



# N.J.B.A.

**NJBA Volume 12, Issue 3 10/29/07**  
<http://njba.abana-chapter.com>

## Editors Soapbox

Hi, we have been working to line up some great events for the next year. You can all help by making suggestions for demonstrators that we can contact and try to arrange in the future. Remember this is your group find some way of being involved and you will enjoy it more. Larry Brown, Editor

## Upcoming events for 2007 –8

Get you calendars out and mark these events down. Please bookmark our web site and check for updated meet information. Remember most of our meets have an "Iron in the Hat" drawing, so be sure to bring something. Meet information starts on this page and continues on page 3.

**November 3rd - 9AM-** Randy McDaniel , Demo on sculptural work – Also this is a membership meeting to vote for the directors. Eric Cuper's shop in Easton Pa. Information on page 3.  
Coordinator—Tim Suter

**December 9th** Holiday Party, Contact Marshall and Jan to find out what you can bring and we hope to see you there!.

**January 2008** possibly Demo by Eric Cuper and Daniel O'Sullivan We will postcard if we can arrange the event and the date

**February 23th, 2008-9AM -** Demo Mark Marrow At Marshalls Mark is our resident sword smith who lives in Brick and has been coming to the open forge at Mashall's. Mark will probably demonstrate making a gladius sword. No fee expected David Macauley

**April 27th 2008 Noon – 4PM** Public demo at Speedwell village in Morristown NJ Will require bringing trailer or personal equipment. David Macauley

**April?** Anvil Repair Workshop If we have enough people, contact Bruce Hay 732-747-4758. If there are any other ideas for a workshop contact Bruce or a board member and have him pass the idea along.

**June ?** Demo at HCSV Its an annual event – I have pushed to have this in June again. Will bring the trailer for a weekend. Awaiting a date from the village. David Macauley

**July ?** Delaware City Day Great family event, will set up the NJBA tent outside Kerry's shop for even more demonstrations, teaching and fun!  
Kerry Rhoades and John Chobrda

**August ?** Middlesex County Fair Need demonstrators during the week. This will be an NJBA event but demonstrators are paid by the fair. David

**September ?** Peters Valley Pig Roast  
**September 28 ?** Red Mill Hammer In, Robert Bozzay, Eric Cuper , Adam Howard

## Randy McDaniel Demo At Eric Cupers Shop

The address is:  
1301 Lynn Street  
Easton, PA 18042  
Any problems finding my shop, call: 908-642-6420  
or 610-438-8694

Continued on Page 3

## Notice

We have received sad news regarding our member Jeff Morelli. Jeff has passed away. Any donations NJBA members are able to make to an educational fund for the benefit of Jeffrey's children would be appreciated. "Morelli Children Fund" and sent to Mark Cubberley, 282 Main Street, Groveville, NJ 08620.

# New Jersey Blacksmiths Newsletter

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## **The NJBA Web Site!**

The NJBA Web Site is up and running at:

<http://njba.abana-chapter.com/>

The Newsletter is at:

<http://members.bellatlantic.net/~vze25jcc/index.htm>

## **Official NJBA Address**

**NJBA**

**P.O. Box 224**

**Farmingdale, NJ**

**07727-9998**

Rather than use room in the newsletter,  
All correspondence between  
ABANA and NJBA is now being posted  
on the NJBA web site.  
If you cannot access it there, contact me  
and I will send you copies

## **NJBA Board of Directors**

## Randy McDaniel Demo At Eric Cupers Shop

### 9AM Start

The address is:

1301 Lynn Street

Easton, PA 18042

Any problems finding my shop, call: 908-642-6420 or 610-438-8694

### Directions:

Assuming everyone is coming from the east. Get to 78 or 22 west from wherever you are coming from. 78 and 22 merge for a while. Take the last exit in NJ, Exit 3, which is Route 22 into Phillipsburg. Take 22 all the way through Phillipsburg, through the toll (75 cents) into PA. You are taking the very first exit immediately off the bridge so stay to the right out of the toll. Exit right and keep bearing to the right on the exit ramp, you will pass under 22 and come to a stop sign at Larry Holmes Drive. Turn left onto Larry Holmes Drive. You will pass McDonalds and WaWa on your left. Take the left onto Lehigh Drive immediately after the WaWa strip mall. My shop is on the corner of Lehigh Drive and Lynn Street. It is the first beige building with burgundy trim on the right, my shop may be entered through the burgundy door at ground level. Parking is available in front of my entire building and all up Lynn Street but please do not park in the driveway on the left side of my building, it is a shared driveway.

You may also take 78 west into PA (also a toll) and take the first exit in PA. I do not know the street names but turn right at the end of the exit and follow the signs for the Crayola Factory/ Canal Museum/ or Attractions. These signs will bring you to a light with McDonalds on your left. Turn left at this light and take the next left onto Lehigh Drive as above.

### Randy McDaniels Biography

Dragonfly Enterprises

Randy McDaniel, Artist, Author, Instructor  
in Forged, Lasered & Fabricated Metals

Mr. McDaniel began his journey into sculpture by learning to shape hot metals with a hammer and anvil.

He began his experience in blacksmithing with a class from an 81-year-old blacksmith in 1972. That was the spark that ignited his passion for forging hot metal. Randy also learned from other "retired" smiths, researching the craft in libraries, by taking craft schools classes from various skilled smiths such as Frank Turley, Francis Whitaker and Ivan Bailey, and by participating in blacksmithing conferences. Mr. McDaniel traveled to England in 1987 to participate in the British Artist Blacksmith Association's International Conference in Hereford and to study ironwork in London. In 1988 Randy was baptized as a smith by Manfred Bredhol from Aachen, Germany.

Originally specializing in Colonial reproduction ironwork taught him the basics of forging hot metal. Randy's blacksmithing experience now includes a wide diversity of works that runs the gamut from designing and producing personal and whimsical items from business card holders and furniture to large-scale lighting, gates, grilles, fountains and sculptural pieces. His design and forging of the artwork for the new Children's Garden entrance arbor at Hershey Gardens is an excellent example of his art and whimsy. Besides forging steel he enjoys working in copper, bronze and titanium.

Over the past 30 years Randy's metalwork has been shown at National juried craft and art shows and then in art galleries such as the Pendragon Gallery in Annapolis, MD, Eisonwerks in Manayunk, PA, and more recently at Gallery 20 in West Reading, PA. He has received many "best in show" awards, and has been highlighted in articles in books, magazines, newspapers, and television shows. He is most recently featured in the book, "Lives Shaped by Steel" by Nancy B. Zastrow.

Mr. McDaniel has also gained recognition and acclaim for writing and illustrating "A Blacksmithing Primer, A Course In Basic And Intermediate Blacksmithing". Originally self-published, due to its' success is now being published as a second edition by Finney Books. Blacksmiths, blacksmithing groups and even schools around the world are using this book to teach basic to intermediate forging. This book has also been professionally filmed as a 6 hour video/DVD with Randy's instruction and

# New Jersey Blacksmiths Newsletter

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demonstration. Besides his book he has written articles for "Fabricator Magazine" on operating a business and the virtues of laser cutting. "The Anvils' Ring" has featured Randy and his works many times over the years.

Randy has taught basic and advanced workshops for more than twenty years. These include workshops at the University of the Arts, Philadelphia, PA, Penland School of Crafts, J.C. Campbell Craft School, Appalachian Center for Crafts, New England School of Metalwork, Peters Valley Craft School and for many regional blacksmithing groups from coast to coast. Randy was also a lecturer and demonstrator for the Artist-Blacksmith Association of North America's International Conference at Alfred, New York in 1990 and at La-Crosse, Wisconsin in 2002.

Randy is a member of ABANA-Artist-Blacksmith Association of North America, PABA-Pennsylvania Artist Blacksmith Association, MASA-Mid-Atlantic Smiths Association and a life time member of BGCM-Blacksmith Guild of Central Maryland. He is also a member of the Berks Arts Council.

In the Winter of 2005 he was mentored by a 74 year old sculptor who has taught Randy the intricacies of producing sounding sculptures from bronze, brass, steel and beryllium copper. He is excited about adding his own skills and imagination to this historical art form. He was accepted to the prestigious Philadelphia Furniture & Furnishings Show 2006, which became his first public showing of his new line of works.

"Creating works in metal is a way for me to express a three-dimensional feeling of motion, life and fun. Now I am able to add sound as another aspect of life which produces an interaction between the work and the participant. My whimsical designs perpetuate a lighter heart for all; for myself while creating and for the client over the years."

Randy will demonstrate sculptural elements  
From his web site;  
<http://www.drgnfly4g.com>

**This is a voting membership NJBA Meeting also. If you want to stay a director or put your name in to be a director try to come to the meeting.**

## NJBA Holiday Party!

The holiday party is to be held on December 3th at Jan and Marshall's house. Many thanks again, to Marshall and Jan for opening their home to us in the holiday season. Members are asked to also bring various trivets, candle holders, or other holiday items they are making to the party. Despite the emphasis on blacksmithing, members are encouraged to bring their families.

### Directions to Marshalls' Home:

Marshall and Jan's "cabin" is not on Marshall's farm, but about 3 miles east of it on the same road. Casino Drive is just off Rt. 9, about 3.5 miles north of interstate I. 195 (exit 28). and about 4 miles south of Rt. 33. Either of these routes can be easily reached from the major north-south highways including the Garden State Parkway, the NJ Turnpike. 1-295, Rt. 18 or Rt. 34. From Rt. 9 northbound. make a right onto Casino Dr.; southbound. take the jug handle to make a left onto Casino Dr. Continue past Marshalls' Farm to #301 Casino Dr., Howell, N.J.

(ph# 732-938-6577) [jlfmib@optonline.net](mailto:jlfmib@optonline.net)

## Events Outside of NJBA

### The 4th Annual Bill Gichner Memorial Hammer-In

Once again blacksmiths up and down the eastern seaboard will congregate on Maryland's Eastern Shore to pay tribute to one of the real powerhouses behind the resurgence of blacksmithing: BILL GICHNER. The 4th Annual Bill Gichner Memorial Hammer-In will take place at the Hutchison Brothers Farm in Cordova MD (just out side of Easton MD) Saturday/Sunday, 12/13 January, 2008. For the early birds, there will be informal socializing starting Friday late afternoon and evening.

This year the featured demonstrator will be Paul Thorne, Thorne Metals Studio, Anacortes, WA <http://thornemetals.com/>. Among other things, Paul will be demonstrating the use of a pneumatic press. As always there will be impromptu demonstrations by some of the top blacksmiths on the East Coast and beyond.

# New Jersey Blacksmiths Newsletter

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Demonstrations start at 9am following coffee and donuts. Lunch will be served both Saturday and Sunday and there is a catered dinner Saturday evening.

After the critical acclaim of last year, rumor has it that the (in)famous John Fee will again act as emcee (be sure to ask John about his "gate"). Don't forget to bring something for the Iron-In-The-Hat and the auction. This is what really pays for the event. The registration fees do not come close to covering expenses.

The fee this year is \$35 if you register by 29 December 2007. After that, the fee goes up to \$50.

**IMPORTANT:** After 1 January, 2008, if you decide you want to come, be sure to contact JoAnn Bentley (see below) to find out if there is still room. MASA MUST have an accurate head count for planning purposes.

If you are a member of MASA you will get a registration form in the next MASA newsletter. If you attended last year, you will get one in the mail. Otherwise, contact JoAnn Bentley, 259 Muddy Fork Rd., Jonesborough, TN 37659 [joann@bentoaks.org](mailto:joann@bentoaks.org), for registration information. If you just can't wait, just go ahead and send JoAnn your name address, phone, and email (for confirmation) along with appropriate fees.

## Northeast Blacksmiths Hosts a Northeast Regional Conference

The dates to save are September 5th, 6th and 7th. The event will be at the Ashokan Field Campus west of Kingston NY. For more information check out ; [www.northeastblacksmiths.org](http://www.northeastblacksmiths.org)

## Help NJBA!

If you have ideas for demonstrators or workshops please contact David Macauley, Larry Brown or Bruce Hay

## NJBA Has NEW T-Shirts!

Our New T-Shirts should be in for the event at Eric Cupers November 3rd, \$15

## Red Mill Demonstration and Picnic

August 19th, 2007

Special thanks to Bob Bozzay, Adam Howard and Eric Cuper for helping to organize and run the event and to the museum and it's staff for having us. I did not see all the demonstrations in the shop but while I was looking in Dan O'Sullivan was demoing an item and Marshall was helping Bob Bozzay forge another item. I spent most of the day walking around tailgating and chatting as there was plenty of opportunity to do so. The rain came in a bit that afternoon but not hard enough to deter the Iron In The Hat crowd or many of the members otherwise. A very enjoyable day with good food, drink and friends. Report by L Brown

## 2007 Peters Valley Pig-Iron Fest

Once again, Bruce Ringier (member of the board of both NJBA and Peters Valley) brought off a successful Pig-Iron Fest on Sat., Sep. 1. I car-pooled up with Bruce Hay, with the full intention of drinking our share of the beer and not coming home till Sunday. (Come to think of it, you don't need to read this report. It's the same one I've given every year I've attended the Pig-Iron Fest!)

The Fest was the usual combination of lots of food, lots of beer (and wine and soft drinks), a demonstrator (Bob Compton), lots of interesting company, the auction (with lots of items), and a raffle of two anvils and a hot-cut hardy. The Fest was earlier in the season than usual, apparently to avoid a conflict, and a class (pattern-welded steel) was in session during the Fest. (I understand that these lucky participants got to partake of the feast for a somewhat reduced admission charge.)

There was a new stage or bandstand across from the blacksmith shop, thanks to the effort of Bruce Ringier and friends. Bruce recounted the harrowing cutting of an old tree standing in the way of progress. The location was dictated by a pre-existing foundation on the site. The structure itself, post-and-beam, was moved from another location in Peters Valley, with new roof and flooring added. (The structure is without walls). The band apparently was quite pleased with the new "digs."

# New Jersey Blacksmiths Newsletter

There were numerous items in the auction this year. I marked down a few I was interested in - but I apparently haven't the disposable income of some of the PV supporters, and bidding rapidly exceeded what I could afford. That was great for PV, but disappointing for me. I had to drown my sorrows, which end was fortunately facilitated by the liquid refreshments at hand!

Bruce and I had intended to schlepp up a few of the stainless steel forge hoods made at the recent workshop, one as a donation to PV, the rest for sale. At the last minute, Marshall Bienstock confirmed he could attend this year and that he had room in his car to take them up. In donating the hood, we'd stipulated PV could use it or auction it off at their preference. They chose to keep it for their use, but Bruce Ringier gave NJBA some great publicity, and we sold one of the other hoods. Furthermore, Bruce Ringier is hanging onto the other (two?) hoods Marshall brought up there, with the intention of selling them for NJBA - probably in the spring when PV classes resume. Marshall also brought, and sold some of, the remaining NJBA T-shirts, which some folks proudly wore that or the next day.

I spent most of my time visiting with old and new friends. Tim Miller showed up with his charming assistant, Mary - a painter working on an MFA, who was delighted to have found a place to learn blacksmithing on Long Island. Tim expressed interest in holding more events on Long Island.

As per the norm, the crowd started thinning toward evening, but a few of us die-hards hung around till well after dark. We sat around the campfire and traded lies. I managed to toddle off to bed in Valley Brook at 2 AM. Bruce Hay slept (?) in a hammock strung across the stage, which accounted for his being up early, hungry, and in need of coffee by the time I was up, showered, and dressed in the morning.

After a breakfast run to Layton, Bruce and I returned to pick up the NJBA T-shirts and to say goodbye to Bruce Ringier and Bob Compton. The Peters Valley short-sleeved T-shirts hadn't nearly sold out, so I bought a dozen, in three sizes, to resell (\$15 ea) at Marshall's open forge meetings.

Interested persons may see them in the carpenters shop along with the few remaining NJBA T-shirts. (Money should come to me, but you can give it to Marshall if you're careful to stipulate it's for the yellow PV shirt, not the blue NJBA shirt.)

Report by Bruce Freeman

## Delaware Valley Engine Show

The show is held at Washington's crossing park in NJ in Titusville, NJ. It was a beautiful day on Saturday when I got to the event. Mike Erdie and Mitch

Swirsky were at John Chobrda's trailer with a fire going and Mike was working at the forge. I spent a while walking around looking at all the tractor, trucks and hit or miss engines in the fair grounds. I can't begin to describe all the equipment that is on display there, much of it restored beautifully. I stayed around and helped make a ring at the forge and then I had to go. The event was held on Friday, Saturday and Sunday and I heard most of the members showed up on Friday. I would recommend this event as a great day out, bring your family and see some history and some forging.

Report L Brown



John Chobrda, Marshall Bienstock and Mitch Swirsky outside the trailer

# New Jersey Blacksmiths Newsletter

## Walnford Day, 2007

by Bruce Freeman, with contributions from David Macauley and Marshall Bienstock

I got off to a late start, and met Marshall Bienstock at his shop about 7:15 AM. He'd already coupled the NJBA trailer to his Chevy truck, so we were off not long after. When we arrived at Walnford, we were flagged through by a ranger to the spot opposite the Walnford Mill, a big blue building, where David Macauley was already setting up his own portable equipment. Tom Majeski arrived soon after, so we made short work unloading the trailer and setting up "shop." This was made even faster by use of a "pop-up tarp" that David had invested in.



Bruce Freeman

Unfortunately, Sarah Bent, the ranger in charge of the event, sweet talked us into setting up in the sun, and despite her promises, the shade of the mill just didn't cut it. Fortunately, around noon it became overcast, which relived the heat considerably.

I was first to start a fire, and soon began a risky project for outdoors - a chandelier (like the one I



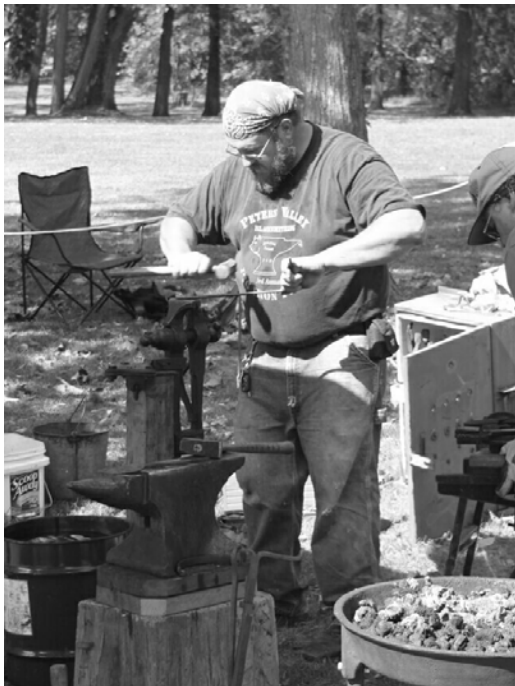
David Macauley

wrote up for the newsletter a year or so back) involving a basket ornament, and, hence, two welds.

Fortunately, the fire itself was shaded by the hood, which enabled me to judge color quite well. Both welds were successful, though the basket had to be tweaked into acceptable conformation. I finished a hook at the top, and bent the four branches into graceful arcs, but stopped there as the next step would have involved threading the ends of the branches.

Larry Brown arrived a little later. He readily showed up my meager basket by making a one-rod "basket" - spiral out from a center, then spiral in to a center and pull apart. Looks like a coil spring with a taper on each end, and is elegant far beyond what these words convey. Folks were admiring it all afternoon.

David's wife, Kathy, and daughter, Molly, arrived after witnessing an episode of road rage on the way (from which Kathy adroitly extricated herself, then reported). She and David discovered that the park service provided free drinks and snacks up



Larry Brown

## When You Can't Light Up The Forge - Practice Hammer Control

Learn hammer control by using a board. First, learn to put your hammer print at the same depth, causing a complete hammer mark in the board. Once you've mastered that, learn to tilt your hammer blows to the left, right, forward and heel. Do this until you can do all five steps without thinking about it. This will help you do better work at a faster pace.

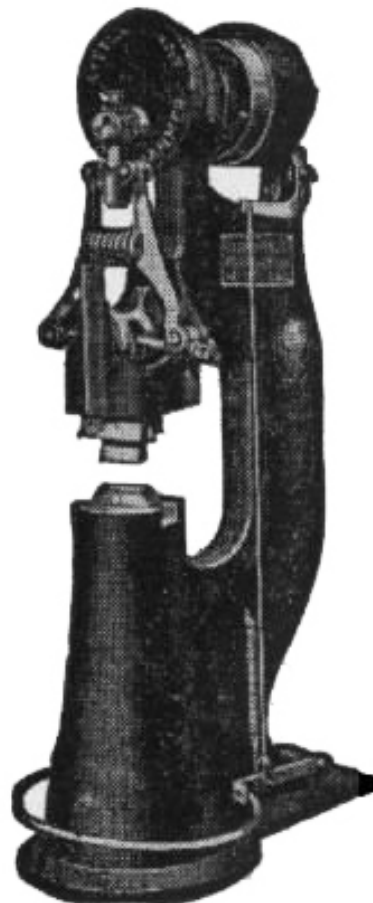
Copied from The Forge Fire News Letter - Indiana Blacksmith Association  
Tip written by Fred Oden

by the barns - a great idea. One of the head rangers indicated that this was in direct response to suggestions from parents. Since there are no food vendors, the kids will not last for a full day. Molly was a good example. This service does not really affect the blacksmiths, but I do think it is indicative of a management who is trying to make the experience of visiting Walnford better.

David made 2 oak leaves that he'll be incorporating into plant stands for his wife. Marshall made some ornaments on a bar and a few nails. Tom worked on a fork. After lunch I attempted to make a toaster, like that on display in the main house in the park, but failed four different ways!

Mark (whose last name I cannot now bring to mind) did a very good job of interpreting our work and organization to the public. This sometimes doesn't seem like much, but it frees up the demonstrators to work the forge, and not be distracted by questions. It really helps quite a bit.

The park personnel let us know several times that they were appreciative of our efforts. Our thanks to those who attended. I think we provided a great show.





# Making ladles and spatulas

by Bob Race

(Bob presented this class at the spring

## THE EXERCISE

Learning to make simple pieces with the least amount of tools possible.

It does not take much imagination to make a triangle bell, nor a bracket to hold it; nor does it take a whole lot of effort to forge out a

spoon, ladle, or spatula that is functional enough for the user to be happy. But it takes practice to achieve the skill to make any of these items look as though they were crafted to be pleasing to the eye. The drawings on this page show variations of original pre-1850 pieces commonly found in museums and antique outlets. Searching the Internet is an excellent source, but be

Drawings from original pre-1850 pieces

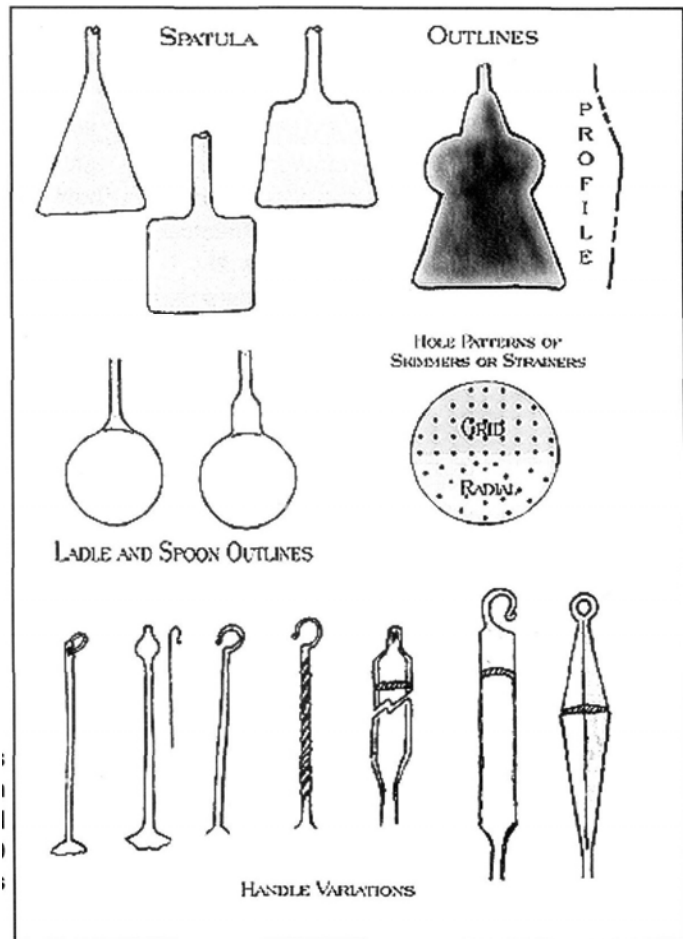
sure to realize which is original. Tasting spoons primarily had a side profile whose line went down the length of the handle and stem, with the lip of the bowl's line with that of the handle. The ladle's bowl lip line was nearly perpendicular to that of the handle.

The lines of holes in skimmers and strainers could go either

way, but the bowl was generally two or three times that of the size of the spoon.

The profile of the handle may have been straight or had a slight curve. Most spatulas were straight in side profile. Remember, these are items of kitchenware and seldom used on the table.

Perhaps the best stock to use in making ladles and spatulas



This information is primarily aimed at students who are in the beginning steps of basic blacksmithing and is only meant as a guide to make their future in this field a little easier to understand. Some of the things mentioned in here may have been pointed out to me numerous times in the past, but some of it did not come of age until the proverbial 'slap along side of the head' was repeated over and over again.

# New Jersey Blacksmiths Newsletter

## ladle and spatula making

(continued from previous page)

### The Art of Fullering

There is no shame in using a spring fuller, guillotine, or similar tool to swage in corners of a piece of material, especially when one is a beginner who feels like he is threading a fine-eyed needle with a piece of limp cord in a bone-chilling wind storm. However, it would behoove everyone who is serious about becoming a good smith to practice fullering in from both sides by using the corners of the hammer and anvil to do the necking down process.

For some it may be a long row to hoe, but once the habit is acquired there is some sort of satisfaction achieved in being able to make do with less.

Find an edge of the anvil face whose corner profile matches the corner of the hammer's face. This will act as a double fuller and give you an initial setup for the stem between the bowl and handle. ONLY go part way, because if

you neck it down too small it will lose material with each heat and become weakened making for a fragile piece by the time you are finished.

Making a spoon or spatula is an exercise similar to learning to play 'Twinkle, Twinkle, Little Star' on a musical instrument. All you

Making spatula profile is not any different than that of the ladle. It is just figuring where to put the lumps in the proper place. Use the "visualization" drawing as a guideline. It all depends on your design.

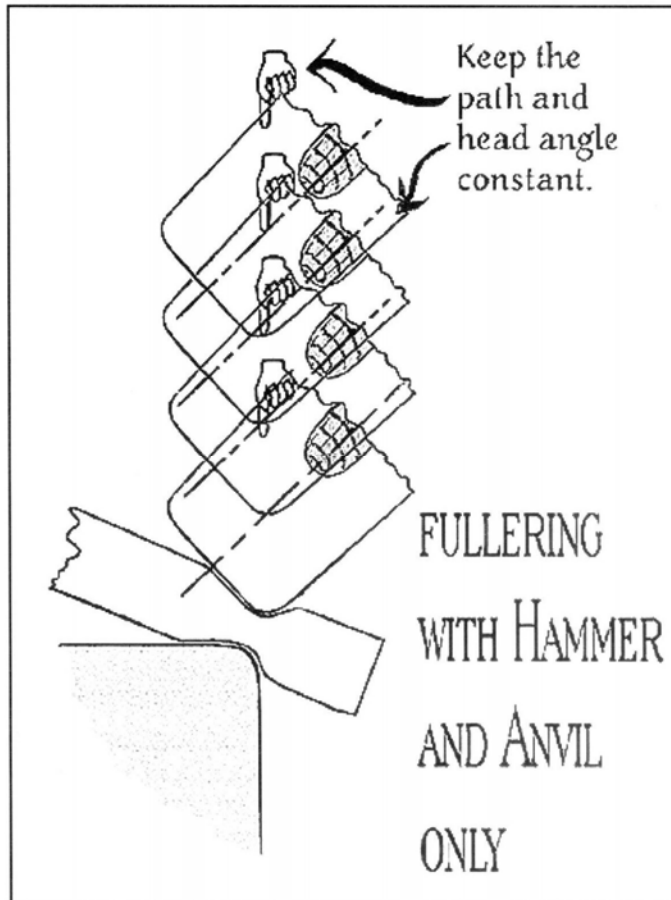
About an 1-1/2" from one end make a mark on the narrow edge of the piece. Heat this up

to a near welding heat, take it over to the anvil and fuller in from both sides using a spring fuller or the method shown on the previous page.

Work on this until the necked down section is about 1/3 the width of the piece. Put the long end back in the fire and heat it up as before, bring it out so the wide part is flat on the anvil and taper back from the end about a third of the way until the narrow edge is a little less than 1/8". Round off the two outside corners.

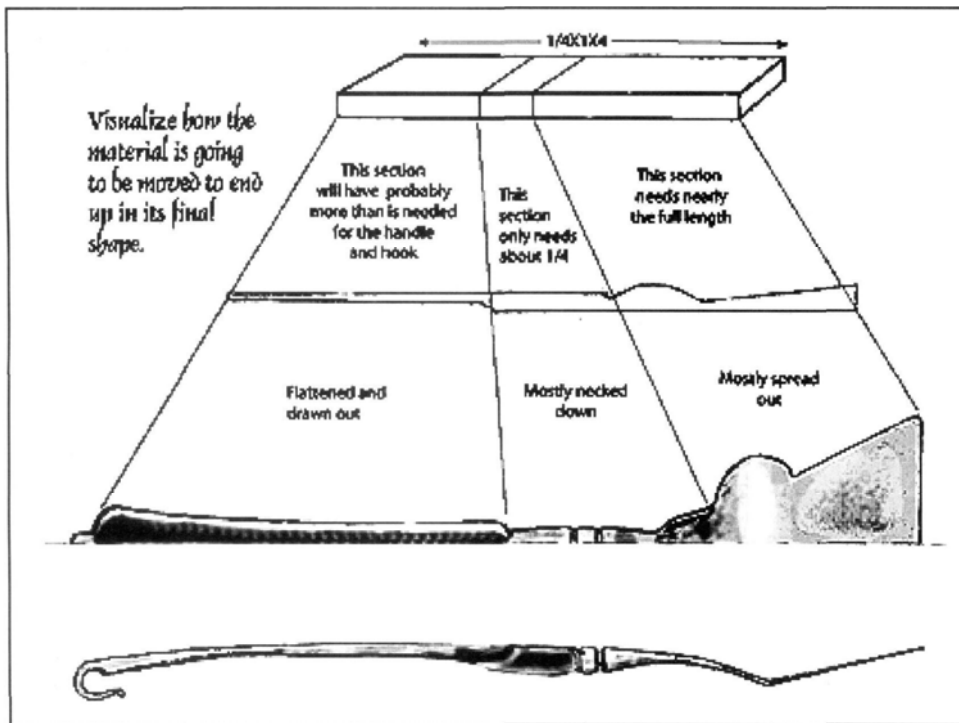
Reheat, then placing the wide section back on the anvil, take your cross-peen and fuller down the center being careful not to get near the neck.

Reheat and spread out from the center to one edge; repeat



need is a 1 / 4"x1&l/4" piece of mild steel, neck it down in the right spot, spread out the bowl or blade, draw out the handle, and you are done. This should give you a bowl that is about 2 1;2" wide and a handle 6 to 10" long.

# New Jersey Blacksmiths Newsletter



paper that is wider than the piece and draw a straight line down the long way and in the center. Lay your piece on the paper so that its centerline coincides with the line you have just drawn. Firmly hold the piece down and trace its outline on the paper. Take the piece of paper and fold it in half along the centerline and hold it up to a

Find a chunk of log which does not have any knots in its end-grain and set it on the floor near the forge. Heat the bowl up to a dull orange and place it over the end-grain. While holding it just immediately above the wood use a ball-peen hammer and shape the bowl.

When it starts getting black, reheat and repeat the process until the bowl is at the depth you wish.

Remember - this is an exercise in learning to neck down or spread out by fullering; nothing more.

Doing the Symmetries

Even though nothing in this world is perfect, the pleasing effects of symmetry will add

to the appeal of your final piece. There is a simple way to accomplish this task and it does not take long.

The first thing to do after you have the rough shape formed with hammering, is to straighten every section along the center line of the front profile; (the side profile should remain a straight line until the last). Make sure that the slightest twist between the handle and the blade or bowl is not visible while sighting down its length. When you are satisfied with the tweaks and twists, lay the piece on the face of the anvil, and with a wooden mallet, gently hit the high spots so that all is nearly flat to the world.

Take a piece of translucent

strong light. Notice that the profiles do not perfectly line up. Draw a pattern to your liking on either side of the folded paper that will cover the existing material. Take a pair of scissors and cut this pattern out and unfold the paper. Usually the handle and stem section are pretty close to what you want, but the bowl or blade section can stand some correction with a belt sander or file. You can cut and paste the paper to the face of the bowl or blade with paper glue. It will dry quickly with a little persuasion from light passes of a propane torch. Sight down the handle and stem and make sure your

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Hot Iron News, 2005/2