



May 2011

# *The Florida* **Clinker Breaker**

Florida Artist Blacksmith Association - *Established May 18, 1985*

## Presidents Message – May 2011

*Jerry Wolfe*

May is always a FUN month. The snow birds have gone back north, you can get around a bit easier with less traffic, it's easier to get into restaurants, etc. The weather is still not TOO hot that it is miserable in the forge shop. So let's start making some things for our annual auction, it's not too early to start.

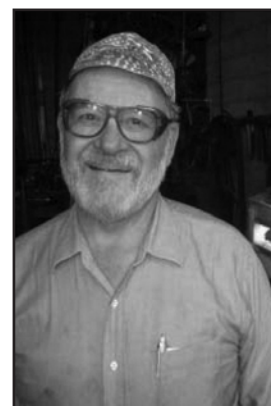
Our new members for this month are:

Christopher & Dawn Jones of Tallahassee; Paul & Elaine Chapman of Sarasota; Wesley & Kristy Haney of Ona and Tina & Rob Moorman of St Petersburg. Welcome to FABAA.

We have had two "statewide" meetings in April and both were well attended and enjoyed by many folks. Brian Brazael made a hammer and many other useful items at Trez Cole's forge & Kirk Sullen made an octopus at the Blountstown Pioneer Settlement.

The Madison SBA conference "group project" this year is a flower with each of the seven clubs making a petal for the flower. I hope by the time you read this we have many petals submitted to be the ONE going to Madison for the group project. Each region should have multiple entries.

FABAA is also responsible for organizing the gallery at Madison SBA; we have several volunteers, but need more. Please let me know if you are willing to volunteer a few hours to help with the gallery or the FABAA booth.



On April 30th a NOMMA meeting will be held at Arts Work Unlimited in Miami. Thanks to Art Ballard and Phil Heermance for inviting FABAA members to join them.

I continue to receive reports and hear that FABAA members are TEACHING others the blacksmith skills they know – THIS IS GREAT – Keep on doing it. Our membership is now at 230 and we continue to have new members each month; so let's keep the old members and continue to grow.

### **SPECIAL NOTICE**

Our Newsletter Editor has resigned for personal & health reasons.

If you can help with this VERY IMPORTANT part of our activities, please call me, Jerry Wolfe, at 941-702 -1719

Please send any articles or files to Jerry Wolf [wolfeforge@hotmail.com](mailto:wolfeforge@hotmail.com)

## 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 want to bring a bag lunch if not otherwise noted. If you have any questions about meetings, please contact the Regional Coordinators:

Northeast Region	Butch Patterson	904-964-2499	bpattr@yahoo.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southeast Region	Ralph Nettles	561-747-5489	ralphnettles@msn.com
Southwest Region	Lisa Ann Connor	813-977-3743	MelisandeAubrey@hotmail.com

### Future Events

#### NE MAY 7 Steve & Kimmy's Bloom's shop south of Archer:

Come and see:

- (1) a demonstration of Don Fogg's 55 gallon drum heat-treating forge in use for hamon generation (if we're lucky) and why normalization is a good idea.
- (2) the new variable speed knife grinder & other cool toys
- (3) a sand casting demo (if Allan Hardwicke brings his stuff)
- (4) and maybe buy some tools before they go to Madison—for sale will be:
  - 135 lb S5 anvil with anvil stand
  - Tinsmith stake
  - Portable coal forge
  - Portable anvil stand/tool bench/post vise
  - Shop coal forge (3'x3' with Centaur Forge cast pot)
  - ½ whiskey barrel slack tub with cypress lid
  - WWII era file machine
  - Beaucoup hammers and set tools
  - And whatever else I find hiding in the corners
- (5) and – of course – the usual chili and salad lunch—bring something to share if you feel inclined.

#### NW May 14 Jim & Nina Labolito's Fern Forge at 1314 Fernwood Road in Tallahassee, FL

From the intersection of Capital Circle NW and US 90 (Tennessee Street) go West one mile and turn left on Fernwood Road to 1314 Fernwood Road.

**SW Meeting Saturday, May 28th at Wolfe Forge.** Trez Cole will be presenting: "Hammers: Myth or Legend", a discussion of hammers and hammering methods, as well as applied ergonomics - i.e. "Hammering: The Real Story". He will then lead a review of the tools used to make the Brian Brazzal hammer with an open-forge for those wanting to make the tools necessary for making the hammer. You will need to bring 1" round spring-steel, 1045 or 1050 steel. A list of tooling will be provided.

**SE Meetings held at Tanah Keeta Boy Scout Camp in Jupiter FL unless otherwise noted.**

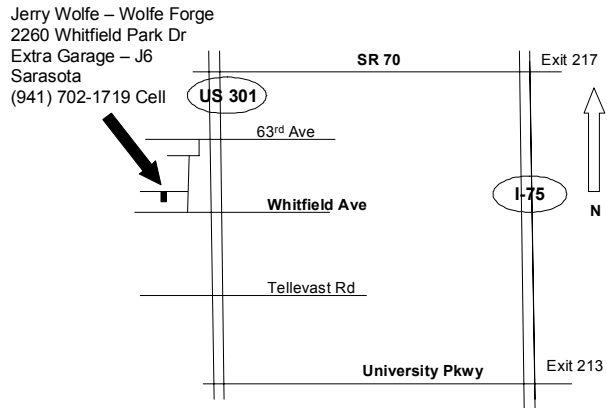
**GA SBA May 19th – 21st Conference in Madison, GA**

**NE June 4 Pioneer Arts Settlement, Barberville, FL.** Open Forges. Jim Robarr will demonstrate Die Forging to make a Mouse Key Chain. Jim will also discuss his "1-brick gas forge".

**NW June 11 Ken and Louise Burnes in Tallahassee with Rob Nichols demonstrating.**

**NW July 9 Bennie Prince's Farmer's Heritage Museum in Cairo, GA.** John Watson will be demonstrating.

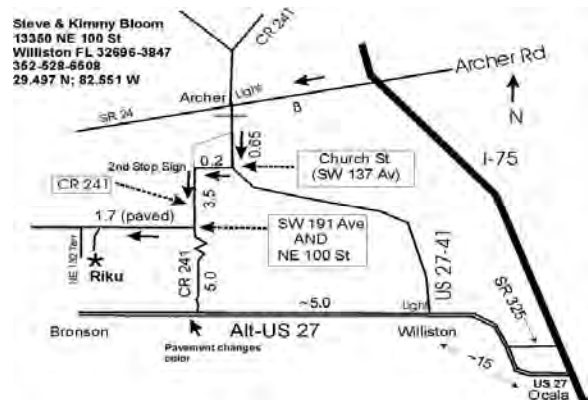
### SW Region



### SE Region



### NE Region



## MADISON SBA CONFERENCE

Please reserve May 19-20, 2011 for the conference in Madison.  
The demonstrators will be George Dixon and Chuck Patrick.

### Report from the Northwest

*By John Boy (Watson) & Billy (Christie)*

The Northwest FABA meeting was held on March 12, 2011, at Vi & Clyde Payton's Forge near beautiful Lloyd, Florida, south of Monticello. We were blessed with fellowship, weather, tailgaters, show & tell a yard sale, a wonderful demonstrator (Trenton Tye), and Clyde's Forge.

Trenton Tye, Master Smith, was the demonstrator who started with a ringing of two bells and Clyde giving a loud shout. Trent is a wonderful vocal & physical demonstrator. He started by giving a brief history of the modern day blacksmith. Repose is a French word meaning "to push away". To make a beautiful Nautilus Shell, Trent made a jig using a modified scroll that was about 12" in diameter, with welded in cross braces through the interior, which provides support in allowing the hammering out of the shell. He suggested using 18 gauge sheet metal, which is cut to the jig's size & shape, then tack welded to the form. Next he suggested using a rose bud to heat the sheet metal and a ball peen hammer to stretch and shape each cell of the Nautilus. Grind off the tack welds, and then finish the item to what ever end you desire.

Next he showed how to make a Lilly Pad using two different jigs. First the 18 gauge sheet metal is cut in the shape of a Lilly Pad and lines are drawn on the pad as a guide. The first jig is on a fixed post and is described as an offset "U" with one of the legs being about 1/2" taller than the other, with a spread of about 3/4". The second jig is also on a fixed post, which looks like a cut off with a rounded edge. With the first jig, the Lilly is guided (with the lines) and hammered between the legs of the jig to establish the vanes of the Lilly. Two or more passes are required to get the correct depth & appearance. When the vanes are completed he moved to his wood stump and finished the Lilly leaf cells.

Trent moved on to demonstrate a spoon made from 1/2" square stock, which was auctioned off by Clyde and sold for \$22. After which Trent concluded by demonstrating a guillotine tool that has a number of different uses, such as to fuller or cut off, there by eliminating the need for a third hand and providing better control of the steel.

The "Iron in the Hat" had all kinds of steel from buckets of bolts to RR spikes, toys to plants, plus hand forged items. Thanks to Lloyd Wheeler and everyone that helped make it happen. Think you one and all for bringing the items and a real thank you for the purchase of the tickets

Thanks to Vi and her great helpers for putting on another delicious feast for lunch. Thanks for the great covered dishes and deserts.

The Show & Tell table had a number of hand made items which were wonderful in design & appearance. The tailgaters were also strong with sales, trades and swaps. As we grazed like a heard of cows, back and forth finding those items we could not go home without.

We would like to thank Trent Tye, Aaron Peck, Clyde & Vi Payton for another fun filled, educational meeting.

### Report from the Southeast Region

*By Ed Aaron*

The Southeast Region participated in the Annual Pioneer Family Farmstead Day at Riverbend Park on March 26th. During the day we had John Struthers, Bill Kahl, Sarah McMurray, Tim and me there working in the forges. Visitors to the park walked around at their own pace. At times, we'd have 10 or more there to see what blacksmithing is all about. I would try to interact with the visitors by asking them if they had any questions and at times, show them what some of the tools would do. John Struthers displayed a large amount of his work and was constantly

working to give visitors something to observe.(see pictures) Bill, Tim and Sarah stayed busy also. This was a great opportunity to show the community what blacksmithing is all about. We also are working with the sawmillers club and the Park to get a smithy built so John doesn't have to provide a portable carport every time that we are there.

## **FABA NE Region April 2, 2011 Meeting**

*By Butch Patterson*

The weather at Barberville could not have been any better for our April 2 meeting. We had a little over 30 people in attendance including some new folks looking in to what FABA is all about. Bill & Karen Tarkington, Jerry & Heather, and Mark Wilcox were all very interested in the demos.

We had two demonstrations while others enjoyed the "open forge". Bill Taylor was forging and Bob Brown was teaching his children Casey & Zoey to forge some hooks.

I was demonstrating my "Bull Head Snake" from a railroad spike. First, I made two cuts along the sides of the spikes head to provide metal for the horns. Then I tapered and drew the shaft out to 20 inches. Next came rounding and bending the shaft to resemble a snake. The bull head was heated to pull the metal back so the horns could be forged. To finish the bull/snake nostrils, eyes, and some chiseled fur were added.

Jordan Thomas made his well known Courting Candle Holder using a 5 foot length of 1/4" round stock. First, he folded about 6" of the rod back onto itself and fire welded the end to the stock. After another heat, he twisted it to make a handle. To complete the handle, he used a hot cut to separate and open the remainder of the handle. Jordan forged a unique hollow heart. Then a small leaf was forged on the end opposite the handle. Jordan had an unusual looking jig – part scroll bender/part spiral winder. He put the jig base in the vise. He clamped the stock near the handle end to the scroll form and bent it cold. Then he added the winder handle to the jig. Now for the fun part! The trick is that the spiral requires continuous winding to get a consistent coil. The only way to wind it is to hold the handle and walk briskly around the vise. Around and around and...well, you get the idea. Once the spiral was complete, poor Jordan was dizzy, but he recovered quickly. And the courting candle holder turned out looking beautiful. Thanks Jordan!

The Buck-in-the-Bucket had some nice items and brought in \$95.

After that, we passed the hat around for the Pioneer Art Settlement and collected \$70. The Assistant Director, Gudrun Benson, was very appreciative.

Many thanks to Emily, my wife, for cooking our pasta lunch and thanks for those who brought salad and desserts! No one went away hungry!

### **NEXT NE MEETING:**

May 7 - Steve Bloom's IronFlower Forge in Archer, FL. Great chili will be served for lunch, so bring a covered dish to share. Steve will be demonstrating.

# Walt Anderson Scholarship Report

*By Will Manning*

## **Making a forging hammer from a caterpillar track pin**

I had a caterpillar track pin and a scholarship. I hoped to return with a forging hammer- made from junk yard steel. OR at least some knowledge to allow this to happen. Upon asking Dave Smucker, my professor for the week, what kind of steel he thought the track pin was, he said, "it's NTS, but it's good for a making a hammer." NTS= not too sure. Based on the pin's use in a caterpillar, it's probably made out of the same steel as bearings, 52100.

NTS steel gets a heat treatment test, get 3 pieces and quench one in oil, one in brine & one in air.

Though we touched on specific steels & their characteristics, the outline for basic classroom operations was this;

1. Forge
2. Normalize
3. Rough grind,
4. Heat treat
5. Final sharpening/finishing

I started by cutting off 3 discs, about 3/8" thick each. These will be my test pieces for finding the appropriate method for heat treating. I used a metal cutoff wheel and I believe it cost the folk school about an entire cutoff disc to achieve this. My follow up studying has led me to wonder why in the heck I didn't anneal the pin first... live and learn.

For anything that seems good to make a hammer out of (i.e., axel, jack hammer bits, track pins, etc.), if you are going to heat test, I'd recommend a proper annealing prior to your attempt to separate three different pieces. Heat it up to its critical temperature (non-magnetic) and slowly cool it in a good covering of vermiculite (available at nurseries). This should take about a day.

We tested the three pieces by starting with an air quench, if this works there's no reason to try an oil quench. However, we moved on to the oil as the file test proved "not hard" with the air hardening. The oil, however, worked. Dave uses used transmission oil with a bit of diesel fuel as thinner and recommends using no less than 5 gallons. We used a simple file test to determine "yes" or "no" to the question of "is it hard?"

The file test- after you have quenched your steel, try to file on it. If it skates across as though it's on ice, then you succeeded. If the teeth cut your steel, it's not hard yet.

Now we knew what to do for the heattreatment... time to decide on the type of hammer we'd like to make. We started with a 4" long piece of the track pin.

Forge to shape.

First using tongs to hold it vertically; we upset the entire piece of steel until it was 3".

We then welded on a piece of rebar to what would become the face of the hammer.

After the handle was on, I had a sure grip on the chunk of steel and proceeded to square it up. After I got it square, I took off the corners & drew out what would become the peen. Leave the peen fairly blunt. You can always thin it out further or grind it down some. It's a bit more difficult to undo that though.

After you have the rough shape achieved, punch the eye. We used a punch in the fly press that was made out of S7. It was a miniature hotdog shaped punch with a blunt face and a slight taper. It worked beautifully in 2 heats. Most of us don't have access to a fly press so, punch the eye hole by hand with a strong and accurate striker.

Once the eye hole is punched, it must be drifted to the right shape and size. Decide what would be best. I would, in the future, use a drift that matches what handles are readily available as I'm also still learning about handles.... At the folk school I went with a rectangular/oval drift that matched many other hammer eyes available for inspection. Make a mark on the drift at the point where the drift is the size you want the eye to be finally. Drift almost to the final size from one side, flip hammerhead and drift to final size. Flip again and drift to final size. The goal is to achieve an eye with a cross section of hourglass-shape so that you can insert a handle and use wedges to make it stay in place.

Once the hammerhead is to shape, let it cool down slowly- no need to anneal it again, but you don't want to quench it either. Cut the handle off with a cutoff wheel and grind to final shape using a belt sander or an angle grinder. The heat treatment...

I hardened and annealed the entire head. Slowly bring entire head to critical temperature and quench immediately in the oil/diesel fuel mix. Move your quench tub close to the forge. You want to quench the steel as the temperature is on its way up, so quick movement from the fire to quench tub is important. Move the hammerhead around and up & down in the quench tub to help it harden more evenly.

Dave Smucker recommends an hour in the oven for tempering most tools, however, with a hammer head, he said to leave it in there for two hours, due to its mass. We tempered every tool, all week long, at the same temperature of 400 degrees.

The hammer works. The next one will be a bit smaller. The piece of steel I started with was about 1/2 a pound to heavy for me in the end. The face, with rounded edges, was still a bit too wide and until I gain more control over this hammer, I'll do better to avoid corner marks by using a more rounded face hammer. The peen is perfect. With the weight of the head behind it, the peen really gets the job done. Like all tools, it has its purpose. Sometimes what I'm using it for is perfect and at other times it completely useless for what I need. The cheeks on this hammer are a bit wide- the part to the left and right of the eye. I'd consider forging those up, down and flat to make a Hofi-style hammer with a tighter center of gravity.



*Thank you, FABA, for sending me to the John C Campbell folk school. Though I never met him, I am thankful for Walt Anderson, the first volunteer editor of THIS newsletter and major contributor to the Blountstown Pioneer Settlement blacksmith shop (where I have seen the most inspiring blacksmithing demos). Thank you, group of blacksmithing mentors.*

## **Florida Artist Blacksmith Association Walt Anderson Scholarship**

This scholarship was established to honor the memory of Walt Anderson, one of our charter members. Its purpose is to further the craft of blacksmithing and is available to any FABA member in good standing. The award is limited to the actual cost or \$1000 whichever is lesser. It may be used for materials, tuition, lodging and transportation (paid at the rate of 43.2 cents per mile or the actual cost of public transportation, whichever is lesser).

A letter of application or a detailed email may be submitted provided the applicant answers the following questions:

1. What is your name, address and phone number?
2. How much experience in blacksmithing do you have?
3. How will this instruction help you with your blacksmithing craft?
4. What is the name of school you wish to attend?
5. What is the name of the course and the name of the instructor teaching the class?
6. What costs will be incurred (tuition, materials, lodging, transportation, etc.)?

Note: By accepting the Walt Anderson Scholarship the applicant agrees to provide a demonstration of skills learned and write a report of the learning experience, including “how-to” for publication in the Clinker Breaker. This next item not required but strongly suggested that an article made by the new knowledge be offered for auction at the Annual meeting.

Completed letters of application or emails should be sent to me:  
John Butler, Chair, FABA Scholarship Committee,  
777 Tyre Road, Havana, FL 32333  
or emailed to [jgbutler@sprintmail.com](mailto:jgbutler@sprintmail.com).

Deadline for receipt is June 15, 2011. Three finalists will be recommended to the Board. The decision of the Board will be final. The successful applicant will be notified.



# The Florida Clinker Breaker

FLORIDA ARTIST BLACKSMITH ASSOCIATION

**Dorothy H. Butler, Membership Records**

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Havana FL 32333

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## May 2011

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

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Treasurer	Dorothy H. Butler	850-539-5742	Treasurer@blacksmithing.org
Secretary	Jim Labolito	850-567-6464	fernforge@comcast.net
Program Chairman	Mark Stone	850-668-9527	markham62@comcast.net
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Trustee NW	Ron Childers	850-878-8537	Ron@munlaw.net
Trustee SE	Ralph Nettles	561-747-5489	ralphnettles@msn.com
Trustee SW	Lisa Ann Connor	813-977-3743	melisandeaubrey@hotmail.com

### FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, Inc.

Date \_\_\_\_\_ New \_\_\_\_\_ Renewal \_\_\_\_\_

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Signature \_\_\_\_\_

Your FABA membership begins when your application and membership fee is received. Membership is per family and lasts one year. Send \$25.00 fee and application to:

Dorothy Butler, FABA Treasurer  
777 Tyre Road  
Havana, FL 32333