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October 2003

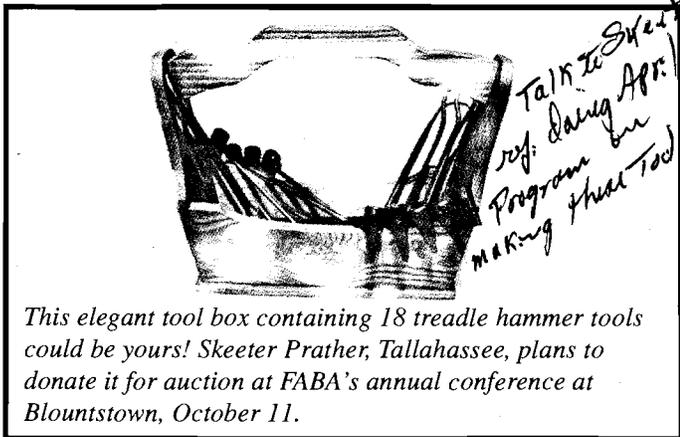
The Florida Clinker Breaker

President's Corner with Bob Jacoby

Blountstown awaits us!

Conference registrations are pouring in and members from FABA's Northwest Region report that everything is in order for the best FABA Annual Statewide Conference ever!

Please redouble your personal (and regional) efforts to make items for the Saturday night auction – the auction venue is large and air conditioned!



This elegant tool box containing 18 treadle hammer tools could be yours! Skeeter Prather, Tallahassee, plans to donate it for auction at FABA's annual conference at Blountstown, October 11.

Remember, the most up-to-date FABA information can always be had at our website: www.blacksmithing.org.

Elsewhere in the state, the Pioneer Settlement for the Creative Arts (i.e. Barberville) is hosting its Harvest Celebration on Saturday October 4th which coincides with our regularly scheduled October NE Regional Meeting.

This event will feature booths selling everything from baked goods to Christmas items and there will be olde-

tyme gospel singing, activities for children and (most importantly) blacksmithing!

Barberville is also hosting its annual Fall Country Jamboree on Saturday and Sunday November 1st and 2nd. This event similarly coincides with the November NE Regional Meeting and will feature exhibits, musicians artists and (more) blacksmithing! Please call Barberville directly with any questions: (386) 749-2959.

Nationally, the National Ornamental Metal Museum, located in Memphis, TN, will host its annual Repair Days Weekend on October 17th – 19th (see www.blacksmith.org for details).

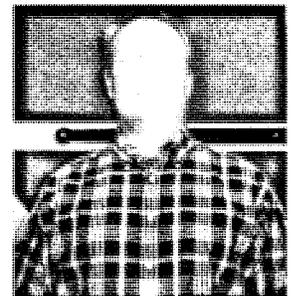
Also, the National Ornamental Metal Museum will be the site of the Artist Blacksmith Association of North America's (www.abana.org) annual board meeting on November 13th - 15th. The meeting is open to all ABANA members.

The final item on the national front: mark your calendars for the 2004 ABANA conference which will be held July 7 – 11 at Eastern Kentucky University, in Richmond.

Back in Florida, I'm happy to report that the Barberville gate has been completed! Many thanks to all those involved in this project. I'd like to especially recognize Joel Clark for his leadership in reinvigorating this project.

We will formally recognize all those involved (over the last 5 – 10? years) at the official dedication currently scheduled for July 2004.

See you in Blountstown!



Florida Artist Blacksmith Association

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SMITHING CAN BE DANGEROUS. Protect your eyes, your hearing, your body, your life and your property. Protect others around you. When in doubt, ask. *You* are responsible for working safely.

Submissions to *The Florida Clinker Breaker*: Articles of interest to blacksmiths are welcome. Your FABA friends want to read about you! We appreciate your contributions to future newsletters. Although we cannot promise to use every submission, this is 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! Photos: high-contrast black-and-white or color prints or digital picture files are acceptable. Text submissions: please send legible handwritten, typewritten, MS Word or Dos text formats.

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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. **At any time, please see the FABA WEBSITE at www.blacksmithing.org for up-to-date information, maps and meeting listings!**

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:

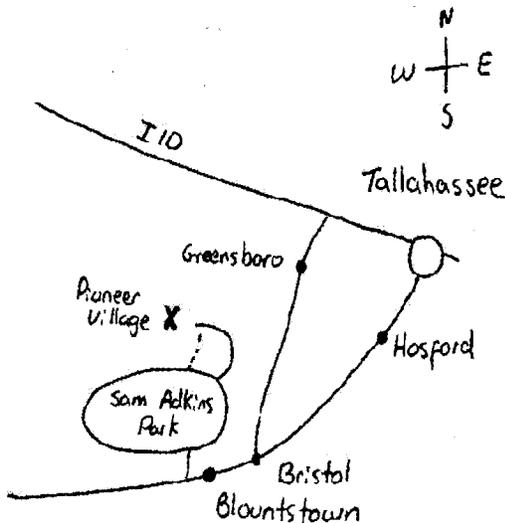
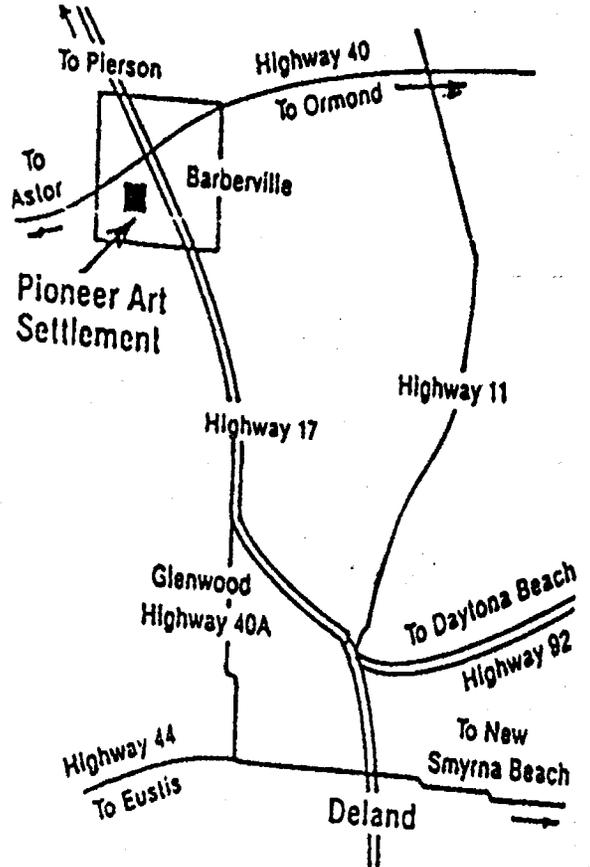
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|--------------------------|---------------------|--------------|----------------------|
| Northeast Region: | Kent & Melanie Owen | 352-307-2033 | Oak1954@aol.com |
| Northwest Region: | Billy Christie | 850-421-1386 | chriswood@talweb.com |
| | Ed 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- |

October 2003

- | | | |
|----|-------------|---|
| NE | Oct 04 | Pioneer Art Settlement - Barberville |
| NE | Oct 10 - 12 | Statewide Conference , Panhandle Pioneer Settlement
Blountstown, FL |
| SE | Oct 18 | to be announced |
| SW | Oct 25 | to be announced |

Extended Forecast

- | | | |
|----|---------|--|
| NE | Nov 1-2 | Jamboree - Barberville |
| NW | Nov 8 | Skeeter and Lou Prather's 2816 Terry Rd. Tallahassee |
| SE | Nov 15 | Charlie Stemmons |
| NE | Dec 06 | Christmas Gathering- Allen and Chloe Hardwick's ho |
| NW | Dec 13 | Jerry & Tycee Grice's Crawfordville |
| SE | Dec 20 | Yesteryear Village- Christmas Party |
| NE | Jan 03 | Barberville |
| SW | Jan 24 | Quarterly Meeting - Eric Fletts' Shop |
| NE | Feb 07 | Juan Holbrook - Gainesville |
| NW | Feb 14 | Ben Ferguson's - Freeport |



FABA Conference 2003



2003 FABA CONFERENCE

October 10-12, 2003 • Blouinstown, Florida

Panhandle Pioneer Settlement

Most demonstrations will begin on Saturday morning October 11 they will continue again that afternoon and then finish up on Sunday morning. Don Hanson III will begin his demonstration on Friday afternoon resuming on Saturday morning and will finish that afternoon.

DEMONSTRATORS:

Steve Bloom – Don Hanson III – Allan Kress

David Ponsler - Robert Johnson - Scott Thompson

Hope you have registered - Classes are filling up!

Classes start on Friday October 10. These classes fill quickly and are first come first served.

Please note that lunch and dinner are NOT provided on the grounds on Friday. Meals will available at the site Saturday and Sunday. There are several restaurants near the Settlement.

DON'T FORGET THE PEOPLES CHOICE AWARD!

This is our own blacksmith Show & Tell.

This exhibit will be in the Dr. Dowling House. Cards will be provided to vote for your favorite piece.

Beginners and experts alike are encouraged to bring in their latest handiwork. The Peoples Choice will be announced at the Auction and the winner will receive a \$75.00 check.

SCHOLARSHIP DRAWING

Fill out the entry form provided in previous Clinker Breakers. You do not have to be present to win but you must be a FABA member. The lucky individual that receives this award will be drawn at the Auction. Any questions about this should be directed to Skeeter Prather (850)386-9246

AUCTION AUCTION AUCTION

This is our major fundraising event. Dr. Tim Ryan will conduct the auction on Saturday night at 7:00 pm.

Please bring something to donate. Blacksmithing tools are sought after, as are pieces of your own work.

This popular event always turns up interesting and beautiful handcrafted items.

ANVIL SHOOT

This tradition is still alive and well in Florida! Our friend and fellow blacksmith, Dr. Tim Ryan will conduct this old blacksmith celebration. He will shoot the anvil on Saturday at 1:45pm. Do not miss this opportunity!

IRON IN THE HAT

Mary Ellen Anderson will have tickets for this fun event. All donations are greatly appreciated and there always surprises in this fundraiser. Tickets are \$1.00 each or 6 for \$5.00 (a bargain).

TAILGATE, TOOLS AND COMMERCIAL SALES

This tool swap and tailgate sales will run through out the conference.

A special area is designated inside the compound. Please check in with Jim Carty for placement and/or assistance.

Registration forms and other FABA info is available on line at www.blacksmithing.org

See you at the Conference!!!!

"Other News and Goings On"

News From The Northeast

From the Hearth: On September 6, 2003 blacksmiths and their families met at the beautiful home and shop of Mike and Melinda Sluss which is located just west of Deland. The ladies gathered in Melinda's kitchen to watch her demonstration of breadmaking, Melinda uses whole grains and grinds the flour as she prepares the bread. This is to ensure that nutrients are not lost as they would be if stored on the shelf.

The kitchen equipment she uses in breadmaking is to "drool over." She explained that a good comparison of her machines would be to think of the tools enjoyed by men: Melinda's grinder of whole grains to Mike's weed whacker. The mixer for the bread to a riding lawn mower!

A reuben sandwich loaf, a pizza loaf, cinnamon loaf and rolls were prepared, baked and thoroughly enjoyed by the group during the covered dish lunch. Also we learned the wonderful, healthy benefits of using whole grains in cooking to ensure delicious, nutritious food for our families. Now, if I can just figure out where to put that weed whacker and riding lawn mower in my small kitchen I will be ready to make those pizza loaves.

We missed you Melinda and look forward to seeing you in October. - Sadie Chaffin

From the Forge: Despite a threat of a drenching rain from tropical storm, Henri, there was a good turnout of smiths, spouses and children at Mike and Melinda Sluss' home for the September meeting of the Northeast Area. Thirty nine people signed in on what turned out to be a beautiful day.

Ken Knight had his foundry forge fired up melting some scrap brass and was remming up some molds from Chaffin's anvil shaped belt buckle patterns. Some guests present got in on the mold making and received a sample of the casting. I even got to bring one home.

Bill Roberts brought a large sampling of work he is doing with nonferrous metals, worked cold under the hammer. He followed a short lecture with a demonstration of his technique and produced several free form art pieces.

Mike and several others were at the coal forge demonstrating to and mentoring several young blacksmiths. I saw horse shoes and crosses being worked on. It is especially heartwarming to see all the attention young people get at our Northeast meetings.

Norman Ceasar was there again with more of his antler carvings, which got a lot of attention from everyone. He was seen cold working some aluminum with a hand hammer and was ramming some casting molds. Maybe we can get him working on some hot iron soon.

The November meeting will be in conjunction with the Jamboree at Barberville. Hope everyone can come to that. See you there. - Thurmond Chaffin

Need Smiths for Pioneer Days at Silver River Museum!!!

Guy Marwick at the Silver River Museum needs blacksmiths for the days of the 4th through 9th of November for their Pioneer days. His Work phone is 352 236 5401 and his home phone is 352 625 2692. How about it folks? Can someone help out any or all days? Blacksmiths will be paid for the days they work. There is a forge and vise there but no anvil. Jim Corbet did this duty for years but has had to give it up. The museum is located near Silver Springs attraction which is near Ocala, Fl.

Melanie is "under the weather". We hope to see her at the Pioneer Settlement at the October meeting. Also on October 4 the Settlement is hosting a "Harvest Celebration". A free admission day for the family. Gospel sing, bazaar and baked goods, children's' activities. Area churches will have booths selling everything from baked goods to Christmas items. Picnic style food will be sold by the Settlement. Hope to see you then.

"Other News and Goings On"

News From The Northwest

The Northwest Region of FABA met on Saturday, September 13, 2003 at The Tallahassee Museum of History & Natural Science. We had 33 people sign in and because there was no admission charge on this particular Saturday we had numerous people stopping by to check out the demonstrations. The weather was picture perfect! Lows in the 60's and highs in the 80's.

Mike "Murf" Murphy gave a great demo on "how to give a demonstration". This was comprised of tips and basic rules and how to appropriately give your demonstration depending on the type and age group of your audience. Murf did all of this while making new wedges for his post vice. Next he made a fancy bottle opener.

Murf also fired up his latest atmospheric propane forge with the new improved dual burners. Nice and quiet. Murf's helpful tips and demonstration was informative, entertaining, and educational (even with the hecklers in the crowd). Juan Holbrook handled the bellows during Murf's demonstration.

Yours truly sold the tickets for the "Iron In The Hat" items, which brought in \$65.00. Linda Holbrook drew the winning numbers. Thanks Linda.

After lunch, Skeeter Prather gave a demonstration on how to make a fancy swan. Looked great, in spite of the fact that Murf assisted him. After making the swan, Skeeter showed everyone how to make a simple leaf candleholder. Great job!

Don't forget we have our annual October conference the 10th through the 12th at the Panhandle Pioneer Settlement in Blountstown, Florida. We need everyone to come out and support our blacksmith club - learn and have fun. What better way to witness and discover blacksmithing techniques from so many artists in one place?

See you there!

Billy Christie, NW Regional Coordinator

First Quarterly Meeting of 2004

The first quarterly meeting will be held January 24th in the South West Region at Erik Fletts' Shop located in Fort Myers, The board will meet at this time so plan to attend. There will also be tailgate/tool sales and Iron in the Hat.

Mike Murphy will be conducting a gas forge building class. The cost of materials is \$180 that needs to be mailed to Mike ahead of time. The class is first come first served. He cannot hold a space for you without a check. Mike is a great demonstrator and teacher. You will go home with a gas forge. If you don't get in the class, Mike won't mind you hanging around to watch. The class size is limited to 9 students. If you have questions you may e-mail Mike at blacksmith@comcast.net

Mail \$180.00 check payable to: Mike Murphy
8537 Moore Woods Road
Tallahassee, FL 32310

Considers joining.

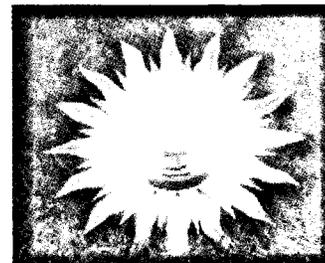
FABA SE Meeting in Miami, Florida



The August 16th SE meeting was hosted by Art Ballard and Phil Heermance at Art's Work Unlimited in Miami. Of course it took twice as long as I thought to get there. It was a pleasure to wind your way through trees for a beautiful back woods area. Who would have thought you could have a secluded work area with a Miami address? By the time I arrived there were already 40 or 50 people there. I couldn't pass up the talk about the tools and methods by Phil Heermance.

When I finally tore myself away from Phil's discussion, I found a table laden with everything from bagels to a fruit platter and a large pot of coffee. What a thing to do to an overweight smith who is trying to drop a few pounds! With my plate loaded and the first of several cups of coffee, I wondered back to where Phil was demonstrating his repousse techniques; making a "sun face" on a 1/8" thick aluminum sheet, which he later gold leafed.

The shop is the size of a small aircraft hanger. There were power hammers with shelves of dies, treadle hammers and more bending jigs than I have ever seen in one place. One forge was large enough to cremate a whole cow. The worktables each had shelves underneath with color-coded tools so they would be in the correct place when needed. As we moved to the back of the shop, Art took over the tour and showed us the band saws, a huge grinder and lots of polishing equipment. There were shears and welding equipment enough that I'm sure that I wasn't the only one to suffer "shop envy."

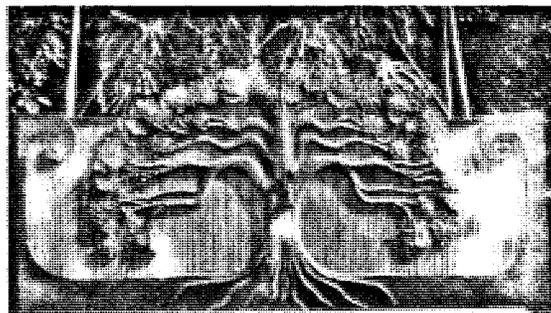


They had been thoughtful enough to provide chairs and tables for lunch. And what a lunch! There was chicken and ribs, huge bowls of salad and coleslaw (enough for an army) and lots for seconds. Art's daughter made the best lemonade I have ever had the pleasure of tasting.

Anyone that was still moving after such a lunch gathered around Art and Paul Saja to learn a lot of his finishing secrets. He showed us his methods of producing a patina, layering colors, and dry brushing of silver and gold. He didn't swear us to secrecy so I know everyone came away from his demonstrations with ideas of how to adapt to their own work.

Art demonstrated copper repousse of a "snapper", using hand tools and the treadle hammer, then torch welding both halves with the help of expert welder, Michael Barry.

If you would like to see some of the beautiful work done in this great shop, visit www.artsworkunlimited.com. There you will see some of the fabulous work done by Art, Phil and their staff.



I want to say a special thanks to their Office Manager, Alyse Avins, for all her efforts in getting out the word for this outstanding meeting.

Lynn Emrich SE Coordinator

“Notices From Around”

The New England School of Metal Work has announced it's Winter Workshops:

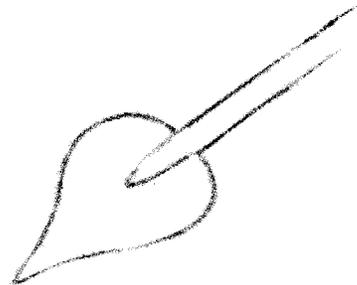
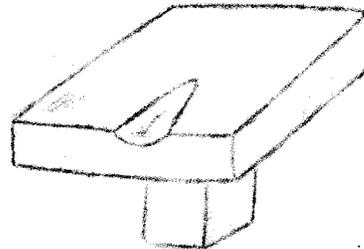
Winter Workshops for 2003 - 2004:

December 12-15	Principles of Traditional Joinery
January 9-12	Beginners Blacksmithing
January 23-25	To Sink or Raise; Vessels
February 6 - 9	Botanical Forms
February 27 - 29	Basic Repousse'
March 12 - 15	Tool Forging for the Smith
April 9 - 12	Basic Architectural Ironwork

See the website for class details www.newenglandschoolofmetalwork.com, or call to register at 1-888-753-7502. Please direct inquiries to dglaser@newenglandschoolofmetalwork.com

TIPS FROM APPLECROSS FORGE

Have you ever gone to all the trouble to upset and make a large leaf on the end of a drawn down piece of stock only to have the leaf break off just when you were about finished? The piece breaks at a weak spot where the large and small areas meet. You can reinforce this area by creating a tongue there on the backside of your piece early on. This gives you extra stock where you need it. *—Bill Robertson*



*******ADVANCE NOTICE*******

HUGE AUCTION !!!

Great Primitives & Hand-forged Tools
"A Fabulous Lifetime Collection"

OCTOBER 10 & 11
(Preview: Thursday, October 9)
9 AM Each Day

Ray Co. Veterans Bldg. * 312 Clark St. * Richmond, MO
(Richmond is located about 45 min. E. of KC, MO, on the Jct. of Hwy 13 & 210 & 10 - About 30 mi. N. of 1-70 at Higginsville)
Artisan & Craftsman Tools for Early American Trades

* Blacksmith * Farrier * Ship Builder * Wagon Maker
* Wheelwright * Stonemason * Cobbler * Saddler * Mining
* Ice Harvesting * Logging * Farming * Trapping * Carpentry
* Log Cabin Building * Leatherworking * Woodworking * Many Other Trades

Such **HAND-FORGED** tools as: All types of Hammers (hundreds, wide range), stone hammers, sno-knocker hammers, travelers, calipers, files, rasps, axes, hatchets, grinders, fireplace tools, drawshaves & other shaves, froes, adzes, bowl adz, scissors & snips, saws (rare rainbow ice saw), mauls & mallets, bear traps, anvils & sm. forges, tongs, smithing accessories, lg. trip hammers, shovels & scoops, wrenches (all styles, plus implement wrenches & lg. lot of named wrenches), clamps, barn drills, etc. & snow shoes, primitive sleds, yokes, wagon seats, leather vises, RR & barn lanterns, conestoga wagon & buggy jacks, bellows, 1908 gas pump, wheel barrows, blacksmith prints & related memorabilia, miniature anvils, tin advertising signs, and Much More!!!! Hundreds of all types of specialty tools for all kinds of trades, crafts & occupations.

Ken & Sandy Wilson, Owners
(1st of at least 2 auctions from their Blacksmith Shop & Museum, next will be in the Spring
Watch our Website for Current Auction Schedule & Upcoming Auctions)

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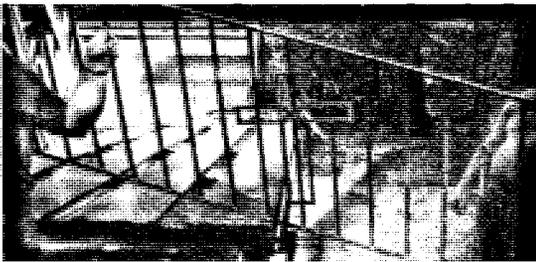
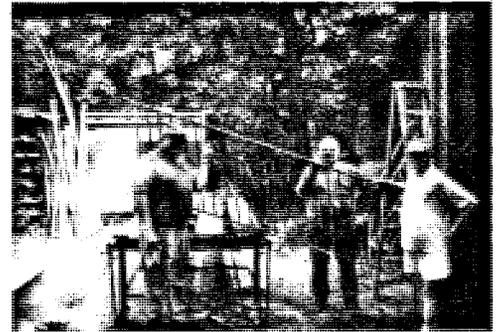
PLEASE WRITE OR CALL FOR CATALOG

(This will have around 900 of the 1200 lots listed. We will have an itemized list of the rest for auction day.)
Check out our WEBSITE for Listings, Photographs, More Listings, Directions, Terms & Conditions & other auction info.
New Super & Model 1-816-79-8038. 10% discount on our auction attendees. Also camping at the fairgrounds. 519 a night. Hotspots, showers, restrooms.

Memorial Project - Dr. Richard Baker

We have been working on a special project in memory of a dear departed friend, Dr. Richard Baker. This request was made to FABAA by Fraser Baker, loving wife of Richard. Richard, as many of our group, belonged to many blacksmith affiliations in the South East and he gave relentlessly to us all.

The rails pictured are for the ST James Church of Quitman, Georgia with whom Richard was associated. John Butler, Jerry Grice, Ray Roberts and Bill Adams have dedicated their sweat equity and remembrance to their friend Dr. Richard Baker. Many of our members



were interested in working on this special project but the logistics and time constraints could not allow everyone to participate.

We still miss the loss of our friend and fellow blacksmith, Richard Baker.

Thanks, Dot Butler

“Read up - Learn More”

Lee H. Stanley of Canada has put together a book in which he has assembled hundreds of tips, ideas, and handy bits of information. He calls it *Just An Idea* and you can have a copy for \$30 U.S. which includes shipping. To get a copy send a check payable to L.H. Stanley at 28 Farr Ave., Sharon, ON L0G 1V0 Canada

Perhaps one of the more interesting names to appear on old anvils is the name *Mousehole*. Is it a kind of anvil or a make of anvil? Perhaps a little of both, but you can learn a lot of the history of the *Mousehole Forge* from **Richard Postman's** latest work specifically about this English firm which made many kinds of thing besides anvils. The book is a delight with many color pictures and fine drawings to get you oriented and Richard's interesting writing. Well worth the only \$25 post-paid. Postma Publishing, 320 Fisher Ct., Barrien Springs, MI 49103 Incidentally, *Anvils in America* is temporarily out of print.

One of the projects which will benefit all of us for many years, especially people new to blacksmithing, is a program called *Controlled Hand Forging*. **Dan Nauman** of Kewaskum, Wisconsin is leading the development of this program. He is an excellent traditional blacksmith and he has gathered some other excellent blacksmiths to help in the development of commentary, drawings, and eventually video tapes to illustrate the steps which it is necessary to learn in order to become proficient in shaping hot metal. Some early parts of this effort are being carried in *The Hammer's Blow* publication of ABANA.

Dan has a very good track record. He arranged the production of a video tape on the work of **Cyril Colnick**, master artistic blacksmith of Milwaukee, who worked in the early to mid last century. Some of **Colnick's** work can be seen today in the Villa Terrace Museum in Milwaukee and in and on a number of fine homes in the area. **Dan** serves on the ABANA board where he is currently up for re-election.

(courtesy of the Indiana Forge Fire, August 2003)

A Machinist "FAQ" of Sorts

By Tom Carboni

This is a listing of the more frequently asked questions I hear when working at Barberville. This is directed at the person who does machine work out of his or her barn or garage. Therefore, the focus is on the needs of the home shop, not the commercial shop.

I am not a professional machinist, nor do I claim to be an expert by any means. I give an opinion as a user. These are solely my opinions. Contents are flammable. Your mileage may vary.

Are imported lathes and/or mills capable of good work?

Yes, the capability is there. I want to temper this with the following observations. The quality of finished work is determined mostly by the operator's skill. It is entirely possible to buy top-grade equipment and still do lousy work. It is also possible to take a badly worn machine and do good work on it as well. To do good work, we need to start with good tools and develop certain skills and abilities. These machines are good enough to enable us to do good work. If you do your job, the machine will do its job.

What's the difference between a new Asian import and a used domestic machine?

I had some trouble answering this because it's not a direct comparison. I think the correct answer comes down to the type of gamble you like to take and we'll discuss both types. Upon acquiring a new or used machine, there's some prep work to do. Expect to do some disassembly, cleaning and inspection of moving parts. There will be some adjusting of feedscrew backlash and gib strips. You may have to replace worn or damaged fasteners. You may also need to make up a sturdy bench to set the machine on. Expect this with any machine tool.

For imports, fit and finish tend to vary. Paint and casting sand may be found where it shouldn't be. Critical parts like the cross-slide, compound and tailstock may need deburring and fitting out of the crate. Quality of electrics is variable, i.e. some new machine owners have had to replace wiring, switches and motors in the first year or two of ownership. Pulleys may need truing and aligning and belts may need replacing. There are some cases of metric feedscrews with inch micrometer collars and vice versa. Imports are generally not perfect out of the crate and take some work in these areas. Think of it as a kit that's about 80% complete. There again, I've bought a couple of imported machines that were excellent right out of the crate and a few folks have related similar experiences as well. That's the chance you take.

Most of the issues with domestic machines seem to center around routine wear and tear. There's usually a consistently good level of fit and finish. Generally, for a complete used machine in good condition, the issues that affect imports don't apply. In many cases, prior owners of used equipment have taken the time to sort out their machines; if the previous owner was knowledgeable, this works in your favor. The condition of used equipment depends to a great extent on how it was treated by the previous owner and therein lies the gamble.

My personal preference is for used domestic machines, mostly because I work in US thread standards and measurements. Eliminating different measuring standards means one less thing to think about. However, so long as a machine has features I need and does its job well, I don't much care who made it. The idea is to get useful work done, regardless of where the equipment is made.

How much does machine wear affect the quality of finished work?

Honestly, I think the impact of wear is often overstated. Every used machine exhibits some wear. Your job as a machinist is to locate the wear, determine the effects on the finished work and how to compensate. Time spent testing and measuring existing wear is very well spent.

Consider this: what makes new machine tools? Used machine tools! Yesterday's technology is making today's tools.

A Machinist "FAQ" of Sorts

For a lathe, I'd consider a reasonable degree of wear to be .005" in six inches. If you're making pistons for a gasoline engine, is a taper of .0025" in three inches a problem? Possibly. If those shiny brass candlesticks for wifey differ in diameter by .035", it won't matter. Keep acceptable tolerances in perspective. Learn to judge acceptable wear and how to work with it. This is one of the hallmarks of good craftsmanship, much like the smith who turns out good work on a less-than-perfect anvil.

Can you use carbide tooling?

Yes, under certain conditions. Carbide needs to be run at three to six times the surface speed of high-speed steel to work well. This means high spindle speeds are necessary, and machining at those speeds takes more horsepower than normal. It also takes more rigidity because carbide cuts by pressure, whereas high-speed steel cuts by angle. Some machines don't have sufficient speed or rigidity to run carbides well. A lot of home shop equipment is geared for HSS and there are several varieties of it that work very nicely. I'd consider tungsten carbide a supplement to HSS, not a replacement.

I've heard a lot of questions about cutting tools in general and it seems to be a topic of curiosity. If there's enough interest, we can do a more detailed writeup of cutting tools and their applications.

What's the difference between a mill and a mill/drill?

Conventional mills have three axes of table movement: X (left and right), Y (fore and aft) and Z (up and down). Z-axis movement is achieved through use of a moveable knee on a dovetailed slide. The knee is a very substantial casting and usually very rigid in operation. Mill/drills have no knee and move the milling head for the Z-axis. Most mill/drills also have a round column, which allows the head to swing horizontally as it's raised and lowered. This often means having to shut down the motor and reset the head's position with depth changes. For some operations, like machining a slot or a recessed dovetail, this can cost time. This limitation aside, mill/drills are good values for the money and useful. Any mill is better than none at all. In order of greatest preference first, this is how I see the choices for milling equipment:

- 1) Knee mill.
- 2) Mill/drill.
- 3) Lathe with milling attachment.
- 4) 3-in-1.

How about a 3-in-1? Are these good machines?

Although it wouldn't be my first choice, a 3-in-1 certainly can turn out good work. It's a better lathe than mill because the milling head is a design compromise. For the machine to perform both functions, the milling head has to move. That's a weakness because it needs to be as rigid as possible and milling is more stressful than turning. Milling operations on these machines will be difficult and tough materials may be unusable due to lack of rigidity. They are good large-swing, short-bed lathes and are usually good values for the money. I still lean towards dedicated machines if the situation allows.

Where situations will not allow for ideals, these are viable. Know that the limits are tighter than for conventional equipment and the learning curve is tougher than average. The work gets done, but not quickly or easily.

A Machinist "FAQ" of Sorts

Can I mill with a drill press?

I don't recommend it. This is like plunging a toilet with a land mine. It won't work well and it's hard on the toilet. Somebody got away with it somewhere, but not for long. It will work with light cuts on wood and plastics and maybe aluminum if you're lucky. Otherwise, I think it will lead to trouble and here's why.

Milling forces are exerted in a direction that drill presses are not designed to handle. They are generally several times greater than drilling loads due to end and side cuts happening simultaneously. A milling machine is designed to take heavy end loads AND side loads on its spindle. A drill press is designed for moderate end loads only. Milling forces on a drill press bend the chuck and spindle such that it runs less true with each pass. That means you can forget drilling accurately after the fact.

A drill press uses one type of spindle and bearings. Mills use a different type of spindle which is supported by different bearings. Those bearings are in turn supported by different castings. The net result is a different machine. Milling is a stressful activity, more so than turning or drilling, and it's best confined to the right equipment. By that, I mean a milling machine or a lathe with a milling attachment.

Are machines like shapers and planers useful in the home shop?

Most definitely. These machines aren't as common as lathes or mills, so I'll describe them. A shaper takes a single-point tool bit, like a lathe tool, clamps it vertically onto the end of a horizontal ram and strokes it across the work. It cuts on the forward stroke only, not on the return stroke. Shapers are sized by stroke length i.e. a seven-inch shaper has a maximum stroke length of seven inches.

With a planer, the work is anchored to a moveable bed that carries the work under a stationary single-point cutting tool. This tool is clamped to the planer's frame in a cutting head that can be adjusted for down-feeds and cross-feeds. These machines are sized by bed length and width. These machines can grow to huge proportions because they do big work cheaply and easily. Planers for the home shop are in demand and probably seldom offered for sale. If you're offered a shaper or planer, by all means, go after it. They are a great value in the home shop.

Is recycling chips worthwhile?

If you do a lot of work in brass, bronze or aluminum (or some expensive material), it may be worthwhile. Access to a foundry is necessary so the chips can be melted down and recast. Should you do a couple of runs of parts in these materials, it may be worth considering. This is a good way of satisfying one's frugal tendencies.

What about imported or Chinese measuring instruments?

I don't own any Asian brands of measuring instrument, so I can't speak from experience with them in particular. I prefer to be conservative in this area. Judge them carefully and be sure there are no defects at the time of purchase. Look for engraved rather than printed graduations. Verify that the jaws close tightly and are parallel to a blackout fit i.e. no light leaks between them. Also verify that they will hold a consistent zero reading. Check for smooth operation of dial indicators, thimbles, racks and pinions. Hitches in smoothness of operation impede one's sense of touch, which is critical to making accurate measurements. There should be no "break-in" per se of moving parts in a measuring instrument. If the products can meet these criteria, they should give good service.

My suggestion is to buy the best measuring instruments you can afford, treat them carefully and check them regularly against measuring standards or gage blocks. I've always considered good measuring instruments a very worthwhile investment. I really feel it's best to not skimp here if you expect to consistently do good work. If you can't accurately measure your output, you don't know what you're producing.

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“Broom Making 101”

Broom Tying:

1. Chop off stalks of the broomcorn about 3/4-inch above where the tassel meets the stalk
2. Soak cut end of broomcorn in hot water (Hottest possible) for approximately 15 minutes. Shake off excess water.
3. Bring String from bottom of spinner too the top of the broom. Tie knot in hole. Keep string from spinner tight. (Hint - to keep tight, push out with feet and don't let out too much string at a time.)
4. Fill in one piece of broomcorn at a time going all the way around the handle. Pull the string tight.
5. Be sure that as you wrap the string it dose not overlap and is constantly working up towards the top.
6. Begin building sides by placing three stalks on both sides. Pull tight.
7. Then 2 stalks on both sides. Pull tight. Then 2 stalks on the other side. Pull tight.
8. Then one stalk on both sides. Pull tight.
9. Using sharp knife, trim up at 45° angle towards handle.
10. Move string up on shoulder touching handle
11. Splitting each stalk of the broomcorn in half. Go all the way around the broom.
12. Wrap string around three times. Pull tight.
13. Trim directly above string.
14. Putting stalks up about 4 to 5 inches go all the way around filling in.
15. Wrap string around 3 times going back to beginning spot.
16. Weave every other stalk over - under - over (If you get back to beginning and it isn't coming out even. then split a stalk in half) Weave up 3 to 4 inches.
17. Take a 14 inch peace of nylon string folded in half. Place the loop under broom string. Wrap tight four to five times.
18. Lock thumb to hold tight. Cut string coming from spinner. Slip string thru loop. Yank two loose ends to pull cut end back under string of the broom.
19. Trim top. Cut string.

Stitching

1. Put spreaders on firmly about 8 inches down from bottom of weave.
2. Get 3 tugs of cotton string and double it.
3. Place loop under broom. Wrap string around 1 time. Put string thru loop. Put string in needle.
4. Stitch broom going over top - thru broom - over top working towards other end. Take large stitches.
5. After completing one row stick needle halfway thru broom. Pull tight. Cut off in middle. Use hatchet to chop ends of broom even.

Source for broomcorn.:

R. E. Caddy and Company, Inc.
P. O. Box 14634
Greensboro, N. C. 27415

Phone 336-273-3609
Fax 336-378-6047

E-mail recaddy@aol.com
<http://www.recaddy.com/>

FABA WEBSITE

Get up-to-date information on upcoming Regional meets, Quarterly events and other “goings-on” at the FABA Website: www.blacksmithing.org!

You can also download .pdf versions of The Florida Clinker Breaker and see more pictures of local smith's work. Contact Steve Bloom to get *YOUR* work posted!

Welcome New Members!

Tommy & Beth Clayton
48876 Crawford Lane
Hilliard, FL 32046
904-845-3816
southernbygrace@msn.com

John & Brenda Guenther
24400 Craft Road
Athcus, AL 35613-7220
256-230-2900 (H)
256-842-8397(W)
jguenther@mindspring.com

Notes From All Over

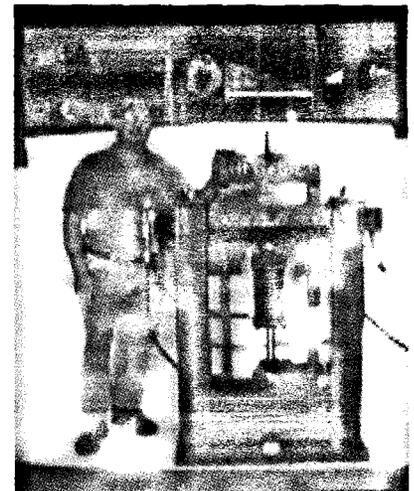
AFC Hydraulic press Raffle

IT'S FINISHED!!!

This press will be at the AFC Conference. AFC will Raffle a press like this at \$5.00 donation per ticket. Drawing will be in April at the Batson Blade Symposium. Proceeds go to AFC Building Fund for an additional demonstration facility at Tannehill. Built by Wiregrass Forge at the Firebird Forge Shop.

- Cliff Ohlerburger

For more information, or to obtain a raffle ticket, contact Cliff at firebirdforge@snowhill.com



ABS Knifemaking Video

Charles F. Ochs has a new digital knifemaking video. Charlie says, "this professionally done DVD shows the entire process, from forging the blade through the construction of the sheath. With a voice over audio track and background music, it's a nice educational video, far surpassing anything else on the market. Priced at \$40.00 plus \$5.00 s/h. Would like to advertise it to the FABA members, as many of them know me."

Charles Ochs is an ABS Master Bladesmith, Knifemakers Guild. His work can be seen at: www.oxforge.com. If you'd like to email him for more information, his email is: chuckandbelle@juno.com

NEW! Copper patina with a brush the same way you use a brass brush to get a brass patina, but at a lower temperature - approximately 250 degrees.

High quality, high fill, .0055" fine wire, shoe handle brushes, 4 by 15 rows.
Copper patina brush - \$13.00; Brass patina brush - \$12.00 Plus shipping.

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FABA CONFERENCE 2003

OCTOBER 10,11 & 12
PANHANDLE PIONEER SETTLEMENT
BLOUNTSTOWN, FLORIDA

SPECIAL EVENTS

Show & Tell General Membership Meeting Iron in the Hat
Peoples Choice Award Auction Anvil Shoot



FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, Inc.

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Phone: Home _____ Work: _____
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Spouse's Name: _____

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

October 2003

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

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