



PRESIDENT'S MESSAGE

Changes in store for FABA Conference

Greetings, Blacksmiths!

As I write this June message on Mother's Day weekend, I realized I should have wished all of the mothers in our organization a Happy Mother's Day in my last message. Anyway, Happy belated Mother's Day to all our wonderful mothers out there. I really appreciate everything you do. I know my Mother had to put up with more than she should have with me, LOL.



Mark Stone

Also, I'll take a moment to say Happy Father's Day to all of the fathers in this organization as Father's Day is approaching. I hope you all were/are able to spend time with your families during this time of social distancing.

Since my last message, we held our Quarterly Board Meeting. A couple of big topics of discussion were our monthly meeting schedule and Annual Conference.

Our monthly meetings will resume in compliance with local and state guidelines, but will also be up to our Regional Coordinators as to whether they will be scheduled.

With state requirements being eased at this time, it is largely the local municipalities that dictate gathering, as some cities/counties may still have restrictions in place and still have a high number of COVID-19 cases.

Remember, if your region does hold meetings, please keep within the guidelines and keep your distance. If you are a high-risk person, you may want to consider not attending.

As far as our Annual Conference is concerned, the

Board will be meeting again in early June to discuss plans. We are planning to have the conference, but it will not be the major production it has been in the past.

Not knowing what the future brings, we feel it best to keep things more local so if we should have to cancel, we will not have thousands of dollars we could potentially lose. We are gathering ideas from the Regional Coordinators and other Board members. If you have any ideas, please submit them to your Regional Coordinator for discussion at the special meeting. We will have more information on this in the next Clinker Breaker.

I have seen a few pictures of some of the projects some of you have been working on, and they look great! I have been so busy with sending people to work from home that I haven't had one spare minute to do much. I'm trying to catch up with spring chores I got way behind on while working nearly every day for about 7 weeks straight.

Things are getting back to a normal work schedule, and one thing I plan to do in the near future is build a table for my portable band saw. I found a design online that I like that easily allows the saw to be removed from the table and used as the portable saw it is.

If you would like to check it out, go to https://www.youtube.com/watch?v=9s_H9xgcXuk.

Hopefully, I'll have it finished by the next Clinker Breaker and can include dimensions and photos of the completed project.

I hope you and your families are all well and be safe! Keep your forges burning and your hammers pounding.

Always think safety,

Mark Stone

Walt Anderson Scholarship 2020

This Florida Artist Blacksmith Association scholarship was established to honor the memory of Walt Anderson, one of our charter members. Its purpose is to further the craft of blacksmithing and is available to any FABA member in good standing. The award is limited to the actual cost or \$1000, whichever is lesser. It may be used for materials, tuition, lodging and transportation (paid at the rate of 43.2 cents per mile or the actual cost of public transportation, whichever is lesser).

A letter of application or a detailed email may be submitted provided the applicant answers the following questions:

1. What is your name, address and phone number?
2. How much experience in blacksmithing do you have?
3. How will this instruction help you with your blacksmithing craft?
4. What is the name of the school you wish to attend?
5. What is the name of the course and the name of the instructor teaching the class?
6. What costs will be incurred (tuition, lodging, transportation, etc.)?

Note: By accepting the Walt Anderson Scholarship the applicant agrees to provide a demonstration of skills learned at a regular FABA meeting, and write an article concerning the learning experience, including a “how-to” article for publication in the Clinker Breaker. The next item is not required but strongly suggested that an item made with the new knowledge be offered for auction at the Annual meeting.

Completed letters of application or emails should be sent to John Butler, Chair, FABA Scholarship Committee, 777 Tyre Road, Havana, FL 32333 or jgbutler@sprintmail.com.

Deadline for receipt is June 30, 2020. Three finalists will be recommended to the Board. The decision of the Board shall be final. The successful applicant will be notified.

Florida Artist Blacksmith Association (FABA)

is a not-for-profit organization chartered with the State of Florida and is dedicated to promoting and expanding the horizons of architectural, artistic and practical blacksmithing while preserving the rich heritage of this craft. FABA Officers and members assume no responsibility or liability for injuries or damage caused as a result of the use of any information, materials, design, techniques, etc. contained in this newsletter, our website, <http://www.blacksmithing.org>, our Facebook Page or provided at meetings or demonstrations.

Contributions to FABA 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. Send to editor@blacksmithing.org. Materials submitted must be your own work, and citations of others must be clearly identified. By submitting materials, you are allowing FABA to edit, print and post them to FABA's website. 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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Calendar of 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, Far West and SW-4th. 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 9 a.m. to 4 p.m., and you'll want to bring a bag lunch if not otherwise noted. If you have any questions about meetings or events, please contact the Regional Coordinators:

Central Northeast Region	Heinrich Hole	386-848-6982	heinrich.faba@gmail.com
North Northeast Region	Ben Thompson	617-388-5695	thompsoncrafted@gmail.com
Northwest Region	John Pfund	850-528-3280	johnwpfund@aol.com
Southeast Region	Peter Hill	651-635-6022	blazeblades561@gmail.com
Southwest Region	Antony Fenn	617-320-4781	antony.fenn@gmail.com
Far West Region	Dave Sandlin	850-974-1548	traditionsworkshopinc@gmail.com

Note: The COVID-19 Coronavirus outbreak has affected all events in the state of Florida. Please check with a regional coordinator before attending any FABA events this month.

Regional Reports

North NE Region

The North NE May meeting was postponed until November due to COVID-19 restrictions. Our scheduled June 27th meeting at Jordan Borstelmann's shop is still expected to happen, but please monitor our social media posts as this is an ever-evolving situation. If we are unable to safely meet in person, Jordan has kindly offered to

conduct the demonstration virtually. Please monitor the NE Facebook page at <https://www.facebook.com/groups/FABA.NE/> for the most up-to-date meeting information.

Stay safe, everyone!

— Ben Thompson, North NE Coordinator

Northwest Region

Hello everyone from the Northwest Region.

As I write this on a Sunday morning, we did not have the May meeting at Mike Luck's that I had hopefully forecasted. I didn't expect to have it, we had already canceled the April meeting, but we had a plan.

Now having missed two monthly meetings, I think we will be starting back having meetings in June. Mike Luck is still ready to host a meeting, so we'll start there. Mike and Marilyn live at 15 Jefferson Heights Road, Monticello, FL.

Last year when we met there, we set up in the shady area behind the shop and had a lot cooler time blacksmithing and eating lunch! We made a trivet using Blacksmith Challenge tools to make the mortices and tenons. I still have the trivet, so I'll bring it to show off and maybe inspire someone to make another.

The last meeting we had was at Mike Bettengers welding shop in March. We had a tong-making workshop with some people demonstrating how to make tongs and some getting

to make tongs, some for the first time! For the meeting we didn't get to have in April, I planned a contest making tongs from start to finish before lunch. That's what we're going to do in June.

Bring your own material and plan to make tongs, starting from basic metal stock and finish by the time we stop for lunch. I encourage people to team up and work together to try to get it done in time. We will cook something special on the grill to celebrate getting to have meetings again, and we should bring sides and desserts to go with it.

Don't forget to bring something for the Iron in the Hat raffle, and I'll have a table for show-and-tell of what everyone has been working on the past couple months. It's about a month until we have this meeting on Saturday, June 13th, so I'm pretty sure we're going to get to have it.

I hope to see you there!

— John Pfund, NW Coordinator

Southwest Region

The Southwest Region has been encouraging our regions members to post photos of what they are working on during this “stay at home” period.

Tony Fenn, SW Regional Coordinator

I tried a fun project (with credit to David Mortimer of BABA). For the smaller ring, I took a flat bar 15” x 3/16” x 3/4”, and simply twisted it a half turn one way, then twisted a half turn the other way, every few inches along its length. The bar was then hammered into 1/2” round, creating the reverse twist within the bar.

Then I made bigger ring, a dragon twist ring, out of 17” x 5/8” square and put both rings together and mounted them on a base of 3/4” by 1 1/2”. This was a present for some dear friends, a prickly retired U.S. Marine colonel and his wife, who went through a lot of health issues this last year but supported each other. I handed it over, at distance, to an emotional response that warmed my heart.

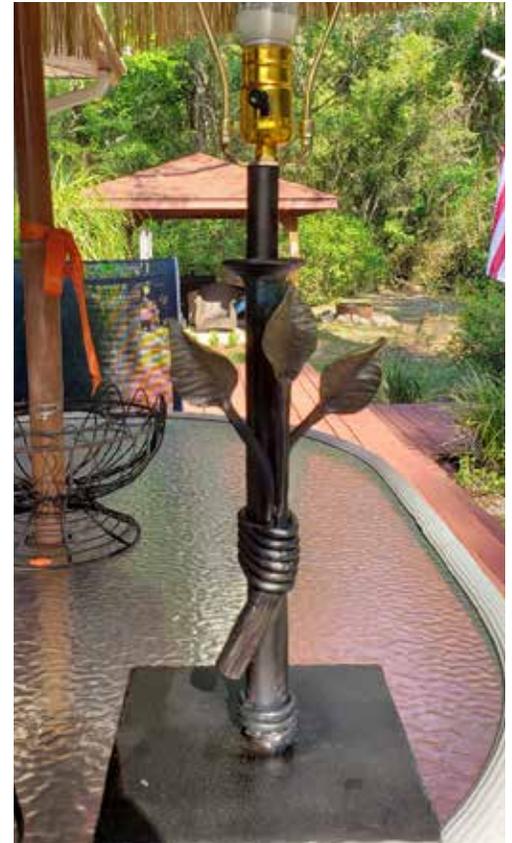


Jerry Wolfe, former FABAs president

Titled: Ginko

Jerry Wolfe was asked by his wife Irene to make a sculpture for their newly renovated bathroom. She basically designed it from examples Jerry showed her to get the size and arrangement to fit the space. The leaves were “rough cut” out from plate and hot textured with tools under the treadle hammer.

Regional Reports



John Boy Watson, former FABBA president

This is the lamp I was going to make for the SW monthly meeting. But with the sudden changes in our society and being homebound, I was able to accomplish a number of initiatives that had been pushed off, which included a complete workover of my work area and forge. Most power tools are now up and workable. I have some oyster knives and RR Spike knives, and now this lamp.

Trez Cole, SW Trustee

I was looking for a project to explore different techniques in blacksmithing. I started out with 1/4" x 2" flat bar 12" long. Cut in the pattern and then started isolating each part of the project. After the forming of each piece to started to come together. One of the skills that we all need to work on is the calculating out the parent stock to make sure you have the right amount of metal to complete the project with no waste.

Far West Region

Sad to report that the forges in the Far West were cold for most of April.

However we did get one project accomplished, when restoring this 1947 armoire we needed to make a hanging bar and some hooks to complete the look and restore the function to this old case.

By the way, when this project came in it was literally a pile of boards found in a chicken coop.

Planning for 2020

The next Far West meeting is scheduled at Traditions Workshop for May 23 rd ! Our May meeting will be kicked off by a presentation on blacksmithing re-enactment tools by Jim Apple. Jim is not only a professional farrier but also a professional re-enactor having appeared on several TV shows and in multiple Park programs. He will discuss the costuming aspects where our blacksmithing skills can help make a re-enactor step out of the past. We will also pick up where we left off and continue to support our members working on their Journeyman handbook by holding our final installment on the use of welding equipment – focusing this time on stick welding. Bring your PPE and be ready to start at 9AM for our business meeting followed by Jim's presentation and then this session on ARC welding. Open forges will be fired up by 10AM and you are welcome to work your own projects until we shut down, usually around 2PM. Please let us know if you plan to attend by signing up for our event on Facebook @FABA Far West - the Panhandle Blacksmiths.

The June meeting will again be hosted at Traditions Workshop so Christopher Mallet can teach the proper use of grinders, belt sanders, and stones for shaping and sharpening.

July and August meeting locations are TBD but we'd like



to hold at least one event closer to Pensacola and one event in conjunction with a museum or library; maybe in Panama City? Topics are also still in discussion but you can plan on more classes to help our members to reach their journeyman certificates.

— David Sandlin, Far West Coordinator

A deeper look into the Journeyman Standards



Example of a riveted piece.

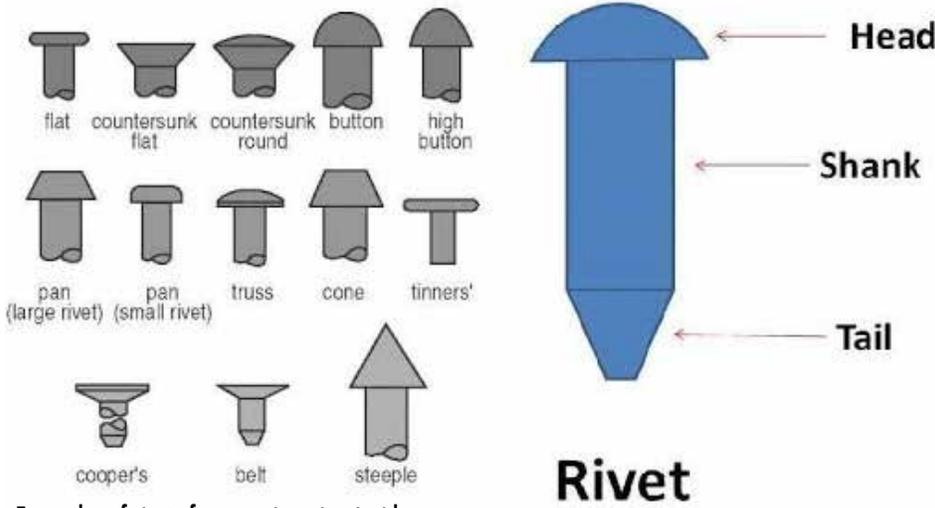
FABA Journeyman Standard #11. Riveting: Make two assemblies from at least two separate pieces for each assembly using hot riveting and cold riveting (pop riveting is not acceptable).

Rivets come in a number of styles, metals and varieties.

For small work, copper rivets can be very useful. They are “soft” when started but will harden as they are hammered, making them difficult to remove. Aluminum countersunk flush rivets represent a specialized class of rivets that are common on aircraft and are set flat on the backside. They are typically set with air hammers.

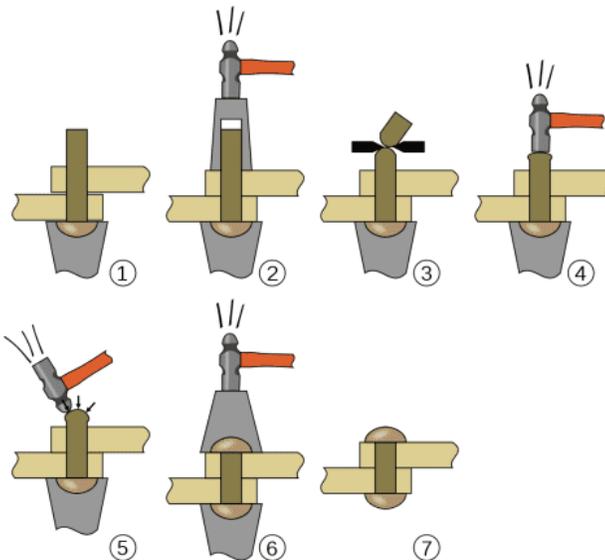
Cap rivets, shown at bottom, work well in leather or cloth but, like pop-rivets, cap rivets do not meet the intent for this standard. Similarly, tube rivets should be avoided even though they are useful in select applications.

Know All About Rivets



Examples of rivets from engineering insider.org

Steps in the process of riveting. 1. Insert the rivet and capture the head in a form that also acts as the anvil for this process 2. Set the plates together firmly 3. Cut off the excess - if any 4. Upset the rivet 5. Use the ballpeen to form the head 6. Then use a form to finish the process 7. As the rivet cools it will draw the parts together making a water tight/pressure tight seal. Photo credit Hackaday.com



Cold riveting is a fairly straight forward process. Line up the pieces of metal to be joined, insert the rivet, flip the work over so you can cup the rivet head in a form and then upset the rivet back on itself to hold the parts together. You can use a ballpeen hammer to form the head in the same way as hot riveting (see the diagram below) or you can just “smash it flat” which is not pretty but may meet your project requirement. Cold riveting is considered a faster process because the heating step is skipped however, cold riveting is not recommended for fluid-tight joining purposes. Cold riveting becomes more difficult as the size of the rivet increases.

Hot riveting is a far more interesting process. A round headed rivet is heated to red-hot, then the straight end is placed through pre-aligned holes in the steel parts to be joined, next the straight end is hammered into a mushroom shape using the ball of a ballpeen hammer to match the domed end. As the rivet cools down it contracts, putting rivet under tension and drawing the two pieces of metal together very tightly. Tight enough that it can form a seal against water or high-pressure steam, iron rivets have been used in the construction of ships and steam engines.



Photo credit ACE hardware

Making a Wine Bottle Chandelier

By David Sandlin

Want to try a simple project that looks complex? You'd think the wine bottle chandelier fits that bill. Maybe, or maybe not. Let's walk through the steps – and a few mistakes.

First step is to cut the bottom off a wine bottle. I've tried using a string soaked in flammable liquid technique with less than desired results; I was shattered.

I then tried setting up a cutting jig to score a line around the bottle. Supposedly, after scoring a line you can tap the glass or use a couple of cycles of hot and cold water to encourage the glass to separate on the scored line; I was NOT encouraged by the results.

In a final act of desperation I got out my tile saw with a new blade and cut the bottle in half. Not as clean as I'd like, but the results were satisfactory after sanding the edges. Maybe I can flame the edges in the forge? We'll look at that later.

Next you make the hanger. Start with 1/4 inch round stock, it needs to be at least as long as the bottle plus enough material to make the hanger, if you want to make a round eye hanger as I did an additional 3 inches are required.

The hook end that will hold the lower unit is drawn down to 1/8 inch which gives you enough length to make the hook without additional length in the rod. The end with the hook must be small enough to pass through the neck of the bottle but large enough to capture the ring that you will put on the lower unit.

One might be tempted to make the hanger and the lower unit in one piece. Not only is a more difficult process to make the upper and lower unit in one piece, especially when trying to

make all the parts without breaking the attached glass bottle (don't ask me how I know) but if the bottle is ever broken it will be impossible to replace the glass without reforming one end or the other (but if you do then I suggest reforming the

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The hook is small enough to pass through the neck of the bottle. You might want to make your hook a bit longer to reduce the chance of the chandelier coming apart if accidentally bumped.



end with the external hook/eye).

To make the lower unit, start with another piece of 1/4 inch round stock around 27 inches long. Draw a short taper of one inch and leave it square so it will have a more positive lock in the vice. Bend the taper over making a

square corner and leaving a point that is about one inch long.

Starting at the bend heat as long a section of the rod as your forge and tools will allow. Clamp the one inch taper in your vice and wrap the bar around the exposed part of the taper where you made the square corner. Don't worry about the loop being too big because as you pull the next loop around it will significantly tighten the first loop. Have a hammer ready

to knock the loops back into place if they try to climb over each other.

Next you will need to make the eye loop on this spiral that will engage the small hook you made earlier. Plan to cut off any excess that would cause the future candle holder to hang below the bottom of your bottle. For the wine bottles I have, I cut the length to 8 inches from where I stopped the spiral, about 2 inches will



To hold a tea light, you will need 4 and 1/4 trips around the vice.

Project Report



Checking the eye in the lower unit to see where it will stop in the bottle.



Remember when bending the holder that the point of the spiral points down, not that that's ever happened ...



This stands only 6 inches tall

be taken up making the eye so plan your project accordingly. You will want to make the eye loop large enough to stop in the neck of the bottle but not so big as everything will hang below the bottom of the bottle when stretched out.

On the next heat use the vice and a hammer to put a 90 degree bend where the spiral ends and then tweak the rod so it stands over the center of the spiral.

On the next heat bring the entire spiral up to orange and then quench the rod and eye before capturing the end of the spiral in the vice.

Use a set of tongs to pull straight up. This will make the basket to hold the tea light. Use a hammer to tap down the spiral if it tries to unravel too much.

If you have a section of round stock or a hammer face that is the size of a tea candle, then use it as a mandrel to control the unwinding.

To put the assembly together slide the thin hook through the neck of the bottle and hold it so the neck is against the hanger at the top and the thin hook is exposed out the bottom of the bottle.

Take the basket and hang the basket ring on the thin hook. Put a lit tea light into the basket.



Steps in pulling out the basket: Heat the coil evenly, then quench the hanging bar so it won't bend as you pull. An even pull straight up will do the trick.

Gently slide the bottle down to cover the tea light and then hang the completed assembly in a suitable location to enjoy the light.

CAUTION:

By the way, if you try to flame the bottom edges of the bottle in the forge the temperature differential may cause some cracking; then you too can discover that getting molten glass off the bottom of the forge is a pain.



No Man Is An Island

By Jordan Borstelmann

I did not get here alone.

The wood of my hammer handle came from a hickory tree, farmed and formed and sent to me. The electricity I run my shop with comes from others' labor and ingenuity. The steel I forge my blades with is shipped from New Jersey. Also in New Jersey, in a brick factory, in the year 1912 (over 100 ago!) men worked hard days and hard nights to bring the anvil I forge my steel on into being.

I did not get here alone.

I've mentioned my teacher, Yaw Owusu Shangofemi. I've lost touch with him by the way, and would love to get a hold of him again, if anyone knows how.

I've been to the Penland School of Crafts, and learned much there from Mark Maiorana. I took a hot work chisel class at Leslie Tharp's shop, taught by a traveling GutterSmith whose name I have forgotten.

All these folks have been paid for their services, however, either in labor or money.

I'd like to talk for a moment now about those who have not been paid. In fact, these folks have been paying it forward. They are folks in my time as a blacksmith who have helped me to learn, without once asking for anything in return.

The [Florida Artists Blacksmith Association](#) gets a good deal of credit in this regard. They are an organization entirely dedicated to the spread of the knowledge of the Ancient Art of Blacksmithing, and run completely by volunteers.

It's through FABA that I have come to know these most generous spirits willing to share their knowledge, just for the joy of it. I can't tell you how many times I've thanked someone for showing me a new technique only for them to say something like: "Well, it was showed to me by Old Schwartz Smith, so it's really his technique. He taught me a few things, so I'm just passing it along"

It is amazing.

Where I expected a group of Old Crusty Curmudgeons hoarding their knowledge for fear of it getting out and breed-



Photo by Charlotte Kesl



The Iron Studio at Penland

ing too much competition, I instead found a group of Old Crusty Curmudgeons perfectly willing to pass what knowledge they have, on to those with the hunger and will to use it.

Let's start with [Dr. Steve Bloom](#). I thought I was going to be on "Forged in Fire." I had never made Pattern Welded Steel before. I had recently joined FABA and had heard of Steve from some other members. I emailed him cold, asking if I could come by his shop and just watch him forge. He said I'd be welcome to come by. What I got from Dr. Bloom was an intense crash course on the particulars of heat treating, and an amazing demonstration of how to forge multiple layers of Steel into a single billet. I will never forget, and always appreciate the generosity of Dr. Steve Bloom.

[Kirk Sullens](#) worked for Bass Pro Shops, as a blacksmith, for I don't know how many years. One of the very few mainstream large companies to still employ a blacksmith on it's payroll at least at that time.. One day Kirk sends me a message that he would like my help on a project. So I show up at Kirk's house and he has some real wrought iron and needs to make a portion of a gate for a tribute to Phillip Simmons. He had heard that I had apprenticed under Yaw, who himself was an apprentice to Simmons. If you need to know who Phillip Simmons was these folks can tell his story better than I : <http://www.philipsimmons.us/aboutsimmons.html>

Kirk didn't really need help. He's been blacksmithing longer than I've been an adult! But he showed me things about working wrought iron I never new. I think we may have learned a few things together.

Member Report



The full gate. Kirk and I worked on the Palm Tree center top.

Chuck Fowler has loaned me the use of one of his awesome Monster Forges, for the Hoggetowne Medieval Faire.

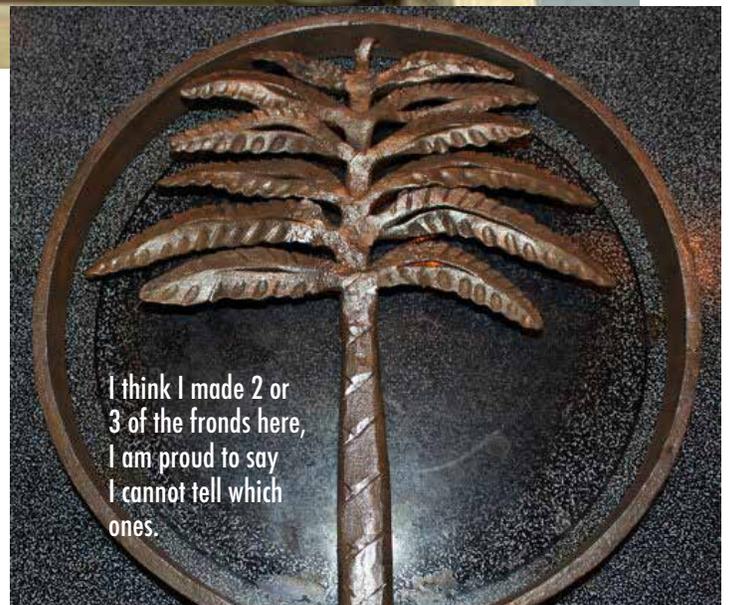
Peter Hill and [Ben Thompson](#) supported me just recently in going to a Tire Hammer Workshop in Louisiana.

All these folks I met through FABA. These, and many other smiths that my faulty brain has forgotten to mention, have helped to play a role in teaching me new skills and growing as a blacksmith.

To say I am grateful, and humbled would be to say that the ocean is a bit damp.

I did not get here alone, and I am proud to say it.

Jordan does regular livestreams of blacksmithing on [Facebook](#) on Thursdays and Saturdays 5-7 p.m.



THE FLORIDA CLINKER BREAKER

Florida Artist Blacksmith Association

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JUNE 2020

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FABA Membership Application: Membership begins when your application and \$30 membership fee is received. Membership is per family and lasts one year. Use your credit card to join or renew your FABA Membership via Paypal by going to blacksmithing.org/membership/join and clicking through the Paypal button. You do not need to have a Paypal account to use this feature. OR send the below application and your check to "FABA" for \$30 to:

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