

April 2010

The Florida Clinker Breaker

Florida Artist Blacksmith Association - Established May 18, 1985

Presidents Message

Jerry Wolfe

Last month I mentioned members of FABAA are the "face of FABAA" to the public; so I continue to highlight their events as I am aware of them. Steve Kalb demos at Koreshan State Park in Estero (Ft Myers) when he can get time away from his "fire fighting" job and other artistic ventures. Butch Patterson has been demonstrating at the Stephen Foster Folk Cultural Center State Park on the Suwannee River in White Springs for several years. If you are demonstrating for a public event, let me know.



I would like to welcome new members: John & Charri Barker; Daryl Bean & Jeff Stain; Bill & Ruth Harris; Stephen & Paula Kraybill; Will Manning; Harry & Cindy Nichols; and Malcolm Spaulding. It's great to see new interest in a craft / skill that is hundreds of years old, yet we can learn something new each month. Make sure you welcome these new members and get to know them.

I had the opportunity to visit the Feb 13th NW region meeting with Juan Holbrook demonstrating scrolls and mortise/tenon joints to make a table base. Great work Juan.

The program team is starting to plan for the October 2010 Conference in Barberville. This year we will be celebrating our 25th anniversary, so we want to make it extra special and honor our charter members. If you have any ideas, please pass them along to Mark Stone.

The 2010 ABANA conference in Memphis TN is shaping up to be a great conference. I would encourage you to go if at all possible. I always learn a lot; meet a lot of excellent smiths and come back energized.

Steve Bloom our EXCELLENT Newsletter Editor is always looking for items to publish; such as demonstrations, how to articles, creative ideas, interesting blacksmith pictures, old

tools, etc; so please pass them along to Steve so we can enhance our Clinker Breaker.

SE Coordinator: Thank you very much Ralph Nettles for agreeing to fill this very important spot in our leadership team.

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 FABAA 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, FABAA Scholarship Committee, 777 Tyre Road, Havana, FL 32333 or emailed to jgbutler@sprintmail.com. Deadline for receipt is June 15, 2010. Three finalists will be recommended to the Board. The decision of the Board will be final. The successful applicant will be notified.

NOTE: John is anxious to get applicants. If you applied and lost out in the past, please try again!

Also, please see pg.2 for conference input - Editor

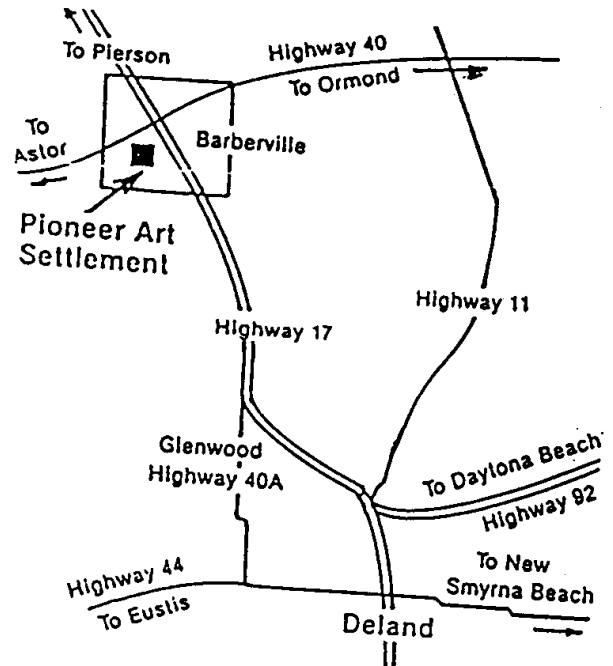
Upcoming Events

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:

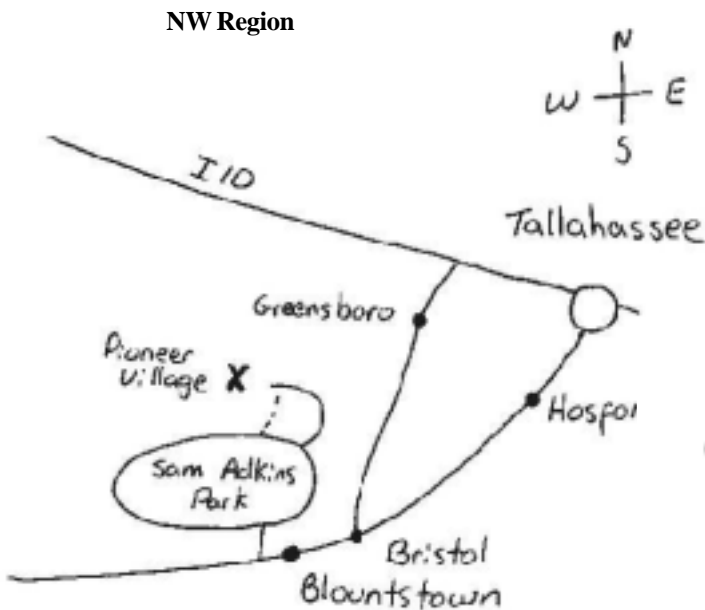
Northeast Region	Mitch Widham	386-673-0174	mwidham@cfl.rr.com
Northwest Region	Billy Christie	850-421-1386	chriswoodforge@embarqmail.com
Southeast Region	Ralph Nettles	561-747-5489	ralphnettles@msn.com
Southwest Region	Lisa Ann Connor	813-977-3743	MelisandeAubrey@hotmail.com

April 2010

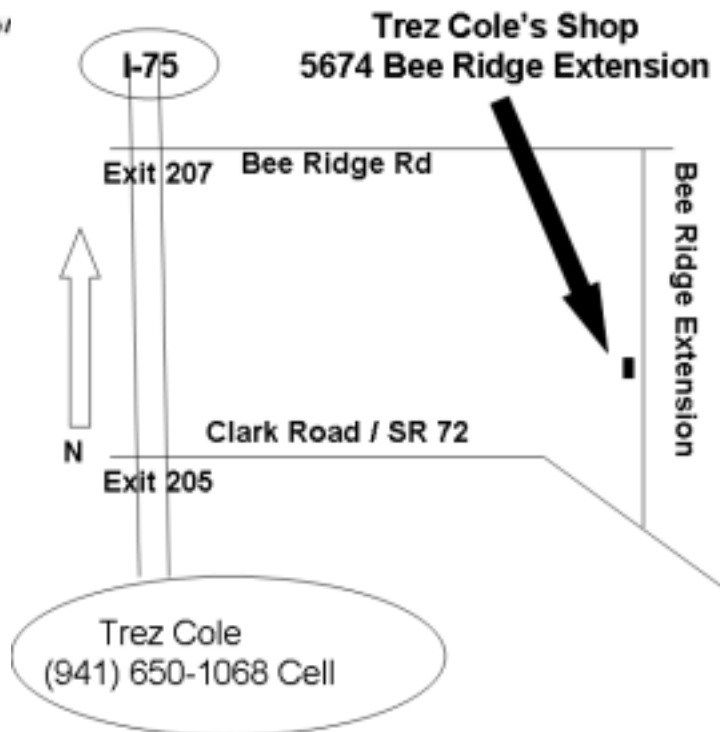
- NE 03** Open Forges @ Barberville
 - NW 10** Panhandle Pioneer Settlement in Blountstown, FL. John Watson & Danny Willis Demonstrating. Think Fire!
 - SE 17** contact Ralph
 - SW 24** -Trez Cole's shop, Sarasota. Jerry back from Lithuania will share his adventures! Please bring some lunch to join in the potluck, and bring the fruits of your talented labours for the Iron-in-the-Hat!!!
- See Notices for Alabama Hammer-Ins



NE Region



NW 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.

Future Events

NE May 1 Steve Bloom's shop - near Archer, FL
NW May 8, 2010 Rex & Mary Ellen Anderson's Shop
outside Monticello, FL

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Editorial/Board Communication

Steve Bloom

Believe it or not - the Board is concerned about spending your money. The conference typically offers beginning and intermediate classes which employ four instructors. FABA pays for rooms, meals and a stipend - to the tune of a total over \$1500. The registration fee defrays only a fraction of the costs (\$10 from potentially 32 to 48 students is only \$320 to \$480). Occasionally, no one signs up for a class and in other cases, too many students appear.

What should we do? One suggestion is to make the classes more entrepreneurial -- if no one shows, the instructor doesn't get paid. Just how this would work is unclear since we often have no clue about the enrollment until the conference and the instructor would still have to buy materials, plan the instruction, and show up. We could require pre-registration and cancel a class if it wasn't sufficiently full, but does that mean if one of the two classes doesn't go, we should drop both? Should we just forget the classes at the conference? Would it be better to schedule an instruction weekends - potentially at the instructors shop with FABA paying a modest stipend and/or with sufficient registration costs to compensate the instructor. The unfortunate fact is that the conference has been running in the red and our membership has declined. We will need to prioritize our spending and you need to talk to the Board and the coordinators about what is most important to you. Do we cut back on instruction? Drop the newsletter size and/or go to a-every-other-month or quarterly format? Cut back on scholarships? We are not facing a crisis yet but the Board could really use your input.

If you are not on the digital distribution list for the newsletter and can get it electronically, consider signing up (just drop me an e-mail with the address you want to use and I'll handle the rest). We save about \$30 per person who elects this option, so it does mount up!

Report from the Northeast

Mitch Widham

On Saturday March 6th at Barberville, with open forges, 33 Smiths showed up to partake in the activities, some forging various items such as tomahawks, knives, and even a couple of wooden pegs/dowel makers were forged, lots of guys showing off beautiful custom made knives, and some folks just visiting while watching and learning. It was a gorgeous day, finally after what seemed like a long cold winter. We had quite a pile of old rusty junk on the table for Buck in the Bucket, which raised \$153.00 for FABA. Keep up the good work of bringing in the interesting items and especially the

hand forged pieces. We didn't do the book exchange this month, however several folks brought them, so we will do it again next month, bring in a blacksmith or related book, and you will leave with a different one. I have been doing it the last three months and have really enjoyed it and learned a lot from them. A hearty lunch was provided as usual with ham, meatballs, chili, shrimp cocktail, delicious side dishes and loads of sweets. Next months meeting in April, we will be



making 6 strap hinges for FABA's storage shed at the settlement, we will divi up the work, some cutting stock to length, some forging the straps, others forming and forging the hinge pins. Please bring any tools that might help, FABA will provide the stock. The Pioneer Arts Settlement at Barberville FL, is looking for Blacksmith demonstrators for their Spring Frolic on April 24th and 25th. If interested or for more details give me a call at 386-673-0174, I will hook you up.

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Report from the Northwest

Billy Christie

The NW Region of FABA had its February 13, 2010 meeting at Juan Holbrook's shop in Gainesville, Florida. We had 40 blacksmiths sign in on this cold & overcast day.

Juan was our demonstrator and he was assisted by Lisa Smith. The first project for the day was to make a leg for a 24" X 17" beautiful, black marble top table. The legs were made from solid 3/4" square stock and Juan used one piece of stock to make two of the legs. First he upset the end to 1" square, with a slight taper toward the bottom of the foot.

Juan also had a great discussion on how to figure how much metal to use when making scrolls. On his example, the tapered end grew 1/2" on each end. The piece needed to be 25" long after being forged to a taper. Juan then used a 24" piece of stock plus the 1/2" gain on each end equaled 25".

Next he made a mortise for a mortise and tendon joint. He used a special tool to mark the center of the stock. Then he used an A-2 drift to start the hole and an A-2 punch to finish the hole. Great job! (see Pg.6 for layout plans - Editor)

The "Iron In The Hat" had several hand forged items and other interesting stuff. The "hat" brought in \$116. Thank you Ester Gurr for drawing the winning tickets.

Several mouth-watering dishes were brought by members to add to the delicious lunch of lasagna, salad, and brownies that were furnished by Juan's daughter, Cornelia Holbrook. Cornelia runs the Sweet Water Branch Bed and Breakfast in Gainesville. Thank you Cornelia, it was superb!

A BIG thank you to everyone who helped make this another enjoyable and educational experience.

Report from the Southwest

Jerry Wolfe

Our SW region meeting on February 27th at Phil Pauley's forge was attended by 13 folks. Our Iron in the Hat resulted in \$42 for FABA. Phil unfortunately had to be out of town for his mother's funeral in KS; so thanks to Bob Vollmert, Phil's brother in law for opening up the shop. (Phil - Our deepest sympathies are extended for your family during this time.)



Bob "Flash" Cangiamila with Jim & Teresa Horne discussing copper repousse (Bob Vollmert in background)

Several demonstrations were conducted during the day. Jerry Wolfe made the elements for a plant stand which included a central post with a scroll and decorative twists, a second scroll and four legs. Bob "Flash" Cangiamila demonstrated copper repousse with many leaf and organic shapes. "Flash" had several of his pieces including a fountain on display.



Trez Cole demonstrated a special twist which I will call cubic twist.

Thanks to all for pitching in during the day to make it a very successful day even though it was COLD and RAINY.

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.

Hammer-Inn's hosted by Alabama Forge Council members

In April of 2010 the Alabama Forge Council will be having two separate Hammer-Inn's in the Southern half of the state. The first on April 17th will be hosted by the Wiregrass Forge Group at Bob Portman's forge in Enterprise AL. Al Stephens, another excellent instructor will be demonstrating basic blacksmithing, hinge-making and a unique plant hanger. This meeting will be open to all.

The second is a Colonial Lamp workshop. The Montgomery Forge Group will host a Hammer-Inn / Workshop focusing on a Colonial style candle lamp at the shop of John Wayne Taylor, Wetumpka, Alabama conducted by Raymond Head. This lamp was taught to me by Bill Richardson and is in the style produced by Jerry Darnell. The project is relatively simple, but teaches many fundamental Blacksmithing skills, such as forge welding, drawing, upsetting, mortis & tinning joints and scrolls. If nothing else it will be hilarious watching me try to teach forge welding to a group. The workshop will be conducted on Saturday April 24th and Sunday 25th, 2010. Lunch will be provided both days by the Montgomery Forge Group as well as coffee in the mornings. We ask for everyone to bring snacks to share with the group. The fee for the two day class will be \$50.00 and will be limited to 14 people. For more information please contact Raymond Head, (334) 514-1065 or raymond_head@bellsouth.net



50-lb Little Giant power hammer.

Combination die set, fairly new motor. In excellent condition - price \$3,500. Contact Patty Draper at 850-668-2876 or applecrossforge@nettally.com.

Blacksmithing Workshop at Fort King George Historic Site

302 McIntosh Kd. SE ;Darien, Ga. 31305 - April 16 & 17,2010. Cost: \$125/person includes lodging and two meals a day. Lodging will be inside the Fort, but participants are welcome to stay in a local hotel at their own expense. Information:912-437-4770

Course Objective: The student will be able to use simple design projects (e.g. hooks, nails) to conduct historical interpretive programs about the history of blacksmithing, its uses, and its techniques.

This will be a two-day workshop for the beginner. It will be devoted to teaching participants rudimentary skills and techniques for blacksmithing interpretation. It is not designed to develop expertise, but instead, to enable students to conduct interpretive programs on the basic techniques, tools, and history of blacksmithing. Day one will be divided into classroom instruction of history, nomenclature, and hands-on technique. Day two will be spent entirely in hands-on practice.

Smithing Gear for Sale

Ken Crowe (oldcrowe@aol.com) is interested in selling his equipment. He's in the Tampa area and has available:
Coal Forge with firepot & hand cranked blower; 6" pole vice
258 lb Anvil 32' X 5" X 12" - ;est 50 lbs of coal. **\$900 OBO**
also welder & cutting tanks ect. Email for details.



Basket Weaving

With DINA ESTENSON

Beginners Welcome.
Workshop fee includes all materials.

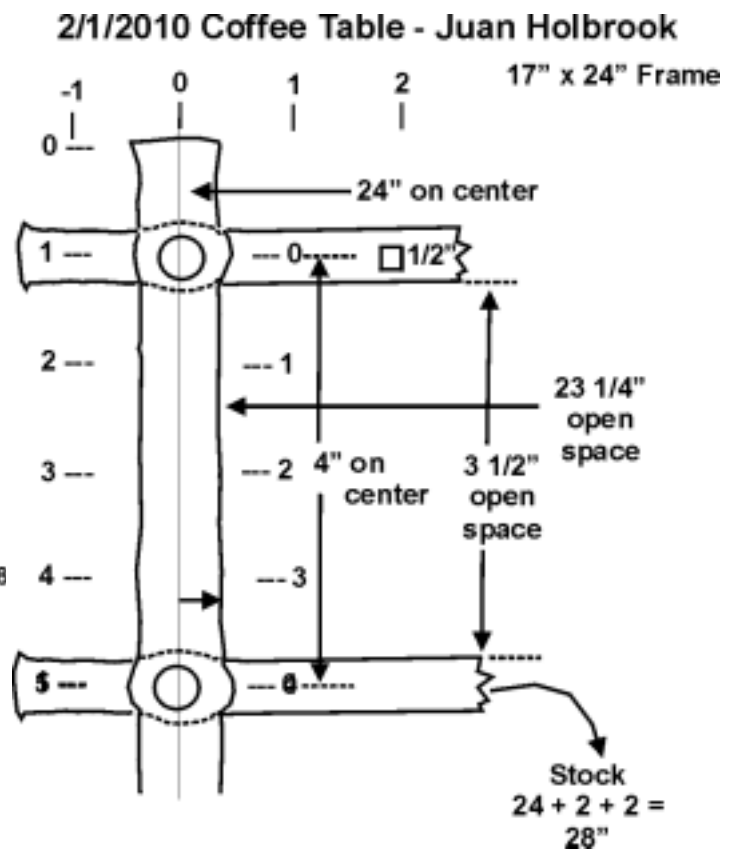
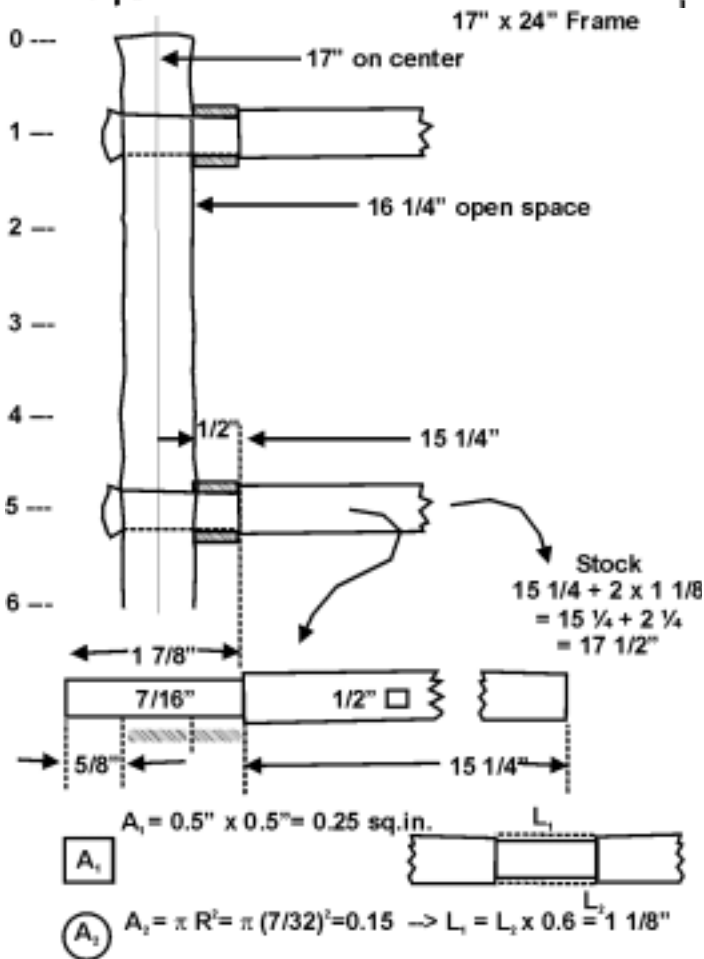
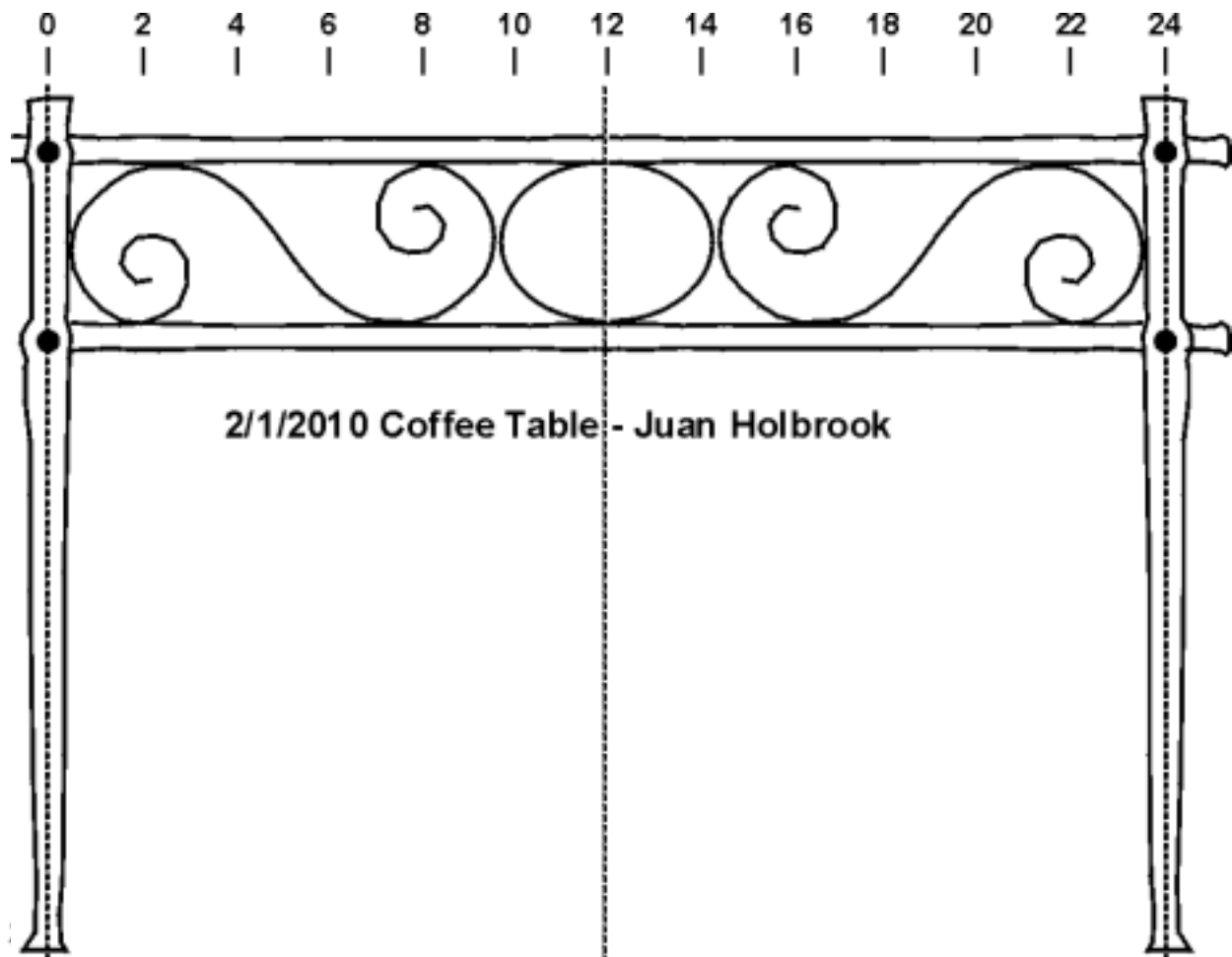
Saturday, April 3, 2010
9:00 am - 12:00 noon

Class Fee
\$15 *

*Settlement members receive 10% Discount

At the
Settlement
see pg.2
for map

Advance Registration Appreciated - Walk-ins Welcome
Register by phone or in person
Cash, Visa, Mastercard, Discover, and
Personal Checks (with Proper ID) accepted



Acetylene Leakage Alert

PURPOSE

This Safety Advisory is issued to warn sites about leaking shutoff valves on acetylene cylinders. Acetylene (C₂H₂) is extremely dangerous because it is easily ignited and burns at a very fast rate.

BACKGROUND

On January 11, 2010, while cutting rebar at the Savannah River Salt Waste Processing Facility (SWPF) with an acetylene torch, a small fire (3-inch flame) occurred at the cylinder shutoff valve. Although the acetylene rig was covered in fire retardant blankets, ricocheting sparks ignited the gas underneath the blankets. A fire watch extinguished the fire. Investigators determined that the cylinder shutoff valve was leaking at the valve stem when the valve was open to allow gas flow to the regulator.

DISCUSSION

Following the determination that the cylinder shutoff valve was leaking, an extent of condition inspection was conducted on acetylene cylinders at the SWPF. Five out of eight

cylinders were found to be leaking in the same location just below the top nut of the shutoff valve. The leaks occurred only when the valves were open. Each of the leaking cylinders had a shutoff valve with a double-nut configuration. Figure 1 shows a leaking shutoff valve that is similar to the one that was involved in the fire. The acetylene cylinders that did not leak used a shutoff valve with a single-nut configuration (figure 2). The leaking cylinders were all removed by the gas vendor. Three days later, the vendor provided seven new cylinders and three of them leaked at the same location. Each leaking cylinder was equipped with a double nut shutoff valve. The gas vendor is conducting an investigation of the leaking valves. Figure 1. Leaking shutoff with a double-nut configuration Figure 2. A non-leaking shutoff valve with a single-nut configuration

There are three different shutoff valves associated with the leaking cylinders. The gas vendor provided the following make and model numbers: Superior VSC CGA510 ; Sherwood S-13 CGA510 ; Sherwood TV CGA510



Figure 1. Leaking shutoff with a double-nut configuration



Figure 2. A non-leaking shutoff valve with a single-nut configuration

Don't forget, "The Customer is Always Right" (or maybe the architect or designer)



Fall 2009



page #13

New England Blacksmiths

Mosaic Pin Saw Jig

Steve Bloom

Since you folks haven't sent anything in, here's another jig from IronFlower Forge. A nice addition to a knife handle is the presence of a pair of mosaic pins. Making the pins can wait for another article but cutting them to size is the subject of this one. Pins are usually made of non-ferric materials (brass, copper and/or nickel silver) and come in a variety of diameters. You can either drill a hole of the appropriate diameter in the tang of a blade or just drill blind holes in the scales - either way, you'll need to cut the pin to the correct length. I've tried using jewelers saws and tubing cutters and wasn't very happy with the results. What does seem to work is a simple wood block combined with a vertical metal cutting bandsaw.

I started with a block of scrap hardwood approximately 2" x 3" x 4" (from the leg of an old, dead desk chair) (Fig.1). Since I have pins of 0.218", 0.250" and 0.279" in stock, I first drilled three holes on the midline (left to right side) using a #2, a 1/4", and a K drill bit respectively. Drill selection is determined by the pin diameter and then looking up the nearest smaller drill bit. The equivalence chart from Enco (#327-0057, \$3.96, useenco.com) is a great help with this. I also drilled a 1/4" hole in the left front corner (top to bottom) and drilled a shallow hole in the bottom large enough to accommodate a bolt head.

The first saw cut (Fig.2) is the initial hinge cut. It passes through the three holes (hence on the midline with the cut running from left to right side, starting at the front and terminating about 3/4" from the rear face). DO NOT cut all the way through to the rear. The 3/4" uncut area will be the hinge.



Figure 1: The block



Figure 2: Initial hinge cut



Figure 3: Vertical cut

Flip the block with the front face down and make a cut from the top to the previous cut (towards the bottom) (Fig.3). The cut is right of the midline (dividing the top surface into a 6:4 ratio - left to right).

All that is needed to remove the right upper "quarter" is to rotate the block so that the right side is to the blade and complete the cut (Fig.4).

The hinge area needs a bit of refinement. Place the left side down, front to the blade and slip the blade back to the uncut hinge area. Remove a couple kerf widths from the left side of the cut (not cutting into the actual hinge area) (Fig.5). Depending on the stiffness of the wood, the length of the uncut area may have to be adjusted.

The last cut (Fig.6) is from the front to just beyond the last hole cutting from top to bottom. This cut provides clearance for the blade of the metal cutting bandsaw. Put a 1/4x20 bolt in the left corner with a wing nut.

To use the block, slip the pin into the block with the desired length to the right of the clearance cut (Fig.7). Tighten the bolt and cut the pin. The block keeps the pin from spinning and the half-holes on the right keep the pin from flying off into the shop.



Figure 4: Quarter removal



Figure 5: Final hinge cut



Figure 6: Clearance cut



Figure 7: Ready to work

Tool Resurrection Kalamazoo 7A Band Saw

Steve Bloom

Continuing the theme of “contribute-or-read-about-what-I’ve-been-doing”, what follows is a brief description of bringing a tool back from the dead followed by probably more than you ever wanted to know about calculating pulley sizes.



Figure 1: Before

Some time back, I was gifted with the remains of what was once a pretty decent horizontal band saw (Fig.1) - A Kalamazoo 7A. I have no real idea of just how old this saw is but there doesn’t appear to be anyone selling a copy on the Internet. It is a massive beast - over 200 pounds of approximately 1/4” plate. Compared to the Harbor Freight units, this is a tank.

I’ve been threatening to get it working for a couple of years and finally did it. I stripped it down to components, wire-brushed and/or washed away years of accumulated grime and rust and slapped (and that is the correct term) a coat of more-or-less matching paint on it - Lowes ‘maybe-I’ll-dry-



Figure 2: After

one-of-these-days” enamel. What was amazing is that everything still worked - not just the steel but the bearings as well as the hydraulics (Ok, they leak a bit but just a few drops a day) (Fig.2).

The only real problem centered on the absence of the motor and the fried on-off switch. I cobbled together a new switch and a new auto-off mechanism, but I still needed to get the saw cutting as close to specified speeds as possible. While I’ve added a coolant system, blade life is enhanced if the saw runs to specs. The details are given in Fig.3.

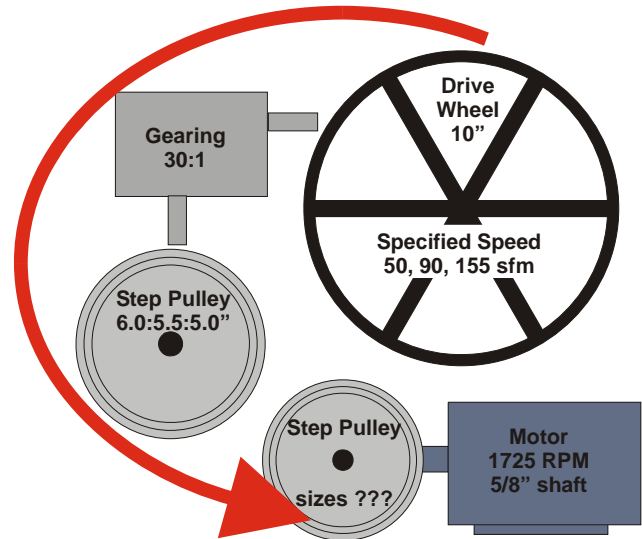


Figure 3: Pulley & speed specifications

Start with the low speed of 50 sfm. Convert that to inches and divided by the circumference of the drive wheel gives the rpm of the drive wheel, i.e., $50 \cdot 12 / 10 \pi = 19.1$ rpm. Multiply that by the gear ratio ($=30:1$) and divide by the rpm of the motor, i.e., $19.1 \cdot 30 / 1725 = 0.322$ which is the ratio of the largest pulley on the saw to the matching pulley on the motor. Since the large pulley is 6” in diameter, then it needs to be driven by a $6 \cdot 0.322$ or a 2” pulley.

If we represent the speeds as $S_i = 50, 90 \text{ \& } 155$; the saw’s pulley sizes as $P_i = 6, 5.5, \text{ \& } 5.0$ ”, and N_i as the needed sizes then

$$(S_i \cdot 12) / 31.42 \cdot 30 / 1725 \cdot P_i = N_i$$

with a bit of algebra, the equation is:

$$P_i \cdot S_i \cdot 0.00664 = N_i$$

So I need a pulley with a 2.0, 3.25, & 5” steps. A quick Goggle search found on Amazon.com a reasonable match: Chicago Die Casting #146; 5/8” Bore, 3 Step V-Groove Pulley, 2”, 3” & 4” Steps for \$13.50

Now - don’t you want to send in something?!

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 _____

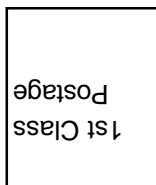
 City State Zip
 Phone: Home _____ Work: _____
 E-Mail _____
 Spouse's Name: _____

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 []



April 2010

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