

August 2009

The Florida

Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

FABA Election

Nominations for FABA Board are:

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

PHILIP SIMMONS; Master Blacksmith

(1912 - 2009)

It is with deep sorrow that we announce that Philip Simmons, America's premier blacksmith, died on June 22, 2009, at Bishop Gadsden Retirement Community. Philip moved to Bishop Gadsden in the spring of 2008 and lived comfortably surrounded by a caring nursing staff and many friends and family. Philip died peacefully. He was 97

Born on June 9, 1912, on Daniel Island, South Carolina, Philip was reared by his grandparents. At age 8 he was sent to Charleston via ferry to live with his mother on Vernon Street. He was enrolled in the first class at Buist Elementary School (now Buist Academy). While walking to and from school, young Philip noticed the ironwork and became intrigued with it. The neighborhood was a Mecca for craftsmen who serviced the waterfront businesses. He began visiting the blacksmith shops, pipe fitters, shipwrights, coopers, and other craftsmen in the area. However, the sounds of the blacksmith shops interested him the most.

Philip Simmons apprenticed under the blacksmith Peter Simmons (no relation), who ran a busy shop at the foot of Calhoun Street. Here, Philip acquired the values and refined the talents that would sustain him throughout his long metalworking career.

Moving into the specialized field of ornamental iron beginning in 1938, Simmons fashioned more than five hundred decorative pieces of ornamental wrought iron: gates, fences, balconies, and window grills. The City of Charleston, from one end to

the other, is truly decorated by his hand.

In 1982, the National Endowment for the Arts awarded him its National Heritage Fellowship, the highest honor that the United States can bestow on a traditional artist. This recognition was followed by a similar award from the South Carolina State Legislature. Simmons was inducted into the South Carolina Hall of Fame in Myrtle Beach, SC, on January 31, 1994. The Order of the Palmetto, the highest award given in the state, was presented to him by Governor David Beasley in 1998. In May of 2001, Philip Simmons received the Elizabeth O'Neill Verner Governor's Award for Lifetime Achievement in the Arts.

Pieces of his work have been acquired by the National Museum of American History as well as the National Museum of African American History and Culture, the Smithsonian Institution, the Museum of International Folk Art in Santa Fe, NM, and the South Carolina State Museum, Columbia, SC.

In 1989, the vestry and congregation of his church (St. John's Reformed Episcopal Church, 91 Anson Street in downtown Charleston) dedicated the grounds of the church to develop a commemorative landscaped garden as a tribute to his exceptional mastery of wrought iron and in recognition of his inspirational character and self-assurance.

Philip is survived by Lillian Gilliam, daughter; Philip Simmons, Jr., son; Rebecca Comings, sister; 16 grandchildren; 17 great and 23 great, great grandchildren, plus many nieces and nephews.

The celebration for Mr. Simmons' life among us will be announced tomorrow. The burial service will be private. Memorial donations may be sent to the Philip Simmons Foundation, Inc, P.O. Box 21585, Charleston, SC 29413-1585, or The Philip Simmons Home and Workshop Fund, Coastal Community Foundation, 90 Mary St., Charleston, SC 29403. (Charleston, SC June 22, 2009)

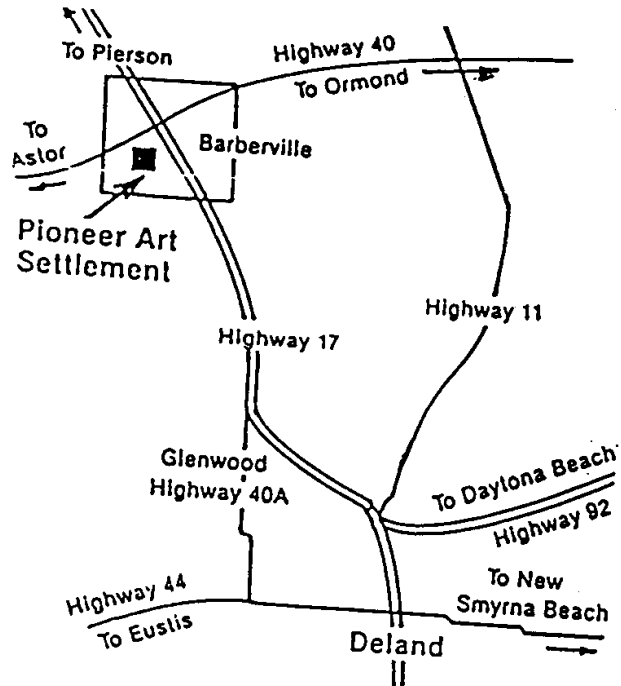
Upcoming Events

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:

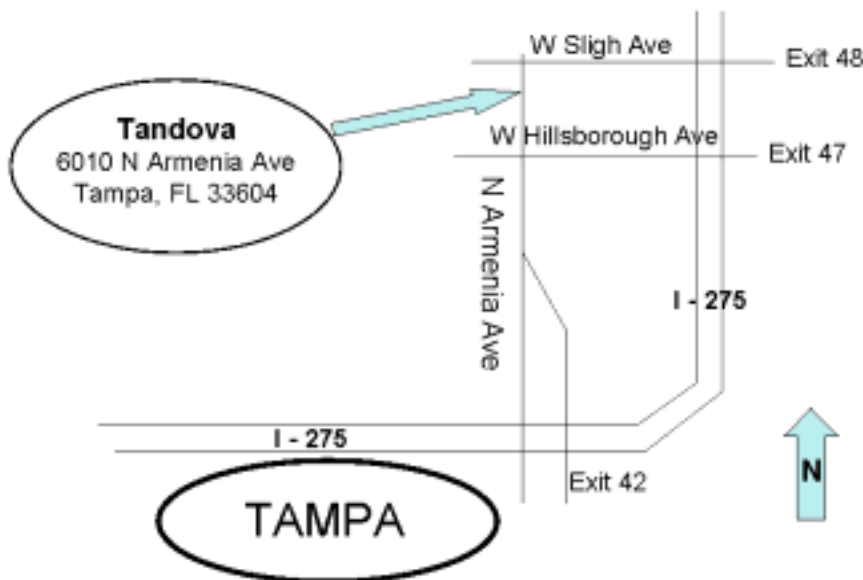
Northeast Region	Mitch Widham	386-673-0174	mwidham@cfl.rr.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southwest Region	Jerry Wolfe	941-355-5615	wolfeforge@hotmail.com
Southwest Region	--needs a volunteer - what about you?		

August 2009

- NE 01** Barberville - Steve Estenson demonstrating traditional blacksmithing techniques
- NW 08** Marty and Pat's, Shimansky Specialty Machining, Inc., 4972-B Woodville Hwy. (You have to turn onto Marpan Lane in order to get to the machine shop.) I can't wait to see the waterjet cutter.
- NE 15-16** Barberville Outdoor Extravaganza featuring, hunting, archery, black powder, hiking, canoeing and much more
- SE 15** Until further notice-Tanah Keeta
- SW 22** Tandova, Inc.; 6010 N. Armenia Avenue, Tampa (se pg.3 for details)



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.

Current Events

SW Aug 22 -Demo by John Perry showing his amazing armor. John has travelled the Renaissance Faire circuit for years as a full-contact joustier! He makes and sells armor for re-enactment organizations, joustiers, and museums throughout the world. John was the demonstrator at the



May meeting showing repousse - this is his other "hat". Also Greg Ecenia will show his welded sculpture dinosaurs and Lash Oberst will show his roller-table for cutting the tanks.

Meeting organized by Lisa Anne Conner - phone 813-505-8041. 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.

Future Events

NE Sep 05 Jordan Thomas, demonstrating courting candles
NW Sep 12 Charles and Nellie Pate's, Hippie's Forge, 5691 Highway 19 and 27, Lamont, FL

Report from the NorthEast Independence Day Celebration Mitchell Widham

The 4th of July at Barberville was a wonderful celebration of our heritage and our Nations Independence from tyranny. It was nice to be able to share the holiday with people that respect what this country stands for and understand and appreciate our history, and are actively involved in preserving that history for others.

Professional well driller and (part-time story teller) Allen Hardwicke, showed the group the finer points (get it) of drill bit sharpening. Allen used a large bench grinder and several machinists drill gauges (59 degrees) to demonstrate the proper technique, you could tell that he's been doing it a long time as he made it look so simple. Allen also showed how to hand sharpen, paddle and auger bits with a file. With the knowledge I learned, I won't be throwing so many old bit into the trash and running to the hardware store as

often. Thanks Allen, for this outstanding demonstration and sharing your expertise with the group.

I can't speak for the other regions but we have some real characters that come to our meeting every month, half the time I can't tell if they are pulling my leg or telling the truth, but I always go home knowing more than when I went, not that I would repeat some of it in pleasant company. Even if you're not that interested in blacksmithing or are unable to do it anymore, the camaraderie and fellowship at our meetings is an experience in itself that is worth the trip. I can't express enough how much I appreciate all of the knowledge and experience that is shared with newcomers such as myself and the willingness of members to pitch in and help the organization. You folks are great, and boy o boy, some of you guys can spin a yarn.

Of course, Bob Mancuso ran the Buck in the Bucket as usual for the 30 members present, after which we moved over to the main pavilion to share a 4th of July picnic with the folk musicians that also meet on the first Saturday and the friends of the Pioneer Arts Settlement. This was a pot luck affair, with everyone bring something to share, of course there was way more food than we could all eat, but we gave it our best shot.

Some of the upcoming events for our gang to keep in mind are: Sept 5th, Jordan Thomas, demonstrating courting candles at Barberville; and in Oct the FAB A Annual conference to be held at the Settlement

Report from the Northwest John Watson & Billy Christie

On June 13th we all gathered at Edgar and Gene Chatten's Forge for a wonderful day of blacksmithing, along with a demonstration by Edgar. He started out the day talking about hawks and then proceeded into the demonstration. He began by first demonstrating how to drift the eye, to get different designs for different uses. As he continued, he walked everyone through truing the head and closing the drifted hole. He then forge welded the blade stock into the base stock. He continued working the pieces to form the tomahawk.

There were some great items in the "Iron In The Hat" drawing, thanks everyone. We made \$178.00. Thanks to Taylor Stone for drawing the winning tickets.

John Watson (Chef John?) was busy all day using his great custom smoker. He cooked sausage for breakfast (with coffee made over an open fire), and cooked scrumptious BBQ chicken for lunch with all the trimmings. Add that to the tasty covered dishes & desserts prepared by Gene and her helpers and it made the hot afternoon bearable. No one went away hungry.

After lunch Nathan Nettles forged out a RR spike into a tomahawk using Edgar's custom horizontal hydraulic press

(assisted by Ron Childers).

Things were still going strong when I had to leave; we do thank the Chattin's for having us and sharing with each of us his knowledge and skilled talent.

Report from the Southwest

Jerry Wolfe

The June 27th meeting had a great attendance of 26 to see Mike Willman demo of knife making. The following various steps were explained and demonstrated:

1. Rough forging of W-1 Steel
2. Fine forging including making handle and slitting
3. Anneal - Heat and cool in vermiculite
4. Rough shaping with grinder and file



5. Coat with Satanite refractory mortar to create "Hamons" during heat treatment - clay coated areas cool slower and create different structure.
6. Heat to "non magnetic" temperature
7. Quench vertical in water.
8. Temper to blue on back and straw on blade edge with torch



9. Use abrasives, power and manual to final shape.



10. Polish to fine finish
11. Reveal hamons with weak acid.

A very special thanks to Mike Willman (yes, He's only 18) for an excellent demo and teaching us all a little about "Japanese" knife heat treatment techniques.

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.

FOR SALE: Tools & Equipment

- Anvils - from 250 lbs to 85 lbs.
New condition - mounted and unmounted
- Post Vises - from 6" jaws to 3" jaws
Excellent condition - mounted & unmounted
- Various handtools

Clyde Payton; Home/shop 850-997-3627; Cell 850-210-5177

ANNOUNCEMENT

Come join us for Fun, Fellowship, and 'Freshments – My darling bride, Vi, and I will be celebrating our Golden Wedding Anniversary on Saturday, August 29th, 2009, from 3:00 pm to 5:00 pm. This event will take place at the First Baptist Church of Lloyd, Lloyd, Florida. So, come help us celebrate our 50 years of marriage bliss! Your love and friendship is a treasured gift and we request no other. For more information call us at 850-997-3627. Mildred Venira (Vi) Cheeks Payton & William Clyde Payton, Sr.



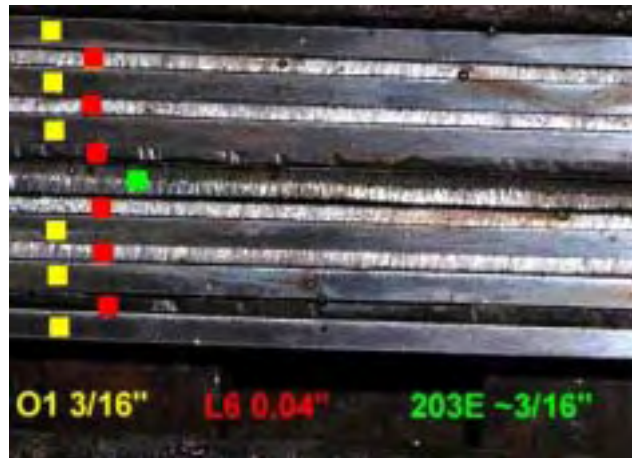
What is it - see pg.9 for the answer

Damascus Workshop

Steve Bloom

Well--I warned you --if you don't send in what you've been doing, you'll have to put up with what I've been doing. This month, it's a workshop with two FABAs members (Gary Kemp & Matt McKenzie) to make Damascus and use the material to build full-tang blades.

We started by assembling the people and the materials. We



started at 09:00 on Saturday morning (the 13th). The billet was composed of three steels (as shown) and measured 1" x 6" x approximately 1.5". The thirteen layers were clamped in a vise, arc-welded into a block and had a handle attached.



Waiting for the right heat

We made two stacks and the participants took turns at the forge and power hammer. The first step (and the easiest) is waiting for the billet to get up to temperature. We used Borax flux (straight from the box). To prevent excessive garbage (scale) from forming during the initial run-up, the billet is allowed to get to a low red heat, then fluxed. Of course, the layers do not uniformly heat, so this process is repeated as each successive layer reaches a dull red. The billet is lightly hammered each time to control heat expansion and separation of the layers.

When the billet appears to be uniformly hot and flux runs freely on the surface (light welding goggles makes this relatively easy to observe and also eases the strain on the eyes), the initial weld was made on the power hammer.



Ready for the 1st weld

Blows are light at first, then heavier. Because of flux spatter, we were wearing either cotton shirts and/or welding leathers. Given that this was mid-June in Florida at ~90 degrees F and 80%+ humidity, there was a modicum of sweating going on.

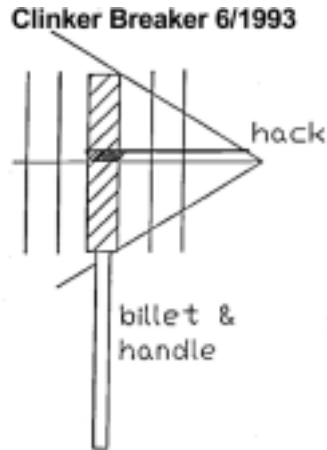
There are three schools of thought on the weld and fold process: (1) use shim stock, make a weld, and you are done; (2) use heavier stock, weld and drive out into a long bar, cut into several segments (cool and band saw or just use a chop saw), restack and arc weld; and (3) use heavier stock, weld, forge to approximately twice as long, cut partially through at



Gary forging out the billet to 2x the length

the center point, and fold. For the last two, repeat until you get the number of layers you want. We followed the third path.

After the first weld, we ran what I call the 'Damascus Dance'. The layout in my shop (relative to the center of the work area) is the 50 lb Little Giant to the north, the forge to the northwest, the swage blocks and short post vise to the south, the usual post vise to the east, and the anvils (and flux box) to the northeast. When the billet had been forged down to approximately 1" x 12", we located the center of the billet using a triangular layout plate (which lives to the right of the hammer). The plate has a center line, a set of parallel lines perpendicular to the center line, and a pair of lines set at the same angle to the center line (see picture above). The billet is positioned parallel to the parallel lines and touching the angled lines at the billet's top and bottom. The center line then defines the center position. We then drew a soapstone line at that point or just positioned the hack on it.



Once the center was located, a hack was used to almost cut through the billet. We only cut all the way through once. The smith then whirls around to the south, talks a couple of steps to the swage block area and locks the billet (hacked surface down) in the short vise. He then picks up the side-grinder laying there (and trying not to lay the hot tongs on the electric cord). The scale is then buzzed off and the billet given a slight crown. This removes any trash in the potential weld area and sets up the geometry such that the flux will squeeze



Buzzing off the billet

out and carry off anything remaining in the weld zone (thanks to Ronnie Fowler for this idea).

The billet then is moved to the main vise (a half step away to the left) and bent through at least 90 degrees.



Typically, the handle will have fallen off (if not on the first or second weld, it will be gone by the third weld), so tongs may be in use to hold the billet. If so, the upper limb of the billet is held in the tongs, leaving the lower weld surface open. The billet then is positioned over the flux box (a .50 ammo box) and flux is spooned onto the lower weld surface. If needed, another set of tongs that can hold the doubled billet is used.



It is then moved to the anvil (another half step) and closed to a 30..45 degrees angle with a hand hammer. If the ends don't align left to right or the center cut wasn't quite in the right place, a bit of adjustment can be done at this time.



The unit is then finally closed on the hammer



and shoved back into the forge.

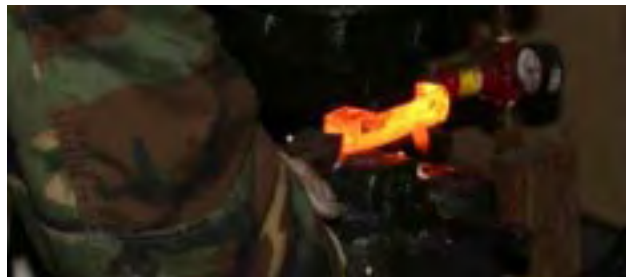


The whole process takes about a minute.

The welding process on the fold billet consists of (you guessed it - wait for it to get hot again). To prevent trapping material in the weld, position the open end towards you and start the weld on the folded end.



Start with light blows to close the weld. If using tongs, it might be necessary to flip the billet around, reflux, reheat and complete the weld.



To get a better idea of what the process really looks like, check out the next two pictures -- why flux splatter is to be expected!



After the last weld (we stopped at 208 layers or 5 welds including the welding of the initial layers), the billet was worked over with a specialized tool, the "Dolly Parton".



The tool consists of two 1/2" diameter ball bearings welded to a paddle. Both surfaces are dimpled when the billet is approximately 1/2" to 3/4" thick. The billet is then hammered to 1/4" to 3/16" thick and approximately 1" wide.



The result is what is known as "shadow" patterns (in this case concentric circles) as shown here in Gary's blade.

The billets resulted in approximately 24" to 30" of knife stock (yup- I didn't measure them). Approximately 5 to 7" of



material was cut off and forged into blades. Both Gary and Matt worked against a pattern I happened to have lying around. The blades were then rough ground (Gary's is shown here) and pin holes drilled in the tang. Amazingly, only a couple of the holes needed carbide bits. We planned on using 1/8" brass stock, so the holes were drilled with #30 drills and then chamfered.

Because of limited time (it's midday Sunday now), I elected to use a differential heat-treat (using the Goddard "Goop") with an oxy-propane torch as the heat source. The blades were normalized (three time to critical temperature, then air cool to gray), then on the fourth pass above the critical point, into the "Goop". They tested out as full hard and were then tempered at 375F for 1 hour (in, of course, a toaster oven). Salt baths are better, but we were running out of time.

It was then back to the Bader and the flat platen to do the finish grind. They were walked up from ~600 grit and etched in Kano Lab's ExRust to give:



The blades were masked and it was time to talk scales. Matt contributed a set of stabilized burl scales. The official description is:

Amboina Burl;

Origin: Southeast Asia, Cameroon, Nigeria

Color: Color variations from orange-yellow to deep red

Characteristics: Closely spaced rows of grains; the veins are rather coarse and scattered; a large number of burls make the wood extremely valuable. A classic: radiates depth and vigor; Amboina is considered to be one of the most elegant and decorative burls in the world.

Application: Very high-quality interior finishing, veneer for exclusive furniture, in solid form for tobacco pipes and objects of art.

We all just thought that the wood grain nicely matched the pattern in the steel. We traced the tangs onto the scales, allowed for a bit of slop, and sawed the four pieces out. The inner surfaces were flattened using a disk sander and each



pair was ground together at the front end so that the transition of the blade to handle was the same on either side of the knife.

The first scale and the tang were cleaned with acetone and then 5-minute epoxy was used to glue the scale to the tang. The epoxy was colored with Brownell's Epoxy Black. Spring welding clamps were used to hold the scale in place until it set up (see picture below and left).

When ready, it was drill press time. A 1/8" bit was used to drill from the tang side through the first scale. A wood block was used on the down side to minimize splinters and the blade was clamped in a cross-vice to minimize lacerations. Care was taken to make the center line of the blade was perpendicular to the drill axis (since the tangs tapered).

The second scale was then glued on using the same procedure outlined above. The holes were completed by drilling through the preexisting holes in the first scale and tang. Pins were cut to be a little longer than needed and were given a quick conical grind on one end to minimize splintering the far side. The pins were inserted (after being 'greased' with epoxy).

It was then back to the Bader to rough grind the handles, then onto the slack belt, variable speed grinder using "J" or flex belts to finish the sanding. The handles were buffed. The tape removed from the blades, and hot beeswax was applied to over the entire knife. The results are shown below.



ABANA Conference News
Demonstrators Announced
July 2009 - Vol. 1 Issue 2

The 2010 ABANA Conference Committee is pleased to announce the first group of confirmed demonstrators. We are working behind the scenes to secure additional demonstrators to round out the conference.

JOE ANDERSON (of NC) will do one demo on forged kitchen ware and 2 sessions on sculpture

MARK ASPERY (of CA) will do tool-making demos.

GERALD BOGGS (of VA) will do a demonstration; subject TBD.

DAN BOONE (of VA) will do 2 demo sessions on dragon's heads and his other products

DAN AND JUDY BOONE will do a round table talk and question session on how they market their wares.

PHIL COX (of MO) will do a session "power hammers - getting the most out of them" including both mechanical and air hammers, he will also cover tips on checking used hammers and rebuilding them

DAN NAUMAN (of WI) will demonstrate repoussé

DARRYL NELSON (of WA) will do a demonstration forging of animal heads.

STEVE PARKER (of IL) will demonstrate power hammer tools and forging.

TOM LATANTE (of WI) will lead the "Meticulous Metalsmiths" forging a lock during the conference.

MARK ASPERY will run the "Green Coal" teaching station, with DARRYL NELSON and GERALD BOGGS.

AMIT HAR-LEV and TSUR SADAN (of Israel) demo topic has not been confirmed

Gallery Open to Public
"Green Coal" Forges
Memphis Style Banquet
Top Demonstrators
Tailgate Heaven
Vendors for the Craft
Lectures Et Workshops

"We will preserve a meaningful bond with the past. We will serve the needs of the present, and we will forge a bridge to the future. Function and creativity is our purpose. Our task is great and so is our joy."

Dimitri Gerakaris, 1973



AgriCenter
International

Memphis
Tennessee

June 2-5 2010

Log on ABANA.org website and sign-up for Constant Contact emails, email address in the box at the bottom of the home page, click on "Get ABANA Email". You will receive periodic ABANA 2010 Conference News.

The ABANA 2010 Conference will be held at the AgriCenter International in Memphis, TN. Located at 7777 Walnut Grove Road, from I-240, on the east side of Memphis, take Exit 13 and drive east on Walnut Grove Road approximately 4.2 miles to Farm Road and turn south, go .1 mile.

"What Is It?" Butch Patterson

The answer is: It is an adjustable pipe tong. The two jaws go around the diameter of the pipe and the adjustment screw positions the top jaw to clamp the outer pipe wall. I picked it up at a flea market for \$5.

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.

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FABA MEMBERSHIP APPLICATION

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

Name _____
 Address _____

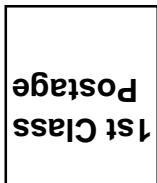
 City State Zip
 Phone: Home _____ Work: _____
 E-Mail _____
 Spouse's Name: _____

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 []



August 2009

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 FLORIDA ARTIST BLACKSMITH ASSOCIATION
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 6418 NW 97 Court
 Gainesville, FL 32653