N.J.B.A. Newsletter

NJBA Volume 25, Issue 1 August, 2021

Editorial

NJBA remains open for meetings, but more and more, recently, it has become obvious that the pandemic is not over. Accordingly, all upcoming meets will remain subject to the special COVID-19 rules in the box on this page.

The situation is bad. From what I read in the paper, more than 10% of Monmouth Co. residents have tested positive for COVID-19. It appears that the situation is less dire in the rest of the state, but that could simply be an artifact of less testing elsewhere.

Should the pandemic rage out of hand again, the NJBA Board may have to reverse the decision to open up, and may and shut down once more. We call upon all NJBA members to observe all precautions and do their part to help to bring this pandemic to an end.

Upcoming NJBA Meets

Sun., Sept. 5. Jonathan Nedbor at EJOT

Plans are well underway to hold a demonstration at East Jersey Old Town in Piscataway, NJ, from 10 AM to 4 PM. Jonathan Nedbor will be our demonstrator. A box lunch picnic for NJBA members will be available. **Tailgate sales are welcome**. For further information, please contact NJBA Director Ryan Amos. (Please observe Special Covid-19 Rules.)

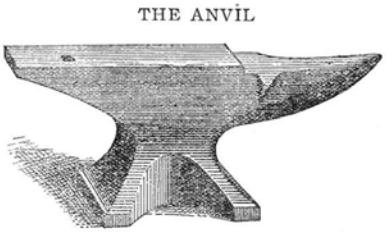
Sat., Oct. 2. Open Forge Meet for Princeton U.

NJBA has agreed to present another open forge meet for the benefit of the students of Princeton University. **Volunteers will be needed** to help set up equipment, coach students in blacksmithing, and break down the equipment at the end of the day. These sessions usually run from 10 AM to 4 PM. For further information, please contact NJBA Director Ryan Amos. (Please observe Special Covid-19 Rules.)

Please See the Last Page of this Newsletter for the combined renewal form, ballot, and volunteer form.

Anvil Repair Workshop

The NJBA Board would like to hold another anvil repair workshop this autumn. Price is not yet determined, but will likely be at least $150 per anvil repaired. If interested, please contact NJBA Director Tom Santomauro.



Special COVID-19 Rules

All attendees at NJBA events ***must***

- be able to prove they are vaccinated
- wear a mask covering mouth and nose,
- observe social distancing by remaining 6 feet apart.

So at *every* NJBA meet you attend.

- Show your photo ID
- Show your COVID-19 Vaccination Record Card (or a photograph thereof)
- Wear a mask,
- Maintain social distance.

You will not be admitted if you fail to follow these rules; you will be required to leave.

New Jersey Blacksmiths Newsletter

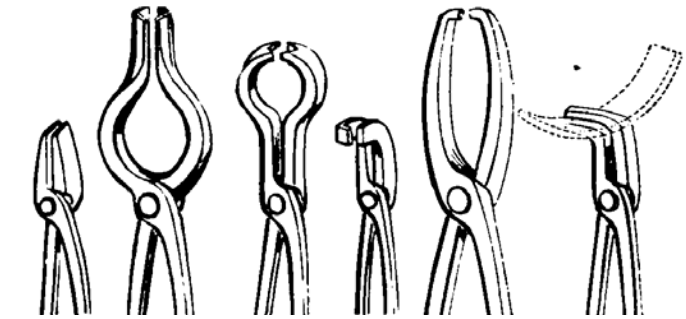
NJBA Board of Directors

Ryan Amos	**Bruce Freeman**
William Barrett	**Mark Morrow**
Marshall Bienstock	**Bruce Ringier**
Bob Bozzay	**Thomas Santomauro**
Larry Brown	**Ben Suhaka**
Eric Cuper	**Dan Yale**
David Ennis	

We like to thank those who joined NJBA as Business Members:
Marshall Bienstock

Blacksmith Coal and Coke Available to NJBA Members

NJBA has "nut" coal of good analysis available for purchase by NJBA members at 20¢#per pound, on a bring-your-own-bag and bag-it-yourself, honor-system basis. Plastic bags of at least 3-mil thickness are recommended. Please inquire of NJBA Director Marshall Bienstock for more information and to make payment.



NJBA's Official Address
NJBA, P.O. Box 224
Farmingdale, NJ 07727-9998

NJBA's Website:
http://www.njblacksmiths.org

NJBA Newsletter:
Will be found on our website (above). Look for "Current Newsletter" and/or "Newsletter Archive."

NJBA's Facebook Page:
https://www.facebook.com/njblacksmiths/

NJBA's IForgeIron subforum:
Scroll down at https://www.iforgeiron.com/.

NJBA's subreddit:
Reddit.com/r/NJBA
You can get a free Reddit account and post questions, links, pictures or whatever here.

Open Forge Meets

(**Important**: See the "Rules for Participation in NJBA Hands-On Events" below, and the "Special COVID-19 Rules," on p. 1).

Monday Night Open Forge, Howell, NJ

NJBA Director Marshall Bienstock hosts an open forge meet every Monday evening at 7 PM, except major holidays. (Please call ahead to make sure the forge will be open.)

Sunday Open Forge, Smithtown, LI, NY

From the beginning of November through the end of April, Ron Grabowski will open his forge in Smithtown, LI, NY, to NJBA members. Please call ahead to confirm and get directions: 631-265-1564. Ronsforge @ aol.com

Rules for Participation in NJBA Hands-On Events

These rules apply to workshops, open forge meets, demonstrations with hands-on components, etc.

1. Participation in NJBA-sponsored hands-on events is limited to adults (i.e., 18 years or older). This rule was effected as of December 4, 2016.
   (Note: This policy ***does not apply*** to open forge meets and similar events *that are sponsored or co-sponsored* by youth-oriented organizations such as scouts, 4H groups, schools or other venues.)
2. Workshops are open only to NJBA members, but nonmembers may join by paying dues when they register.
3. All workshop fees are due upon registering. Any materials fee is not refundable. A workshop fee is refundable only if your place in the workshop is filled by another person.
4. If you only want to watch the workshop, the fee is half the listed workshop fee.
5. Workshops are intended for the purpose of teaching certain skills and/or completing certain projects, and are subject to the authority of the workshop leader or instructor. Accordingly (as per a vote of the NJBA Board on Jan. 28, 2018.):

- The participant shall work *only* on the project at hand and not on any other projects, *without exception*. (Note: Any NJBA member may attend an NJBA open forge meeting to work on his own project.)
- Every participant will be required to follow the instructions of the workshop leader, especially any instructions pertaining to safety, or he may be ejected.
- A person who has a history of failure to follow instructions may be refused admission to any workshop, at the sole discretion of the workshop leader.

Old Leg Vise from Higgins Armory
(A wrench, out of sight in rear, is used to tighten.)

Demonstrators Needed

East Jersey Olde Towne in Piscataway NJ is looking for blacksmiths to demonstrate to school groups and the public weekdays and weekends through the fall. The Historic Village is open 8:30 till 4:00 PM and is located in Johnson's Park across River Road from Rutgers's Stadium.

Anyone who is interested can contact Matthew Stroh at EJOT 732.745.3030 Ext 304. More information can be found at http://www.middlesexcountynj.gov/Government/Departments/BDE/Pages/East-Jersey-Olde-Towne-Village.aspx

NJBA Director Bob Bozzay (robert.bozzay@gmail.com) currently works there two days a week. He can provide additional information.

ABANA'S Iron to Art Festival
Tickets are on Sale -- Register Early, Save Over 30%

The dates are set, October 14 through October 16, 2021.ABANA will host the Iron to Art Festival at our new headquarters in Johnstown, Pennsylvania. Tickets are on sale now.
https://event.abana.org

Early Registration Discounts Available!

-Member registration:	$125 before 8/31, $165 after 8/31
-Member Spouse registration:	$ 50 before 8/31, $ 75 after 8/31
-Non-Member registration:	$185 before 8/31, $245 after 8/31
-Non-Member Spouse registration:	$ 70 before 8/31. $ 90 after 8/31

ABANA would like to interest you in being a Craft Vendor at Iron to Art Festival. This is our inaugural event in Johnstown, PA and ABANA wants you! We are expecting 500 + visitors to the conference with 5000 visitors to Johnstown itself over this new three-day event and ABANA wants you to get in on the action. Rent a 12x12 vendor booth for $250 (for all three days), comes with electricity and if you're performing live demonstrations for your craft you will receive an ADDITIONAL ½ space for free to showcase your skills. There will be visitors and exhibitors from far and wide, what a perfect venue to showcase your crafts and passions. See ABANA.org, Iron to Art, then click on the vendor icon and we will SEE YOU THERE!!

Join the fun! Volunteer at the Iron to Art Festival. Help out for a while behind the scenes and get a free T-shirt! Email exedir@abana.org for more details! Volunteer opportunities, Indoor, outdoor, and tailgating spaces available. https://abana.org/volunteers-needed/

Business of Blacksmithing digital class taught by Leigh Morrell. The ABANA Business of Blacksmithing Classes are now complete. We are planning to make the class recordings available to members for purchase at the end of May, AND offer a new series on this topic! Please check or site for more

details. If you have any questions, or an interest in classes like this in the future, please email the Executive Director at exedir@abana.org

Discount Providers. There are several vendors that value us as customers and offer discounts to ABANA Members. The ABANA website has a list of those vendors that we can support while saving a few dollars. There is a new offer, a grinder discount, for ABANA members from Beaumont Metals. See the ABANA site for more details. Please visit www.abana.org to find discounts under the marketplace / vendor page.

ABANA is creating a touchmark registry. ABANA is creating a comprehensive registry of touchmarks. To submit your touchmark, please check the ABANA webpage and follow the instructions. https://abana.org/touchmark-registry/

Report on the July Board Meeting

In attendance (by telephone) were Ben Suhaka, Billy Barrett, Bruce Freeman, Dave Ennis, Marshall Bienstock, Ryan Amos, Tom Santomauro, and Dan Yale.

The upcoming picnic at EJOT was discussed. Ryan Amos will head up this effort with the support of Dave Ennis and Bob Bozzay.

No crane rail anvils have sold as yet.

The idea of holding a gas forge-building workshop was discussed. We still don't have plans for Mark Morrow's design. One of David Hammer's designs was considered. As yet, nobody has agreed to coordinate such a workshop. We'd need to fabricate at least one such forge before committing to holding the workshop.

Marshall and Tom reported on Walnford Day.

Bruce reminded everybody that dues are due.

Bruce reported that only five completed ballots received. Cut-off date is early September.

A possible anvil repair workshop was discussed. Tom reported that three anvils available for repair. Marshall recalls one more. The weldors need to determine a price per anvil ($150?) for the workshop that will cover our costs. Tom will revise the workshop announcement for the upcoming newsletter. Billy may be able to solicit donations of welding wire, so weldors should determine what they need.

Princeton University approached us for another open forge meet. Ryan will coordinate.

Bruce requested a policy be set regarding sending an email ("spam") to the NJBA membership. Marshall moved that the policy for sending out emails to the entire membership is that there should be 3 board members that agree on sending out any particular email. Motion passed.

Rough-Cut Crane-Rail Anvils Available to NJBA Members

Former NJBA Director Dan O'Sullivan donated some heavy crane rail to NJBA for conversion into anvils. NJBA Director Larry Brown torched these to rough anvil shape.

We are now offering these rough-cut anvils to NJBA members for $3/lb. Four such pieces are available:

- =2 ea. ~9.5" long and 28 lb, $84.
- 1 ea. ~13" long and 38 lb, $114.
- 1 ea. ~13" long and 40 lb., $120

Purchases will be cash only. Please contact NJBA Director Marshall Bienstock if interested.

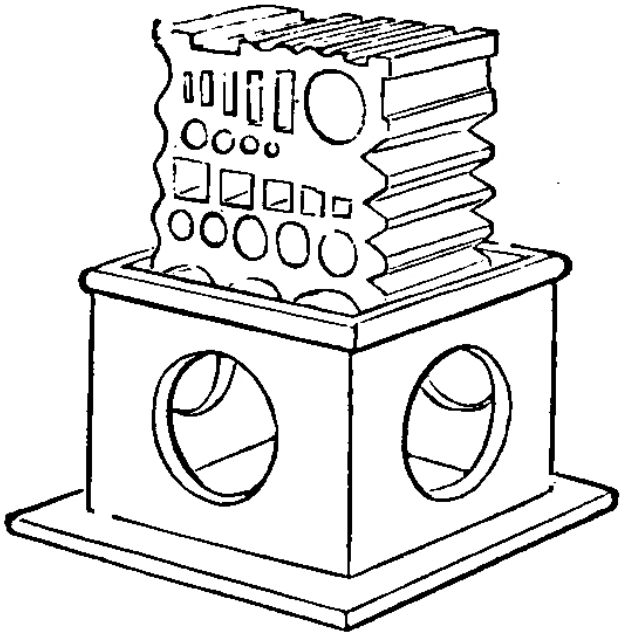
Reports on Walnford Day, 2021

by Marshall Bienstock
Tom and Marshall loaded up one forging station on Saturday. Sunday, Walnford Day, the weather was great, but few folks showed up much before noon. Larry showed up and stayed a couple hours. The three of them traded off at the forge, giving each other time to interact with the visitors. Later, Tom and Marshall worked together on a project.

by Tom Santomauro
Great day at Walnford. Marshall and Tom set up the NJBA forge and took turns demonstrating. We set up a very nice display of blacksmith projects for visitors to look at and ask questions. We promoted the NJBA to park visitors. Tom forged out a Fredrick cross and hook. Larry joined us later in day and made a leaf key ring. Marshall made a a back plate heart shaped bracket with three heart-shaped hooks. All around it was a great day and every one enjoyed the blacksmith demo.

by Larry Brown
On May 16 th I decided to play hooky from working on my house and go see what was going on at Walnford. I haven't been there in quite a few years and I have to say the park was nicer than I remembered it. Tom and Marshall had set up the tent, display tables and forge before I got there and Tom was forging when I arrived. I spectated for a while and talked to some of the people visiting the park as they came by. When Tom was done, I forged a small leaf with a ring for a key chain. Marshall forged next as is seemed Tom had pieces prepared for him to use. He made a Friedrich cross from a railroad spike and was then working on a coat rack bracket if I remember correctly. I left before he had completed the project as I had stops to make on my way home. It was good to get out and do something! I keep a mask on while walking around the grounds and most people were using a mask. I was vaccinated a while ago, but why push my luck?

Tom Santomauro at the anvil, with Marshall Bienstock "supervising." Photo by Larry Brown



Call for Entries - ABANA Home Office Sign:

The ABANA Home Office in Johnstown, Pennsylvania is looking for members to design signage for the new Home Office location. The chosen blacksmith will have the honor of creating the sign for ABANA's first Home Office at the historic train station and will be paid to forge and fabricate the sign or sign(s). Included in the entry should be the cost or quote for creating each sign including labor and materials.

This call for entries is for ABANA affiliates and members to propose designs and quotes for two types of signs:
* A flat building-mounted 3' X 5' foot vertical sign (side of building)
* A hanging sign that will jut out from the building with a forged bracket 4' X 6'

The signs need to include the ABANA logo (trademarked) and the street address: 47 Walnut Street, in the design. The location where each sign will be installed is pictured. Submit your design entry/ quote.

Entries must be submitted via web link, postmarked or email by August 31st , 2021

Submit your interest by completing this web form:
https://abana.org/call-for-entries-home-office/

For details or questions on both opportunities, contact:
Janie Grela, ABANA, Executive Director:
PO Box 426, Johnstown, PA 15907 814 254-4817 OR
emailed to: exedir@abana.org

Learn How to Make Your Little Giant Power Hammer Work Harder than Ever!

In 1991, Sid Suedmeier, having recently acquired the dusty remains of the Little Giant business, hosted his first Little Giant Hammer rebuilding class.

This 2 1/2 day class is a hands-on format. You will help transform a 25 LB Little Giant hammer from sloppy to sharp. **This is the last class that Sid Suedmeier, intends to teach.** He will be handing the reins over to David Sloan, who has attended at least 15 classes and has assisted Sid through the years.

An old style 25 LB Little Giant will be rebuilt during the class, and a new style machine will be on hand to demonstrate proper assembly and adjustment of both styles.

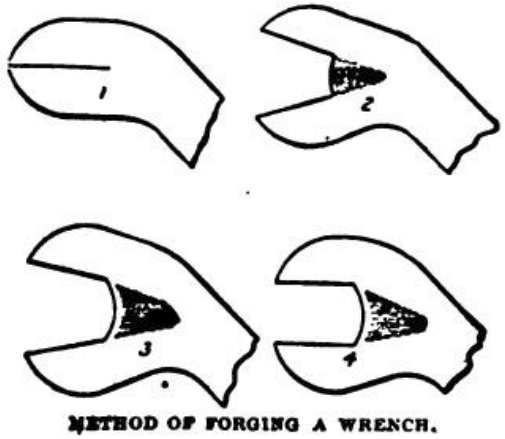
School Dates: October 15-17

Please call or email if you have any questions, or prefer to register by phone. You can reach us at 402.873.6605 or Sidsshop@windstream.net.

Sid's shop is located at 420 4th Corso, Nebraska City, NE 68410.

QUICK AND EASY WAY TO FORGE A WRENCH.

A simple and expeditious method of forging a wrench is described herewith. A ¾-inch wrench of medium weight is mentioned for the sake of convenience. Take a piece of steel ½ by 1⅛ inches, says B. E. Pease in the American Blacksmith, bend to shape and round the corners, then split, as in Fig. 1, back ¾ of an inch. Next take ⅝-inch fuller (if you do not have one at hand, use a ⅝-inch round iron) and fuller



METHOD OF FORGING A WRENCH.

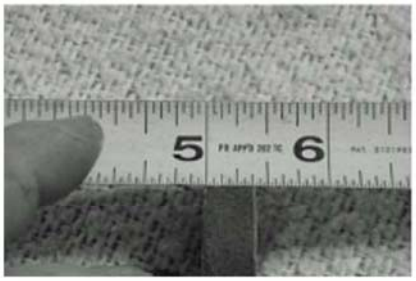
in a little to spread the jaws. Fuller on one side only. Then with a ¾-inch fuller spread the jaws wider, as in Fig. 2. Next drive the fuller in between the jaws until they are spread the right width, Fig. 3. Then turn the jaws and forge the handle to suit the work required.

This 1 page article reprinted from the New England Blacksmiths, Summer 2012

A Forged Rosette

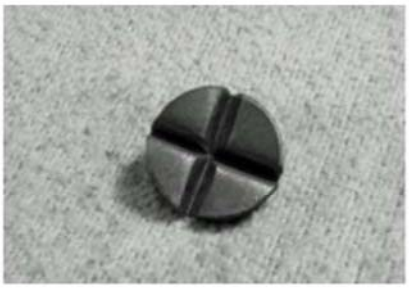
By Judson Yaggy, VT Rep

Here is a way to forge a rosette that can be applies to any number of pieces. You could rivet this onto larger piece, or weld it onto a threaded shaft to make a small door pull, whatever you dream up.
Start by sawing off a slug of round stock. The one shown is around 1-3/4" diameter by 7/16" thick, but anything approximating those proportions will work.



Get it good and hot and using a hot set or a hot cut chisel bisect the disc to a depth of around 3/4 the thickness. Repeat with the hot set 90 degrees to your first incision. You are dividing the stock into 4 equal parts.
Using a teardrop shaped punch, shape the 4 resulting flat spots by sinking the wide section of the punch close to the center of the circle and the narrow end pointing toward the edge.

To make a teardrop punch forge some round alloy steel as if you were making a simple chisel, but after the first few blows change your hammer angle from making an even thickness edge to one that is thick on one side and thin on the other. Liberal grinding of the punch to get whatever shape you are after is okay.



Repeat on all 4 quadrants of the stock. What makes this element look good is the deformation of the straight chiseled edge when the tear drop punch sinks into the adjacent material. Don't be afraid to really send the punch into the work piece.

Lightly sand and then oil with your finish of choice.

Just Stay Put! By Bob Pickens

This guillotine is made pretty much from the standard design you may have seen but, it has one big difference that will make it stay in place and not bounce. Movement in the use of this tool is annoying and the cut or groove you are making can get out of line with the tradition square hardy post. This design has a "lock" that will keep it firmly in place and will eliminate movement when you are striking the hammer block of the guillotine. This "lock" can also be added to any tooling you would like to secure in your vise. Follow the step by step instructions for a good fit.

If you already own a guillotine, you can add this locking device to yours or if you are building one, make plans to add this nifty device to hold it in place. The following directions are for a 1" hardy, if your anvil has a larger hardy hole, adjust accordingly.

1. The "lock" is designed to fit in your hardy hole and is made from 3/8" X 1" X 10" flat bar, bend in a "U" shape using a 1/4" flat bar spacer in the center.
2. Heat the 3/8" X 1" flat bar in the center (heat with a torch to control the bending area). Place the 1/4" flat bar with a rounded end in the center of the 3/8" X 1" flat bar. The rounded end on the spacer flat bar avoids sharp corners on the inside of the "U".
3. Your first bend is done in the anvil upright, the continued bend is done squeezing the two ends together. One end will be slightly longer than the other, grind to match.
4. Prep the two ends to weld to the bottom of the guillotine by grinding a 45 degree bevel with an 1/8" land (flat spot). Make sure it is lined up with the guillotine and MAKE SURE you have it in the correct orientation. (Because…."it" could happen"!)
5. The drift is made from a piece of 1/4" X 1 1/2" flat bar, saw cut at an angle from 3/8" of an inch to nothing over 6 1/2", approximately. A hole can be drilled in an end to secure with a chain or for hanging up. This would help it not be confused with just a piece of extra material in the shop.

Bob has a complete guillotine for sale with this locking mechanism if you are interested.
Call: 412-496-9389 or country_fab@msn.com



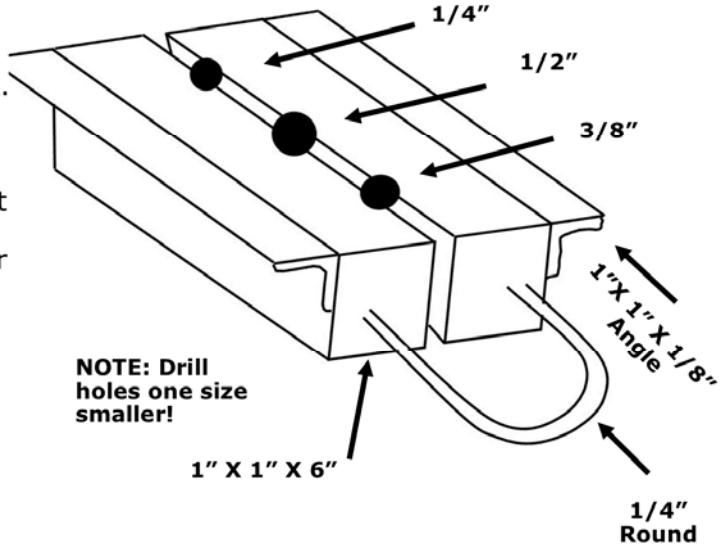

"U" is folded in half, cut ends to match. Grind 45° angle with a 1/8" land for weld. The drift can be cut from 1/4" X 1 1/2 " flat bar, grind corners round. Drill hole for a chain or attachment so it does not get lost or is mistaken for a piece of stock! That can also happen!

The articles on this page and the previous page are from PAABA Newsletter, May, 2021

Bob Elliott Forge

Upsetting Tool

On Upsetting:
Upsetting tool for 1/4", 3/8" and 1/2" round stock.
How to:
Place a business card between two 1" X 1" X 6" mild steel and clamp together. The business card serves two purposes, 1. for spacing, 2. the drill bit will follow the card and stay on center. Drill one size smaller than 1/4", 3/8" and 1/2" in the center of the two clamped bars. After the holes are drilled, weld angle iron on both sides. The angle iron will hold the tool in your vise. Finish by welding on a "U" shape on the end of bars. This upsetting tool will securely hold your metal in place while you hammer.
The angle iron is used to hold the tool in the vise.



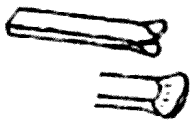
Colonial Lighting

By Jerry Darnell, From the Hot Iron Sparkle, Notes by David Tucciarone, Drawing by Kim Harris

LAMP

1 **Tripod Base:** use 3 16" x 3.4"

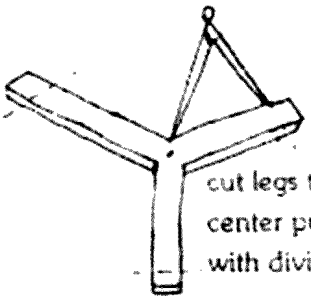
Piece 1 cut to length of one leg (your choice). on one end, scarf corners and bring out middle (no more than 1/2" scarf).



Piece 2. cut 2x's length of piece bend on edge, in center, to 120° scarf outside corner of bend

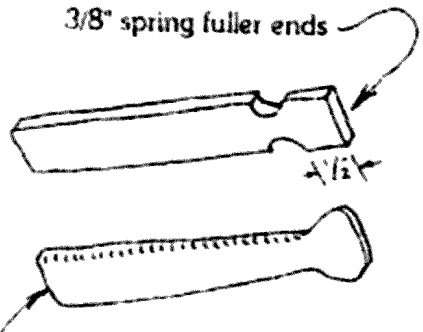
WELD 1 and 2 together.

SHAPE: legs should be 120° apart.



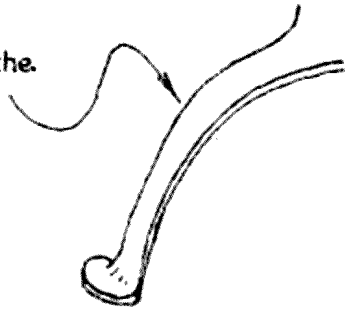
cut legs to equal lengths by center punching then scribe with dividers.

3/8" spring fuller ends



straighten legs, chamfer slightly, work feet into desired shape. (beans, circles, etc...)

Bend legs over the horn, then feet



2 **UPRIGHT:** use 1/2" rd

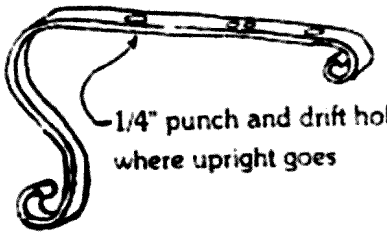
CUT 14" long , taper, and straighten.

upset one end to 5/8" form 3/8" tenon

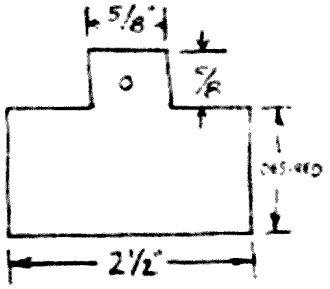
Colonial Lighting - continued

3 ARM: layout by eye (no set length) use 3/16" x 1.2" bar

make ribbon scroll ends bend 3/4 turn scrolls to your liking



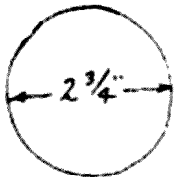
4 CANDLE CUP: use 16 or 14 ga sheet. layout and cut per drwg mount cup with seam toward upright



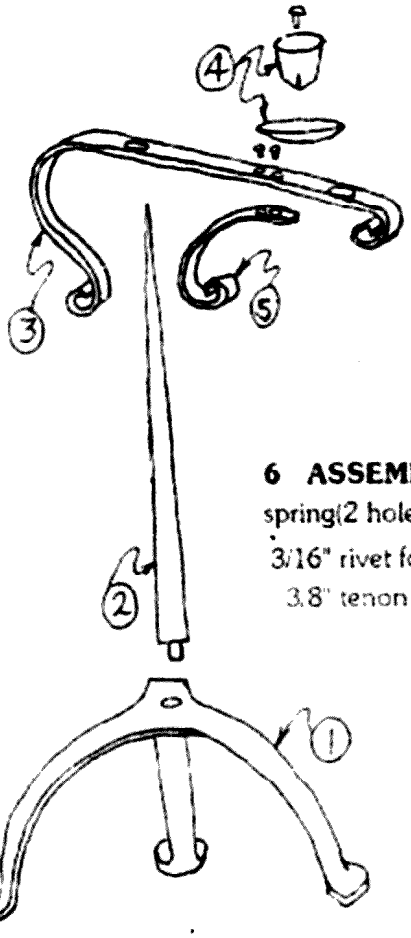
drill 3/16" on bottom tab
bend bottom over, then shape 3/4" round cup.

5 SPRING: use 3/16 rd. 1055 flatten out. form 3/4 turn scroll and shape end as necessary

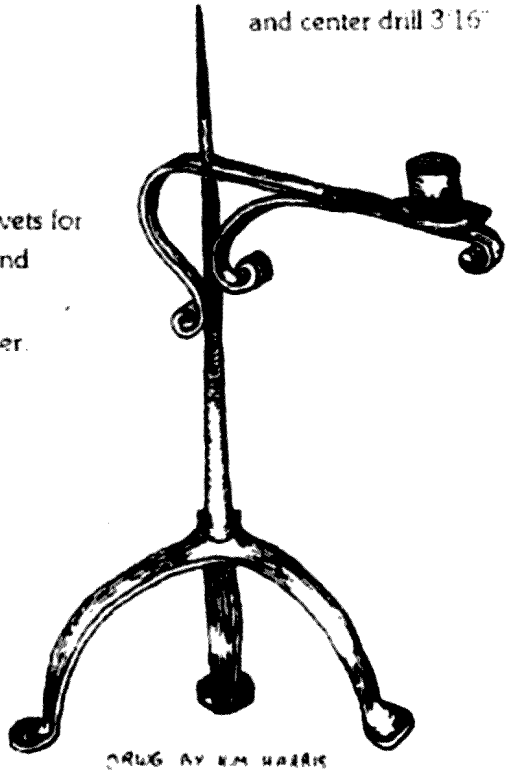
ALLOW SPRING TO COOL!



shape drip cup as desired and center drill 3/16"



6 ASSEMBLE: using 1/8" rivets for spring(2 holes. attach to arm) and 3/16" rivet for candle parts.
3.8" tenon upright to base center.



DRWG BY KM HARRIS

Easy Candle Cups

David Bridenbaugh

(Photos by David Bridenbaugh)

These candle cups are easy to make once you get the procedure worked out. This is how I make them, but, of course, there are different ways to do it. We will be using 3/4" schedule 40 pipe. The actual dimensions of the pipe are 0.824 ID, 1.050 OD and 0.113 wall thickness. It makes me wonder why it's referred to as 3/4", but we won't go down that road today. Cut the pipe to a length of 3.5", and scratch a line all around it at the midpoint of 1.75". This mark won't be used until later, but it's easier to do it now.

The first step is to flare the opening at each end. I made these top and bottom hardy tools to flare both ends at the same time. It would work just as well to flare them on the horn of the anvil with a ball peen hammer. The next step is to use your favorite fuller tool (guillotine, spring fuller etc) to fuller the midpoint down to about 1/4" - 3/8" diameter. Cut them in half and grind the stub down.

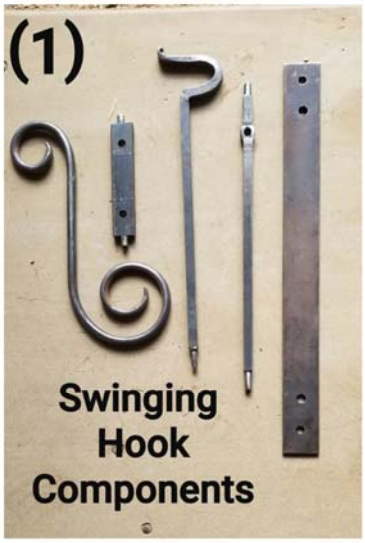
The drip tray can be a 3" diameter circle, slightly dish shape. A square (2 1/2") with the corners curled up and slightly dish shape looks nice also. Drill a hole and mig weld the candle cup from the bottom.

♦

The Swing Hook Project: Enhancing Basic Skills

Len Ledet

Several years ago Mo Hamburger received a commission to construct several "swinging hooks". It was a good project that encompassed the applying of many of the basic skills of blacksmithing. This included joinery skills thru the construction of tenons, heading of tenons, and collars as well as heating, drawing out, bending, upsetting, and piercing . With Mo's blessing I decided to re-create the project. It was a fun project and great to practice and enhance basic skills.



Hook Components: Scroll:1/2" round 14 inches long; Tenon Bracket: 1/2" x 1 1/4" x cut length 2"; Hook: 1/2" x 1/2" x 17" long; Swing Bar: 1/2" x 1/2" x 15"; Mounting Bar: 2" x 3/16" x 22" long; Collar Material: 3/16" x 1"

Swing bar with ai"Slit and Drift" hole and tenon. See Mark Aspery "Mastering The Fundamentals Of Traditional Joinery". Excellent book.

Tenon bracket, Cut both ends 2 inches long.

Tenon bracket and collars ready for assembly

Tenon bracket ready for welding

Tenon in countersunk hole.

The Swing Hook Project: Enhancing Basic Skills (continued)

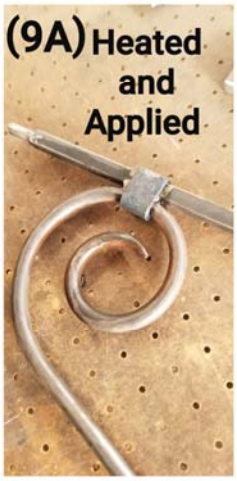
Tenon Joinery

Ready to head the tenon

Heating and forging the tenon head

The complete joint

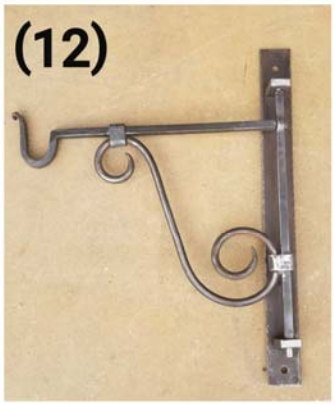
Collars forged and ready to be applied



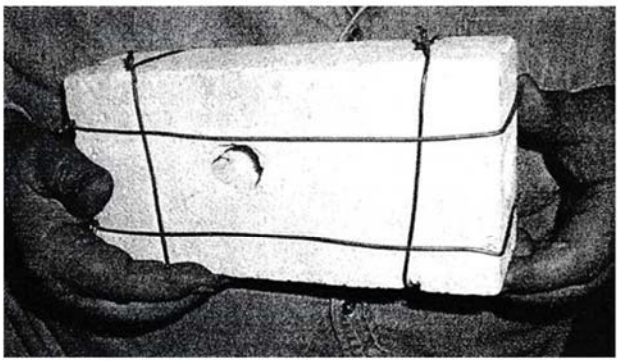
Collar applied

Slip the swinging assembly into the top tenon bracket.

Slip the swinging assembly into the bottom tenon bracket and weld that bracket to the mounting bar.



Finished



Making the One Firebrick Forge, My Way

By Jim Battee

In his book, Wayne Goddard's $50 Knife Shop, the author tells of his micro-forge made out of a single SOFT firebrick and heated by a simple propane torch. I emphasize the word SOFT, because he says the hard brick simply does not work. Mr. Goddard is primarily a knife maker, specializing in "wire Damascus," a.k.a., a cable knife, and he uses this little forge for making small blades and heat treating. Any small project such as small hooks, stems and leaves, or small implements can be fabricated. He explains what he calls "the world's smallest forge" workings, and how it is utilized in some detail, but when it comes to actually coring out the firebrick, he more or less leaves one to his own devices. Goddard says he makes his by using an old knife or an old drill bit. What I found to be a simple method, for me, was to use a woodworker's auger bit in a brace to do the drilling. My drill press was too short to fit the brick standing on end and the length of the auger.

My solution to the problem was to mount the brick in my Black & Decker WorkMate with it resting on the vertical cross member so it would be supported from below and I would not have to over tighten the tables. Doing this enabled me to stand with the drill bit aligned as vertically as I could approximate. Because the brick is light and fragile, drilling was done VERY slowly. I drilled about 3/8" then backed the auger out to clear it. Virtually no downward force was used on the bit. Knowing that trying to drill all the way through that way would amplify any error; I stopped about half of the way in, and finished drilling from the other side. This proved to be a wise decision, as the bit had angled away from the centerline I was trying to follow. Fortunately, I didn't poke through the side with the auger, but the brick is a little thinner there than what I had planned. However, it did not affect the brick's working effectiveness. Drilling the heat hole in the center was easy. Just be very careful not to crumble the brick. If you have to, make a small starter hole to gauge how much wall you have to penetrate. In my case, it was only about a half inch.

Since I made the first one, I have come up with some solutions to problems making it. One thing I will do differently on the next one I make is to use a softer steel wire in making the wire reinforcing cage for the brick. Mr. Goddard suggests doing this as a precaution. Once fired a couple of times, the stability of the firebrick decreases, and the wire around the brick makes it sturdier. I used a galvanized steel wire which I found did not conform to the contours of the brick the way I wanted. My suggestion: use something more pliable. I have not experimented with copper wire, but on my next try that is what I plan to do. It may have too low a melting temperature, but I won't know unless I test it. Also, I propose to drill a pilot hole. I have some small diameter jobber length bits that are just shy of the length of the brick. Mounting my drill press on spacers and pivoting its head will let me use the longer bits, so the next one should be spot on. I will still use the auger bit and brace for the larger holes as I fear the drill press might be too much torque for the fragile soft brick. Firing up the micro-forge is easy. You mount the forge brick on top of several garden variety bricks or hard firebricks to elevate it off any surface and prevent it from setting it afire. The propane torch used has to be set so the nozzle is about an inch outside the side hole in the brick. Set the flame as fuel rich and let it curl around the hole. In about 5 minutes, you should be up to working temperature, if the torch is set right. You may have to play around with the fuel setting to get optimal heat, but once you get right, you can run at that until you run out of fuel.

A little piece of advice: instead of buying a steady stream of small propane bottles and discarding them when they get empty, Harbor Freight sells a propane bottle refill gadget (that really does work) for about $10, if you catch it on sale, which is pretty often. Mine has saved me a ton of money on bottles that would have only been thrown away without it. The propane tank that is used with your back-yard barbeque is the source of your fuel. It's a lot cheaper to refill, than to buy a dozen or so smaller ones.

/From BCGM's *The Hammer & Tong,* Nov.-Dec. 2005

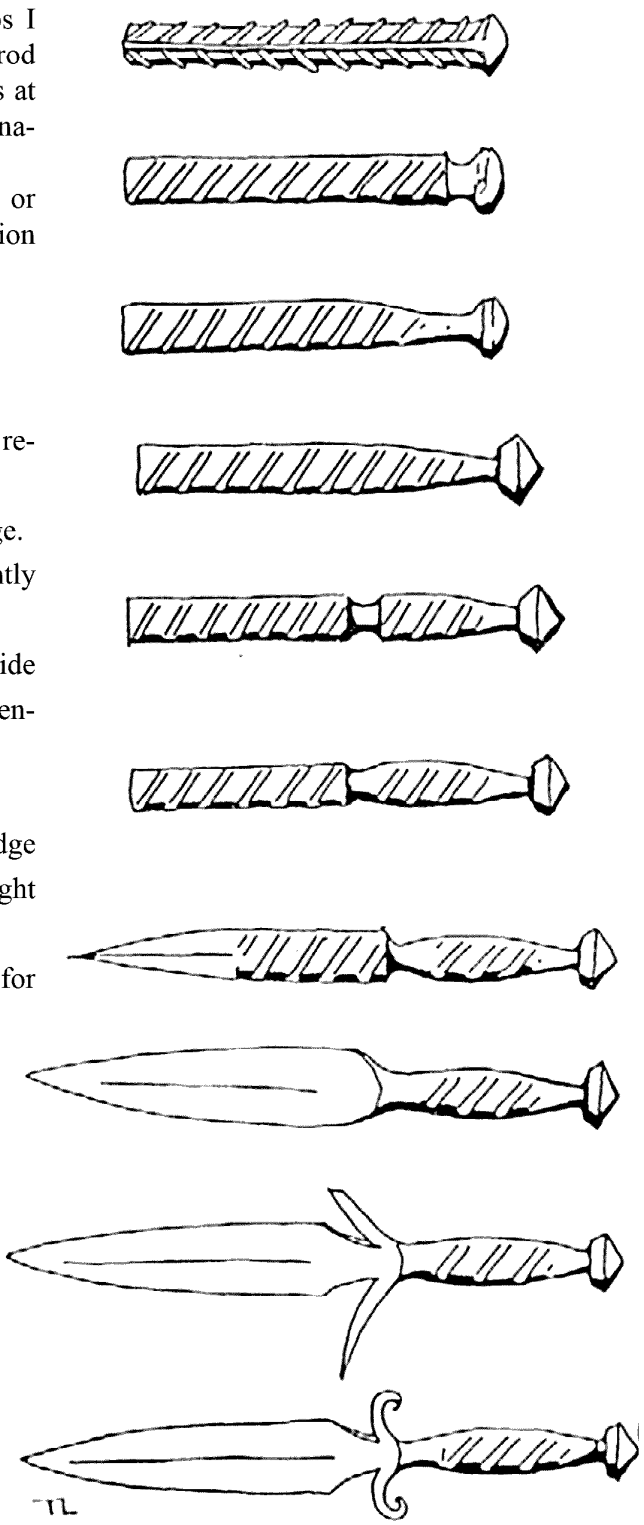
Letter Opener

Article by Tom Latane
Reprinted with permission from *On the Anvil*,
Newsletter of the Philip Simmons Artist Blacksmith Guild

The drawing [to the right] shows the steps I used making a letter opener from reinforcement rod from the Berlin Wall. Lots of smiths bought pieces at the past two Metalsmith Madnesses thanks to donations by Doug Johnson.

The project can be done from any rebar or round rod. Round rod will not have the nice decoration on the handle.

1. Upset end slightly.
2. Fuller around and below upset.
3. Draw down to fullered depth (do not reduce to less than 1/2 the original diameter).
4. Dress ball or knob on end over anvil edge.
5. Fuller to define handle allowing slightly more than 1/2 bar length for blade.
6. Draw down to fuller depth on handle side taking care to preserve a portion of ridges at center of handle.
7. Point blade drawing squarely.
8. Flatten blade in plane with continuous ridge on each side of bar. Spread with cross or straight pein for greatest width.
9. Chisel away a portion each side of blade for guards. Draw guards to points.
10. Scroll guards, dress with file.



Reprinted from Guild of Metalsmiths, July 1992

NJBA Membership Renewal, Ballot, and Volunteers' List

1) ***The dues holiday is over. Please Renew Now for 2021-2022.***
2) ***If you want to receive printed Newsletters by mail, please also remit the $10 subscription fee.***
3) ***Please Vote for the Board of Directors.***
4) ***Please Volunteer.***

Mail completed renewal form and ballot, along with check for dues, to:
NJBA Election, P.O. Box 224, Farmingdale, NJ 07727-9998

Name _____

Address _____

City, State, Zip_____

Phone Number(s): _____

Your correct Email address is essential if you don't care to pay $10 extra for a mailed Newsletter! Please Print Clearly!

Email address _____

My check is enclosed: [ ] $20 (regular membership dues), or
[ ] $40 (business membership dues)

Ballot for the Election of the NJBA Board of Directors

Vote for each Director by checking the box by his name.

Nominee	Nominee	Nominee
[ ] Ryan Amos	[ ] Larry Brown	[ ] Mark Morrow
[ ] Billy Barrett	[ ] Eric Cuper	[ ] Bruce Ringier
[ ] Marshall Bienstock	[ ] Dave Ennis	[ ] Tom Santomauro
[ ] Bob Bozzay	[ ] Bruce Freeman	[ ] Ben Suhaka

NJBA Volunteers List

"Please put my name on the list of potential volunteers:" (**Circle** all that apply.)

Availability: Saturdays Sundays Weekdays
Interests: Demonstrating Coaching Novices Assisting at Workshops
Blacksmithing Experience: Novice Intermediate Experienced Professional
Other Experience: Weldor Fabricator Other Metalwork
Writer Editor Photographer Videographer
Facebook Contributor Yahoo Group Management IForgeIron Contributor
Other: