

August 2024

CLINKER



BREAKER

Florida Artist Blacksmith Association

Established May 18, 1985



FABACON REGISTRATION IS OPEN

The 2024 conference website is live with our list of classes, vendors, and demonstrators. Get your hotel reservations now at blacksmithing.org/fabacon. **Info, Page 4**



NW MEETING

The Northwest Region had their July meeting at the Homestead Barn, and 31 people signed in. Read the report, pages 9-10.

Forge a Chili Pepper from pipe

A Step-by-Step Guide

By Chris Cauthen (Double C Forge)

Pages 17-22



Regional Events & Information



FABA has eight regions, and regular meetings are held in each region on the following Saturdays of each month: 1st Saturday—Central NE / 2nd Saturday—NW / 3rd Saturday—SE, Greater Orlando & Gainesville / 4th Saturday—Far West & SW.

The NNE meetings will be the 2nd or 3rd Saturdays (depending on the month) in 2024.

The regions have no boundaries – everyone is welcome everywhere. Come to more than one if you can!

The dates may vary, so check the schedule noted in the Regional Reports or on Facebook, or contact the Regional Coordinator.

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 9 a.m. to 4 p.m., and you'll want to bring a bag lunch if not otherwise noted. If you have any questions about events, please check the region's Facebook page or contact the Regional Coordinators:

Greater Orlando Region	John Hare	802-373-1190	legacy.john.hare@gmail.com
Gainesville Region	Jordan Borstelmann	352-727-8260	crookedpathforge@gmail.com
Central Northeast Region	Heinrich Hole	386-848-6982	heinrich.faba@gmail.com
North Northeast Region	Doug Hayes	910-330-7601	djhayes29@hotmail.com
Northwest Region	John Pfund	850-528-3280	johnwpfund@aol.com
Southeast Region	Peter Hill	651-635-6022	blazeblades561@gmail.com
Southwest Region	Antony Fenn	617-320-4781	antony.fenn@gmail.com
Far West Region	Christopher Sandlin	850-865-9596	Chris@traditionsworkshop.com

Florida Artist Blacksmith Association (FABA) is a nonprofit organization chartered with the state of Florida that is dedicated to promoting and expanding the horizons of architectural, artistic and practical blacksmithing while preserving the rich heritage of this craft.

FABA Officers and members assume no responsibility or liability for injuries or damage caused as a result of the use of any information, materials, design, techniques, etc., contained in this newsletter; our website, www.blacksmithing.org; our Facebook Page at www.facebook.com/FloridaBlacksmiths; any of our regional Facebook pages; or provided at meetings or demonstrations.

Contributions to FABA 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. Send to editor@blacksmithing.org. Materials submitted must be your own work, and citations of others must be clearly identified. By submitting materials, you are allowing FABA to edit, print and post them to FABA's website. 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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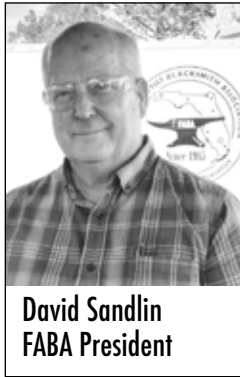
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Florida tax rules & FABACon reminders

Our statewide conference November 8-10 at the Best Western Gateway Grand, Gainesville, is in full swing, registration is open and classes (at least most of them) are posted. Don't forget to book your hotel room before it is too late!

Part of the business as president of our non-profit is keeping up with the ever-changing rules and regulations governing businesses in Florida and the USA. The latest rule to catch my attention is called BOI, brought to us by the Financial Crimes Enforcement Network of the U.S. Government. So instead of spending time at the forge this weekend, I got a chance to read up on this newest ruling. BOI stands for Beneficial Ownership Information, a required report for all businesses – and because FABA is a corporate entity registered with the state of Florida, we are technically a “business” and have to pay attention to this part of the Corporate Transparency Act.



David Sandlin
FABA President

Fortunately, in paragraph C.2, there are 23 exemptions, and thankfully, tax-exempt entities are exemption number 19 (and we are a 503(c)1 educational tax-exempt entity). So, BOI reporting does not apply, but law does require us to report that we exist using the same form as any other business. We just don't have to report any beneficial owners' information since technically we don't have owners. (Yes, your government is hard at work to help you).

I bring the BOI issue up for two reasons: First I do know there are other business owners in FABA that might not have seen this information. Failure to comply can result in a \$10,000 fine. And second, to implore you, the membership, that if you in your business or daily routines come across something like this that has the potential to up-set our apple cart please bring it to my attention so we can deal with it in a timely manner.

Now on to more interesting information: I am really, really thankful for all the volunteers who have already stepped up to support FABA Con 2024. You might not realize how much work goes on before the actual event but there is steel, coal and T-shirts to be ordered; websites to be built/updated; contracts to be negotiated with the hotel; demonstrators to be found; vendors to be sought after. Budgets have to be built and managed. ... Again, my hat is off to Lisa-Anna and her crew.

A big way you can help her (and FABA Con 2024) right now is to start the “buzz.” Social media takes time to energize. “Liking” a post is helpful but “loving” a post carries more weight, and making a comment or reposting

really helps bring our message to the top of the news feed. If you see one of our posts (or even make your own post about our Veterans Day weekend conference) take the time to repost to the appropriate groups you are a member of.

Don't forget there are other ways to join the fun. As we approach the main event, we still have jobs that need to be done for our conference to run smoothly. For example, we need Ice Men, Coal Boss, Trash Pickup. ... If you see a need where you can help, please volunteer before the conference so we know that aspect of the operation is covered. We welcome you to the team.

I am really happy to mention we have some new Damascus sponsors. Duir Grove Forges LLC (James Worm's shop) has pledged to run four back-to-back oxy-propane brazing classes for FABA Con this year (Friday and Saturday). He is securing materials, fuel, tooling and is even bringing the tent to host the classes, making a significant in-kind donation to FABA. Iron Osprey Forge (Doug Hayes shop) has also committed to donating equipment, materials and instructor hours, especially for classes targeting first-time blacksmiths, instructing solid fuel management, hammer ergonomics, hammer dressing, heat treating and a veteran's class. Look for Doug to be on the field teaching all three days – and bring him some cold water.

Mission San Luis, in Tallahassee, has also joined us as a steel sponsor with a \$100 donation.

Lastly, congratulations to Doug Hayes, winner of our Walt Anderson Scholarship for 2024. Doug will be attending class at Zion Blacksmith School in Utah, studying with Gordon Williams and bringing back lots of great tips, techniques and processes to spread the wisdom of blacksmithing around to the rest of us.

Stay cool! Hope and Pray your anvil rings true throughout the year and eagerly looking forward to seeing you all November 8, 9, 10 at the Best Western Gateway Grand, Gainesville.

– David Sandlin, President

FABA ELECTION NEWS

FABA's 2024 ballot is set, with candidates for four posts. Please visit www.blacksmithing.org/elections to cast your vote in FABA's 2024 elections! Or they can email it to Tia Kitchen at secretary@blacksmithing.org.

Treasurer – Dawn Fortenberry

SE Trustee – Steve Silvers

NE Trustee – Ben Thompson

Editor – Jennifer Jhon



FABA CON 2024 CHALLENGES

REGIONAL CHALLENGE

Theme: Medieval Folklore and/or Religion

Rules: Three or more members must contribute to the piece

Judged on: adherence to the theme; techniques used; quality of work; number of contributors

Winners receive bragging rights and get to pick the 2025 theme.

EXCHANGE ITEM

Theme: Something with TEETH

How it works: Bring a pre-made item to the conference that represents the theme. At the banquet, each person who brought something draws a name and gets to take home the piece that person made.

The theme this year is broad. Think about all of the things that have teeth - gears, saws, animals, skulls, zippers, pianos, combs, etc.

SCRAP BUCKET CHARITY CHALLENGE

How it works: Pay a small donation at the registration desk to pilfer the scrap bucket for your piece of metal. Make anything you want from that metal.

Rules: Only scrap from the bucket can be used; must be completed and in the hotel lobby front desk before noon on Sunday, Nov 10th

Judging: Hotel staff picks their favorite

Winner receives challenge proceeds to benefit charity of their choice.

GALLERY PEOPLE'S CHOICE

How it works: Bring an item to place in the gallery. Gallery visitors "vote" on their favorite throughout the conference. Make sure you get your piece there on Friday so more people can see it.

The winner of the people's choice is awarded \$75.00.



FABACon Planning

Greetings from Your Conference Team! Thanks again to all of my/*your* hardworking Conference Team! From all of your suggestions for demonstrators, to helping hash out the details for the website, and especially for trying to keep me calm when I want to...well, hit things with a hammer!?!

I had really hoped to have all the necessary paperwork in hand before we went to print, but it just hasn't quite happened yet. Nonetheless, I will make sure an email update goes out as soon as I have signatures on contracts! Please keep checking the conference website at blacksmithing.org.

So many of us are traveling this summer, whether attending shows or festivals, or working and teaching at various venues all around the world. I hope that you will consider a brief write-up for the Clinker Breaker on your adventures, and I know that pictures are always welcome! There's always some metalwork *somewhere*.

Fall will ramp up quickly, with more Florida events on the horizon. Let your FABA family know what you are up to, and consider honing your presentation skills at a local or regional gathering. Having served as a regional coordinator for almost a decade, I can tell you that they are often looking for demos and classes.

Keep hydrated!

— **Lisa Anne Conner, Vice President and Program Chair**

Regional Reports

SW Region Meeting, Aug. 24

Our Southwest meeting will start at 10 am on Saturday Aug. 24th at the workshop of our great friend David Reddy in Tampa, who recently passed away. His wife Kathy is hosting a sale of David's equipment.

Please try to attend and consider purchasing an item or two. I personally would like a hammer or some hand tool that I can enjoy using while thinking back on times spent with David. Cash or Venmo only. Please see the list below. Contact me via email at antony.fenn@gmail.com or via facebook messenger if you want a price list.

A pizza lunch will be provided.

Address: 3120 West Burke St, Tampa

Sale Items

Great condition Peter Wright Anvil 141 lb

Great starter power hammer for light work BullDog Air hammer - Rating of 22 lb

Air Compressor (2 HP; 29 Gal) - needed to run the air hammer

Hells Forge 2 burner Gas Forge,

Post vise

Harbor Freight anvil - good for a beginner

Abrasive wheel cut off saw

Belt Sander

New Harbor Freight Oxy Acetylene torch kit (no tanks)

Oxy Acetylene torch complete with tanks and gas saver

Harbor Freight up to 3/16" plate Flux welder

Lots hammers

Small hand power tools, various tools for forging, gloves, tongs, Scrap steel, KoaWool

Lots of other miscellaneous items.

Please check our FABA SW Facebook page for more info at www.facebook.com/groups/228279738123674, or contact antony.fenn@gmail.com. Thank you!

— **Tony Fenn, SW Region Coordinator**



CLINKER BREAKER

SW Region Meeting Report

Thank you to everyone who participated at SW June meeting at the forge at Crowley Museum. I'm sorry I couldn't make this one as I picked up a flu bug. It was a lighter attendance than usual but not surprising given the heat of summer is really upon us.



Trez kept us going with a demo of all things to do with rivets including making rivets and a rivet header.

Welcome to Elijah Ramos, a new young member who came to his first meeting. Trez helped Elijah through some basics to get his smithing journey going. Thanks to Elijah's mom who brought some delicious desserts.

I only got the one photo from the meeting, from Ed Bopp, of Trez stoking the fire in the Crowley workshop.

— **Tony Fenn, SW Region Coordinator**



Far West Report & Schedule

Far West had its monthly meeting at Saint Michaels Brewery, where we demonstrated how to make bottle openers for the membership. We encouraged people to join FABA to join in and make their own and got 8 new members to sign up. It was a lot of fun despite the heat we are all feeling.

MEETINGS:

August 24: John Butler Farm in Milton

September 28: John Butler Farm in Milton

October: Traditions Workshop in Fort Walton to prep the trailer

November 23: Timber Creek Distillery for a forging contest

December: No meeting to observe Christmas

— **Christopher Sandlin,**
Far West Region Coordinator

SE Region Meeting Schedule

The SE Region meets every third Saturday of the month at The Farm, 1566 S. Military Trail, West Palm Beach, FL. The Farm is located off Military Trail; just turn at the pole painted red, white and blue, and follow your GPS or Google maps. It should get you there!

Get more info on the FABA SE Facebook page:
www.facebook.com/groups/603288803747002

Greater Orlando Meeting Schedule

Greater Orlando meets on the 3rd Saturday of each month at UnderGround Metal Works in Maitland, FL.

For more information, contact John Hare at 802-373-1190 or legacy.john.hare@gmail.com.

— **John Hare, Orlando Regional Coordinator**

Central NE Region Meeting, Aug. 3

Where: Barberville Pioneer Settlement

When: Aug. 3 starting at 9 AM

We'll be continuing work on the regional project in August. Progress is coming along nicely thanks to the awesome core team we have. Open forges will also be available for those of you that want to work on personal projects. Lunch will be provided by myself but feel free to bring side dishes if you'd like. Cya there. :)

— **Heinrich Hole, Central NE Coordinator**

Gainesville Region Report

We had 4 members at the July meeting and made some tooling needed for the group project. For folks interested in attending the Gainesville Regional Meetings, please send me an email at crookedpathforge@gmail.com.

— **Jordan Borstelmann, Coordinator**

Support our FABA business members

DAMASCUS SPONSORS

David Sandlin - Traditions Workshop - Ft. Walton Beach, FL

Duir Grove Forges LLC - Brooksville, FL

Doug Hayes - Iron Osprey Forge - St. Augustine, FL

Benchmark Abrasives - Flagstaff, AZ

STEEL SPONSORS

Greg Hagen - Holland Anvils - Holland, MI

John Elliot - Blacksmith Supply - Chester, VA

Michael Oliver - Turn and Burn Metalworks - Lakeland, FL

Mission San Luis - Tallahassee, FL

IRON SPONSORS

Scott Brown - Medieval Smith - Land O' Lakes, FL

Jordan Borstelmann - Crooked Path Forge - Gainesville, FL

Rick Smith - Gainesville, FL

Nicole Horenstein - High Springs, FL

Mark Fillmore - Naples, FL

Cameron LaFrance - Micco, FL

Interested in being a FABA sponsor or expanding your sponsor listing? Contact FABA President David Sandlin at President@blacksmithing.org and include your business name, tag line, and contact information.

NNE Region Meeting, Aug. 17

The North Northeast region had a small turnout, but it was fun and productive. The heat and some last minute work and family events kept some away, but long-time FABA member Bob Jacoby came by and jumped in, getting his hands dirty helping with forge welds and bending rings. Doug and William got a lot done from design decisions, forge welds, layouts and planning for the competition project. Still lots to do, so make the next meeting, Aug 17th at 9 a.m. at Iron Osprey Forge (102 Marshall Circle, St Augustine) or message Doug for an assignment.

— **Doug Hayes, North NE Coordinator**





NW Region Meeting, Aug. 10

Our August meeting is going to be held at the home of Brooke and Jeff Mohr. The address is 22 Ironwood Court, Crawfordville, Florida. 32327. The meeting will be held on Aug. 10th. We've been meeting in Jeff's shop lately on Thursday mornings for open forges and we've been making fire place tool sets. We'll have them on display at the meeting. Roger Bell is going to demonstrate making a oyster knife from a railroad spike. Roger says he'll have extra spikes and some of them partly premade, so anyone who wants to can make and take home a knife. It's a good thing to have on hand as we will have a bag of oysters for the meeting and Jeff is going to make us a bonfire to steam them on. I'm going to bring a rotisserie chicken and some fried chicken too, for lunch and we should bring sides and desserts to go along with them. Thanks everyone and keep bringing the great things for the raffle! We're still giving out lots of free tickets for things that you have made, and it's ok to bring things for "show and tell" without having to donate them to the raffle. We're always interested in what you've been working on. This should be another great meeting and I hope to see you there. Looking ahead on the schedule, our September meeting will be at the Panhandle Pioneer Settlement. We're going to start back teaching classes at the settlement in September and will have classes on the first and third Saturdays of every month until the weather gets hot and we stop for the summer. October meeting will be held at Aunt Louise's Farm, this is their Fall season and we'll be onsite every weekend while they're open. November we're not going to have a meeting as the conference falls on the second Saturday. December at Mary Ellen Anderson's house. January at Bettingers welding shop..

— **John Pfund, NW Coordinator**

NW Region Meeting Report

The Northwest Region had our July meeting at the Homestead Barn, and 31 people signed in. We set up on the front porch area of the big building. I brought two forges and three anvils. Chris Cauthen brought his portable anvil and post vice. We had a good participation on open forges.

We had people working right up until we stopped for lunch and some even started back up after. I made a pair of EZ tongs and encouraged others to make tongs also. I'm not sure who all did though, I got busy making a couple loaves of fresh bread. Dot Butler helped me with the bread. We had three pots of chilli and lots of sides and desserts. Great participation in the raffle and two knives were donated and auctioned off. We've got some cash surplus again and I'm going to use some of it to buy some metal and make a Mr. Charcoal Maker Jr. for the club. I'll provide some pictures of the process in next months report. Thank you Mark Winchester for hosting our meeting and everyone else who attended, participated and donated items and service to help our meeting happen.



Regional Reports



Summer camp is back at St. Petersburg Pioneer Settlement

By Jay Dugan

After a four-year hiatus, the Pioneer Camp at Pioneer Settlement in St Petersburg has re-introduced blacksmithing as an activity. I have the opportunity to be the blacksmith in residence there for the summer. The campers get to do a simple hands-on project with safety protocols and adult supervision.

The first week was a wonderful experience for me, and I think the kids enjoyed it too. According to the St Petersburg Parks and Rec, the camp focuses on crafts and activities to foster team building, leadership, and self-esteem. Campers will experience a time when family, friendship, and character were as important as food, water, and shelter.



FABA Announcement

Florida Artist Blacksmith Association Veterans Scholarship Fund Application 2024

1. Recipients must be veterans of the U.S. Armed Forces (Navy, Air Force, Army, Marines, Coast Guard, Space Force).
 - a. Individuals must be able to provide proof of service/separation (DD 214 or an appropriate ID)
2. Scholarship will reimburse 80% of a blacksmithing class/course(s) registration fee up to \$100 upon completion of the course, whichever is less. (for example, if the course(s) cost \$135, 80% of that is \$108, so the awardee would receive \$100; if the course(s) cost is \$95 then the awardee would receive \$76). Formula for determining award:
$$\text{Registration fee(s) \$} \underline{\hspace{2cm}} \times 0.80 = \underline{\hspace{2cm}} \text{ TOTAL (awardee would receive \$100 or less of total course registration costs)}$$
3. The coursework must be considered to be directly related to blacksmithing (not welding/fabrication). The FABA Scholarship Committee (defined in article 12 below) reserves the right to determine which coursework is appropriate during the review process.
4. The course instructor must be someone who regularly provides paid blacksmith instruction – in other words is recognized as a legitimate, accepted teacher. Classes at a recognized blacksmith conference (such as the FABA annual conference, The Southern Blacksmith Association biannual conference, SOFA, etc.) are acceptable and specifically at these events, 2 or more classes in one weekend could be stacked and counted as one ‘course’. So, for three (3) FABA intro courses at \$45 apiece, the total would be \$135; 80% of that would be \$108, so the award would be \$100.
5. Before awardee is reimbursed, he/she must provide some proof of completion (documentation of work produced, email from instructor and receipts from course costs). This scholarship is intended for course registration fees only, and does not cover materials or equipment unless those items are part of the course of instruction (i.e. a hammer making course). Students may apply for up to 2 courses per year, but not more than once per six-month cycle and for no more than 3 courses in total.
6. The student must apply for the scholarship prior to the beginning of class (not retroactive). The committee will meet February 15 and August 15 each year to review applications (every 6 months). Up to three applications will be awarded every six months. Coursework does not have to fall within the cycle the student applies, if the application is submitted prior to the start of the course (for example, the student could plan 1 year ahead). The FABA Scholarship Committee (defined in article 12 below) will make that determination during the application process.
7. In any 6-month cycle, preference will be made for beginner classes, then intermediate skill classes as the primary purpose of this fund is to assist veterans to begin their blacksmithing journey.
8. Applicants must be a FABA member to apply and while taking the class/course.
9. Funds can be applied to the FABA annual conference courses, or to similar classes from other guilds or organizations, within the United States. See article 4, above.
10. If anyone wishes to donate additional funds to this scholarship, they agree to abide by the rules above. In other words, future donors cannot modify or change the administration or award process for this scholarship. Any funds donated specifically to this fund will be considered encumbered for this purpose only.
11. Applicants will complete the application and submit their request via email to (add email contact) or through the electronic form on www.blacksmithing.org.
12. The FABA Scholarship Committee is comprised of a three-member panel of FABA members. At least one member of the panel will have military experience (active duty or reserve) and two others will be FABA Board members. The President, Treasurer and Vice-President will appoint the members of the Veterans Scholarship committee. Members will serve a minimum one-year term but may be reappointed multiple times.
13. Awardees will be notified via email and USPS the status of their application approximately two weeks after the committee meets.

Contact Doug Hayes at djhayes29@hotmail.com or download an application at www.blacksmithing.org

FABA Veterans Fund Blacksmith Class Scholarship Application 2024

Overview:

The FABA Veterans' Scholarship Fund was established to help veterans to experience the world of blacksmithing. The intent is to assist veterans to get started in the craft with an experienced teacher to provide a guiding hand at the start of the journey, maximizing their learning experience. As such, it is not intended for those with intermediate or advanced skills to hone their craft – rather to assist beginners to learn the basics or to advance to some intermediate skills. First priority will be given to first-time students or early beginner level classes, and then to intermediate level courses.

Required Information:

Name: _____

Branch of Service: Army / Air Force / Navy / Marines / Coast Guard / National Guard / Space Force

Dates of Service: _____

Blacksmithing Experience: _____

Address: _____

Phone: _____ Email: _____

Title of course: _____

Anticipated Cost/Tuition: _____

Location of course: _____

Instructor/school/conference information (website, email, phone): _____

What do you hope to learn from this course: _____

I agree to provide some proof of completion of the course in the form of photos, certificate, email from instructor and receipts from the course cost.

Signature: _____ Date: _____

Complete and send a copy via email to: djhayes29@hotmail.com or mail physical copy to Doug Hayes 3541 Lone Wolf Trail St. Augustine, FL 32086. Applications should be received before Jan 30 or June 30 for each period.

Award Committee:

Approved by: 1) _____ 2) _____ 3) _____

Date of Approval: _____ Date Completed: _____

Building a Star Trek bar

By David Sandlin

Is this blacksmithing? Well, sort of. At least a lot of metal work was involved.



At Traditions Workshop, we are privileged to get unique projects almost every day. Those projects require my son and I to have a raft of skills that range from wood working, to stained glass, to leather craft, to finishing, to all types of metal work. However, when we were approached by a local tech company called “Bit Wizards” to build a bar for their break room we really had to expand our skill set.

We had just finished rebuilding several breakroom tables for Bit Wizards in the “green and green” style and while delivering the tables to their new building I asked about the large blank space in the break room. We were told that space was reserved for a company bar that the contractor had failed to delivered on. Casually we asked about what they were looking for and the answer was “we’re not sure, really just something that we can use as a hang out space on Fridays.” To which I replied “So why not build Quark’s bar from Deep Space 9?” (Fortunately, I’d been to Quark’s bar in Las Vegas on an Air Force assignment years before, so I had some ideas already). The business owners are big Star Trek fans and they jumped at the idea. A quick internet search and a few sketches on the back of a napkin, and we had the job.

Our Wizzy Space 9 (shortened to WS-9) tasking was simple; build a “dry bar” for a company that is comprised of nerds. Specifically, a bunch of nerds that love Star Trek, Star Wars and almost anything else in the space science fiction genre. We were given a budget, plus free artistic license for the design and build based on our initial sketches; our timeline was 9 months.



One of the biggest problems we had with this task was “mission creep.” One good idea spawned a dozen more. We wanted the bar to have a metallic look like the TV series. So, the cabinets were made of MDF, which I hate to work with but it is dead flat and when treated with Modern Masters metal paint, it looks the part for a metal bar. The front face of the bar is corrugated roofing plastic that we discovered could be cut smoothly with a jig saw.

FABA Project Report

Discovery and experimentation were watchwords for this effort. How could we get the light to defuse in the slits in the bar front? We tried fogging clear plastic with sanding and a number of aerosols before we read about using vellum (paper) to hide the pinpoint lights of the LEDs we were using. Almost every step required us to try something new, often we were not sure if our solution would even work until we tested it. There were many failures.

Our biggest experiment was our decision to top the bar with 16 gauge steel, and then provide a steel drink spill rail all around. Quark's bar in Deep Space 9 has a perforated aluminum top, which we deemed as totally impractical since a spilled drink would go right into the cabinets where the tribbles were hiding.

Welding ¼" railing to 16ga sheet metal proved to be much more challenging than we expected. We sought expert advice from other FABA members and tried all the techniques suggested to keep the sheet metal cool, but we still warped the 16ga. We also tried to un-warp the steel: Flame on one side and then pouring cold water on the other side is effective (and exciting) except when you have a heavy top rail and a 1/8-inch-thick, 2-inch-wide apron welded all around the sheet. Things don't go as expected.

Consequently, we now have plenty of warped 16ga in the shop for future projects like bosses for Viking shields and making steel bowls.

After 3 tries, our successful technique was to use contact cement to bond the 16ga steel to a 1-1/2 inch substrate as one would bond a Formica top to a cabinet. We then used both hot and cold bends to fashion the 2-inch wide, 1/8 thick apron so it would tightly encompass the bar top. Finally, we gas-welded the drink spill rail together, holding it off the bar top by several inches so we could shape it.

When it came time for the final fit-up, we would clamp everything in place, decide where we needed to tweak or bend a part, hold just that section off the table top with some 2-inch-thick steel blocks (55 # each) and use a torch to heat. We then would drop the piece onto the table top, lever everything into shape, clamp it down and douse it all with water.

After the section was heated to a dull orange using a torch, we could do the whole tweaking process in 15 to 20 seconds so there was only a little heat transfer into the 16ga, and that was quickly mitigated with the quench.

Once the fit up was complete, everything was bonded with liquid nails, a LOT of clamps and a couple of MIG tack welds (quickly quenched). The following day was spent grinding to final shape. We then used muriatic acid to clean the mill scale off the metal. (Wear your PPE!)

The final look on the steel was accomplished with "Steel FX" pantina. First using their "copper fx" product followed by their "Blue Halo." These products react with the metal in seconds, so we had to work quickly to get the effect we wanted. It was a three-man job. One on pantina, one with a hose to wash it off, and one with an air hose to dry it quickly. After everything was colored and dried off, we used two-part automotive clear coat to create a hard shiny finish. By the way, catalyzed lacquer on steel does not work (another failed experiment).

The bar back is perforated aluminum. Although more expensive than painted steel, it definitely had the look we wanted; plus, it was considerably lighter. After all, we had to deliver the finished project to the customer's location, and moving several hundred pounds of steel superstructure was an intimidating prospect.

I've had considerable experience with theater lighting so adding the LED tape lights and other electric elements was not difficult for us, just time consuming. The huge backlight panel is made of the same LED lights you'd find the ceiling of a modern office building today. However, when we assembled the superstructure and the bar back for the first time, we immediately realized the system was too tall to be operated comfortably by normal height humans. Vulcans on the other hand would have had no problem. So, the 6 foot tall light panel had to be cut back by 6 inches. Fortunately, the light panels were made of thin steel that cut easily with tin snips. We cut one strip of the LED lighting out and had the system rewired in a day. Cutting and squaring the aluminum super structure took longer.



Bar top, 16 gauge steel with Steel FX pantina.



Grinding and forming the steel top with drink spill rails.

FABA Project Report

We looked long and hard to find the all the unique bottles that make up the bar's window dressing. The original labels were removed from the bottles and replaced with vinyl decals that we produced in house. Using our vinyl cutter, we also created masks for the glasses so we could use an etching fluid to add Trek-like logos to the drink glasses.

Centerpiece on the bar back are the two "replicators." The system we used is called a "bottoms up" dispenser and fills specially designed glasses from the bottom. Very cool, and with the built-in flashing lights they look very futuristic when in operation. These dispensers require cooling to function correctly, so we designed a system to route cooling water parallel to the keg lines running up from the two refrigerators in the lower bar back unit. Unfortunately, we could only make the system replicate beer, other replication functions are not available.

As we drew closer to delivery day we had to declare a last good idea cutoff date, something that we still violated as someone on the team always seemed to have another "eureka" moment. For example, the colored light cooling fans are actually the high-volume type fans found in gaming computers and were added only a week before delivery.

Due to limited shop space we had to build the bar in two phases. First phase was to build and deliver the bar front. The second phase was to build and deliver the bar back. Our customer came to the workshop prior to delivery of each phase but they never saw both pieces together until final delivery. For that matter, neither did we. We just knew it was going to all work together. At least it was supposed to based on our paper models. And it did when we delivered! Task complete and a happy customer.



Bottom filling beer dispenser, automatically turns off when it reaches full.



How to Forge a Chili Pepper from Pipe

By Chris Cauthen

At the 2018 Florida Artist Blacksmith Association (FABA) conference, I took a chili pepper class. I had only been smithing for about 3 years, so I was still beginning. I loved the challenge of drawing down the end of the pipe. Making the stem was so fascinating, it showed a completely new way to shape metal. I made a few more peppers after the conference and then moved on to other adventures.

In 2024, I was perusing Mark Aspery's book *The Skills of a Blacksmith, Volume II: Mastering the Fundamentals of Leaf-work* and found a section on chili peppers. I picked up a few tips that I did not learn in the class, like shaping the crown. So, I started making peppers again and I was asked if I would do a workshop/demo at the FABA-NW Region January meeting.

I spent a couple of weeks making peppers and creating a storyboard. The workshop was a success, and five people made peppers. It was one guy's first time blacksmithing, and he completed a pepper. So after the meeting, I decided to try a how-to video and I started a YouTube channel "Double C Forge" to post the video @ doublecforge.

As long as you have done a few classes and are progressing, you should have no trouble making a pepper. But I would suggest that a less experienced smith find an experienced smith who can help guide you. The hammering is light, but there are two forge welds.

These are just fun to make, and people love them. I hope you try making one and have as much fun as I do.



Materials:

- 4" 3/4" black pipe schedule 40
- 6" 1/4" round rod



Chili Pepper Part 1: Drawing out the Point

Using a V swage block, or anvil step, slowly hammer and rotate the pipe, closing the end of the pipe without fish mouting. You want to end up with a gradual taper about two inches long. Leave a tiny hole for the stem. I created the V block by welding a 3/4" square mild steel to a Hardy post. I ground the corner off one end of the V block, and this made hammering the point easier as it got smaller.



Heat the point red, put a little flux on it, and bring it to forge temperature. Once it is forge welded, square up the tip, but leave blunt for now. It will be drawn out to a point later in the process.



Part 2: Necking the Top

Using a 1/2" round spring fuller or guillotine tool, start fulling about 1/4" from the other end of the pipe. Slowly rotate and hammer, trying to keep the neck round and in the center of the pipe. Be careful the first few heats to get the neck even all the way around.



Once you get the neck small enough, insert the 1/4" rod and fuller around it. You want the 1/4" rod snug but still removable.



Cool the pepper and cut off the fuller end, leaving about 1/4" to 3/8" that will form the pepper's crown.



Divide the crown into five sections and, using a file or grinder, round out between each section.



Part 3: Adding the Stem

Add a couple of 1/4" ball bearings or BBs to the pepper, and they will rattle like seeds. Use the 1/4" rod to tap in balls if they are tight. Insert 1/4" rod about 1-1/2" into the neck opening. Tap in with hammer if needed.



FABA Project Report

Heat neck to red and put flux around the stem. Heat to forge-weld temperature, and using the fuller, forge weld the neck to the stem.



Part 4: Shaping the Crown

Heat the neck and stem. Using a bolster plate or pritchel hole drop the stem into the hole and hammer down on the point of the pepper. You are pushing the neck and stem into the body of the pepper. Stop when there is about a 1/8" gap.



Holding the pepper from the point, heat the crown and tap the tips of the crown down, so that it touches the pepper body.



Part 5: Finishing the Point

The point of the pepper should be a square taper from earlier. Draw out the square taper to a sharp point and then round the point. You can make a little bend of the point to make it look more natural.



Part 6: Shaping the Body of the Pepper

Using the V Swage block, or anvil step, hammer one side into the V to start forming a three-sided pepper. As you hammer, the middle of each side will naturally buckle in. Rotate around the three sides until you get the shape that you like.



Part 7: Shaping the Stem

You can do all kinds of things to shape the stem.

1. Create a slight bend to make it look natural.
2. Draw out the stem and create a natural looking loop, so the pepper can be hung up.
3. Flatten the end of the stem and curl it over to make a bottle opener.
4. Use a longer 1/4" rod and use the pepper for has a handle.

You can also bend the pepper to give it a more natural look.



Part 8: Finishing

Wire brush and coat however you like.

I did paint a pepper with a red body and green stem.

I got mixed reviews.



Options:

These same steps can be used with other sizes of pipe to create several types of peppers or okra. With a larger pipe, you may be able to make a bell pepper. And with a longer pipe, make a carrot.

THE FLORIDA CLINKER BREAKER

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