September 2007

Contributors

Ed Aarons
Steve Bloom
Billy Christie
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Bill Robertson
Mark Stone
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The Florida Clinker Breaker

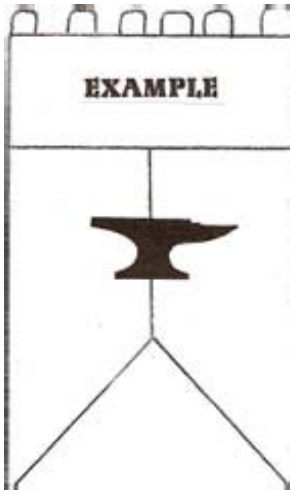
Florida Artist Blacksmith Association
Established May 18, 1985

President's Corner

Bill Robertson

September is here and you should be receiving your FABA Annual Conference registration packet in the mail about now. I know with the mention of "conference," most of you who have been to one before will never read these lines as you have already skipped down to the next paragraph to avoid reading blaa blaa conference, blaa, blaa. So these next few lines are for you new members who have yet to experience one of our conferences. It is the best thing we do and the only time you will get to meet with FABA members from throughout the State. Once a year we use this get together to showcase our art and learn new things about blacksmithing and buy sell and trade tools of the craft. It is also one of the few opportunities left in America to see a hundred pound anvil shot into the clouds. Short and sweet and in a nut shell, if you are interested in blacksmithing, this is where you will want to be October 12, 13 and 14.

FABA members, this will be your last reminder about the banner contest that was mentioned in the June issue of the Clinker Breaker. You can become a part of FABA history by creating the winning design for the banner to be displayed at FABA events. The winning design will be chosen by popular vote at the October conference. The design can be made to scale from the actual size which will be 22" wide by 36" long. It can have up to three colors and must have the words Florida Artist Blacksmith Association (or Assoc.) and an anvil on it. Any other art can be included as well. It will be a horizontal split tail design. Mail your design to Skeeter Prather, Banner Contest Coordinator, at 2816 Terry Rd, Tallahassee, FL 32312 or bring it to the Annual Conference on Friday October 12, 2007.



What makes FABA great? I think I can provide a partial answer to that. As you may remember, Juan Holbrook of Gainesville donated a 25# power hammer to FABA last year. Well, it had been sitting in his shop ever since. I did not want to saddle the next President with my leftover chores so I decided to get it moved over to the pioneer settlement in Blountstown where it is to be set up and will be available for FABA events when needed. All it took was a few calls and I had a crew ready, willing, and able to give up a Saturday morning, drive 50 to 100 miles out of their way to dig a hole for the platform into what was as close to concrete dirt as I have ever seen. (I could have saved myself a lot of sweat and sore muscles if I had remembered to write down the names of a few other people that had volunteered at the previous meeting to come out and help). Did I mention we were working in 100 degree heat? My thanks goes out to Keith Ivey, Billy Christie and Charles (Hippie) Pate for helping to dig and an extra thanks to Hippie who drove all the way from Tallahassee to Gainesville the day before and then to Blountstown to bring the hammer over. It is this kind of unselfish volunteerism towards a common goal that makes FABA the great organization that is.

Next month, a little FABA history that I think will surprise you.

Upcoming Events

The calendar includes events of interest to the blacksmithing community Florida Artist Blacksmith Association (FABA) sponsored events are highlighted in bold typeface. The regions have no boundaries - everyone is welcome everywhere. Come to more than one if you can. We hold regular monthly meetings in each region (except that we all try to get together at one Statewide Meeting each quarter) on the following Saturdays of each month: NE-1st, NW-2nd, SE-3rd, SW-last. The actual dates may vary from month to month; check the schedule below. Our meetings are informal gatherings around the forge. Prospective members are always welcome. Come for all or any part of a meeting, bring your tools, or just watch. Most meetings run from 9AM to 4PM, and you'll need to bring a lunch if you stay all day, unless otherwise noted. If you have any questions about meetings please contact the Regional Coordinators:

Northeast Region:	**Ken Knight**	**(352)-339-0629**	**Ironken@aol.com**
Northwest Region:	**Billy Christie**	**(850) 421-1386**	**chriswoodforge@earthlink.net**
Southeast Region:	**Ed Aaron**	**(561) 748-9824**	**EdandMickieAaron@aol.com**
Southwest Region:	**Jerry Wolfe**	**(941) 355-5615**	**wolfeforge@juno.com**

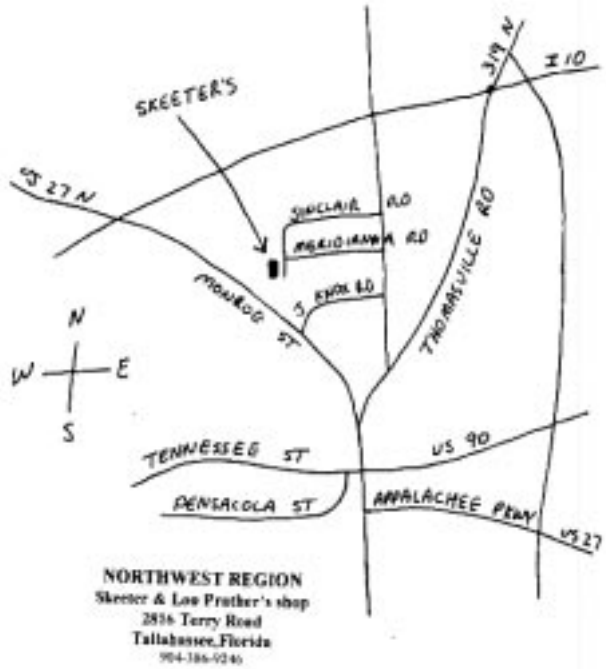
September 2007

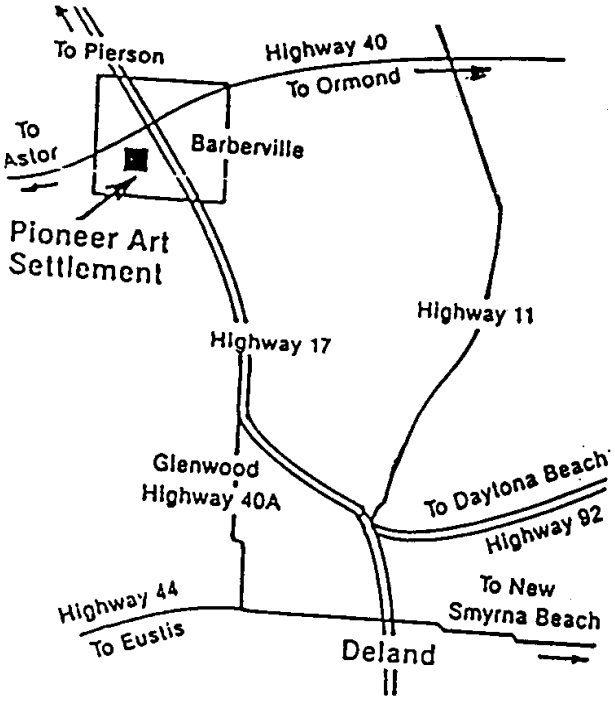
NE 01 Barberville - Open forges

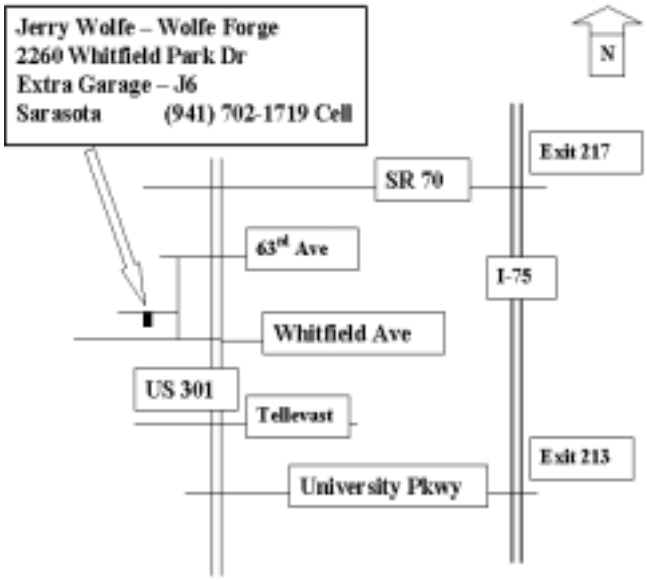
NW 08 Skeeter & Lou Prather's shop in Tallahassee, FL

SE 15 Boy Scout Camp: info from : 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.

SW 29 **5th Saturday** :Wolfe Forge - Francis (Trez) Cole - Demo on raising a bowl from steel. Under standing techniques of quality hammer work from the past in armor making, to the present in contemporary blacksmithing.







Future Events

SE		until further notice - Boy Scout camp
NW	Oct	Annual Conference in Barberville, FL

Candidates

The following have been drafted / hijacked / coerced / conscripted / forced / driven / condemned / enticed / threatened / wooed / beholded / begged / tricked / conned / beguiled / cooed / roped / conjured / haggled and then they consented - into serving in the following FABA Board positions for the years of 2008 & 2009:

President - Rex Anderson
Vice President - Mark Stone
Secretary - Jim Labolito
Program Chair - Tom Kennedy
- Ray Nager

Bio:
REX ANDERSON:
Rex is a building contractor and building inspector in the north Florida Area. He and wife Mary Ellen have just finished their new home and blacksmith shop near Monticello. Rex has been blacksmithing and welding for many years and loves to host meetings in his new shop.

MARK STONE:
Mark and wife Kimberly live in Tallahassee. Mark is the Network Administrator for Affiliated Computer Services and has been blacksmithing for seven years. Mark is always a tremendous help in setting up and working at blacksmithing hammer-ins.

JIM LABOLITO:
Jim and wife Nita pastor the Fernwood Baptist Church near Tallahassee. Jim is an avid blacksmith and teaches blacksmithing to a group of old and young at his home shop. He also teaches smithing at all the Northwest regional meetings.

TOM KENNEDY:
Tom lives in Montverde and works for Disney World. He has been a FABA member and been blacksmithing since 1994. Tom has been invaluable in helping with FABA past annual conferences.

RAY NAGER:
Ray and wife Pattie live in Lakeland. Ray has been a professional blacksmith, welder, and metal fabricator for some thirty years. Ray's specialty is metal sculpturing which he has exhibited in many arts and craft shows.

(Editor comment **:** While we joke about forcing folks to step forward, the truth is that all of us are dependent on the few who are able and willing to put their shoulder to the wheel. Without volunteers, FABA would vanish. My personal take on serving is that I have personally derived an immense amount of good from FABA - not just in information and the opportunity for training, but in making some really good friends. There is no way I can repay the folks who helped me (and are still helping!) except by "paying it forward" . Please think about that the next time the call goes out - have you benefited? can you help?).

Report from the Northwest

Mark Stone & Billy Christie

We held our meeting at the Panhandle Pioneer Settlement in Blountstown with 21 blacksmiths in attendance. We worked on a few different projects including fixing the lights in the shop. Charles "Hippie" Pate forged a couple of hot cuts and other tools for the auction.

On display, Hippie showed the chisels he made and items he also repousse' with the tools he made at the John C. Campbell Folk School with the scholarship he won. Nice work Hippie. Jim Labolito made two long "S" hooks for the settlement kitchen. Ron Childers also made a small sword out of a horseshoe nail and Brenton Jones worked on a campfire tripod for cooking.

Lunch was provided by the settlement with Linda Smith and helpers, again providing a delicious lunch and great desserts with a few others bringing covered dishes to add. "Iron In The Hat" brought in $53.00.

Our region decided on our project for the auction. We are making an approximately 2' diameter heart with an arrow through it and will place forged flowers from our regions members along the perimeter of the heart. So bring your forged flowers to the September 8th meeting at Skeeter Prather's to be attached. Jerry Wolfe of Sarasota will be the center-of-attention at Skeeter Prather's meeting. Jerry is the S.W. Region Program Coordinator and is becoming known far and wide for his skills at the anvil with red hot iron. Notably, Jerry is a graduate of Indiana Institute of Technology with a degree in Metallurgical Engineering; and spent essentially his entire professional life "doing what metallurgical engineers do" with Timken Company (they make roller bearings!!). He is now retired and with his lovely wife, Irene, resides in Sarasota. (However, Jerry continues to take special assignments from Timken and travels to far away places where Timken has plants, doing whatever a metallurgical engineer does for Timken in far away places!)

At Skeeter's Jerry will first "give a little talk" addressing "Practicable Metallurgy for the Backyard Blacksmith." Then secondly, at the fired forge, using multiple techniques, hammer-out a mystery artistic object!! Come, hear, watch and learn.

Lunch and drinks will be provided by the Mistress of the place, Lou Prather. However, because of attention to the health of her husband, she doesn't do desserts!! A map is provided to Skeeter's at 2816 Terry Road, Tallahassee FL 32312, or call 850/ 386-9246 if you need further explanation. Happy Hammering! :)

Trez Cole, Dick Cornelius, Mike Barry, Bob Lillis, Phil Pauley

Report from the Southeast

Ed Aaron

We finally finished instruction to the Boy Scouts for earning their Metal Work Merit Badge. It proves difficult to try to provide instructors since no one knows how many Scouts will show up until time for the class to start. Don Shedlock bailed me out again this year, instructing a day during all 4 weeks, Sue Lampbert contributed 2 days, Sarah McMurray 1 day . Lynn Emrich was gonna help, but I advised him that I had been told no Scouts had signed up for that week. 8 did show up.. so as I stated, can't tell how many will be there. I usually learn more that I try to teach since I have a long way to go in dealing with kids and instructing..

Our monthly meeting was also held at Tanah Keeta, with 10 in attendance. We did a little forging and had a discussion on holding a workshop to build guillotines or something like a smithing magician.

Eric Velleca has agreed to let us meet at his shop for our August meeting where we will work on another workshop- a bending tool. We will also discuss the design and dies for the "magician" workshop. Don't know where we can hold that workshop. Hint Hint.

Please look at the web page for any changes in scheduling since we are usually meeting at Tanah Keeta. Thats it for now----Ed

Max (from Troop 142 in Tampa) learning the art of blacksmithing in Henry's forge. Henry Kuczwara is a BSA Merit Badge Counselor and, under Henry's guidance, Max earned the BSA Metalwork merit badge on July 7, 2007

Report from the Southwest

Jerry Wolfe

The July 28th meeting was held at Phil Pauley's shop in Port Charlotte with 8 members attending. Phil demonstrated techniques in making tomahawks. We also worked on our project of making a forge for the annual meeting. The chili was HOT and great - Thanks Phil. One of our members - Hank Kuczwara has been busy with the Boy Scouts - helping them earn their Metalwork Badge. Thanks Hank.

Notices, For Sales & Want-Ads

Clark forklift - lifts 7000 lbs, all new tires and rebuilt 6 cyl. gas - $4,500.00 ; ***Cold saw*** - 14 in. 2sped, 3 phase, 4 degree locking vise, coolant - $4,500.00 new saw is 1 year old - $2,000.00 == Ray Nager - 863-398-4995

BLACKSMITH COAL AVAILABLE SOON!
Coal will be available at the FABA conference in October.

The Settlement would appreciate advance purchases. $22 per 100 lb bag. (Pickup only)
Send money order to: Pioneer Settlement, P.O.Box 6, Barberville, FL 32105 Call for details: 386-749-2959

Dennis Smith has ***coal for sale*** in Fort Pierce: 5 barrels of coal, approximately 300# each; $60.00 per barrel, includes barrel. Buy all for $250.00 and receive 1 barrel of coke free; Also for sale; miscellaneous scrap iron; (772) 468-2378, please call before 9pm

Clay Spenser's New address

New address is 73 Penniston Private Drive, Somerville, AL 35670, new phone 256 498-1498, new cell is 256 558 3658, new email is clay@tirehammer.com

Ray Clontz Tire Hammer Plans by Clay Spencer
These plans are for a 50 lb. power hammer that uses the rear axle and hub from a front drive car and emergency spare tire and weighs about 700 lbs. It is powered by a 1 hp, 1750 rpm electric motor, 120 or 240 volts, runs about 250 blows per minute and uses a spring toggle mechanism similar to Little Giant hammers. The anvil is 6" solid round (minimum size) by 36" high and the frame is 5" square tubing. The plans are 40 pages, printed front and back on 20 sheets that include parts list, detail and assembly drawings, sources, notes, installation, adjustments and maintenance. Over 250 hammers have been built using these plans. Price is $30US including postage to US and Canada, $32US to other countries. Send check or money order to Clay Spencer,73 Penniston Private Drive, Somerville, AL 35670. 256 498 1498 cell 256 558 3658
E-mail clay@tirehammer.com Tire hammers for sale, $2000.
Beverly Shear Blades Sharpened. Remove blades from shear and ship to Clay Spencer, 73 Penniston Private Drive, Somerville, AL 35670. $35 plus postage, additional cost for deep notches or blades previously sharpened at angle.
Web site coming soon tirehammer.com

Railroad Rail Anvils :

Wayne Goddard on the knife-list@kepler-eng.com contributed the following to a discussion on using railroad rail as an anvil:

" Rail work hardens real well. When you put a dent in it take the largest ball pein you have and use the pein end to work down the area around the dent. You'll be making the anvil harder. Don't worry about the irregular surface it won't make a divot 1/10th as deep as the marks you leave on the other side with your hammer. I've got the head of a large ball pein worked into a giant pein, that works real good for work hardening the face of an anvil. Lots of good anvils are ruined by being ground or machined flat, do so with care.

The photo shows my #1 working anvil. It was worn nearly flat by years of use. That made it somewhat harder than new rail. It was boxed in with heavy stuff and a 1" hardie hole created by adding heavy plate and bar stock here and there. Weight on it is 110#, it sits on 385# of iron hidden in the wood base. No movement with the heaviest hammer blow, all the inertia goes into the object being forged..... and no ring. When forging blades I work from the end, gives me the edge of an anvil under first one side of the blade and then the other. Same way the Japanese smiths do it. I'll send a picture of the horn in a separate package.

Here's my double bick (portable horn). It's made out of a rail spike driving hammer. It's mounted on the big rail anvil shown in the previous package. Note how the hardie hole was created so that I wouldn't have to drill a square hole in the rail. 1" square bars welded on – one inch apart, then 1" end plate welded to that.

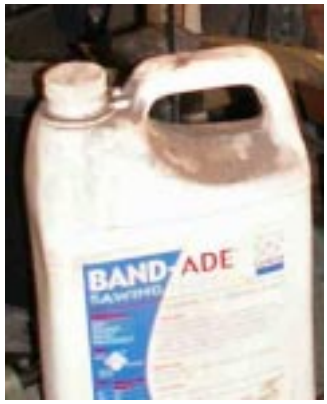
Bandsaw Aid - Homemade Coolant System

Steve Bloom

If you are like me (cheap!), you may own or are thinking about the cheap horizontal-vertical bandsaw sold by Harbor Freight. There is a whole lot to be desired about these tools but they are hard to beat at $165- $200 (depending on sales) (item 93762). You will want to spring for a decent bimetal blade (~$20 each), so anything that keeps the blade cutting longer is not to be sneered at. A simple way to better than double the life time of the blade is a coolant drip. Of course, you could buy a commerical unit (about 50% or more of the base cost of the saw), but if that's your path, you probably will buy a better saw in the first place. A real simple system consists of a :

A: The saw
B. The nozzle (delivery tube)
C. The hose (1/4" rubber)
D. A valve
E. A plastic bottle
F. A light

The optimal bottle is something like a Gaterarde bottle - but anything with a molded shape that you can tie a string around will do. Screw an anchor above the saw and hang the bottle. You can set up a siphon system - consisting of a cork with two holes - one for an air vent (a short piece of tubing just long enough to get through the cork), the other for a piece of metal tubing (~ 12" long). I've found that the stuff we use for mosiac pins from the Ace hardware stores is fine. Hook a 24" piece of rubber tubing to the tube (get it when you buy the tubing and make sure it fits). We've already hit the hard parrt - keeping the rubber tubing from crimping. You can either bend the metal tubing into a "U" (good luck!) or wire a scrap piece of PCV pipe (anything ~ 1" diameter) into the system so that the rubber tubing makes the 90 degree change without crimping. Place a small needle valve on the end of the tubing (back to Ace if you didn't read all of this before going shopping) and then connect more tubing to reach the saw. As you can see in the pictures, I drilled and tapped a hole midway on the saw frame and attached a plate. A magnet from a dead hard disk and some scrap made a nozzle locator

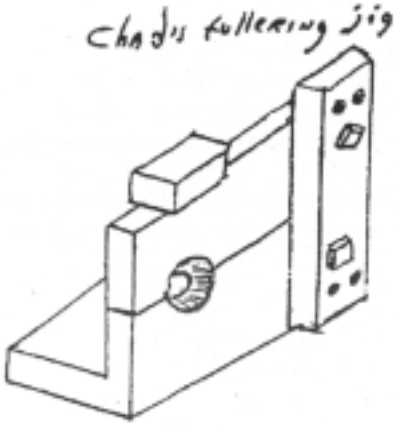


The end of the hose goes into the nozzle (or you could use an old syringe). Once the siphon has been established, all you have to do is (1) position the end of the hose over the cut location (as shown in the pics), open the valve enough to get a steady drip and turn the saw on. An alternative arrangement would be to hand the bottle upside down, rig the air vent as the "U" shaped tube and hook the delivery hose to the short tube (the trade off is maintaining a siphon versus a leaky cork).

The only thing left is "what coolant"? I've found that a product available from MSC (http://mscdirect.com) - BandAde - works wonderfully. It comes in gallon jugs as a concentrate (9:1 dilution), runs about $11 or so, and does not promote rust.

From: The Blacksmiths Guild of the Potomac 1996

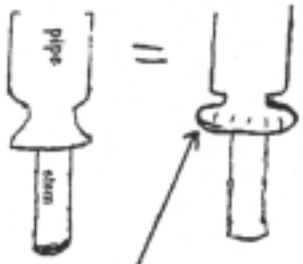
CHAD GUNTER'S CHILI PEPPER



Material: 3/4" black iron pipe
Work in high yellow heat, almost white

#1 - Fuller pipe 1/2" back and down to 3/8" hole.

#2 - Forge weld in fullering jig.
Chad mixes various fluxes in even proportions.
Prefit 3/8" round stem in pipe - there should be a slight gap so flux squirts out later under impact of fuller.
To flux, get pipe especially hot and keep turning it in fire, fuller and weld.



#3 - Place stem in pritchel hole so bottom of pipe flares out.

#4 - Draw out stem on your side of the anvil.
[N.B. Keep cleaning stem with wirebrush, as the flux sticks]

#5 - File 5 flats with a rasp on collar while piece is in vise.

#6 - Heat, quench stem and collar, then seat over pritchel hole.
Hammer end to seat collar against body and give top of pepper a little swell.

#7 - Place pipe in vise and fuller two parallel lines at 5 points equidistant apart on the collar.

#8 - Make pigtail hook

#9 - Fuller at about 4" mark of pipe but don't pinch off yet.
Taper bottom third of pepper.

#10 - Use cross peen to fuller 4 parallel grooves; also put in some dents and wrinkles, then add a slight curve.

#11 - Fuller pepper almost off at the 4" mark, then separate by twisting it off.
Rasp or sand pointed end

#12 - Brass brush top portion of pepper, and finish with Johnson's paste wax.

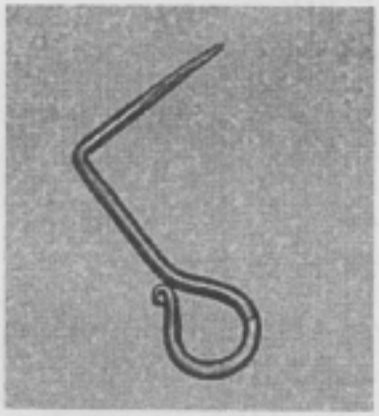
*- from notes by **Richard Long** and **Jim Frazier***

DRIVE HOOK DEMO

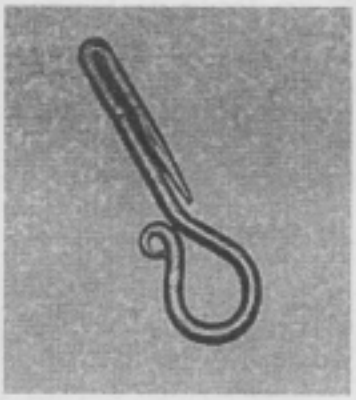
The New York State Designer Blacksmiths are fortunate to have Ray Smith, an ABS Master Bladesmith, as one of our members. Ray has hosted several meetings for the Southern Tier Region and it is always a thrill to visit Ray's shop to see what he has been up to and see him demonstrate. Ray also demonstrates at area Rendezvous and offers a line of camping gear and black powder accessories. In March of 2004 Ray demonstrated the drive hook, which he says, is popular with the primitive campers. I have found this hook to be a great shop hook because it does not require any fasteners. You just hold it up and swat it with a hammer to drive it into the wall. THANKS RAY!

Stock: ¼ round

Procedure:
To start the drive end draw out the end approximately 1 ¼ inches to a sharp point - this will be the nail
Insert the point into a vise about 2 1/2 inches and bend ninety degrees, square up the bend & adjoining sides

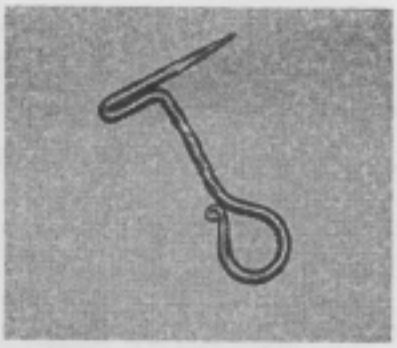


Continue the bend on the anvil to 180 degrees and hammer the loop closed



Insert the closed loop end into the vise about ½ - ¾ inches and bend the long leg to a 90-degree angle to expose the point

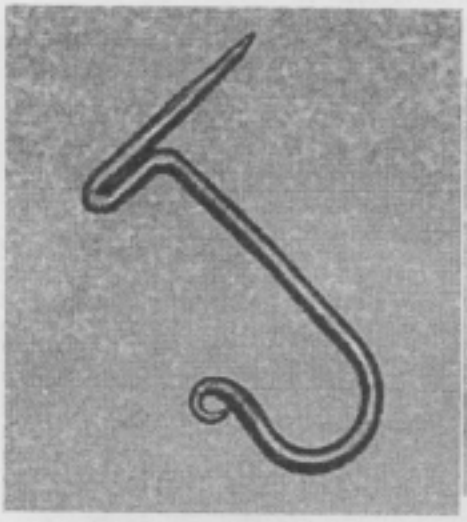
Square up the round stock just below the drive end about
1 ½ inches and twist - decorative option

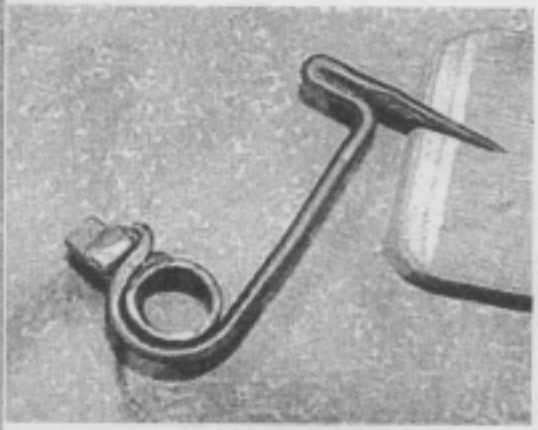


Cutoff stock 6 inches below the drive end

Draw a taper and scroll the end - scroll toward the drive point side

Using the hook jig or the horn of the anvil cool the scroll and bend the hook, away from the point toward the drive end to the desired shape and opening
Optional bending jig shown below makes repeatable bends and uniform hook opening
Wire brush and coat with Butcher's wax, or your favorite finish





Bill Banker
12/28/2005

Bending Jig

Metalsmith Vol.31(2) - June 2007

Vinegar as a De-Scaling Agent

By Albin Drzewianowski (Condensed by Editor)
From "Hammer & Tong," Blacksmith Guild of Central Maryland - May / June 2007

Lately I have been experimenting with vinegar as a method to clean fire-scale off of forged ironwork, before putting a final finish on the item. I am very pleased with the results. The down side to this system is that you have to schedule in something like 3-5 days for the vinegar to "do its thing." If you plan ahead and include time for the vinegar to de-scale your work, it saves a lot of time spent with the wire wheel and does a better job.

Vinegar is a very mild acid, acetic acid. It does not work fast, but neither does it pit the work like some other acids might. As you use the acid, it gets weaker and weaker. It still works but takes longer. A major plus is that vinegar is relatively cheap. I buy the white vinegar in the gallon jugs at the super market.

You need to accumulate a number of differed size plastic containers. For small pieces, I have a couple of different size Tupperware containers. For large pieces, I have a Stearlite plastic container meant to store clothes under the bed. It is about 4" high and 20" by 14". I found that I needed a long narrow container for de-scaling roasting forks, ladles, fireplace pokers, etc., so I bought a piece of 4" PVC pipe, cut a piece about 28" long and then glued (using the appropriate cleaner and cement for PVC pipe) a cap on one end and a screw cap on the other (all parts available from your local box/hardware store). Unfortunately, it does not stand upright by itself, so I keep it in a 5 gallon bucket. You need to be creative to find containers that will allow you to submerge your ironwork in the vinegar.

Once I have put ironwork in the vinegar, I agitate it every once in a while. Also, I am told that it works better if the vinegar solution is hot. So in the future, I will be experimenting with that also. When I am finished de-scaling, I filter the vinegar to get out the flakes of scale that remain. I figure if you leave in the flakes of scale, the vinegar will continue to eat away at them, leaving you with weak vinegar. So I use a large funnel lined with a paper coffee filter when pouring the vinegar back into its storage container. This is a slow process, but I think it lengthens the effective life of the vinegar.

Rumor has it that this vinegar which has been in contact with iron/steel makes a great stain for oak wood. I have not tried that yet, but have set some aside for a later experiment.
Safety issues: always wear eye protection, even though this is just vinegar, it is still an acid and you don't want any in your eyes. Also, it is a good idea to wear rubber gloves. When the acid is "worn out," then add some baking soda to neutralize it before discarding.

Pickling

From Discussions in The Forge – ABANA
Printed in "The Upset", April 2006, Mississippi Forge Council

I've been an advocate of using vinegar to pickle scale from steel. One downside to this is that vinegar is volatile and the smell gets bad (metallic) when pickling steel indoors. So, I finally got around to trying a sodium bisulfate pickle. Sodium bisulfate is available at pool supply stores for keeping the pH of pool water neutral. It comes as fine white crystals packed in one- or two-quart containers.

After some experimentation, I used about one to two cups per gallon of water. (I used a rectangular plastic storage box as my vat.) The crystals go into the solution fairly easily, producing no discernable heat on dissolving. (Serong acids produce lots of heat when mixed with water).

Much of the scale soaked off the steel within a couple hours. Some was more persistent, but came loose with overnight soaking. The resulting steel was nearly charcoal gray in color. Where it was not under the solution, the steel acquired a lovely rust patina, probably more from the humidity than anything else, but this largely sponged off. The scale did not completely dissolve. Much of it simply fell to the bottom of the vat. I plan to filter this off through a cloth when I transfer the acid solution to a jug for storage.

I did this on my kitchen counter. There was virtually no odor. Once or twice I splashed a little solution on my hands. I rinsed them soon after and experienced no problems (acid burns). I did wear glasses, however. I don't care to get this stuff in my eyes.

The Florida Clinker Breaker

September 2007

FLORIDA ARTIST BLACKSMITH ASSOCIATION
Juan Holbrook, Membership Records
6418 NW 97 Court
Gainesville, FL 32653

1st Class Postage

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FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, Inc.
Chapter of ABANA, Inc.

Date _____ New Renewal

Name_____
Address_____
_____
City State Zip
Phone:Home_____Work:_____
E-Mail_____
Spouse's Name:_____

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

Send this application and 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 membe begins when we receive your payment and lasts year Membership is for a family. You don't ha be an ABANA member to join FABA, but man FABA members are, and we encourage membe in both organizations.