

# November 2002

THANKS TO: STEVE BLOOM  
FOR PAGE 2, PATTY DRAPER  
FOR THE LABELS, AND TO  
ALL THOSE WHO HELPED.

## The Florida Clinker Breaker

FLORIDA ARTIST BLACKSMITH ASSOCIATION - AN AMERICAN ORGANIZATION.  
Established May 18, 1985

### President's Corner

President's Message - November 2002

by Bob Jacoby

First, big thanks to everyone who made the Annual Conference such a huge success! We had a great turnout, wonderful food, skillful demonstrators and a good time all around! The final numbers aren't in yet, but it looks like we turned a profit which allows us to offset the cost of our newsletter



This approach helps to keep our membership dues affordable. Speaking of memberships, think of giving a FABA membership special for a full 12 months!

Also, a quick reminder: The Southwest Region will host a statewide meeting on January 25th at Erik Flett's shop in Fort Myers. Both Meagan Crowley (Peters Valley Craft School) and Chris Winterstein (Penland School of Crafts) will be demonstrating. Erik's shop, Iron On The Edge Studio, is located at 2547 Katherine Street in Fort Myers and the meeting will probably get started around 9:00 AM. Hope to see everyone there!

The holidays are almost upon us! Happy Hammering.

# 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 listed below:

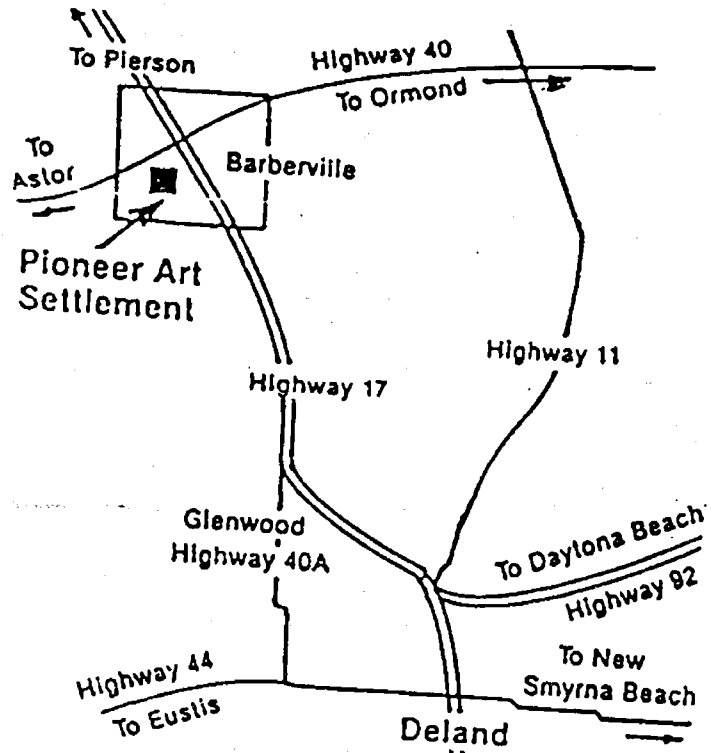
<b>Northeast Region:</b>	<b>Bob Mancuso</b>	<b>(386) 774-2926</b>	<b>rmancuso@cfl.rr.com</b>
<b>Northwest Region:</b>	<b>Dr. Ed Crane</b>	<b>(850) 893-3212</b>	<b>ncrane8364@aol.com</b>
	<b>Billie Christie</b>	<b>(850) 421-1386</b>	<b>chriswood@talweb.com</b>
<b>Southeast Region:</b>	<b>Richard Loughlin</b>	<b>(561) 287-2224</b>	<b>-unknown--</b>
<b>Southwest Region:</b>	<b>Erik Flett</b>	<b>(941) 437-3844</b>	<b>-unknown--</b>

## November 2002

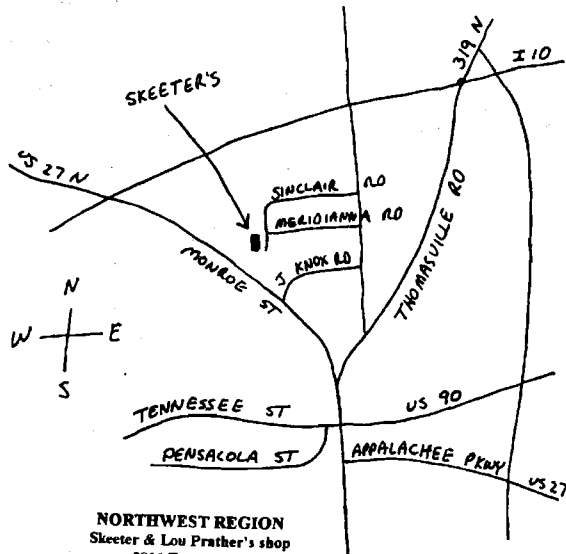
- NE Nov 2-3 Barberville: Country Jamboree
- NW Nov 09 Skeeter & Lou Prather's - Tallahassee
- SE Nov 16 Charlie & Evelyn Stemann - Lake Worth
- SW Nov 23 -- to be announced--

### Extended Forecast

- NE Dec 07 Allen Hardwick's shop
- NW Dec 14 Bill Robertson & Patty Draper's - Tallahassee
- SE Dec 21 YesterYear Village (X-mas Party)
- NE Jan 04 Pioneer Art Settlement - Barberville
- SE Jan 18 Matty & Irene Spinelli - Okeechobee
- SW Jan 25 Eric Flett - Fort Myers
- NE Feb 01 Juan & Linda Holbrook's Shop, Gainesville
- SE Feb 15 Yesteryear Village - Quarterly meeting
- NE Mar 01 Pioneer Art Settlement - Barberville
- NE Apr 05 Transportation, Tools, and Trades - Barberville
- NE May 03 Steve and Kimmie Bloom's Shop, Gainesville
- NE Jun 07 Pioneer Art Settlement - Barberville
- NE Jul 05 Pioneer Art Settlement - Barberville
- NE Aug 02 Pioneer Art Settlement - Barberville

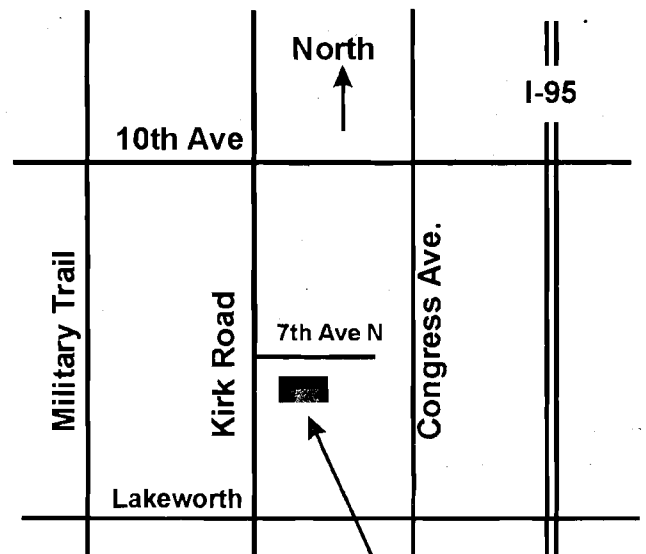


NE region : Nov 02



**NORTHWEST REGION**  
 Skeeter & Lou Prather's shop  
 2816 Terry Road  
 Tallahassee, Florida  
 904-386-9246

NW region : Nov 09

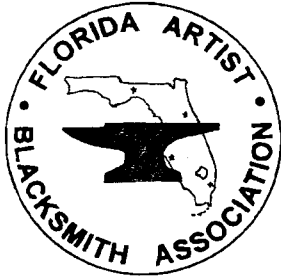


**Charlie Stemann - (561) 964-8834**  
 3984 7th Ave. N

SE region : Nov 16

**FLORIDA ARTIST BLACKSMITH ASSOCIATION, INC.**

777 Tyre Road, Havana, FL 32333 (850)539-5742



**What a great conference October 2002 has been!**

John and I would like to thank all of you who attended. We had people come as far away as Mississippi, North Carolina, South Carolina, Tennessee and Georgia to participate. There were great demonstrations by Clay Spencer, Ryan Johnson and Jerry Grice.

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The blacksmithing, bladesmithing and forging classes were filled with excited students that put great sweat equity in their projects. The nonforging classes seemed to go well too, as there were many smiles to go along with the precious hand made treasures of the day.

Many thanks to everyone that helped such as Steve Bloom, who put things on website for me and brought a forge set up for the conference itself. Jim Corbet brought in a station to, and he also gave me a ride on the motorcycle. Maggi Rubio and friends fed us very well. Skeeter helped set up the site with the help of Greg Ross and Jeff Mohr. Many hands helped to keep things going smooth.

The anvil shoot by our Tim Ryan held the rapt attention of all us. The anvil went up and came down with a joyous song. Our auction was a tremendous success. The items donated were incredible in talent and generosity. Tim helped us give FABA our money. We raised \$6292.00 in the auction. Our plain old buck-in-the-bucket raised \$696.00.

Thanks to Marilyn Breeze and all the staff at Pioneer Arts Settlement for putting up with us. We appreciate your humor and kindness to our group.

Our conference was a success because of the support of you, our members. Take care till next year and we'll do it one more time.

Dot Butler

**Past Presidents**

Willard Smith 1985-89  
Lewis Riggleman 1990-91  
Tico Rubio 1992-95  
Ray Roberts 1996-97  
Clyde Payton 1998-99  
Patty Draper 2000-01

## SE NEWS

The SE chapter had their meeting of 9-21-2002 hosted at the home of Greg Ross. He is one of the premiere local knife makers. The meeting was well attended and included: Debbora Docsa, John O''brian, Joan Struthers, Ray Reynolds, Matty and Irene Spinelli, Sarah McMurray, Frank Hecker, Eugene Whitaker, Reagan Sims, and Saul Diaz observing.

Greg had his forge going full blast when I got there and his little giant running. He says the clutch of the little giant "fixed its self" but I think it had some help. John used the forge and little giant to start forming a very large bowie from a lawn mower blade. He came back to the forge later and pounded out some hooks with twists and "curleyques", while a group of us stood with heads nodding knowingly.

Sarah had her farrier truck backed up to Greg''s garage with her forge glowing it''s usual cheerful red making, of all things, horseshoes. As she formed the shoes she explained to the group around her truck that this type were called bar shoes and the extra bar gives support to the horse''s foot.

Greg went back to his forge and did his magic with cable. As he was heating up the cable he illustrated the sound that properly welded cable should make by dropping one piece on the concrete and striking another suspended on a string. In both cases the steel rang like a bell. Great sound! We kept a steady stream of questions about cable welding but his usual reply was that it was easy, just heat it up, sprinkle on borax, heat again and strike it firmly and quickly. Easy for you to say Greg! For good measure he also welded up some plate that he had wired together.

Greg kept the coffee and ice water flowing and supplied home made brownies and there were some donuts fresh from a new Krispe Kreme shop in West Palm Beach supplied by a non-cook (me). In short a great time was had by everyone there learning, trading tips, tricks and stories in the shade of Greg''s yard.  
Lynn Emrich

**NW Meeting for November 9, 2002** will be held at Skeeter & Lou Prather's home and shop located at 2816 Terry Rd. in Tallahassee. Lunch will be provided. Remember to bring your "Iron In The Hat" items. Dr. Ed Crane will demonstrate his pine cone, pine needles and pine branch. Rex Anderson will also be demonstrating. November will be a great meeting. Hope to see you there.

P.S. We are going to have our Christmas Party/Meeting on December 14, 2002 at Bill Robertson & Patty Draper's "Applecross Forge" from 3:00 PM until 9:00 PM.

HO! HO! HO!

Begin making your plans to be there.

## Conference 2002 by Bob Mancuso

The conference is over for this year and was a success thanks to Dot Butler and her entire crew. Many items were bought and sold or traded at the tailgate sale. Everyone seemed to have a good time. As usual shooting the anvil was done by Tim Ryan. While those who have seen this before enjoyed it the best part was watching the faces of the members who had never seen it before. It was great, thanks Tim. Because Maggie was in charge of food this year it was wonderful. If anyone went away hungry it was their own fault. As usual Maggie put out a buffet that was outstanding. A special thanks to Maggie and her crew for all the hard work both before the conference (in preparing and gathering supplies) and on the weekend for all the work in cooking, setting up and feeding us. Everyone appreciated the effort put forth by the demonstrators and the instructors. Saturday evening saw many of us in the main building for the auction. With Tim Ryan as the auctioneer the donated items were sold to willing customers. Those who made donations are the ones who made it possible to have this auction and raise needed funds for FABA. With the conference over many people are already looking forward to October 2003 and the next conference.

Here is a long heads up for the January meeting from Erik Flett. We'll put the map in the January CB

**The S. W. Region** is looking forward to hosting, the FABAs quarterly meeting , January 25<sup>th</sup> 2003 at Erik Flett's, "Iron on the Edge Studio "located at 2547 Katherine St., Fort Myers. Fl. 33901. phone: 239-437-3844 or cell 239-872-7841. (see map attached )

The guest Artist Demonstration will be Meagan Crowley, who is currently the head coordinator of the Blacksmithing Department at Peters Valley Craft School, in New Jersey. Meagan is bringing to us new innovative techniques of forging hollow pipe and organic sheet metal forms. Meagan's education includes a BPA from the University of the Arts in Philadelphia, and a M7FA in Metal smithing from the Cranbrook Academy of Arts in Michigan. She recently demonstrated at ABANA International Blacksmith Conference, 2002.

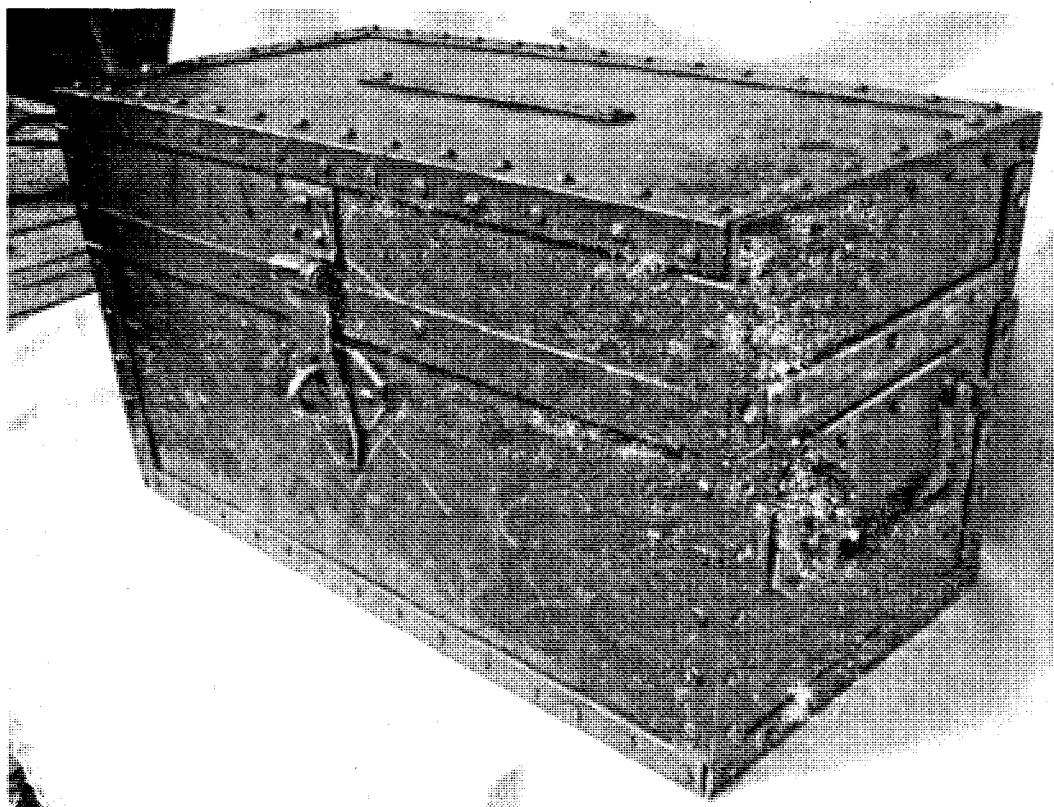
Chris Winterstein is head coordinator of the Blacksmithing Department at Penland School of Crafts in North Carolina. His current work, in iron is focused on working aggressively with mass ornamental forging of which moves in the three dimension. Chris worked and studied with Jim Wallace at the National Ornamental Metal Museum. He has also worked with Scott Lankton and John Medwedeff.

We are privileged to have these two outstanding creative educators at our meeting, demonstrating together. ADDED BONUS!! A new glass studio is in progress, at this time, with-in the Iron on the Edge Studio". If time permits, we hope to have a glass blowing demonstration.

I am excited for the awesome possibilities we have in bringing new high-energy techniques of forging to our area.

An old fashion BBQ is planned. We look forward to seeing you., If you have any questions, feel free to call Erik Flett at IRON on the EDGE STUDIO.

Here is pics of the auction project of the northwest region. A strongbox. JB



Barberville

On Friday to Barberville I went  
A really good time to be spent

There was broom-making, wool into thread  
Also two copper classes to be had

There was glass art for all to see  
And the anvil shot above the tree

There were Blacksmith classes too  
But to deciding which one to do

There were plenty of demos that I saw  
But the "mokame" held me in awe

There were plenty of tailgate sales  
As well as lots of Blacksmith tales

There was food for all to eat  
Old friends and new ones to meet

The old school building was quite a sight  
Its where the auction was held Sat. night

At all the classes & demos I observed  
There was a tale to be heard

Sunday time was taken to meditate & pray  
Even though it was a short day

I'm sure I've left out a thing or two  
This was my first conference, its still new

I'm letting you know what a good time I had  
And joining FABA has made me glad

Esther Gurr  
Oct. 11 -13 Year 2002

Welcome New Members

Mary & Ron Kiefer  
1305 Savannah Drive  
Panama City, FL 32405  
850-271-8683  
[kkprec2@bellsouth.net](mailto:kkprec2@bellsouth.net)

Maurice & Bess Ellis  
RR1 Box 1442  
Belgrade, MO 62622-9709  
573-766-5346  
[mbellis@misn.com](mailto:mbellis@misn.com)

Kenneth "Aaron" Stern  
3202 W. Fielder St.  
Tampa, FL 33611  
813-558-8280  
[guinar\\_goldblade@hotmail.com](mailto:guinar_goldblade@hotmail.com)

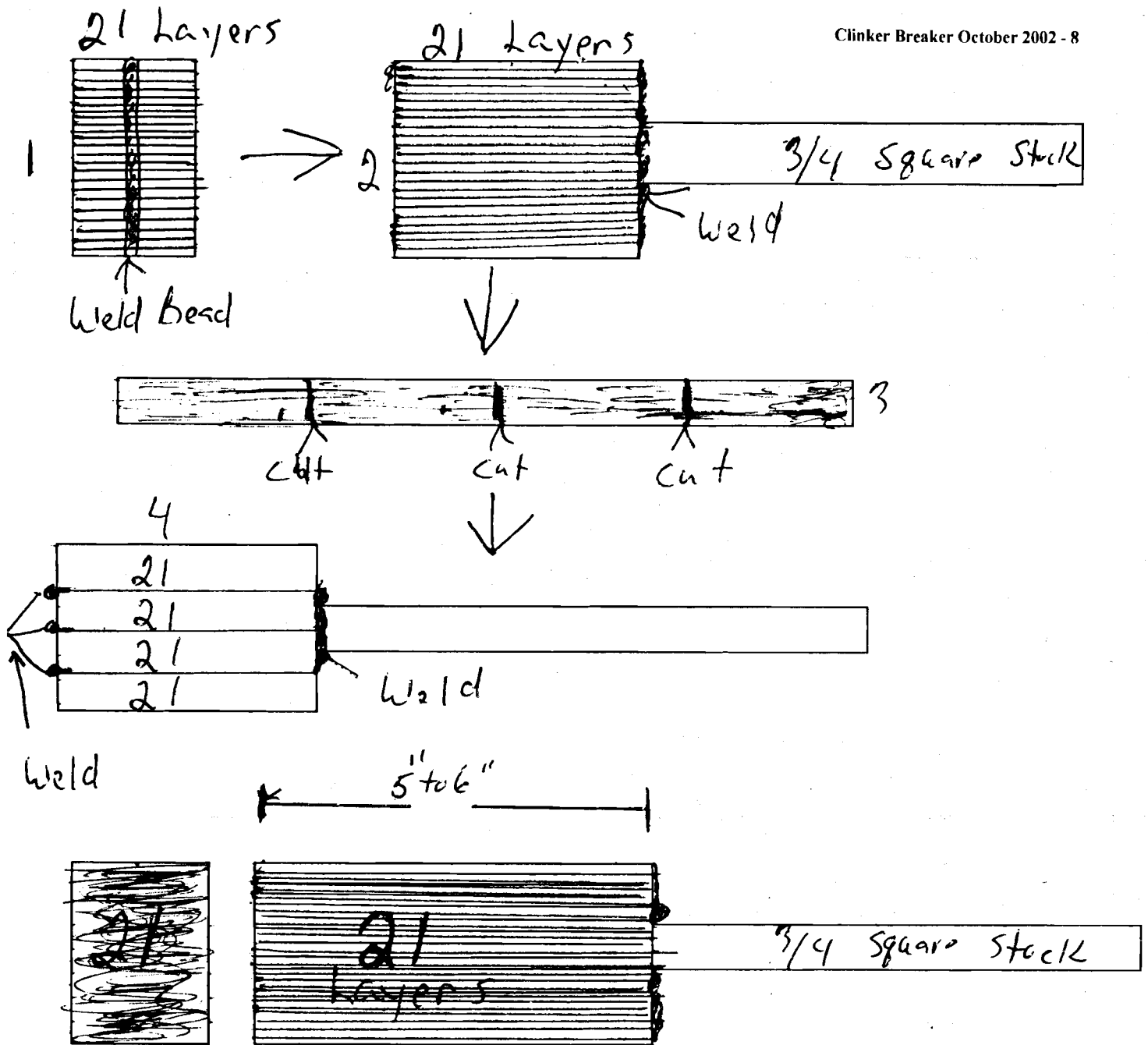
**ANVIL REPAIR**

BTW Bob Seward tells me  
that there were some  
discrepancies on the last anvil  
repair article. For one thing  
the welding rod should be  
MG-710 and not  
MS\_710. He'll respond to  
your specific questions at  
308-995-8019 73109 R Rd,  
Holdrege, NE 68949

## Damascus Billet Twisted

By  
Billybob Sowell

This is how I make a twisted Damascus billet. First I saw up pieces for billet using 1"x1/8" 1084 and 1"x.49ths" 15n20 into 5 to 6 inch pieces. And stack starting with 1084 and ending with 1084 till you have 21 layers. Layer of 1084 and layer of 15n20 ect.21 layers is a good place for me to start. Keep the thicker 1084 steel to the outside because it will not cool as fast as the thinner 15n20 when making first weld. After stacking I mig weld both ends of billet, just run a bead down both ends so it will stay together, then using anything for a handle as long as it will hold billet up during the forging, I weld the handle to one end of billet. I use 3/4" square stock, because it makes it easier to hold in vise when grinding. We are ready for the forge. I use gas forge, to be honest I don't know if I know how to forge weld in coal but I am sure most of you can do it. Gas is fast, easy, and clean. Start bring billet up to welding temp, when it shows color flux. Also I pre-heat my dies on the hydraulic press. I use a press, a power hammer will work also, and with this many layers to start off with, and it would not be a good idea to do by hand with hammer and anvil I don't think. When billet get to welding temperature some where around 2250 to 2350 (I use a pyrometer), I make my first weld, I just give it a light squeeze with the press, when I have it solid I start to draw it out trying to keep it even and straight. When billet staring losing color I brush, re-flux and bring back up to heat. Then draw it out till it is some where between 12 and 16 inches long, 1 1/2" to 2" wide and about 1/2" thick. Now put the billet in post vise by the handle. (This is why I try to use 3/4" square stock, it hold the billet while you grind off scale) let it cool off if you want to, then grind off all scale on all sides. So what we have now is a billet of 21 layers that is 12 to 16 inches long. Now cut the billet into 3 or 4 even pieces, and stack, weld ends, weld handle back on, and weld again just like you did at first. Keep drawing out and grinding, stacking, and welding till you have the layer count you want. (For random pattern you can go as high as u like) I use 175 to 225 layers for a twisted billet. When I have my layer count, bring back up to welding heat and I draw the billet out trying to keep it square till I get it 3/4" to 1" then I round the corners so it is now round billet. Now the fun begins bring billet up to welding heat (always work layers at welding heat) brush all scale off and during whole time you are twisting try to keep it as clean as you can. Put billet in post vise with about 1 inch of tip first, put a twisting wrench on the handle (again the square stock for a handle) and start twisting, and twisting till billet starts to lose color, the more twist u have the tighter the pattern will be. If it twist more in one place than another try heating just the part that needs twisting. I twist till it looks like a rubber band, usually about 3 heats. Now just re-heat, brush, and flatten till billet is about as thick as you want it. Remember to leave enough for grinding off scale if u want to use as stock removing, or leave it on handle, flatten it to about 1/2" to 1/4" and forge a blade as you would any other Damascus. I hope this will help someone. There are many ways to do this; just is how I do it. And if I can help just ask me. Also Sheffield Knifemakers Supply 1-800-874-7007 has 1084 and 15n20. Their prices are about as good as any.



depends on what width stock used

1. cut 1084 + 15 N'20 to 5" to 6" strips. stacking and Mig Weld ends
2. Weld a handle on.
3. Cut into 3 or 4 even Pieces.
4. Re stack, Re handle

## New Jersey Blacksmiths Newsletter

### Ring Roll

by Art Miller, Riverside, California

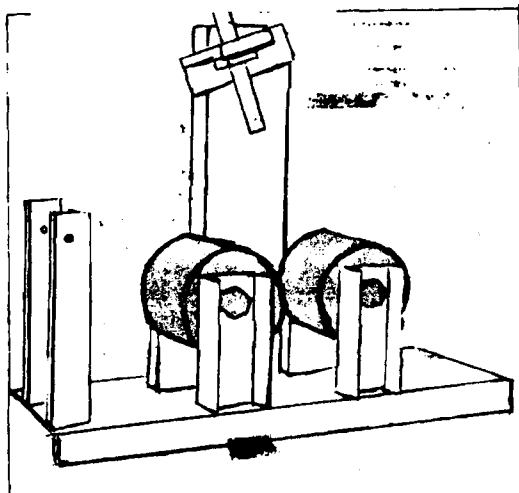
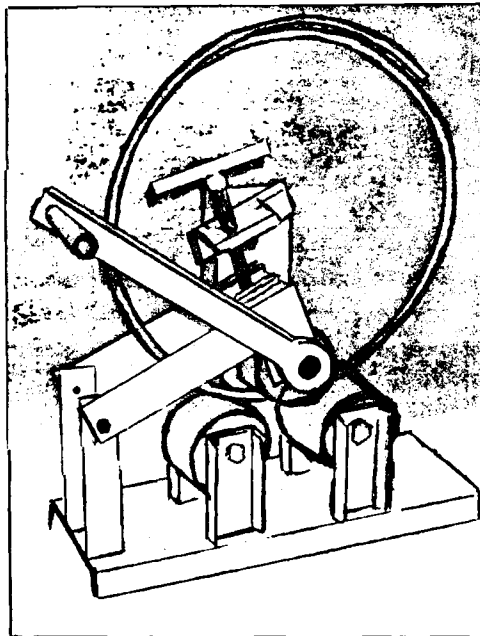
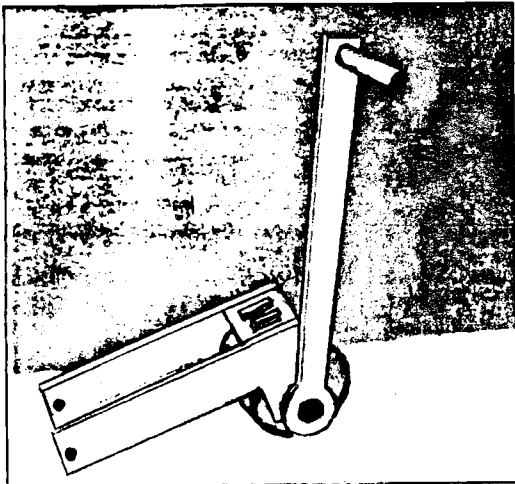
In the need for a ring roller I copied and scaled down a ring roller used in a fabrication shop. It's made from miscellaneous cutoffs and was fabricated with a cutting torch, a cutoff saw, drill press, hand grinder and an arc welder.

The fixed roller and crank assembly is removable from the base to allow installation and removal of welded rings.

The 2 1/2" wide rollers are made from Sch. 40 pipe (3 1/2 O.D.) with 1/4" plate end caps.

3/8" bolts are used for axles. The fixed roll has a 3/4" diameter shaft with the fixed roll pinned through this shaft with a 1/4" diameter rod which is brazed to the pipe roll O.D.

Tip: The roller will not bend the ends of the materials. The length of the straight section will depend on your roller spacing. Mine leaves a little less than 2" straight on each end. So I calculate the ring material length ( $C = \text{Pi} \times \text{mean diameter}$ ) and add 4". Cut stock and prick punch 2" from end of stock. Lay out ring length and prick punch at other end of material. Roll ring and cut off at punch marks.



### FABA Officers

President	Bob Jacoby	(904) 260-9981	jacoby@fdn.com
Vice President	Bill Robertson	(850) 668-2876	applecrossforge@nettally.com
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Past President	Patty Draper	(850) 668-2876	applecrossforge@nettally.com
Trustee #1	Joel Clark	(904) 321-2116	jac@net-magic.net
Trustee #2	John Butler	(850) 539-5742	jgbutler@sprintmail.com

### FABA MEMBERSHIP APPLICATION

Florida Artist Blacksmith Association, 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 \$20.00 to

Dena Bagett, FABA Treasurer  
6840 Bird Song Trail  
Tallahassee, Fl 32309

Make check out to FABA. Your FABA membership begins when we receive your payment and lasts one year. Membership is for a family. You don't have to be an ABANA member to join FABA, but many FABA members are, and we encourage membership in both organizations. See our web site for details.

*the florida* **Clinker Breaker**  
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 407-847-6900 day or [Insreprice@hotmail.com](mailto:Insreprice@hotmail.com)  
<http://www.blacksmithing.org>



## November 2002

Clyde & Vi Payton [4/2003]  
 250 Payton Road  
 Monticello, FL 32344-7002

Check your membership expiration date, get your dues in on time please !

The Florida Artist Blacksmith Association(FABA) - Chapter of Artist Blacksmith Association of North America, Inc., 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.

