

September 2009

The Florida

# Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

## Editorial Musings

Steve Bloom

The next scheduled Board meeting will be at the Annual Conference - 6:00 PM October 9. All members are welcome to attend (but bring your own coffee).

Our 'Election' this time is pretty much cut-and-dry. Of the five positions, there was only a single candidate per position, so not much of a horse race. To comply with our ByLaws and to save you, the membership, approximately \$150, we've elected to use page 5 and 6 of this issue as a mail in ballot. Personally, I don't expect that Jim will have much problem tallying up the results.

You will be receiving the conference registration materials in the near future. What is going to be a change is how the T-shirts are going to be handled. You'll have the option of pre-ordering by size, color, and type and including the costs in your conference fees. You get what you want and FABAA will not have boxes of unsold T-shirts, so everyone wins! It's going to be a great design, so you may want more than one.

I'm still trying to find out what folks want in the way of classes- both at the conference and at member's shops. I'm nominally teaching forks and utensil hangers at the conference but I can accommodate lots of various projects as long as I know that (1) you're taking a class and (2) what you want to do (which makes having materials on hand a lot easier!). Chest hardware? Candle Holders? Fireplace

and cooking utensils? Just drop me an e-mail at smith@blacksmithing.org and let me know what you want.

We are in the preliminary stages of building a storage module at Barberville and I will publish the details as they become available.

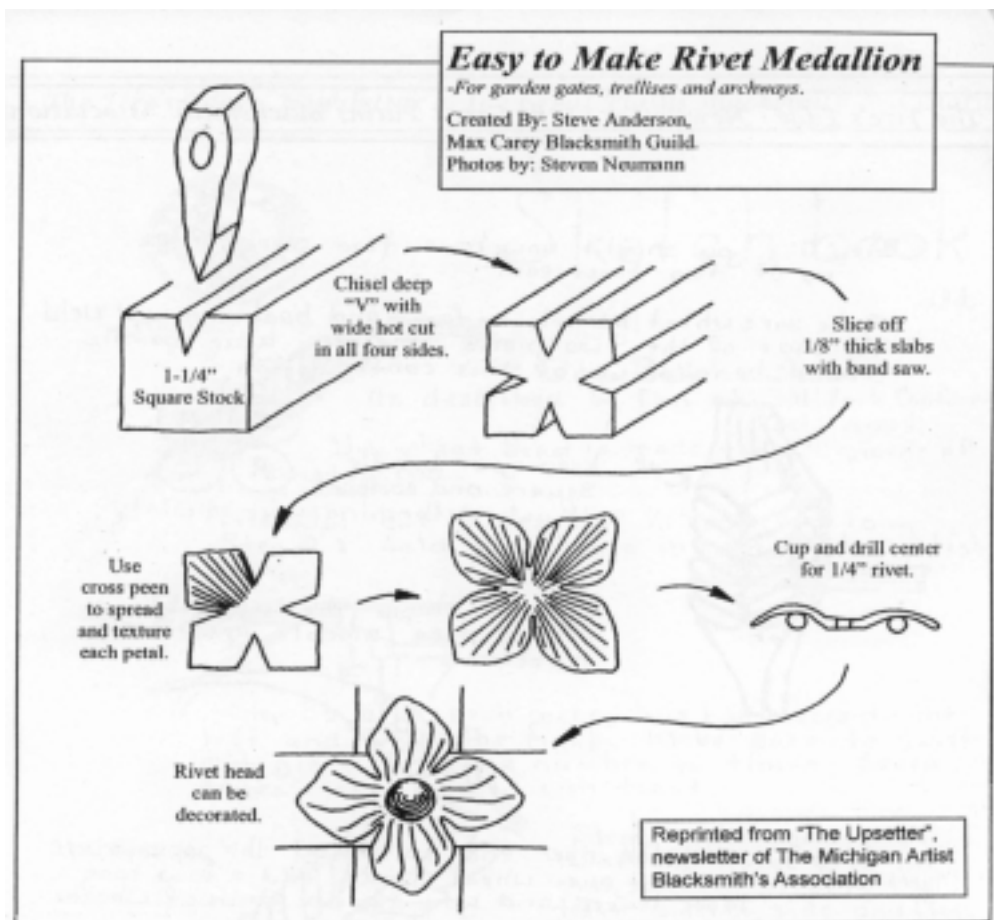
## Books on the Web

Pretty simple stuff, but perfect for a beginner :

[http://bryantrv.com/misc/Basic\\_Blacksmithing.pdf](http://bryantrv.com/misc/Basic_Blacksmithing.pdf)

All of the Rural Craft Publications books are still available for download at: <http://www.hct.ac.uk/>

[Downloads/craftpublications.html](http://www.hct.ac.uk/Downloads/craftpublications.html)



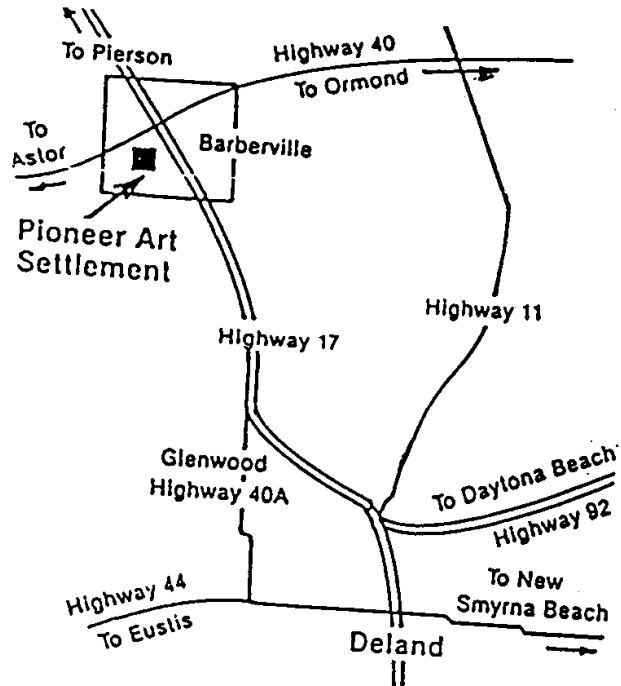
## Upcoming Events

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

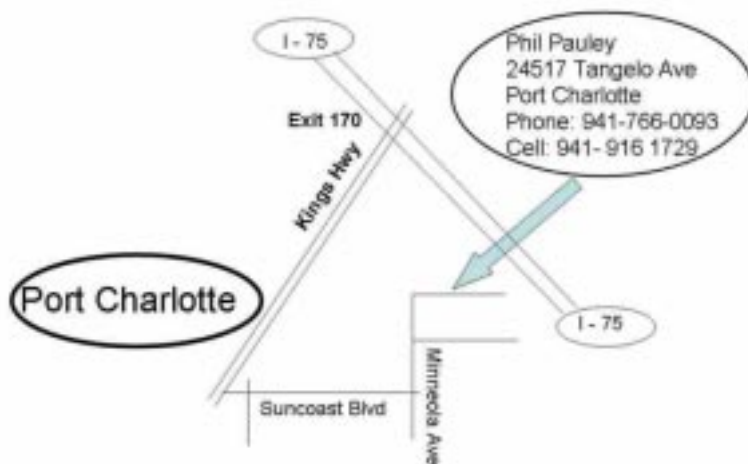
Northeast Region	Mitch Widham	386-673-0174	mwidham@cfl.rr.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southwest Region	Jerry Wolfe	941-355-5615	wolfeforge@hotmail.com
Southwest Region	--needs a volunteer - what about you?		

### September 2009

- NE 05** Jordan Thomas, demonstrating courting candles
- NW 12** Charles and Nellie Pate's, Hippie's Forge, 5691 Highway 19 and 27, Lamont, FL-- located about one mile North of Lamont, FL at 5691 Hwy 19 & 27.
- SE 19** unknown
- SW 26** Phil Pauley's Shop - Port Charlotte--no details at press time. Demonstration starts at 10AM, come for informal hammering starting at 9AM. We will have our normal Iron in the Hat and a pot luck dinner - Bring a dish to share.



NE Region



SW Region

### SE Region

Boy Scout Camp: from I-95 exit go east onto Indiantown Rd, go north (left) onto Island Way (1st traffic light). Stay on it until it ends at Country Club Dr. Go left—it ends at the entrance to Boy Scout Camp.

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## Current Events

## Future Events

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### Report from the Northeast

*Thurmond Chaffin*

On a hot August 1st 35 smiths signed the register sheet at the NE FAB meeting. Christian Lishen one of the young aspiring blacksmiths was grabbing time on any forge he could. He was showing off some knife blades he's working on. (he is the son of new Director of The Settlement)

Steven Estenson was our main demonstrator at this meeting. he showed his way in some traditional forging. He seems to always be involved with anyone needing some help.

Allen Hardwicke had the power hammer banging on something. The same hammer that was declared no good by someone and was slated to go someplace, but some timely intervention by some knowledgeable members save it and it is a great asset to the shop\*.

A brother and sister -Joshus and Morgan Mahan accompanied by their Grand Patents attended the meeting and are getting into blacksmithing. Jordan Thomas and Tom Kennedy were mentioned as helping them get started. Way to go guys. Someone mentioned that Donna the grandmother was inquiring about arrangement for food, so maybe some goodies are forthcoming. Grandpa is Ward. Please make them welcome at the meetings.

Tim and Melanie Harding were main food providers and there was plenty and delicious. Thanks. The buck in the bucket brought in \$200.00. Bob Mancuso as usual managed that chore. Bob mentioned that he has been diagnosed with cancer so keep him in your thoughts and prayers. The september meeting will be at Barberville with Jordan Thomas demonstrating courting candle stand making. Everyone is welcome. Does anyone else feel that we need a new directory. There are a lot of new members that need to be listed.

\*Clarification: The 50lb hammer is in need of tender loving care (speaking as someone who uses one virtually every time I go into my shop and has been using one since the mid 1980's). What was in the works was a swap for the 25 lb unit generously donated by Juan Holbrook- a hammer in excellent condition. The swap fell through. --Editor

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### Report from the Northwest

*John Williams & Billy Christie*

The July 11th meeting was held at Rob & Valynda Nichols forge in Lloyd. The demonstrators were Ron Childers and

Charles (Hippie) Pate. The demonstration was filled with great ideas and ingenuity. They made a fire place poker with a number of twists and a basket weave handle. While Ron was working on the drag of the poker, Hippie started to make a hot dog fork with a twisted shank. He folded his steel rod in half with a tight fold on the ends, set one end in the vice, grabbed a drill, chucked in the other end, and engaged the trigger. The twist this created was quick & even (no one expected the use of a drill – it works). Hippie then made a wall hanger with a



**John Butler, Billy Christie and Hippie Pate - you'll have to ask one of these guys just what was going on here. Picture by John Butler (or maybe Dot)**

square knot in the middle (it should be noted that while Ron was working on the poker, his cell phone kept ringing, as well as others, adding to the enjoyment of the moment). Next Hippie did a folded handle with two rods, folded in half to accomplish a four piece basket weave and Ron finished his great looking poker, which was sold by auction. No one was disappointed and we say thank you to the demonstrators and host.

The "Iron In The Hat" had some great hand forged items and brought in \$102.00, with Lloyd Wheeler drawing the winning tickets. Clyde Payton auctioned off the fire poker demo piece for \$40. Thanks, Red.

We would also ask that you keep Edgar Chatten in your prayers, as he has been diagnosed with bladder cancer. He will be meeting with his doctors later this month for upcoming surgery. If you would like to send him a card his address is P.O. Box 340, Woodville, FL 32362.

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## Report from the Southwest

*Jerry Wolfe*

The July 25 meeting was held at Wolfe Forge with Paddy Falvey giving a demo on making horse shoes. Being a farrier



**Paddy Falvey**

is a lot more involved than most of us thought. Some very critical operation to allow the horse to walk and run correctly as well as having good posture. It takes many years for a farrier to master all the skills needed to care for the horses



**Channel Scroll**

and not get kicked out of the stall. We had 11 folks that endured the heat under the "Tree of Gold" (no chestnut trees here in FL) to learn Paddy's profession. Thanks Paddy, Very interesting. We also had a brief demonstration by Jerry Wolfe concerning making a scroll and other elements from C Channel - 1/2" x 1 1/2". It makes an interesting scroll as well as some Fleur de Lis type architectural elements. If you really want to make a nice wall hanging, see the Blacksmith Journal Sept 1990 for the details. The channel is folded to make a cross section about 1/2" square, then forge weld the end and make the scroll.

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### **Notices, For Sales & Want-Ads**

#### **BLACKSMITH COAL**

\$35 per 100 lb bag (Pickup only) & details - Pioneer Settlement, contact the Settlement at 386-749-2959 or 386-749-2087 or mail your order with payment to PSCA/COAL, P.O. Box 6, Barberville, FL 32105. Accepted forms of payment: cash, money orders, checks, MasterCard and Visa.

#### **Video about Philip Simmons**

<http://vimeo.com/4800067>

Philip Simons flim - Ed Aarons

#### **Annual Yesteryear Hammer In**

A Big Event is occurring at the Yesteryear School of Blacksmithing September 4-5th. Mark Aspery will be in town and doing a full demonstration for our 4th Annual Yesteryear Hammer In. There will be a lot going on that day too with our tailgaters, brunswick stew, HUGE Iron in the Hat, our Doug Merkel Hammer Raffle, and more!

Blacksmith Supply will be on site with all of the wares any of us could ever need, along with several other tailgaters!

Mike Tanner, owner and operator of Yesteryear Forge and Yesteryear School of Blacksmithing, will open his working forge for people to see his extensive anvil and tool collection. His anvils range from 1,245 pounds to 20 pounds and are stacked 8ft high all around the building. It is truly a forest of anvil trees!

The cost is only \$10.00 per attendee for both days. Children under 12 are free. This is most certainly a family friendly event! For more information on the Hammer In please visit: <http://www.blacksmithguildofva.com>

The school also has some very exciting classes coming up with Mark and Mindy Gardner, Mark Aspery, and Brian Brazeal. It is not too late to sign up for any of them. There is only one spot left in Mark Aspery's class!!! For more information on classes please visit: <http://www.yesteryearschool.com> or email me at this email account or give me a call 434-390-6203.

## FABA Election Ballot

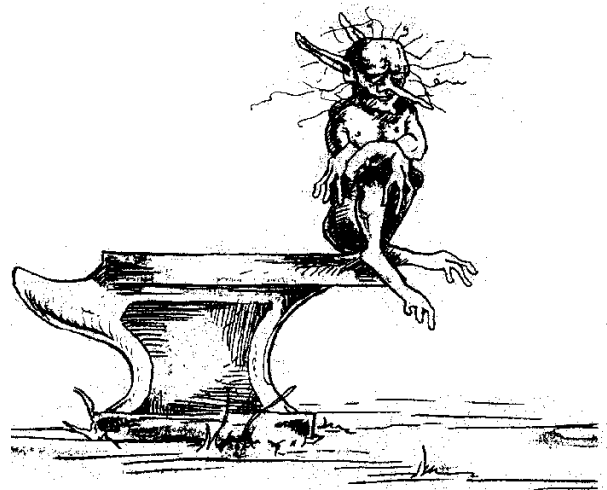
The five positions open this election are listed below. There was only one individual per position nominated and who agreed to run. To avoid the cost of mailing a ballot to each member, the Board decided to use the center (single) page from the Clinker Breaker as a ballot. If you wish to write-in a candidate, you can do so.

President	Jerry Wolfe	[ ]	or	_____
Vice-President	Charles Pate	[ ]	or	_____
Secretary	Jim Labolito	[ ]	or	_____
NW Trustee	Ron Childers	[ ]	or	_____
SW Trustee	Lisa Ann Connor	[ ]	or	_____

Mail to: Jim Labolito  
FABA Secretary  
314 Fernwood Road  
Tallahassee FL 32304



THE SMITH

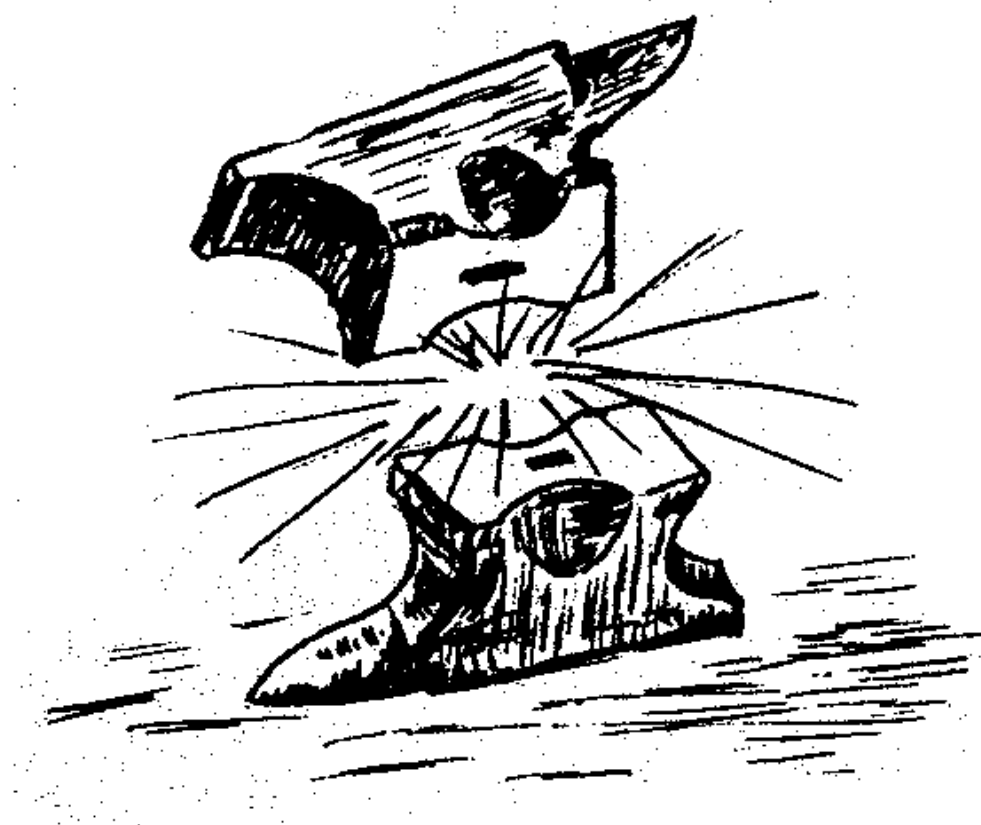


Janet R. DuPuy © 1995

Jim Labolito  
FABA Secretary  
314 Fernwood Road  
Tallahassee FL 32304

First class postage

**Jim Labolito**  
**FABA Secretary**  
**314 Fernwood Road**  
**Tallahassee FL 32304**



# New Jersey Blacksmiths Newsletter

## HEAT TREATING STEEL - QUICK GUIDE

Temperatures in Degrees Fahrenheit

Type of Steel	1045	1095	4140	5160	5210 0	L6	O1	A2	H13	S1	S7
Quenching medium	Water	Water	W& Oil	Oil	Oil	Oil	Oil	Air	Air	Air/Oil	Air/Oil
Forging Preheat	None	None	1250	None	None	None	None	1250	1400	None	None
Not Over	2275	2100	2250	2200	2100	2000	1950	2000	2100	2050	2050
Not Under	1600	1500	1600	1600	1700	1550	1550	1700	1650	1600	1700
Normalizing (Air)	1650	1575	1600	1600	1625	1600	1600	Do Not	Do Not	Do Not	Do Not
Annealing:	1550	1475	1550	1450	1450	1400	1400	1800	1600	1475	1500
Down To	1200	1200	1200	1200	1275	1000	1275	1000	1000	1000	950
Max. Drop/Hour	50	50	25	Air cool	10	40	40	20	50	40	25
Preheat Soak	None	None	None	None	None	None	1200	1200	1175	1200	1250
Hardening Temp	1550	1475	1575	1525	1550	1550	1475	1750	1700	1700	1725
Low Temp Required before Tempering	100	150	150	150	125	125	175	150	125	150	150
Tempering: After Quenching Temper All to At least 300 Degrees F											
45RC	600	800	750	425	800	1000	Not Rec	1200	1100	1100	1150
50RC	400	700	600	350	650	900	Not Rec	900	1050	800	875
55RC	As Quenched	600	As quenched	300	500	700	600	550	As Quenched	450	600
60RC		400		As Quenched	350	400	475	400		As Quenched	300
62RC or Higher		As Quenched			As Quenched	As Quenched	As Quenched	As Quenched		As Quenched	As Quenched

Industrial heat treating practices such as soak times, Variations for steel thickness, alternate hardening temperatures, alternate quenching mediums and temperatures, various annealing practices and more accurate tempering temperatures will be

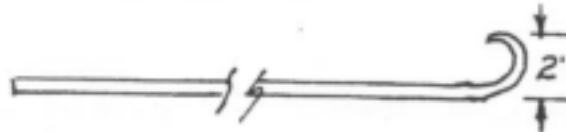
## Upright Hanger

This device has a number of uses such as for planters, camp lanterns, cook pots, etc.

**MATERIALS:** 1 piece 1/2" ID black pipe 4 ft. long  
 1 piece 7/16" round rod 5' long  
 1 piece 7/16" round rod 18" long

### PROCEDURE:

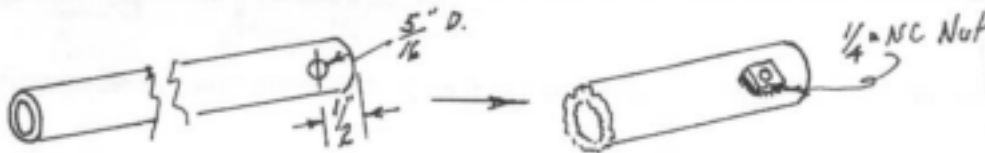
1 - Heat one end of the 5' piece, taper slightly and form about a 2" hook.



2 - Now, using bending forks (Project 61) proper heat (cherry red) form an 18" diameter semi-circle on this hook end.



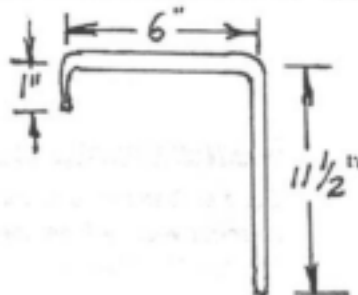
3 - Next, drill a 5/16" hole 1/2" below one end of the 1/2" pipe and through one side only. Then braze or weld a 1/4" x 20 TPI (threads per inch - national coarse) nut over this hole.



4 - Heat the other end to orange-yellow and flatten about 3".



5 - Now flatten about 1" at the end of the 18" round. Then form this piece to look like this.



6 - This piece is then welded to the low end of the pipe 9" from the bottom.

Reprinted  
 from OVBA  
 Jan 2006



# New Jersey Blacksmiths Newsletter

## Heat-Treating Data for Selected Tool Steels

(All temperatures are in °F)

Steel Notes	Forging Temperature (start/stop)	Anneal From	Harden From'	Quench In	Temper Temperature'
W-1, W-2	1900-1825/1500-1450	1425-1400	1450-1410	water/brine	300-600, 3
O-1	1900/1500	1450	1475	oil	300-600, 5, 8
O-6	1950/1500	1500	1450-1480	oil	300-1000, 4, 8
L-6	1900/1650	1375	1500-1550	oil	200-700
A-2	2050/1700	1650	1775	air	300-1300, 4, 5, 8
A-6	2025/1675	1375	1525-1600	air	200-1000, 5, 8
D-2	2050/1700	1650	1850	air	900-1200(900-960 Rc59)4,5,6,7,8
D-3	1900/1700	1600	1740	warm oil	400-1300, 5, 8
D-5	2000/1750	1650	1850-1875	air	300-1000,4,5,7,8
S-1	2100/1660	1475	1750	oil	300-1200, 4, 9
S-3	1900/1700	1375-1525	1600 (1450)	oil (water)	300-400, 10
S-5	1950/1650	1450	1600	oil	300-1300, 9
S-7	2050/1700	1550	1725	air <2' inch	300-1300, 4, 5, 6
H-13	2150/1650	1600	1850	air	1050-1150, 4, 5
6150	2250/1950	1550	1550--1600	oil	400-900

### Notes:

1. Variations in temperature may depend on size, and higher temperatures may give greater hardness at the expense of increased grain size.
2. Higher temperatures give higher toughness and lower hardness. Generally the lowest temperature gives about Rc 60 and the highest about Rc 30.
3. W-1 and W-2 come in different carbon contents. The higher the carbon, the lower the forging, annealing, and hardening temperatures. This also applies to the SAE 10xx carbon steels.
4. Steel needs an intermediate temperature (about 1200°) soak before heating to final hardening temperature.
5. Controlled atmosphere furnace preferred, but packing in a neutral medium like cast iron chips is also possible to prevent decarburization. Air hardening steels may be wrapped in stainless steel foil during heating to prevent decarburization and scaling.
6. Large sizes (generally >2 1/2-- 6 inches) are quenched in oil
7. Draw temper twice, with the second draw about 50° lower than the first.
8. Furnace cooling required for annealing (20 °F/hour maximum). It is not realistically possible to anneal these steels properly in a blacksmith shop.
9. May be quenched in water for simple sections.
10. There are different heat-treating procedures (oil/water/case harden/temperature) available for different purposes.

Submitted by Jan Kochansky Blacksmith Guild of the Potomac March/April 2007

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

### FABA Officers

<b>President</b>	<b>Rex Anderson</b>	<b>850.997-2748</b>	<b>rexaanderson@embarqmail.com</b>
<b>Vice President</b>	<b>Charles (Hippie) Pate</b>	<b>850-997-6986</b>	<b>-unknown-</b>
<b>Treasurer</b>	<b>Juan Holbrook</b>	<b>352-374-8888</b>	<b>talcaforge@craigfitz.net</b>
<b>Secretary</b>	<b>Jim Labolito</b>	<b>850-567-6464</b>	<b>fernforge@comcast.net</b>
<b>Program Chairman</b>	<b>Mark Stone</b>	<b>850-668-9527</b>	<b>markham62@comcast.net</b>
<b>Newsletter Editor</b>	<b>Steve Bloom</b>	<b>352-528-6508</b>	<b>sabloom@ironflower.com</b>
<b>Past President</b>	<b>Bill Robertson</b>	<b>850-668-2876</b>	<b>applecrossforge@nettally.com</b>
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<b>Trustee NW</b>	<b>Ron Childers</b>	<b>850-878-8537</b>	<b>munlaw2@hcsmail.com</b>
<b>Trustee SE</b>	<b>Ralph Nettles</b>	<b>561-747-5489</b>	<b>ralphnettles@msn.com</b>
<b>Trustee SW</b>	<b>Jerry Wolfe</b>	<b>941-355-5615</b>	<b>wolfeforge@hotmail.com</b>

Steve Bloom, Editor; P.O. Box 760; Archer, FL 32618; (352) 528-6508 or [smith@blacksmithing.org](mailto:smith@blacksmithing.org); <http://www.blacksmithing.org>

### FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, Inc.  
 Founding member Southern Blacksmith Association.  
 Date \_\_\_\_\_ New      Renewal

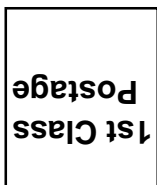
Name \_\_\_\_\_  
 Address \_\_\_\_\_  
 \_\_\_\_\_  
 City                      State              Zip  
 Phone: Home \_\_\_\_\_ Work: \_\_\_\_\_  
 E-Mail \_\_\_\_\_  
 Spouse's Name: \_\_\_\_\_

Send application & a membership fee of \$25.00 to

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

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

Don't list me in the directory [  ]



**September 2009**

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