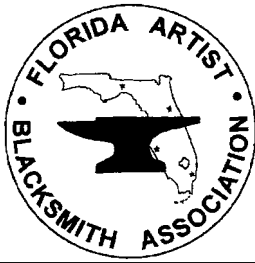


January 2010



The Florida

Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

Presidents Message

Jerry Wolfe

I want to wish each of you a very happy 2010. Keep the forge fires hot and the hammer swinging to make many useful items this year. Hopefully you will consider making some items to benefit your local FABAs section or make items for the annual



auction in October, it's never too early to start planning. Many of us make "lists" of items to do in the new year and this year I have started a list of items as the new FABAs president. Many of you may realize that 2010 is FABAs silver anniversary year, can you believe it – 25 YEARS since the humble beginnings. Some of our present members created FABAs and we need to make sure they realize we all appreciate the hard work that was done for the past 25 years. What shall we do to celebrate and make our chapter better and better in the upcoming years. One of our on-going goals is to teach blacksmith skills, so each region as well as the annual meeting should create opportunities to teach new skills to each of our members and visitors. Let's have a goal for each one of us to teach someone something we know how to do; that's not too much to ask, is it? The board will be planning many activities for the coming year when we have our first board meeting on January 21st.

One of the major activities for ABANA will be a conference in Memphis TN – Get your registration in before the end of December and you can save \$\$\$. Look at the ABANA website for details.

The safety suggestion for January is to be very careful when using a hand held power wire brush – It can get away from you very quickly and do extensive damage to your clothing and skin. Using a leather apron is a very useful safety precaution.

I would like to hear your ideas and suggestions; so please contact me anytime. wolfeforge@hotmail.com or 941 355-5615

The By-Laws state that

SECTION 4. APPOINTMENT OF REGIONAL COORDINATORS. At the beginning of each calendar year, the President shall appoint or reappoint a Regional Coordinator for each region to serve for the year at the President's pleasure; the President may appoint a new Regional Coordinator at any time to fill a vacancy or replace a Regional Coordinator.

Before the end of the year, and early enough for Members to respond, the President shall publish a request to all Members for recommendations and comments on candidates for the President to consider for appointment to the position of Regional Coordinator in all regions for the following year.

So, as president, I need your input concerning coordinators in your regions. Please send me any advise you have and names of those to consider.

E-mail change

Ron Childers can now be reached at: Ron@munlaw.net

Editorial Musings

The unexpected passing of Bob Mancuso and the sale of his tools to a vendor (see page 5) highlights a potential problem for many of us. When we finally put down the hammer and move on, we might like to have some of our collections of tools move to specific people and/or institutions. If we don't leave instructions specifying what we want to happen, the odds are good that those wishes will not be respected. While I realize that we all are immortal, writing down what you might like to happen and passing it on to whoever might be executor of your estate is probably the best way to insure that your wishes will be respected. FABAs has organized auctions on the liquidation of a member's shop specifically to maximize income to the family and some members have bequeathed tools to equip smithies at historical sites (for example: Dr. Carl Van Arnham at the Morningside Center in Gainesville). Give this some thought.

Steve Bloom, Editor

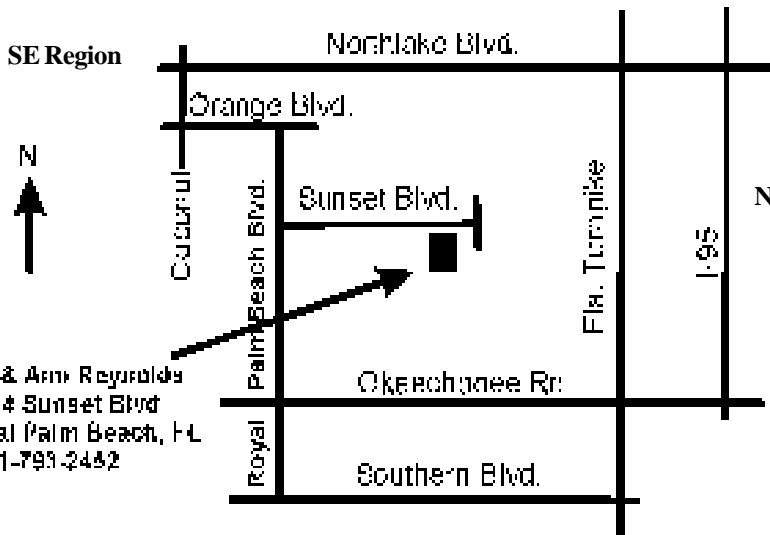
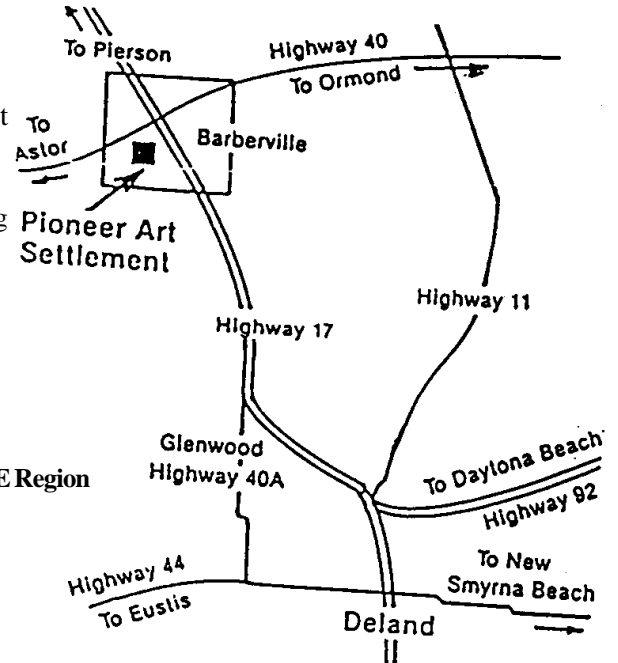
Upcoming Events

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:

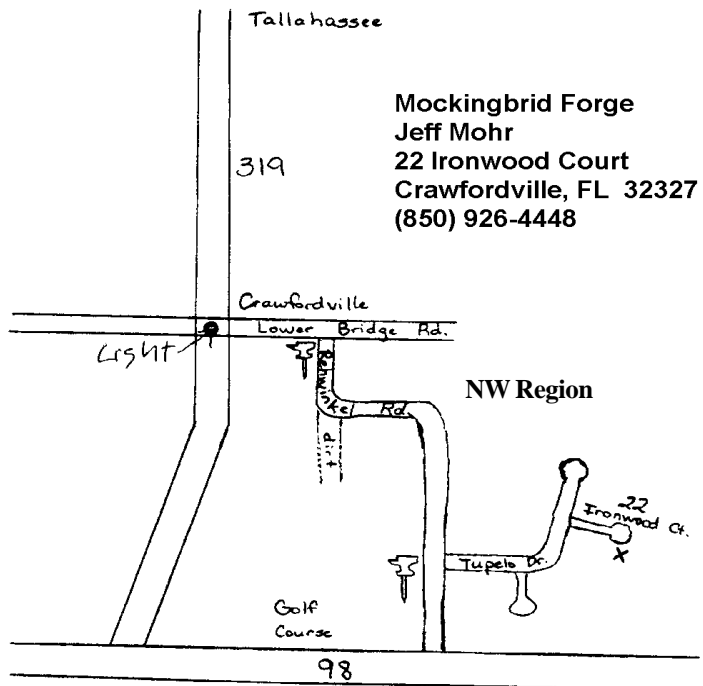
Northeast Region	Mitch Widham	386-673-0174	mwidham@cfl.rr.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southeast Region	--needs a volunteer - what about you?		
Southwest Region	Jerry Wolfe	941-355-5615	wolfeforge@hotmail.com

January 2010

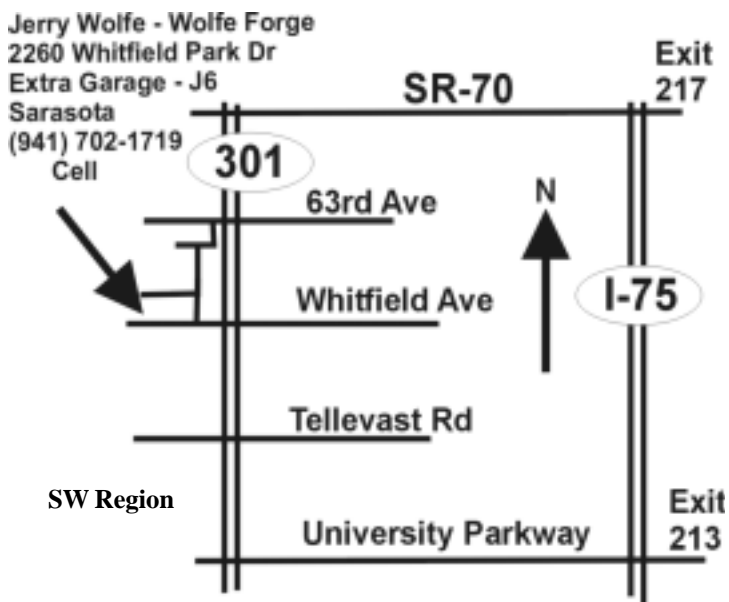
- NE 02 Open Forges @ Barberville
- NW 09 Jeff and Brooke Mohr's Mockingbird Forge (see Current Events for details - pg.3).
- SE 16 Meeting to be held at Ray Reynolds' Shop (ditto pg.3)
- SW 23 - Wolfe Forge - Demonstration of forged elements for making tables by Jerry Wolfe.



Ray & Ann Reynolds
11064 Sunset Blvd
Royal Palm Beach, FL
561-793-2432



Mockingbird Forge
Jeff Mohr
22 Ironwood Court
Crawfordville, FL 32327
(850) 926-4448



Jerry Wolfe - Wolfe Forge
2260 Whitfield Park Dr
Extra Garage - J6
Sarasota
(941) 702-1719
Cell

Current Events

NW Jan 09 Jeff and Brooke Mohr's Mockingbird Forge at 22 Ironwood Court, Crawfordville, FL 32327. Please remember to bring a 'hat' item and a covered dish to be shared by all. Not sure what the program will be, but its always interesting at Jeff's shop.
SE Jan 16 - Ray & Anne Reynolds's shop. Plan to work on a food/pizza chopper if you are so inclined. If you are able to, please bring a dish to share for lunch. Hope to see all in January

Future Events

NE Feb 06 Open Forges @ Barberville
NW Feb 13 Juan Holbrook , Gainesville, FL.
SW Feb 27 Regional meeting -Stay tuned for details.
NW Mar 13 "Payton Forge" outside of Monticello, FL. Trenton . Tye from Albany, GA demonstrating
NW Apr 10 Panhandle Pioneer Settlement in Blountstown, FL. John Watson & Danny Willis Demonstrating. Think Fire!
NE May 1 Steve Bloom's shop - near Archer, Fl
NW May 8, 2010 Rex & Mary Ellen Anderson's Shop outside Monticello, Fl

L

Report from the Northeast

*Mitch
Widham*

Saturday Dec 5th was the North East Regions Annual Christmas Gathering at Allen & Chloe Hardwicke's in beautiful Altoona Fl.



We never did get the old forge fired up, however the fireplace in their new addition was roaring as it was a rather cold and damp day. We shared a wonderful meal and the company of each other. Thanks to Allen and Chloe for being such generous hosts and to all that brought the wonderful dishes to share. The Buck in the Bucket draw was a little disappointing only raising \$75.00 this month; let try and raise our standards a little guys, you either need to bring in better junk or buy more tickets. We are going to try a new twist at the Jan 2nd meeting at Barberville, in addition to the normal Buck in the Bucket draw we will do a book exchange; how it is going to work is, you bring a blacksmith related book to exchange and will be given one raffle ticket, then after the other drawing, those that donated a book will have a 2nd raffle and you will be able to choose a book from the table. The point of the whole thing is to share books that you

either know inside out, or are no longer using and to get them into the hands of someone seeking the information, thus sharing the knowledge of Smithing. If it is successful we might try it with other items, like jigs, hammers or tongs. Let me know what you think or want to try. I just know some of you "Old-timers" are hoarding this stuff, lets see if we can get some of it back into circulation and in use. Additionally I am always looking for demonstrators and people to host a meeting, as well as I would like for our group to make a project for this year's auction at the annual conference, if you have any suggestions or ideas, please get with me.



As was mentioned in the last news letter, a Memorial service was held at the La No Che Scout Reservation on Nov 21st for long time FABA Member Bob Mancuso, whom suddenly passed. About 15 of his FABA friends attended the large and moving service. Bob was heavily involved with many organizations and was recognized by each as a wonderful mentor and a person of extraordinary selfless service to those organizations. A tree was planted at the spot that he always set up his blacksmithing trailer to teach the metal working merit badge to Boy Scouts of America. Jordan Thomas made a beautiful Spanish Cross out of 1 inch square stock to be installed there also. Bob was known for teaching many of us the techniques of making these and they meant a lot to him. I couldn't think of a more fitting dedication from our group, great job Jordan.

Hope to see you all at the Jan meeting, bring a friend.

L

Report from the Northwest

Billy Christie

The NW Region of FABA had its November 14, 2009 meeting at Ken & Louise Burns shop in Tallahassee. There were

several new people in attendance, and we had a total of 29 people sign in. Troy Brown had been scheduled to demonstrate making a knife; but due to having gall bladder surgery Troy was unable to demonstrate. However, Troy was able to attend the meeting and is doing much better. We were able to get our very own bladesmith, John Butler, to demonstrate how to make an Upswept Skinner Knife out of a piece of 1095 high carbon steel. John started by forging out the blade, then he forged out the tang, and then the handle area. After he was happy with the shape, he normalized the handle area by heating it up to subcritical (600-700) & letting it cool down slowly (a couple of times), then he was able to drill the holes in the handle that were used to mount the exotic Padavk Wood handles. Since I'm not sure about the following, please ask John about specifics: The blade is heat treated in a toaster oven at 425 degrees for 1 hour. After the wood handles were shaped to his liking and drilled, they were riveted on cold. This knife turned out beautifully created and could be yours for only \$125.00. Thanks, John, for stepping in and demonstrating a superb skill.

The "Iron In The Hat" had some very interesting objects, including several hand forged items. The sale brought in \$133.00. Thanks again to Dot Butler for helping out and to everyone else that participated in the 'hat' drawing. Jim "Rev" had a table set up with a nice variety of FABA T-shirts and sweatshirts and sold a total of \$115.00. Yeah, Preacher!!

Ham, turkey, burgers, and lots of covered dishes and mouth watering desserts were enjoyed by everyone. As always, a BIG thank you to everyone involved with making sure that a scrumptious lunch was enjoyed by all.

Once again, we'd like to thank Ken and Louise for the opportunity to visit/enjoy their great (remodeled) shop; and, to John Butler for sharing his wealth of knowledge.

Until I see you again, Happy Hammering!

Report from the Southeast *Ed Aarons, Boy Scout Liaison*

Our SE Group really went beyond the call Nov 14th to instruct the Boy Scouts in the Blacksmith option of their Metal Work Merit Badge. Seven of us gave up Saturday to help out with a total of 20 scouts finishing that option. Pietera, the person in charge of getting things organized for SAW weekend said that when a group would leave our class with projects in hand, others would see and try to sign up. She stated that there is a lot of interest from the Scouts and several of the Parents. I gave info on joining FABA and that I would try to have instructors available for a group. Thanks from the Scouts to Peter Brandenburg, Danny Cunniff, Jan Dion, Sarah McMurray, Ray Reynolds and Don Shedlock.

Ralph Nettles

The southeast had a very good meeting on Nov 21 at John O'Brian's forge. There were 34 attendees - that's right 34 people. Don Shedlock was our demonstrator with a tropical fish weather vane. It is South Florida - that's why it is a tropical fish.

17 people took part in making the project working into late afternoon Lunch was pulled pork with lots of covered dishes to share. The iron in the hat brought in \$104.00 Many thanks to every one who put lots of work to make this a great meeting it was good seeing all of the fun and fellowship that was enjoyed by new people and old time FABA friends and members

We will not have a meeting in December But look forward to January's meeting at Ray and Ann Reynolds open forges bring a project you are working on or one you want to share with everyone



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.

Bob Mancuso's tools for sale

Greetings,

My name is Tom Lent and I am contacting you regarding Bob Mancuso. As you are aware, Bob recently passed and Bob's brother Tom Mancuso had made arrangements with me to sell Bob's Tools and Equipment. I will be listing Bob's things on Ebay and wanted to make you aware of this as some of you and your Associations Membership may be interested in having something of Bob's.

I am still sorting through the large amount of things he had, but the list will include 2 Hay-Budden Anvils (circa 1900 & + 100-150 pounds), a Swedish Kohlsaw Anvil, his Mobile Blacksmith Forge on Iron Wheels with Columbia Blower (if anyone knows any history on this piece please contact me to let me know), large bags of Charcoal, numerous huge antique Leg Vises and Blowers, an Electric Furnace/Kiln, Bandsaws, dozens of Tongs, Hammers, Shop Supplies, etc.. I also have, but will not be listing on Ebay, hundreds of pounds of steel and various metals of all shapes that he had in inventory. If anyone is interested in that they can contact me via email.

I sell on Ebay under the Ebay ID name "102257tl" if anyone is interested and will start listing the items Sunday November 28. If you knew Bob and his shop, then you know how much stuff he had so it will take me awhile to get through it all.

Coal Forge needed

Beginner blacksmiths looking for a portable coal forge with blower (Preferably manual, but either will work). Must be in good, working condition, please. Located in Montverde (close to Clermont). We usually go to the monthly meetings in Barberville and/or we can pick up the forge, if it's relatively close. -- Please e-mail jdmahn@yahoo.com with pictures/info/asking price. Joshua Mahn <jdmahn@yahoo.com>

Power Hammers Wanted

Wanted 25 Or 50 LB. Little Giant Power hammer . Sarah McMurray 561-385-9199 <sarah.mcmurray@att.net>

I would like to pick up a Little Giant Hammer. If you or any one you know is getting rid of one, please contact Richard Hurwitz <psychic1@bellsouth.net>

Rail Road Spike Knives

Ken Admire <Kenneth.Admire@huskyenergy.com> wrote: I saw in one of the articles that you're looking for ideas on RR spikes. I have 5 sons and a son-in-law that I started in blacksmithing using spikes. Plentiful, useful, and a gem in every one of them waiting to come forth.

Attached are just a few I've made for co-workers as give-aways. The one for an electrician has an AC adapter in the end (joke). Two slots punched and a hole drilled under them.



A Christmas Star

Created by Joe Wilkinson

Reprinted from BAM Sep-Oct 2003

A few minutes of observation of the pictured candle holder quickly reveals the finished product is made up of 9 identical elements plus 2 half elements to complete the base. The elements look like this



Now all blacksmiths know our greatest challenge is to make 2 or more identical elements, therefore we need a jig. I made mine from a piece of 2 in angle iron about 7 in long, so I could clamp it in the vise. It looked something like the sketch "A" below.



Next cut 9 pieces of 1/4 in round stock 6" long. Place 1 piece in the jig and using the torch, make a tight bend exactly in the center. Heat the bend so there will be no spring back. Now reverse the stock in the jig to be certain it is bent in the center— if it is off a little, either adjust the jig or adjust the length of your stock, they must be exact.

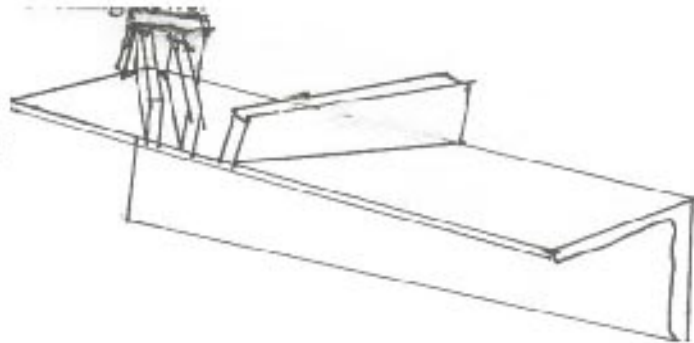
Now lay 2 elements against a straight edge and weld the center tips.



Repeat with the other 3 pairs of element.

We now have 4 and one-half larger elements. Lay 2 and one-half elements flat on your welding table and form a flat star—tack the joints together. In my shop I keep a 4 in deep rectangular pan of dry sand next to the welding table. Stand the first star upright in the pan. Next position the remaining 2 elements in their appropriate position, getting as close to perfect as your eyeball will let you. Now tack weld at the top and remove from the sand pan. Check for alignment and adjust as necessary, heating the tack welds with the torch so you don't break them.

Now add the 2 half elements at the bottom to complete the second star. Reinforce all tack welds as necessary to complete the stars. All that remains is to make 5 candle cups and weld in place. Sweep up, wash your hands and you still have time to catch the evening news.

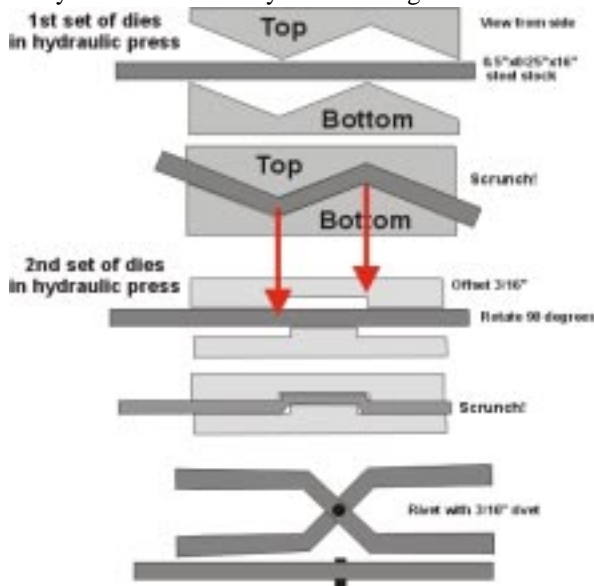


Joe

Quick Tongs

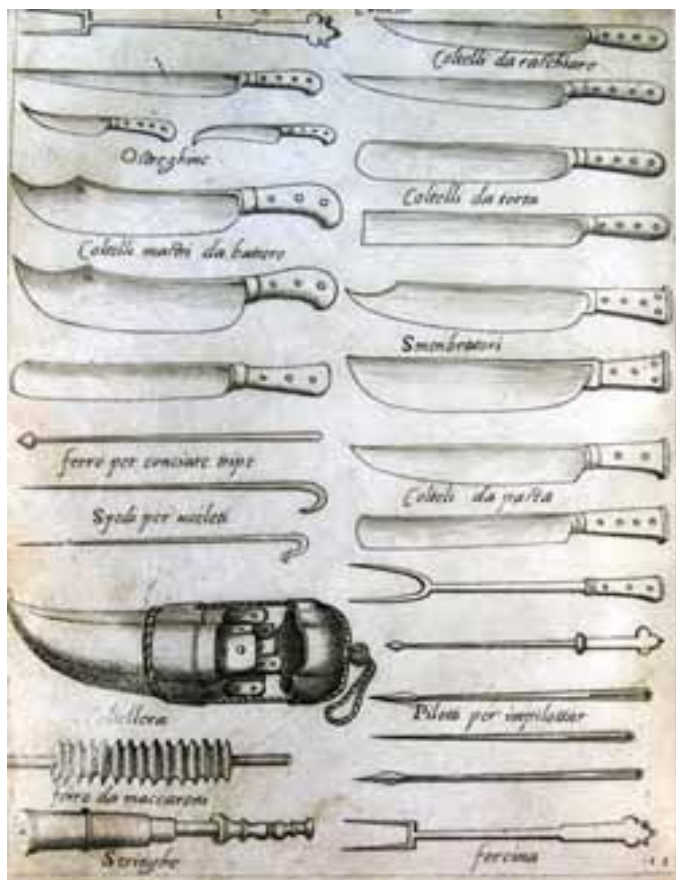
Steve Bloom

This was the system used to make tongs for the teaching trailer from 1/4"x 1/2" stock. Given the press, a pair took about 30 seconds. If you have the stock, drag it to my meeting in May and we will make you some tongs.



The Opera of Bartolomeo Scappi (1570): l'arte et prudenza d'un maestro cuoco By Terence Scully

A compendium of cooking - shown here is an illustration of various kitchen knives



North Florida Antique Power Association

<http://www.nfapa.info/index.html>

Hosts two shows a year at the Glen Nursery Plantation (west of Jax, near I10) and would love to have Blacksmithing and/or Farrier exhibits along with what ever your organization deems necessary.

If you are interested in demonstrating, contact Leigh Dubie <crazyembarker@yahoo.com>. Fees and other requirements are likely to be waived. The pictures are from the Fall show.



JUNKYARD STEELS

The following list describes some potential types of steel used for common junkyard items. This information was compiled from several sources, Machinery's Handbook, Country

Blacksmith, Blacksmith's Journal and Carpenter Technology Corp.

Machinery's Handbook is an excellent source for heat treatment of these steels.

APPLICATION	Number	Letter
Agricultural steel	1080	
Axels	1040	
Ball Bearing Balls	52100	
Ball Bearing Races	52100	
Band Saw Blades		L-6
Bits, Router		M2
Bolts, anchor	1040	
Bolts, heat treated	2330	
Bolts, heavy duty	4815	
Brake Lever	1030	
Cams		A6, S7
Chisels		O2, O6, L6
Clutch disk	1070	
Clutch Springs	1060	
Coil Springs, auto	4063	
Coil Springs, truck	5160	
Cold-rolled steel	1070	
Connecting Rods	1040	
Crankshafts	1045	
Cutters, Bolt		S2, S7
Drifts		L6, S2, S7
Drills		M2
End Mills		M2
Fan Blades	1020	
Files		W-2
Gear shift levers	1030	
Gears, transmission	3115	
Hammers		L6
Harrow Disk	1080	

APPLICATION	Number	Letter
Hay Rake Teeth	1095	
Jackhammer Bits		S-5
Knives, machine		M2
Knives, woodworking		O2
Leaf Springs	1085, 5160	
Lock Washer	1060	
Mauls		L6, S2
Mower knives	1085	
Music Wire	1085	
Nail Sets		L6
Plow Beams	1070	
Plow Disk	1080	
Plow Shares	1080	
Pneumatic Tools		L6, A6, S7
Punches-Cold		A2, O2
Reamers		M2, O2, A2
Roller Bearings	4815	
Screw Drivers		L6, S2
Snap Rings	1060	
Spring Clips	1060	
Spring Steel, clock	1095	
Steering Arm Bolts	3130	
Steering Arms	4042	
Taps		M2, O2
Transmission Shafts	4140	
Tubing	1040	
Universal Joints	1145	
Valve Springs	1060	
Wrenches		L6, S2

New Jersey Blacksmiths Newsletter

EFFECTS OF COMMON ALLOYING ELEMENTS IN STEEL

By definition, steel is a combination of iron and carbon. Steel is alloyed with various elements to improve physical properties and to produce special properties such as resistance to corrosion or heat. Specific effects of the addition of such elements are outlined below:

Carbon (C) is the most important constituent of steel. It raises tensile strength, hardness, and resistance to wear and abrasion. It lowers ductility, toughness and machinability.

Manganese (Mn) is a deoxidizer and degasifier and reacts with sulfur to improve forgeability. It increases tensile strength, hardness, hardenability and resistance to wear. It decreases tendency toward scaling and distortion. It increases the rate of carbon-penetration in carburizing.

Phosphorus (P) increases strength and hardness and improves machinability. However, it adds marked brittleness or cold-shortness to steel.

Sulfur (S) improves machinability in free-cutting steels, but without sufficient manganese it produces brittleness at red heat. It decreases weldability, impact toughness and ductility.

Silicon (Si) is a deoxidizer and degasifier. It increases tensile and yield strength, hardness, forgeability and magnetic permeability.

Chromium (Cr) increases tensile strength, hardness, hardenability, toughness, resistance to wear and abrasion, resistance to corrosion, and scaling at elevated temperatures.

Nickel (Ni) increases strength and hardness without sacrificing ductility and toughness. It also increases resistance to corrosion and scaling at elevated temperatures when introduced in suitable quantities in high-chromium (stainless) steels.

Molybdenum (Mo) increases strength, hardness, hardenability, and toughness, as well as creep resistance and strength at elevated temperatures. It improves machinability and resistance to corrosion and it intensifies the effects of other alloying elements. In hot-work steels and high speed steels, it increases red-hardness properties.

Tungsten (W) increases strength, wear resistance, hardness and toughness. Tungsten steels have superior hot-working and greater cutting efficiency at elevated temperatures.

Vanadium (V) increases strength, hardness, wear resistance and resistance to shock impact. It retards grain growth, permitting higher quenching temperatures. It also enhances the red-hardness properties of high-speed metal cutting tools.

Cobalt (Co) increases strength and hardness and permits higher quenching temperatures and increases the red hardness of high speed steel. It also intensifies the individual effects of other major elements in more complex steels.

Aluminum (Al) is a deoxidizer and degasifier. It retards grain growth and is used to control austenitic grain size. In nitriding steels it aids in producing a uniformly hard and strong nitrided case when used in amounts 1.00% -1.25%.

Titanium, Columbium, and Tantalum (Ti, Cb, Ta) are used as stabilizing elements in stainless steels. Each has a high affinity for carbon and forms carbides, which are uniformly dispersed throughout the steel.--Thus, localized precipitation of carbides at grain boundaries is prevented.

Lead (Pb) while not strictly an alloying element, is added to improve machining characteristics. It is almost completely insoluble in steel and minute lead particles, well dispersed, reduces friction where the cutting edge contacts the work. Addition of lead also improves chip-breaking formations.

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

President	Jerry Wolfe	941-355-5615	wolfeforge@hotmail.com
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Secretary	Jim Labolito	850-567-6464	fernforge@comcast.net
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Trustee SE	Ralph Nettles	561-747-5489	ralphnettles@msn.com
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Steve Bloom, Editor; P.O. Box 760; Archer, FL 32618; (352) 528-6508 or 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 _____

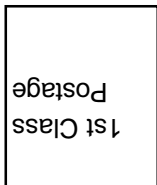
 City State Zip
 Phone: Home _____ Work: _____
 E-Mail _____
 Spouse's Name: _____

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 []



January 2010

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