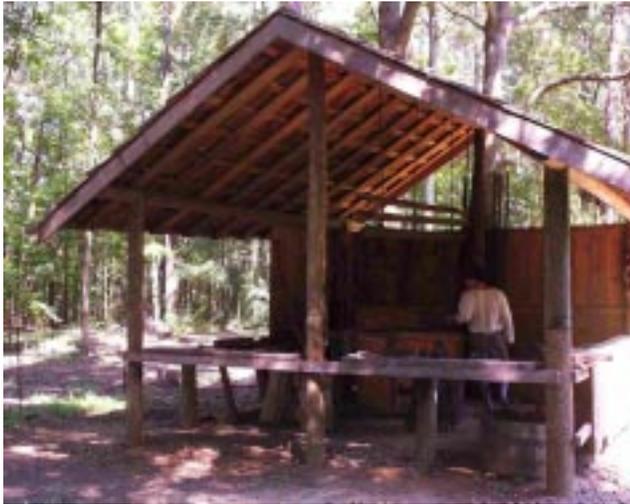


Fig. 1: The smithy

The smithy (Fig.1) is a reproduction from the Spanish occupation of Florida circa 1600-1700. The overall construction



Fig. 2: The anvil & vise

is an open-air shelter containing a forge with bellows, an anvil, a vise (Fig.2) , and the usual miscellaneous pieces of equipment - like a smith.

The forge (Fig. 3): It is typical "waddle and daub" construction. The Spanish learned this from the Apalachee Indians, the Natives of the Tallahassee Area; here when the Spanish arrived. It consists of a framework of four posts (4-6" diam.) set vertically into the ground . The front two are about 36" high; the back two about 48". A header frames the upper circumference. The back "baffle" is there to protect the



Fig. 3: The forge

leather bellows from sparks (Fig 4 A).

Before the headers are placed, stakes (2" diam.) are driven in between the corner uprights about 8" - 10" apart. They stand high enough to reach the underside of the headers (Fig, 4 B). Vines and small tree-shoots are weaved onto and about these stakes - forming the "waddle". Thus is formed the matrix into which clay is "daubed" (Figs 4 C). Figure. 4 D shows waddle in place ready for daubing. Before the clay is daubed, a steel air pipe is placed through the rear of the structure. It is in a "Y" shape. At San Luis this pipe is welded-up 1" black pipe. It is placed at a level sufficient to enter horizontally the bottom of the finished fire pit (Fig.5). It's believed that the smiths in the 1600's used bamboo; two tubes. These would burn out near the fire, but the hardened clay maintained the holes; and the "cool end" continued a satisfactory/working connection to the air source, the leather bellows.

The daub is given several days to "set"/dry. The inside is then filled with dirt. A "fire-pit" is scooped out of the top near

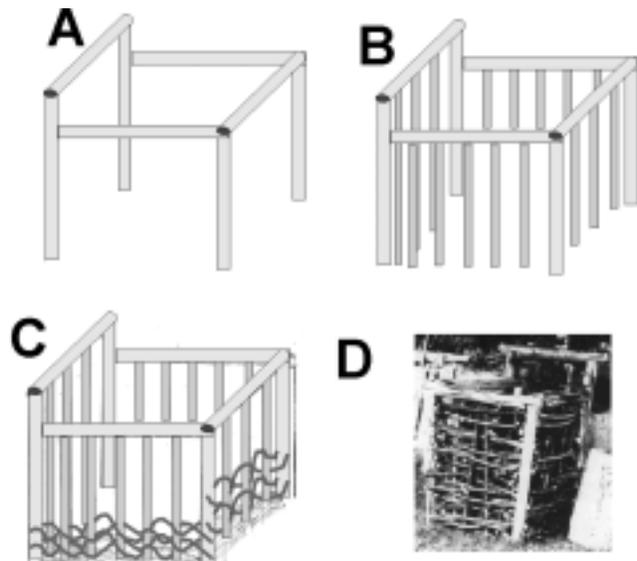


Fig. 4: Waddle & daub construction

the back end - of sufficient depth to end up with a fire pit 5 - 7 inches deep. A layer of clay is placed over the entire top of the forge structure and into the fire bowl. Care is exercised not to cover the end of the air pipe. Figure 5 represents these relationships.

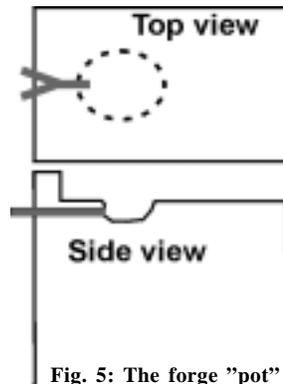


Fig. 5: The forge "pot"

Two forges have been constructed at San Luis. The first was daubed with pure, unadulterated Georgia red clay. Over time the clay dried, cracked and chunks fell off. A lot of effort was spent keeping it repaired. The second, new location, new shop, new formula for the daub: Ga. red clay, wall plaster mixture, 3 to 1 mixture (clay to plaster). It's 5 years old and holding up very well.



Fig. 6: The bellows

That's the forge structure; now some words about the air source - leather bellows (Fig.6): There are two: 12 inches in diameter, 34 inches long. Made of leather, sewed into tubes. Three hoops made of white oak are tied inside each equidistant apart. They keep the open shape of the tubes. A system of valves control intake and expulsion. Employed alternatively they provide a steady blow of air into the fire. They are mounted on a frame placed some 15 - 20 inches behind the forge. Figure 7 represents the mounting arrangement. Note the valves. Two wood frames support the bellows and facilitate their operation. The front frame is made of two round posts (about 5" diameter) and a 1" X 12" rough board nailed horizontally between them.. The posts, about 40" high and placed about 36" apart are sunk into the ground about 18" back of the forge. Two wood disks 12" in diameter and 1.5" thick with a groove sawed around the perimeter (the bellows are removable for storage away from the squirrels);

the grooves facilitate "staying" of leather throngs tied around the ends of the bellows stretched over the disks) and a 4 X 4 inch hole sawed in the center of each is attached to the horizontal board (which has a matching hole) on its interior surface; i.e., the surface to which the bellows will be attached) with 3" clearance between them. A flap valve of tempered hard board (with a thin leather gasket) is affixed over the hole to the "exterior" surface. A strip of leather serves as a hinge. A wooden square box is constructed - approx. 6" X 6" X 4" with a 5" round hole in its exterior surface, and fixed onto the horizontal member over the valve. Were I to do this again I'd put the valve box on the interior surface and thus hid inside the bellows. Cones of sheet steel are made a little less than 5" diameter at one end and a hair larger than 1" at the other, with a length of about 18". They are long enough to bridge the gap between the 5" hole in the "valve box" and the end of the 1" air pipe. The seam is not welded nor braised nor soldered. When in place the ends are sealed with clay daubing and the entire pipe "hidden" in a clay covering. The distal end of the bellows frame is "movable". It consists of two upright "levers" - to which the distal ends of the bellow tubes are attached. Simply a 2" X 4" board about 38" long. A 12" round disk with an off center 3" round hole is attached such that the disk center is 28" up from bottom. As with the front disks, the rear disks have grooves sawed around their perimeters. The distal ends of the bellows are attached hereto and fixed with leather throngs. The lower ends of the "levers" are fixed in place. Short 10" - 12" long 8" diameter posts with notches cut into the top ends are buried 16" apart. The "notches" (Fig.7) form a "socket" into which the lower end of the "levers" are hinged. The bellows so fixed are operated by a back and forth motion such that an uninterrupted flow of air is maintained. A couple footnotes: The measurements here given are those of the present forge at San Luis. The height/measurements of the forge are not critical and adjustable to the comfort of the

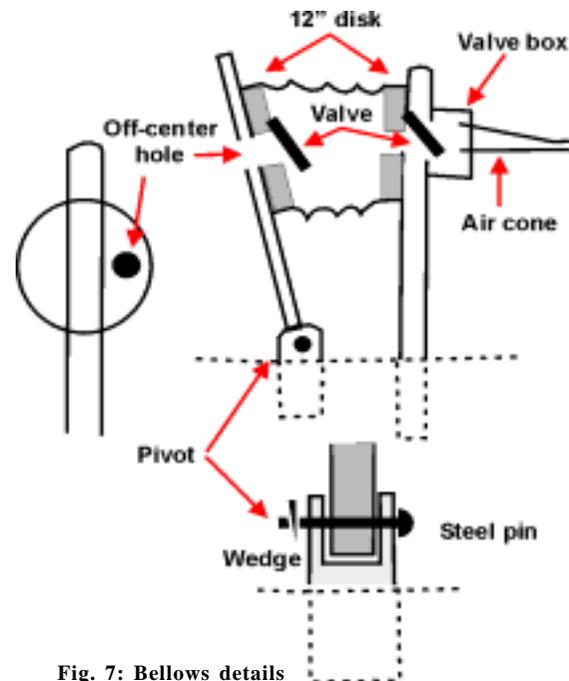


Fig. 7: Bellows details

smith. The measurements are 42" long x 36" wide x 36" high to top of forge, & another 12" for the "fire-wall".

All "exposed" fasteners, all nails, are hand wrought. The "hidden" ones are commercial screws and nails. Fuel is charcoal or dry hard wood blocks is/are the only fuel; mostly charcoal (and that's hardwood chunk "charcoal"; not the backyard bar-b-q biscuits stuff!) It does leave ash. It's just scooped out by hand daily just before firing-up first thing in the morning. Contact "Charlton Prather" <luec@nettally.com> if you have questions.

## Courting Candle Jig

For some reason only known to the digital gods of the internet, a set of pictures generously provided by Bob Brown got sidetracked were only discovered lurking in one of my e-mail accounts in last few days. I don't have any information of dimensions of stock or any other information, so if anyone out there would like to send what they know to me, I'll be happy to publish an addendum. But for the moment, here are the pictures.



**ABANA Conference News**  
**Shelley Thomas added as Demonstrator & Camping Arrangements Finalized**  
**October 2009 - Vol. 1 Issue 3**

The 2010 ABANA Conference Committee is pleased to announce the addition of Shelley Thomas as a 2010 conference demonstrator. This addition demonstrator rounds out the conference demonstrator list.

**Demonstrator List Addition:**

Shelley Thomas - who regularly demonstrates at the Kew Bridge Steam Museum, London, UK, will round out the international demonstrator list for the conference.

You can check out her work at her web site: [www.shelleythomas.co.uk](http://www.shelleythomas.co.uk)

On hearing this announcement, member Paul Casey said:

"I visited Shelly a couple years ago at her shop and admire her work. Good choice! Her work is a bit of whimsy, a bit of fun and the craftsmanship to back it up. Exactly the infusion of energy we all need now. Bravo!"

**On-Site Camping:**

Camping Arrangements have been finalized. Requests should be directed to the Agricenter RV Park Manager Mark Hoggard at 901-757-7777 ext 7200. All campsites have water and electric @ \$20 per night, if someone would want sewer and or 50 amps service the cost is \$ 30 per night. However there is a dump station on site.

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

Log on ABANA.org website and sign-up for Constant Contact emails, email address in the box at the bottom of the home page, click on "Get ABANA Email". You will receive periodic ABANA 2010 Conference News.

The ABANA 2010 Conference will be held at the Agricenter International in Memphis, TN. 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.

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.

### FABA Officers

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<b>Vice President</b>	<b>Charles (Hippie) Pate</b>	<b>850-997-6986</b>	<b>-unknown-</b>
<b>Treasurer</b>	<b>Juan Holbrook</b>	<b>352-374-8888</b>	<b>talcaforge@craigfitz.net</b>
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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 [  ]



**December 2009**

*The Florida Clinker Breaker*  
 FLORIDA ARTIST BLACKSMITH ASSOCIATION  
 Juan Holbrook, Membership Records  
 6418 NW 97 Court  
 Gainesville, FL 32653