

February 2008

*The Florida*

# Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

## *President's Corner*

*Rex Anderson*

Rex apparently doesn't have much to say this month...he's probably building his house and getting ready for his demo at Juan's next month.

If Rex doesn't get around to it, I'll tell you what happened at the Board meeting on the 19th.



## *Editorial Musings*

*Steve Bloom*

The **coal forge workshop** has had several folks volunteer to help and one (yup - just one) person who wants to build a forge. Cylda is chasing down prices on SOFA pots and the Sanders are getting prices on materials. More in the next issue.

Skeeter has contributed a neat article on hardness testing - I want to build one of the units and compare it to my commercial hardness tester, so look for that down the road (once I can break some time free).

We have lots and lots of talented folks - just look at the Gallery at any of our conferences! What we don't have is folks sending me a few pictures of what they have been doing! In an effort to get you, gentle reader, off of dead stop, I'll toss a couple of my latest items into the pot. If you don't contribute, expect to see more of this type of stuff whenever I have white space going - a - begging.

welded Damascus with bronze cast fittings (lost wax). The friction (aka primitive) folder used a neat trick. Imagine the fun of trying to hold a piece of crown antler stable on a band saw when cutting the slot. I happened to have an old thermoplastic cast around. I cut off a chunk, heated it in boiling water and wrapped it around the antler when the antler was in the correct position for sawing. The material hardened when cold and the sawing was easy.



The dagger is 500+ layer pattern-Fel

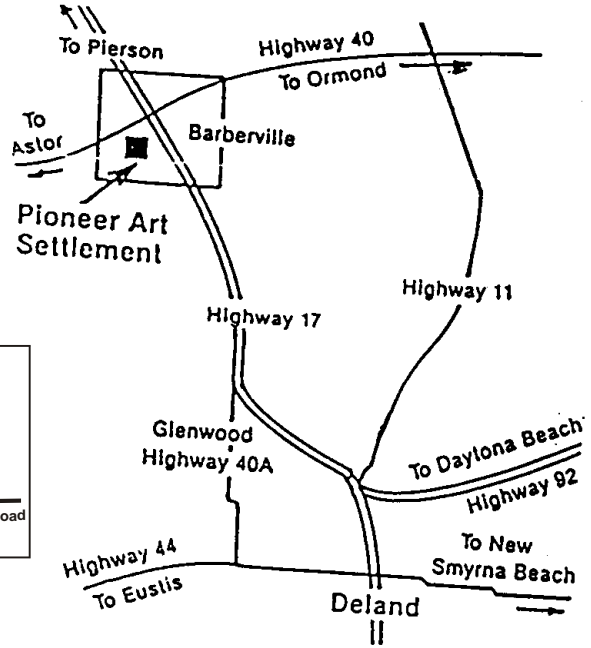
## Upcoming Events

The calendar includes events of interest to the blacksmithing community. The regions have no boundaries - everyone is welcome everywhere. Come to more than one if you can. We hold regular meetings in each region on the following Saturdays of each month: NE-1st, NW-2nd, SE-3rd, SW-4th except for quarterly Statewide meetings. The actual dates vary so check the schedule below. Our meetings are informal gatherings around the forge. Prospective members are always welcome. Come for all or any part of a meeting, bring your tools or just watch. Most meetings run from 9AM to 4PM and you'll need to bring lunch if not otherwise noted. If you have any questions about meetings, please contact the Regional Coordinators:

Northeast Region	Ken Knight	352-339-0629	Ironken@AOL.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southeast Region	Ed Aaron	561-748-9824	edaaron9824@bellsouth.net
Southwest Region	Jerry Wolfe	941-355-5615	wolfeforge@juno.com

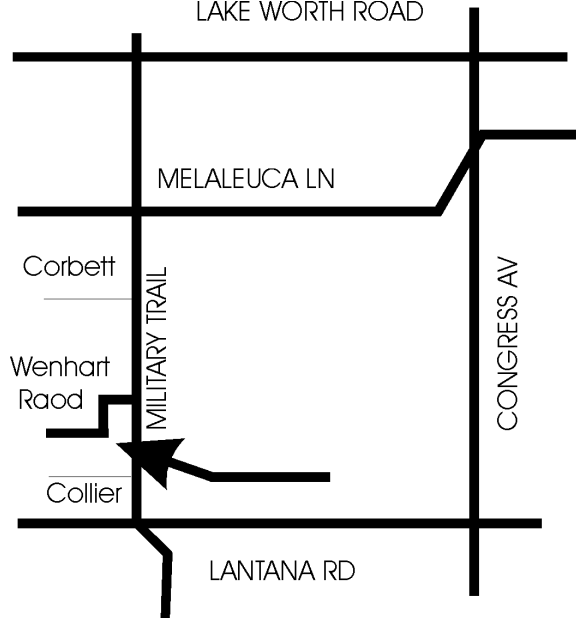
### February 2008

- NE 02 Barberville workshop
- NW 09 Juan & Linda Holbrook; Gainesville, FL: Rex Anderson will be demonstrating
- SE 16 Greg Ross's Home. Bring lunch.
- SW 23 Wolfe's Forge - See SW report for details



NE Region - Feb 02

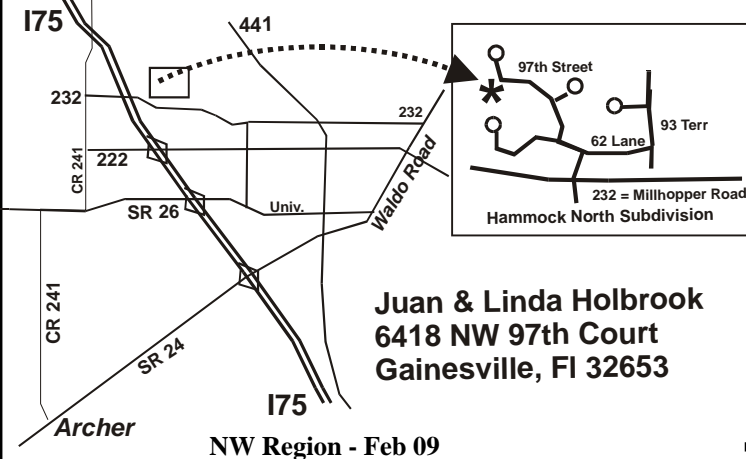
LAKE WORTH ROAD



Greg Ross Site: between Lantana Rd and Melaleuca Ln off of Military trail at dogleg on Wenhart Rd. Wenhart may be misspelled but it's between between Collier Rd and Corbett Rd.

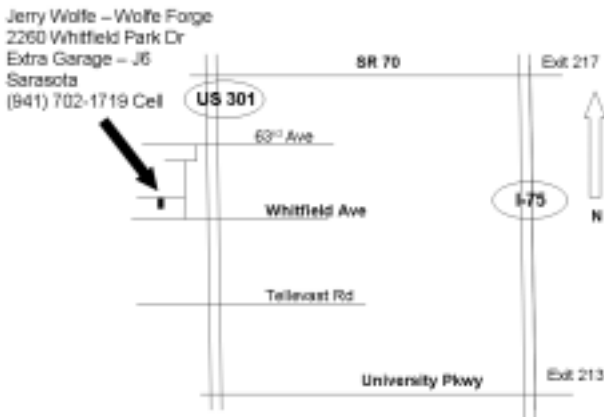
SE Region - Feb 16

### Gainesville



**Juan & Linda Holbrook**  
 6418 NW 97th Court  
 Gainesville, FL 32653

NW Region - Feb 09



SW Region - Feb 23

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## Current Events

## Future Events

NE - Mar 01 - Barberville

NW - Mar 08 - Clyde and Vi Payton; Monticello, FL (see NW report for details)

SE - Mar 15 - possibly at Art Ballard's with Susan Dunsmoor Demonstrating.

NW - Apr 12 – Panhandle Pioneer Settlement, Blountstown, FL with Jesse Frank making an iron bloom using a Kodai furnace (type used by Vikings, Romans, and Japanese)

SE - Apr 19 - at Artwork with demonstrators Susan Dunsmoor, Phil Herrmance and Art Ballard plus a shop tour

NE - May 03 - Steve Bloom's shop, near Archer FL

NW - May 10 - Rex & Mary Ellen Anderson, Monticello, FL

NW - June 14 – Jim and Ann Hartman, Perry, FL

NW - July 12 – Rick and Joyce Jay, Fountain, FL

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## Report from the Northeast

***Ken Knight & John Butler***

Thirty one of us gathered at David Ponsler's shop on 5 January. The weather was great as was the comradery and demonstration by David. David's shop is an old Police station located strategically beside the Fire department.



Bronze casting

David is a true artisan and a great demonstrator! Not to mention a great host. David demonstrated lots of tricks and skill using a power hammer. He also hand forged a bar of wrought iron into a ring. He forged bronze that he brought to temperature in an incredible gas forge (see picture on this page). I know that I speak for all when I thank David for demonstrating something that none of us have ever seen or even considered. It was truly awe-some to see such large pieces of silica bronze being heated and worked under a Monster hammer. Thanks again David and I hope you will invite us again.

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## Report from the Northwest

***Billy Christie***

December 8th was a beautiful sunny day at Bill Adams' "Blind Hog Forge" in Havana, FL. The projects for today's meeting began by pretending it was 1865 and the Civil War had just ended and the South had lost the war. Things around here were looking pretty dim, so we decided that it was time to head west. We had a Dutch oven but we needed a campfire set, which had to be made. We built a tripod to hold the Dutch oven over the campfire and a trammel hook (a hook on which a kettle or pot can be hung and raised or lowered) was also made with a trace chain on it. We, also, needed a couple of tools for the campfire: 1) a "lid-lifter" which is a tool to use for placing and removing the lid on the Dutch oven, 2) small shovel to help control the heat/fire under the oven.

We started by dividing into three different forging stations each with one of the above projects. There were 30 people who signed in so we had plenty of help to go around and things really got busy.

Prior to the meeting, Bill had been busy cleaning out his shop and had several tables full of stuff that needed a new home, plus the "Iron In The Hat" items that were sold brought in \$169.00. Thanks for your help Ester Gurr and Linda Holbrook—Great Job!

Lunch was delicious thanks to Bill's chicken and rice along with the tasty covered dishes. There was more than enough to go around.

After lunch all of the projects were completed and we were ready to test out our campfire set. This project turned out excellent. Thanks everyone for a fun-filled Saturday. Happy New Year and Happy Hammering!

PS: Don't forget the NW February 9th meeting at Juan and Linda Holbrook's shop in Gainesville, FL. Five free tickets for hand forged "hat" items.

**REGIONAL MEETING - Clyde Payton**

The MARCH NORTHWEST REGIONAL MEETING will be held at Clyde and Vi Payton's shop on Saturday, MARCH 8, 2008. We are putting together a series of demonstrations and classes to fit several interests.

- THE NAIL HEADER & MAKING NAILS
- MAKING A REPOUSE'
- BAMBOO FROM TUBING
- THE COOKING TRIPOD – BUILD YOUR OWN
- BEGINNERS AND INTERMEDIATE CLASSES

In addition to blacksmithing there will also be several other crafters demonstrating: A. POTTER, SILVER/COPPER SMITH, LEATHER WORKER, WOODCARVER AND A JEWELER have promised to make presentations. We are especially inviting you to bring SHOW & TELL items to display at this meeting - bring your own folding table for this use if you possibly can. TAILGATE SALE is always a big feature of this meeting; so load up your extra "stuff" and let's do some serious bartering! THE IRON-IN-THE-HAT raffle is likewise a popular feature, not to mention LUNCH served at 12:00 noon.

SOooo, ...here's what to bring – covered dish for lunch, donation to the raffle table, your show and tell items, folding table, a folding chair, tailgate sales merchandise, your spouse, all the kids, and Grandma too!

Look to the March issue for a map and directions to PAYTON FORGE, at 250 Payton Road, Monticello FL 32344. For further information or directions call 850/997-3627 or 850/210-5177.

Hope to see all of you on March 8th.

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### Report from the Southeast

*Ed Aarons*

Update for our October Meeting: There were 15 or more in attendance at Matty Spineli's Forge. Our meeting was spent with my getting lost while everyone else checked out equipment and other things to see how it made it through the hurricanes. I hope that we have Matty at more of our meetings for his knowledge of forging.

Our Dec. meeting at Tanah Keeta had less attendance, with 5 people in attendance. We spent the time discussing our region's activities and some open forge time. Not much for writing now.

I hope to see lots of people from other regions at Eric's for the State Quarterly Meeting.

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### Report from the Southwest

*Jerry Wolfe*

No report since we had a combined November and December meeting.

SW Region Meetings - Feb 23rd Meeting at Wolfe Forge - Demo on making a Belt Buckle. We will attempt to use the FLY PRESS and various tooling to produce a Blacksmith's



Belt Buckle. Bring your own ideas of design and then use your skills to make your own.

Come and enjoy the company of "fellow smiths" and learn from them. I learn something new each meeting, so I can guarantee you it will not be a waste of time. You might even enjoy the lunch and Iron in the Hat.

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### Notices, For Sales & Want-Ads

#### **BLACKSMITH COAL NOW AVAILABLE!**

\$22 per 100 lb bag (Pickup only) - Pioneer Settlement, Barberville, FL - Call for details: 386-749-2959 - [www.PioneerSettlement.org](http://www.PioneerSettlement.org)

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#### **Wrought Iron Basics**

from TheForge - by Andy Vita

Drawing and rewelding comprise the process of refining. As it comes out of the furnace, the bloom is worthless. There are numerous voids in the iron, much of which is filled with slag. The purpose of drawing the bar is twofold. It alters the bloom into a useful form (bar, sheet, etc.) and also it drives out the excess slag.

As the slag and the iron are drawn, they intermingle with each other, forming long threads of iron and iron silicate which orient themselves parallel to the direction in which the bar is being drawn and resulting in an almost wood-like structure.

After the first drawing, most of the slag has been forced out, but much remains. The grain structure is coarse and under the hammer may have some rather undesirable characteristics, such as splitting like wood when forged at anything less than bright yellow heat. Such iron is called "muck bar" and is good for many applications, but not all, e.g. the creation of fine architectural work including gates and window treatments, or furnishings such as tables, or utensils such as forks.

Nicking the muck bar and rewelding/redrawing results in a single-refined iron. Such iron will be a bit more forgiving than muck bar in terms of temperature, but not so much. Nevertheless, it has its uses - e.g. some of the simpler straight elements in a garden gate such as uprights.

Another reweld/redraw produces double-refined iron, which has yet more slag forced from it, a finer grain structure, and

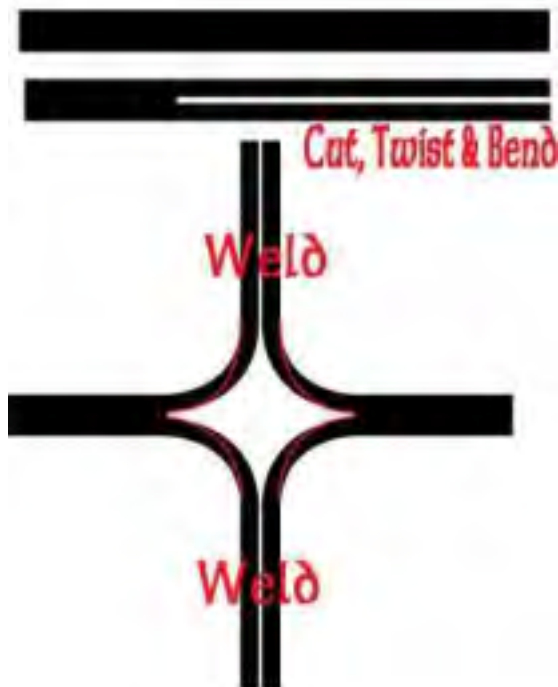
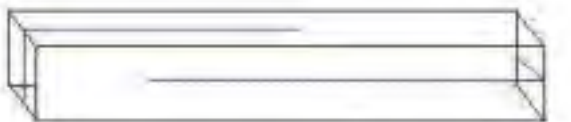
is therefore a finer product. Such iron may be suitable to the decorative elements of that garden gate including scrolls, leaves, animal figures, etc.

Yet another reweld/redraw results in triple-refined wrought iron, the highest grade commonly available. This iron is very fine-grained, far more forgiving in terms of cold-shortness, and would be used in the production of the finest items such as instruments, tools, household utensils, etc.

There was another grade that was finer yet and that was called king's bar. There is not much in the literature about it, save to say that it was the finest iron available, was very costly, extremely fine-grained, and not very common at all.

That's wrought iron refinement in a very small nutshell. I hope you find this marginally helpful at the least.

I've accumulated some info on the cross product (no - nothing to do with statistics). If this doesn't make sense, buttonhole Ron Childers who makes these!



# For your Tool Box

## Paul Garrett's Three Fingered Bending Fork

by Dave Smucker

Bending forks have been around forever and there are many ways to make them, but I think that Paul's idea is something new or at least it is a design that I have never seen. I even said to Paul "It makes me mad, because I didn't think of it myself."

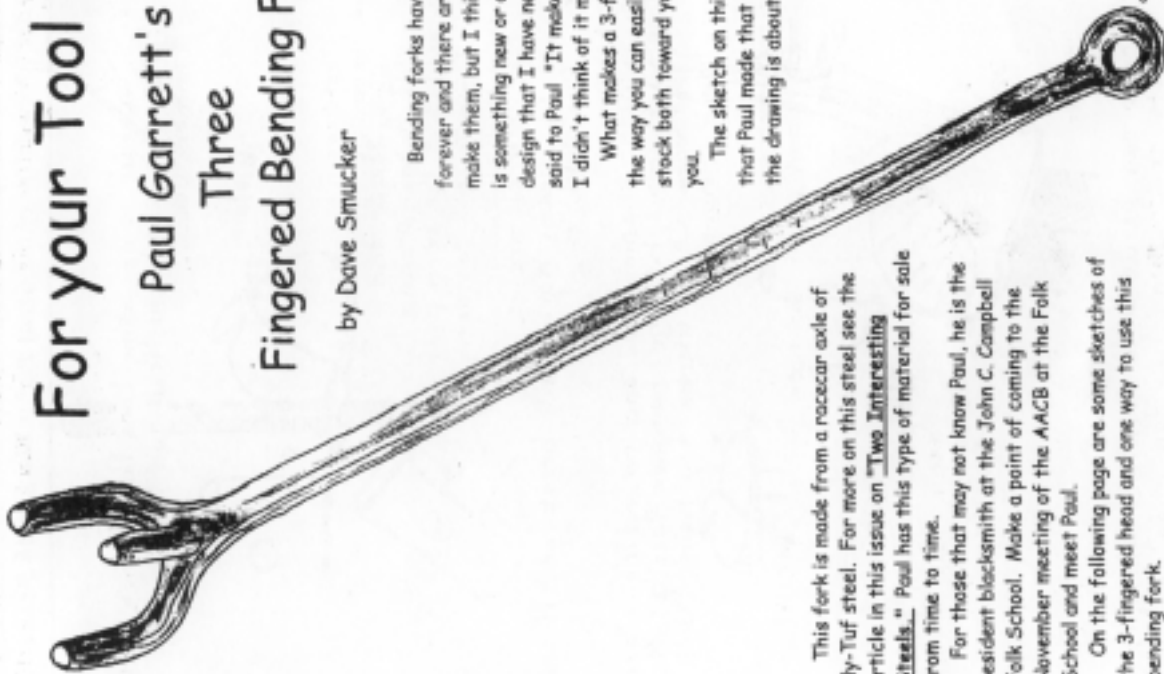
What makes a 3-fingered special is the way you can easily use it to bend stock both toward you and away from you.

The sketch on this page is of a fork that Paul made that is 24 inches long the drawing is about 1/3 actual size.

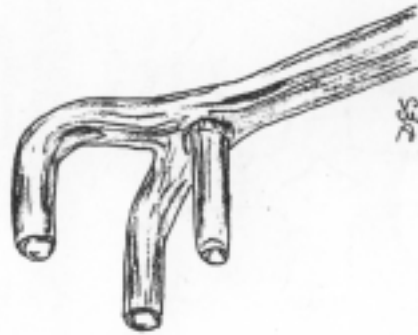
This fork is made from a racecar axle of Hy-Tuf steel. For more on this steel see the article in this issue on "Two Interesting Steels." Paul has this type of material for sale from time to time.

For those that may not know Paul, he is the resident blacksmith at the John C. Campbell Folk School. Make a point of coming to the November meeting of the AACB at the Folk School and meet Paul.

On the following page are some sketches of the 3-fingered head and one way to use this bending fork.



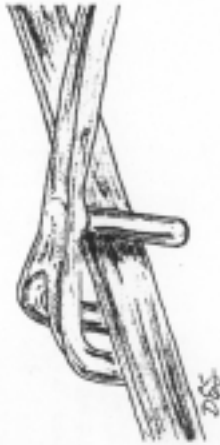
To make the fork Paul first drew out the axle and then flattened the bending end. He then split this end and forged the two fingers and bend them 90 degrees. He then hot punched a hole in the base of the wye for the third finger. This finger he drew out of additional axle material fitted in place and arc welded top and bottom.



Here is a view from the other side.



This view shows one way of using the fork. In this position, the blacksmith is bending the material towards themselves. In other words, towards the bottom of the drawing. (There are many positions you can use the fork because of the many ways you can place stock between the three fingers.)



In this view, the smith is bending away from himself or herself, towards the top of the picture.

The really neat thing here is to make a correction to an over bend one does not have to reposition the fork, only shift from one pin (finger) to the other. This requires a handle movement of only about 90 degrees, much much less than in a 2 pin or fingered bending fork.

Making this tool out of a 220,000 psi (pounds per square inch) steel makes this a supper tough tool you can really lay into. Make some of these forks in different sizes and you will really like them.

# Sketch Book

**Rail Road Spike Buffalo Head**  
 Demonstrated By Ron Lehenbauer  
 Sketched By Ricky Misbaum

Step 1. Using the 90° step on anvil, start shaping head and nose.

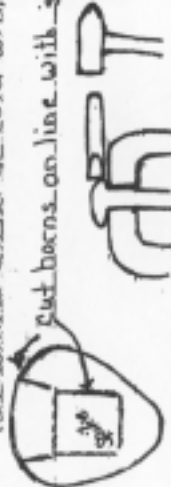
Step 2. Round nose.

Step 3. Cut horns by placing spike in vise and cutting hot with a chisel or cold with a saw.

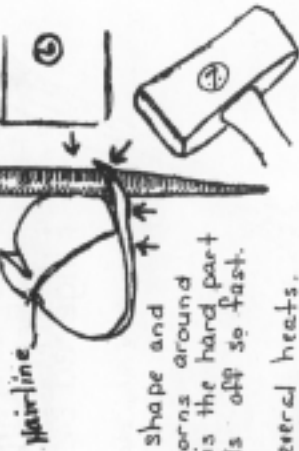
Cut horns on line with spike sides.

Step 4. Round top of head.

Step 5. With hammerpeen mark hair line.



Step 6. Spread horns using long thin punch/drift. Force punch between head and horn using hammer peen.



Step 7. Form, shape and draw out horns around punch. This is the hard part because it cools off so fast.

It will take several heats. \* work at red heat, horns will break off if work too cold.

Step 8. Finish shaping head and rounding edges starting just below hairline, hammer face a little lower. Hammer chisel marks for hair. Don't hit face area or horns.

Step 9. Punch eyes. use small round punch for nose.



Step 10. Brush and apply wax finish.

Buffalo head can be used to create draw pulls, belt buckles, or anything you can imagine. (6)

# The Florida Clinker Breaker

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

## February 2008

1st Class  
Postage



The Florida Artist Blacksmith Association (FABA) is a 501(c)(3) non-profit educational organization whose purposes are to teach, promote, and preserve the art of blacksmithing. Contributions are tax-deductible to the extent provided by law. FABA publishes the Florida Clinker Breaker monthly, and FABA membership includes a subscription. We solicit correspondence and unpaid articles on any subjects related to FABA's purposes. ABANA chapter newsletters may reprint non-copyrighted material if it is credited to the author and this newsletter. You need the publisher's permission to reprint copyrighted material unless otherwise noted.

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### FABA MEMBERSHIP APPLICATION

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Send application & a membership fee of \$25.00 to

Juan Holbrook, FABA Treasurer  
6418 NW 97 Court  
Gainesville, FL 32653

Make check out to FABA. Your FABA membership begins when we receive your payment and lasts one year. Membership is for a family.

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