



N.J.B.A. Newsletter

NJBA Volume 16, Issue 1 4/28/11
<http://njba.abana-chapter.com>

Editors Soapbox

We need some more activity from our members!

As editor I would appreciate some help in writing up events for the newsletter. Recent events in the lives of some of our directors have made it hard for NJBA to be all it can be. We need more people to help out other than the same few doing everything. It would be great if we could have some of you helping scheduling meets that are local to you. You can see we do not have much to list here. Please talk to one of the directors to find out what you can do to help!

We are also looking for members who have a pickup and would be interested in helping bring the NJBA trailer to meets. If you are interested in helping please contact one of the board members listed on page 2. Larry Brown, Editor

Upcoming events for 2011

Get your 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.

May 7th Walnford Park, David Macauley will be doing a demonstration See page 3 for more info
May 15th 10am to 5pm, Set up 9AM Tuckerton Seaport, 5th Annual Bluegrass & Barbecue Festival and Traditional Arts Show, see page 3 for more info

June 11th - 12th Cold Spring Village, See page 3 for more info

June 18th Mini Press Workshop See page 4 for more info

July 16th Delaware City Day See page 4 for more info

July 17th Cold Spring Village See page 4 for more info

August 1st - 7th, Middlesex County Fair 3 of the days See page 5 for more info

August 20th Canal Day Wharton NJ See page 5 for more info

August 27th and 28th Seafarer's Weekend in Historical Cold Spring Village. Cape May NJ See page 5 for more info

September 11th, Sunday, 10:00am - 4:00pm Red Mill Tool Swap/Picnic, See page 5 for more info

October 1st Walnford Park See page 6 for more info

NOTICE!

The NJBA Renewal and Board of Directors Ballot is on the last page. Please fill this out and send in as soon as you can.

The date of your last renewal is on the mailing label.

If your date is 2009 or older this is your last newsletter.
Act Now!!!

New Jersey Blacksmiths Newsletter

The NJBA Web Site!

The NJBA Web Site is:

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

The Newsletter is at:

[http://
members.bellatlantic.net/
~vze25jcc/index.htm](http://members.bellatlantic.net/~vze25jcc/index.htm)

or use the link on the NJBA web site
for the newsletter.

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.
ABANA is communicating again so
check it out

NJBA Board of Directors

Directors are available on request or
on the hard copy version

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Walnford Park, May 7th

David Macauley will be demonstrating at Walnford Park on May 7th. Walnford is also known as Crosswicks Creek Park and is in Upper Freehold, N.J. Please come out especially with your family to enjoy a day at the hidden jewel of the Monmouth County Park system.

Coordinator David Macauley,
drmacauley@att.net , 732-310-1300

Directions: Please note: If you choose do an internet search for directions to this address, be aware that the parking lot on site is not accessible from the Walnford Rd/Hill Rd intersection. Directions below. From the East Via I-195: Take Exit 11 (Imlaystown/Cox's Corner) and turn left onto Rt.43 (Imlaystown/Hightstown Rd). At the first intersection, turn right onto Rt. 526/Red Valley Rd. At the first light, turn left onto Sharon Station Rd and follow approximately 2 miles. Turn right onto Rt. 539 North. Travel a short distance and turn left onto Holmes Mills Rd. Make first right onto Walnford Road which leads directly into the park.. From the West: Follow I-195 to Exit 8 (Allentown), Rt. 524/539. Turn right and follow Rt. 539 through Allentown. Turn right onto Holmes Mills Rd and then right onto Walnford Rd, which leads directly into the park. From the North: Take Rt. 9, 79, or 34S to 537W to Rt. 539 in Upper Freehold. Turn right onto Rt. 539 (Forked River Rd), then left onto Burlington Path Rd. Turn right onto Holmes Mills Rd and then left onto Walnford Rd, which leads directly into the park.

Tuckerton Seaport

5th Annual Bluegrass & Barbecue Festival
and Traditional Arts Show

May 15th 10am to 5pm, Set up 9AM

Open Demonstration

On Sunday May 15 NJBA will be doing a demo at Tuckerton Seaport, at their Annual Bluegrass & Barbeque Festival. We did this event a few times before and always had a good time. So come on down, or up, depends where you live, and spend some time with us. Do a little blacksmithing, enjoy the music the food and the seaport.

Directions: To get to the seaport take the Garden-state parkway to Exit 58 Rt 539 go east or follow the signs at the top of the ramp to Rt 9 (Main st) in Tuckerton make a right the seaport is on the left. Hope to see you there.
For information on the seaport go to www.tuckertonseaport.org

Cold Spring Village

June 11th - 12th

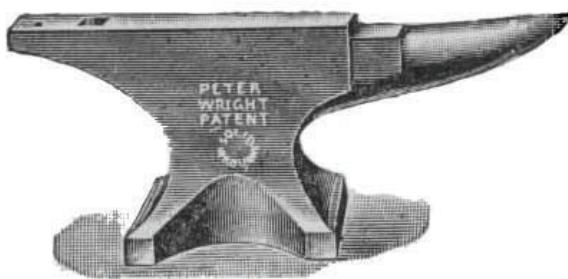
Jerry is not in the village David will interpret the shop. As always, these date correspond to when his family vacations in Wildwood. For those with children, visiting Cold Spring Village is a great time, you can also visit Wildwood and Cape May - a lot of fun. For the July and August dates, we do demonstrations/ hammer ins. Since he am the one usually bringing equipment, he would appreciate knowing how many smiths plan on attending.

Generally we start set up around 9AM and break down by 5PM. Travel time from central NJ is about 2 hours and Cape May is wonderful place to visit with your family.

If you need further information, please contact me at your convenience. The web site for HCSV is:
<http://www.hcsv.org/>

Thanks,
David Macauley drmacauley@att.com

Directions: Take exit 4A south from the Garden State Parkway and follow the signs to Historic Cold Spring Village 720 Rt. 9 Cape May NJ 08204 (609) 898-2300.



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Mini Press Workshop

June 18th

A workshop to produce a mini air press similar to one Mark already owns and was used in the damascus workshop. Almost 10 people already expressed an interest in the workshop.

Mark Morrow will be collecting a \$100 as a deposit due by June 1st. Please get your money to him or the next person on the list will be given the option.

One mini Press frame, one set of flat dies, one set of drawing dies and 20 ton air Jack for \$225. The Workshop will be held at Marshall's shop in Howell.

Contact Mark Morrow:

Mark's email address is sword-smith2001@verizon.net and his shop phone 732-458-5823. Mailing address is; Mark Morrow, 53 Beverly Beach Rd, Brick, NJ 08724

Delaware City Day, Hammer-In and BBQ **July 16th**

Kerry Rhoades and John Chobrda, along with the New Jersey Blacksmiths Assn. would like to invite all smiths, metal heads, and their families to the Annual forge in and BBQ on Saturday July 16th at Kerry's shop, "Forged Creations" in Delaware City, Delaware. This event is being held in conjunction with "Delaware City Day" a day of parades, games, and fireworks.

John and Kerry are going to be working on a seafood theme this year instead of the pig roast as in the past. If possible bring a side dish or dessert to help the event.

We will be setting up portable forges and display tables for you to display and sell your work, also to demo to the general public and teach some of us old dogs new tricks. We ask that you bring a covered dish or something to share with others. Space is available for tail gating so bring any tools, anvils or stuff you no longer use.

Kerry's shop is located at 124 Clinton Street in Delaware City, try to come early as the parade runs down Clinton Street and it will be closed at 9:00 AM. phone numbers are:

302-832-1631

302-757-0733

Come on out on the 16th of July, bring your family, your work, a hammer, your hunger and something (food) to share. Hope to see you then.

Historic Cold Spring Village (HCSV)

July 17th

NJBA is holding a public demonstration/hammer-in at Historic Cold Spring Village (HCSV) in Cape May on July 17th NJBA has been holding this event at (HCSV) for several years now. I will be bringing the NJBA trailer and some personal portable equipment down to the site, so you don't need to lug any equipment. If you are interested in demonstrating to the public or just hanging with the Smiths please join us. I can obtain free passes and meal vouchers for all demonstrators. I do need to know in advance if you are coming one or both days, so I can make arrangements. We have also been known to have a nice a lunch at the Grange on the property.

Generally we start set up around 9AM and break down by 5PM. Travel time from central NJ is about 2 hours and Cape May is wonderful place to visit with your family.

If you need further information, please contact me at your convenience. The web site for HCSV is:
<http://www.hcsv.org/>

Thanks,

David Macauley

drmacauley@att.com

Directions: Take exit 4A south from the Garden State Parkway and follow the signs to Historic Cold Spring Village 720 Rt. 9 Cape May NJ 08204 (609) 898-2300.

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Middlesex County Fair

August 1st - 7th

We have been invited back to Middlesex County fair which runs from August 1st through the 7th in East Brunswick. We demonstrate 3 of these days, check back for a schedule, We will have the NJBA trailer at the site for the entire time and we will probably have additional forging stations. We will be under a tent with other crafters. The site has easy access to water and power and we will have tables to display our forged items. All smiths are encouraged to attend. This is a wonderful fair to attend and is great opportunity for the entire family.

Here are the driving instructions:

The Middlesex County Fair is located on Cranbury Rd. where it intersects Fern Roads in East Brunswick. Take Route 18 into East Brunswick, follow the directions for Cranbury onto Cranbury Road (Rt. 535 South), pass East Brunswick High School on the left, keep left at the fork, and continue on Cranbury Road for about three miles to the fair. 655 Cranbury Road.

FROM OLD BRIDGE-Take Route 18 north toward New Brunswick, pass the Colonial Diner and head toward Cranbury over the Route 18 overpass and proceed past the high school and bear left at the fork, as above.

Route from north county (this is the least congested route), take Exit 8A on the New Jersey Turnpike. Turn right on Route 535 North directly to fair-grounds (5 miles)

For further information please contact David Macauley, drmacauley@att.net 732-206-1568

Canal Day Wharton NJ

August 20st

I will be doing a demo at Canal Day in Wharton NJ 10Am - 5PM. Here is the URL: <http://www.canalday.org> I will have two forging stations. All NJBA smiths are welcomed. This was a great

festival in 2010. Some good bands, food and vendors. Great family event.

Coordinator David Macauley,
drmacauley@att.net, 7320-310-1300

Seafarer's Weekend in Historical Cold Spring Village. Cape May NJ.

August 27th and 28th,

I will again have two forging stations. There are some great displays of boats made in the bay area of Cape May county. Some darn realistic pirates with accurate and authentic weapons. Again great family event. this is the middle of the Macauley Family vacation. Please come and enjoy the blacksmithing and the beach. This is a particularly great location to have people experience blacksmithing first hand. In July when I was demoing there, I had some great help running the blower and few striker candidates. Here is the URL: <http://www.hcsv.org/>

Directions: Take exit 4A south from the Garden State Parkway and follow the signs to Historic Cold Spring Village 720 Rt. 9 Cape May NJ 08204 (609) 898-2300.

BLACKSMITH HAMMER-IN & TOOL SWAP

At the Red Mill Museum Village

Sunday, September 11th, 10:00am - 4:00pm

The Red Mill Museum Village is pleased to announce its annual Hammer In and Tool Swap on Sunday, September 11th from 10-4pm. This event is hosted by the NJ Blacksmith's Association, under the direction of association trustee, Eric Cuper, and our own resident blacksmiths Dave Ennis and Robert Bozzay.

NJBA members who want to demonstrate should contact Dave Ennis and register for a time

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slot in the schedule so the museum can publicize them and the event

The day's activities will center at the Museum's Blacksmith Shop where local blacksmiths and the New Jersey Blacksmith's Association, a non-profit organization dedicated to the promotion of the art and craft of blacksmithing, will have members on hand to demonstrate and sell their work. Tool dealers and collectors are invited to tailgate, sell and swap their smithing tools and accessories. We are currently registering blacksmiths and tool collectors. Among the items to be found will be anvils, blowers, forges, vises, hammers, and tongs. Should anyone have a "what is it" cluttering up the garage, bring it along and we will be glad to identify it for you.

Admission for the day's activities is \$8 for adults, \$6 for seniors, and \$5 for children (6-12). Free for children under 6, museum members and for NJBA members. Included in the price is admission to the Museum's historic buildings and exhibits. The Red Mill Museum Village is located at 56 Main Street in Clinton, NJ. For more information, or to register call the Museum at (908) 735-4101.

Directions:

Red Mill Museum; Take exit 15 on I-78 onto old route 22 going North (routes 513 and 173), make a left onto main street before bridge. Museum straight ahead.

Walnford Park

October 1st,

We will be demonstrating and holding a membership meeting at Walnford Park on October 1st. Walnford is also known as Crosswicks Creek Park and is in Upper Freehold, N.J.

Hammer in and demo at Walnford Park. Please come out especially with your family to enjoy a day at the hidden jewel of the Monmouth County Park system - Walnford park. NJBA will have the trailer with three forges at the demo. We will be immediately across from the working gristmill. There are many activities for children so this is another great family event.

Coordinator David Macauley,
drmacauley@att.net , 732-310-1300

Historic Walnford is the 36 acre Historic District at the heart of Crosswick Creek Park. This country estate and former mill village provides a window to view more than a century of social, technological, and environmental history in Western Monmouth County.

The site includes a large home built for the Waln Family in 1774, an 1879 Carriage House, and assorted outbuildings and farm structures. Much of the site's interpretation is connected to the newly restored and operating late 19th century Gristmill.

Directions: Please note: See page 3 under the May 7th event for the directions



Henson Scout Reservation Is Looking For Help Starting a Blacksmithing Program

Henson Scout Reservation in Rhonesdale, MD contacted me to get a smithing merit badge program up and running. Right now they have nothing in the way of tools or equipment. So to start they are looking for anvils. Since this will be kids making only small projects the normal size anvils we use are not needed. They are hoping to find 10 used small anvils, say 50—100 lbs. So if anyone has some they are looking to sell drop me a line and let me know what you want for them. Also small post vices or any other tooling is on the list. Thanks guys.

Dave Collier
410-482-7863

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Report on Blacksmithing Demonstration Eric Cuper and Daniel O'Sullivan at Cuper Studios Saturday, February 5

NJBA would like to thank the members of the involved groups who braved some black ice covered roads to get to the meet. Eric and Dan once again presented a scintillating demonstration for NJBA, PABA, NOMMA, and others. Eric started the day with some basic blacksmithing for the future smiths that were present and then went into some scrolls he used as elements on some projects,

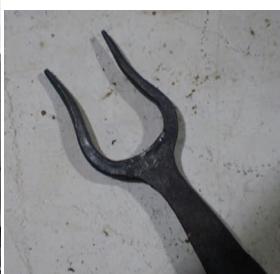
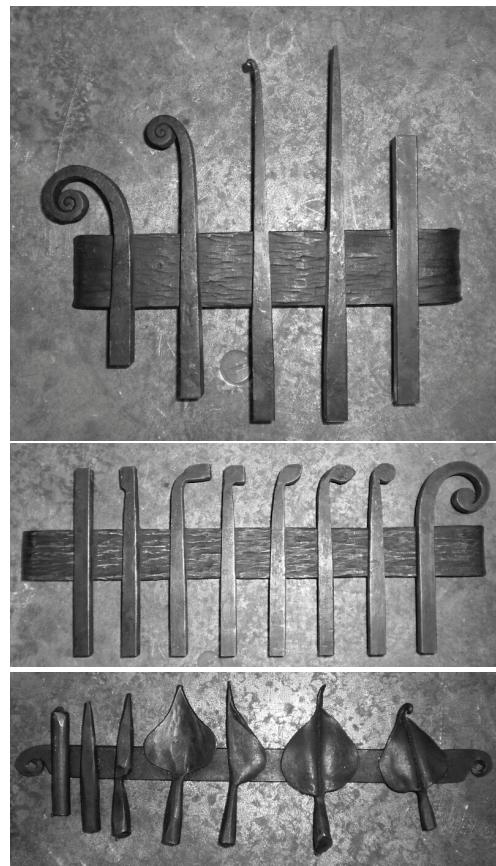


Dan continued on the scroll theme, demoing various scroll ends,



Ellen Durkham then held every ones interest with her fork demo in the afternoon. Ellen's web site is: <http://ellendurkan.com>
Photos from Larry Brown and Ron Jani
Sorry Dan I got none of you that came out.

Scroll Demo Boards



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Blacksmithing Workshops and Classes:

Peters Valley Craft Education Center
19 Kuhn Rd., Layton, NJ 07851 (973)948-5200
pv@warwick.net www.pvcrafts.org

Academy of Traditional Arts
Carrol County Farm Museum
500 South Center St. Westminster, MD 21157
(410)848-7775 (410)876-2667

Touchstone Center for Crafts
R.D.#1, Box 60, Farmington, PA 15437
(724)329-1370 Fax: (724)329-1371

John C Campbell Folk School
One Folk School Rd.
Brasstown, NC 28902
1-800-365-5724 www.folkschool.com

Brookfield Craft Center
286 Whisconier Road
P. O. Box 122
Brookfield, CT 06804-0122
203.775.4526

Open Forges

If any members have a forge at home and work in the evenings or weekends and want to open it up to help a few local guys, let me know, Larry Brown, editor, as we get requests from members who have a hard time traveling to some of the open forge locations.

Please contact, Larry Brown, Editor.
We want to encourage all to join us at:

Monday Night Open Forge in N.J.

Marshall Bienstock is hosting an open forge in his shop at 7 pm almost every Monday night (Please call ahead on holidays to make sure , (732)780-0871)

Open Forge in Long Island

Sunday from 10:00 am to 6pm.
Starting the 1st Sunday in November until the end of April. Please call ahead to confirm and get directions. Ron Grabowski, 110 Burlington Blvd. Smithtown, NY (631) 265-1564
Ronsforge@aol.com

Business Members

We would like to thank those who joined with our new Business Membership category .
Business dues are \$40

Please show them our support

Marshall Bienstock, Marshall's Farms

663 Casino Dr., Howell, NJ 07731
732-938-6577, 732-780-0871
jlfmib@optonline.net

John Chobrda, Dragon Run Forge

P.O. Box 315 Delaware City, DE, 19706
302-838-1960 jchob@verizon.net

Eric Cuper Artist Blacksmith

109 Lehman Lane, Neshanic Station, NJ 08853
908 642-6420 ericuper@msn.com

Bruce Hay, Jr.

50 Pine St., Lincroft, NJ 07738

Jayesh Shah, Architectural Iron Design
950 S. 2nd St., Plainfield, NJ 07063
jay@archirondesign.com

BLACKSMITH TOOLS FOR SALE!

John Chobrda

Has a large selection of tools for sale.
Anvils – Forges - Leg Vices—Blowers

Tongs – Hammers
and/or resurfaced Anvils

Call John for prices and availability
(302) 838-1960 cell (609) 610-3501

In Southern NJ contact

Joshua Kuehne, 543 Amos Ave.
Vineland, NJ 08360
(856) 503-5297 iforgeiron88@yahoo.com

In Northern Delaware and Southern NJ,
contact Kerry Rhoades or John Chobrda
Kerry (302) 832-1631 John (302) 838-1960
(609) 610-3501 (cell)

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HOLCOMBE JIMISON FARMSTEAD MUSEUM 1605 DANIEL BRAY HIGHWAY (RTE. 29) JUST NORTH OF LAMBERTVILLE



The Holcombe Jimison Farmstead Museum is located on the oldest recorded farmstead in Hunterdon County. The day-to-day rural agricultural life of the county's farmers and their families is presented in the museum exhibits with authentic tools and equipment. Through various grants and donations the property has been restored. Several small buildings have been added including a general Store, Post Office, **BLACKSMITH SHOP**, Print Shop and a typical farm workshop. The museum is open to visitors on Sundays from 1:00 to 4:00 PM starting the first Sunday in May and going through the last Sunday in October. The museum is open every Wednesday from about 8:00 AM to 12:00 PM and is considered a work day.



This is the day members show up to do repair, maintenance and whatever is necessary to keep the museum going. Visitors are welcome and can see our members working on the museum.

The museum is located on Route 29 just north of Lambertville. If you are traveling on Route 202 in New Jersey, use the "last exit before toll" and follow signs to the Farmstead. From Pennsylvania, exit immediately after crossing the toll bridge into New Jersey. The museum is on the right.



Become a part of history, help out a fellow blacksmith. Make something for the shop or museum and get your name on the wall of a historic blacksmith shop in Lambertville. Drop by any Wednesday (or any Sunday, May through October), bring your favorite hammer and tongs or use ours. We have decent coal and typical farm yard scrap metal. Experience our unbelievable chimney, the fire is actually pulled sideways. The chimney was made by a master mason that really knew his stuff. We have two sources of air. A hand crank blower for use on Wednesday and a bellows hanging from the ceiling that we use to impress our Sunday visitors.

Bring the family, we have lots to see.

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METALSMITH'S QUIZ - WELDING

By: Tommy Ward

Since many metalsmith's employ some form of welding, brazing, or soldering in their craft, this issue's quiz is on the subject of non-mechanical metal joinery. Check your knowledge for fun, and play fair - no Googling.

1. Electric welding

- a) was developed in the aircraft industry during WW II
- b) was inadvertently discovered by Nikola Tesla during his experiments with high frequency electric discharges.
- c) was not common in amateur use until about the 1960's.
- d) was once banned from railroad use due to uncertainties of the integrity of its weldments

2. Oxy-acetylene welding can not be successfully used on aluminum.

- a) true
- b) false

3. Copper can be welded to ferrous metals using DC reverse polarity with a Monel rod.

- a) true
- b) false

4. The technique of electric underwater welding is called

- a) Thermite welding
- b) metallic arc welding
- c) submerged arc welding
- d) none of the above

5. Which of the following brazing rods could be expected to give the best cosmetic appearance in copper joints

- a) Harris 0
- b) Harris 15
- c) Sta-Silv 37
- d) Allstate 11

6. The first two digits of the four digit number on an electric welding rod indicate

- a) its carbon content in hundredths of a percent
- b) the positions in which it can be used (i.e., flat, horizontal, inverted, etc.)
- c) its tensile strength in thousands of pounds
- d) a quality control code

7. Acetylene gas

- a) was once furnished by mixing water and calcium carbide in a special pressure vessel and then distributing the gas throughout large shops and factories.
- b) is produced through a petroleum distillation process
- c) is a fairly benign product that produces a "softer" and less aggressive flame than propane
- d) will not explode when kept in a liquid state below 25 degrees F

8. Wire feed welding must be used in conjunction with a special non-reactive shielding gas such as argon or helium.

- a) true
- b) false

9. Copper welding

- A) can be done with electric or gas equipment.
- b) is best accomplished with a oxy-acetylene torch
- c) is not possible
- d) a & b

10. Brazing

- a) can be accomplished at temperatures as low as 436 F
- b) involves the use of special filler rods with silver content
- c) can achieve joints stronger than the parent metal in some circumstances
- d) is not suitable for medium to high strength joints

11. In reverse current welding the electrode holder

- a) is connected to the positive terminal of the AC welder
- b) is connected to the positive terminal of the DC welder
- c) contains a water coolant system due to the high directed heat generated by this type of welding
- d) is pointed forward to prevent undercutting

Continued on the next page!

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12. The maximum withdrawal rate of a fuel gas cylinder
a) is 10 lbs. per hour
b) is determined by the size of the torch tip
c) has been changed from 1 /7 to 1 /10 of the capacity of the cylinder per hour by the CGA
d) is a calculation used by the distributor when refilling the cylinder
13. The minimum recommended filter lens shade for protective goggles used in gas brazing is
a) determined by the type of gas to be used
b) 3-4
c) a matter of personal preference d) 6
14. A suitable flux for brazing aluminum can be made by mixing Dawn dishwashing detergent and Twenty Mule Team Borax into a thick paste.
a) true
b) false
15. Though fine for heating and brazing, an oxypropane flame does not generate sufficient heat for cutting or welding steel.
a) true
b) false
16. Which of the following "stick" welding rods would be least suitable for overhead welding
a) 6010 b) 6011 c) 7018 d) 7024
17. MIG welding
a) always requires a special shielding gas
b) can be accomplished without a shielding gas by using a flux-cored wire
c) is not suitable for high production work
d) is not a good choice for use on thin gauge sheet
18. TIG welding is expensive, difficult to master, and outside the scope of the amateur or art metal field.
a) true
b) false
19. Silver soldering
a) is capable of comparatively high strength and is a good choice for decorative work in which a visually pleasing joint is desirable
b) is used mainly in the jewelry field
- c) cannot be performed at temperatures below 1250 degrees F
d) is a term mistaken given to any kind of low temperature brazing that leaves a "shiny" joint
20. High carbon steel
a) cannot be successfully "stick" welded
b) should be welded using pre and post heating and a low hydrogen rod
c) should be cooled in a brine solution immediately after welding to minimize the chances of cracking due to unrelieved internal stresses
d) none of the above
21. In certain circumstances of repeated exposure to electric welding "flashes" it is theoretically possible for a contact lens to become melted or "welded" to the wearer's cornea.
a) true b) false
22. A small welding bottle can be refilled in the field by connecting an appropriate hose and regulator between it and a larger bottle that is more than 75% full.
a) true b) false
23. "Peening" a weld to relieve internal stresses
a) should not be done on the weld bead itself
b) should only be done after the welded area has cooled to room temperature
c) should be undertaken with care to prevent damaging the strength of the metal,'
d) a&b
24. Glycerin can be used to lubricate a sticking oxygen tank valve.
a) true b) false
25. Certain electric soldering irons are capable of sufficient capacity to heat large areas of copper for soldering.
a) true b) false

The answers to this quiz are published in this newsletter, somewhere. You can find 'em , they're here.

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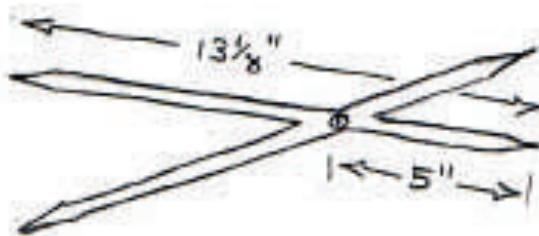
TWO FROM ROBB GUNTER

Here's two neat ideas from Robb Gunter, from the "I really wish I'd have thought of this" department.

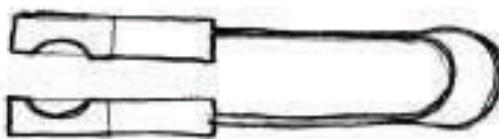
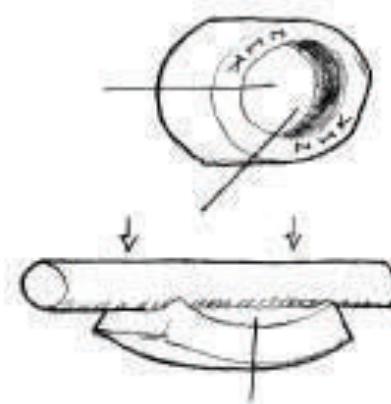
The first is for Golden Ratio dividers, which automatically gives the 1.618 ratio that those really old guys (Pythagoras supposedly discovered the golden ratio) thought was most beautiful. It's so simple that it defies description.

The second idea is from Robb's ABANA Flagstaff Conference demo, it's a simple method of making a spring swage to forge ball shapes in the middle of a bar. Cut a section from a roller bearing race, flatten it with a solid bar that's the same diameter as the bearing balls. Cut this in two, and weld onto a flat bar handle. Anneal the whole thing, since you'll be hitting this with a hammer... remember, hardened steel shouldn't strike hardened steel.

Hammers Blow 83 SUMMER 2000



Robb Gunter's Golden Ratio dividers



Robb Gunter's ball swage

The Safe Shop... Baby Ears

This comes to us from Bill Fiorini and Kirsten Stiles, proud parents of a soon-to-be striker. Very little ones in the shop need special precautions to keep them safe. "I checked with our family doctor on baby ear protection. She gave me 2 good options.

1. an ear wax that fits into the outer ear (not the ear canal), available at pharmacies.
2. child ear muffs available from the audiology department at our clinic for \$16. They are supposed to be adjustable to infants.

John Medwedeff's tip for eye safety is to use swim goggles on kids. He says they form a tight seal and are difficult for a young child to pull off."

The Safe Shop... Tongs Under The Power Hammer

A pair of tongs like the ones shown above would be a good choice for power hammer work, where it's especially important to keep a very firm grip on your work. Use two pairs if necessary, make sure they fit well, and *always hold the reins to your side*. A power hammer, especially a large one, can very easily kick your work straight back at you with considerable force. If the reins are pointing straight at your belly, things could get a little gory. So get into the habit of resting your back hand on your hip when holding tongs or long work, and stay out of harms way

New Jersey Blacksmiths Newsletter

Tips, continued

OKI FORGERS Newsletter -July 2008

From "The Safe Shop"

By Brian Gilbert

Stretching Exercises

There are several easy stretches you can do to warm up before work. One is to lay your palms flat on the anvil, fingers pointing ahead, and slowly lean forward, stretching your wrist tendons. Do this a couple of times.

Next, grab a heavy hand hammer... say, three pounds or so ... and hold it by the handle, straight up and straight out in front of you. Lay the hammer slowly over to one side, and then the other. We're stretching the tendons that rotate the wrist here, with the help of gravity on the hammer head. You're also building upper arm strength as you hold a three pound weight at the end of your arm.

A centipede is an inchworm that has switched to the metric system.

A great way to kill off a good idea is to do nothing but entertain it.

Do's and Don'ts of S- 7 Tool Steel

Allan Kress, Cullman Forge

from the Alabama Forge Council

S- 7 steel is air harden steel, so never quench when there is any redness on the tip. If you think that you have quenched it when it was red, reheat it and let it cool slowly.

S- 7 is a very tough and durable steel. You can push it beyond many other steels. It will work harden on the top, or strike end, of the tool. If you see any cracking or chipping, grind out the crack and anneal. Then you can get back to work. Even though the top end has not

been previously hardened, it can work harden. It can be harder than your hammer. Beware of chipping of your hammer or tool. It can also put marks on your hammer face.

Keep your tool cool, never let it get too hot. With a hand hammer, hit 3 times then cool in water, in and out very quick, then go back to work. On a treadle hammer or a sledge hammer, hit twice, then cool in water, in and out quickly. Never quench when the tip is red. If you break the tip or crack it, just grind or reforge, then anneal, and back to work.

If you are deep slitting or punching holes there are many high temp greases with moly out there. My standby is to drop in a dab of coal dust. Works great. I never slit or punch a hole unless I have some coal powdered up. The best way to mess up one of these tools is to stick it up in a piece of steel. It's no fun to get it out.

Warning: Caution should be taken when striking or hitting these tools. Injuries can happen if care is not taken. Always visually inspect all tools, hammers, chisels, and dies before use. Always anneal if in doubt.

Dumb Things Not To Do By Harold Hilborn

We were working in the shop the other day (my helper and I) and had just finished a project. I told him, "Finish the part with boiled linseed oil, rub it down with a rag and then go home". I had to leave and run some errands. So he did exactly what I told him to do. What I did not explain to him was what to do with the rag when he was through with it. I also had never told him about spontaneous combustion of boiled linseed oil soaked rags, which I knew about, (ask Joe Hernandez for more details).

I came back from my errands about 2 hours later walked into the shop to a strong hot odor of linseed oil. I found the towel folded up laying on the floor next a gallon can of linseed oil

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and a can of mineral sprits. I know what some of you are thinking, " What kind of idiot keeps flammable material in his smithy?" I assure you I don't. I keep them in another building but sometimes things just don't get put back. Any-way, when I picked up the towel, it was so hot I could hardly hold on to it. Took it outside and opened it up; the whole inside was charred black but no flame. I was very lucky, to say the least, because all of this was laying next to my oxy- acetylene rig.

Well, I then grab the linseed oil can and read it. (Who reads warning labels anyway. Right? I new it was dangerous.) Sure enough there in big red letters is a warning about rags and what to do with them. It says to let them dry outside flat, and then rise with water before discarding.

So there you have it folks, watch those oily rags.

Some thoughts on Tools

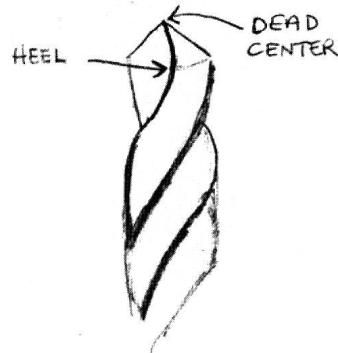
Mary Ann LaRoche

Metal working can range from the use of just a few tools, to actually acquiring a slew of them. No matter what type of tool you have or use, from the simplest to the most complex, they all require some sort of maintenance to keep them in tip top shape. Of course the more advanced blacksmith can always fabricate his/her own tools, but, why have to replace something that you already have made or purchased.

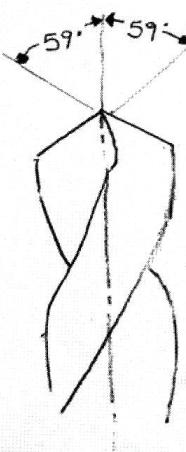
One of the more simplistic yet extremely handy tools is the hand file. File care should start with the storing of them, so that they do not rub or batter against one another. Rust and corrosion will dull them quickly. Cuttings that get packed in the gullets of the teeth will prevent the file from biting in. Tapping the file on a wood bench helps free the shavings caught, as well as using a wire brush with bristles help to remove the cuttings. A simple trick to help remove the stubborn pieces is to use a short

strip of some soft metal, like brass or aluminum about $1 / 16"$ and $5/8"$ wide. Simply press the lower corner of the end of the strip down against the teeth and push it across in the same direction as the teeth are slanted. This will form a sawtoothed edge which will dig down into the teeth and clean them of packed metal. Finally, to keep your file sharp, going in one direction across your work will keep the cutting bite sharp.

Drill bits can be your best friend, when sharp and used properly, yet we have all been lazy at one time or another, and found our dull bit to take forever, maybe even producing that lovely gnawing loud squeal. There is a lot to know about this seemingly simple tool - the twist drill, including sizes, speed, lubricants, and tricks of the trade to learn how to grind a drill so it cuts easily.



First, just by examination of the twist drill look at the tip, it really isn't a point like an auger bit, but is actually a sharpened flat. This is called a dead center, because it really doesn't do any cutting, hence the reason for the punch mark, or why it ends up skating across the work piece. If you look at the drill from the side you will see that each cutting edge or lip, has a slope of about



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59 degrees to the vertical axis of the drill. The shoulder-like portion of the drill tip slopes on each side, back and down from the actual cutting edge. This is called the "relief or "clearance angle" and is the most critical angle when sharpening a drill. Without this angle, usually 12-15 degrees, the drill simply will not cut. The grindstone is the best tool to use for sharpening. Its rotating abrasiveness combined with a swinging and rolling motion will produce the desired angle on the drill tip.

It also pays to avoid destructive practices of the twist drill. One such no-no is to use it to enlarge a hole just a slight bit smaller than the drill. You might for example, have a 1/2 inch hole that you want to open up to 9/16. Trying to run a larger drill into such a hole concentrates all of the cutting action on the extreme outer corners of the lips and flute margins. This usually causes a wedging and wearing action which reduces the diameter of the drill and causes it to bind. This type of job is best left for a reamer.

Drilling speed, and lubricant are another way to extend the life of your drill bits. The actual force that tends to burn or break the drill is a combination of both speed and feed. Using a lubricant will help cool the drill and lets the chips slide more freely. These chips that get wrapped around and stuck in the hole are culprits which can actually twist a drill off. Common drill lubricants are: a good grade of SAE 10 or 20 automobile engine oil, machining and a sulfur-based type lubricant sold as threading and cutting oil, turpentine or kerosene, for tough hard steels, lard oil for softer steels, kerosene for aluminum and other soft alloys, paraffin oil or drill dry for brass, and for cast iron drilling dry is recommended.

These are only two simple tools that we rely on in our shops, they take on a lot of abuse, but, with simple care and attention, they make our jobs so much easier.

Also, just a quick FYI regarding the use of shearing tools, which are great for short cuts in sheet metal. The best technique is to work the metal well up into the throat of the snips, cut about two-thirds of the way towards the snip jaw tips, and then advance the shears again. If you make a full cut to the end of the jaws you will wind up with a series of little notches or jogs in the metal which are hard to clean up. From the "The Anvil's Horn"

Tommy's Tips

BY: Tommy Ward

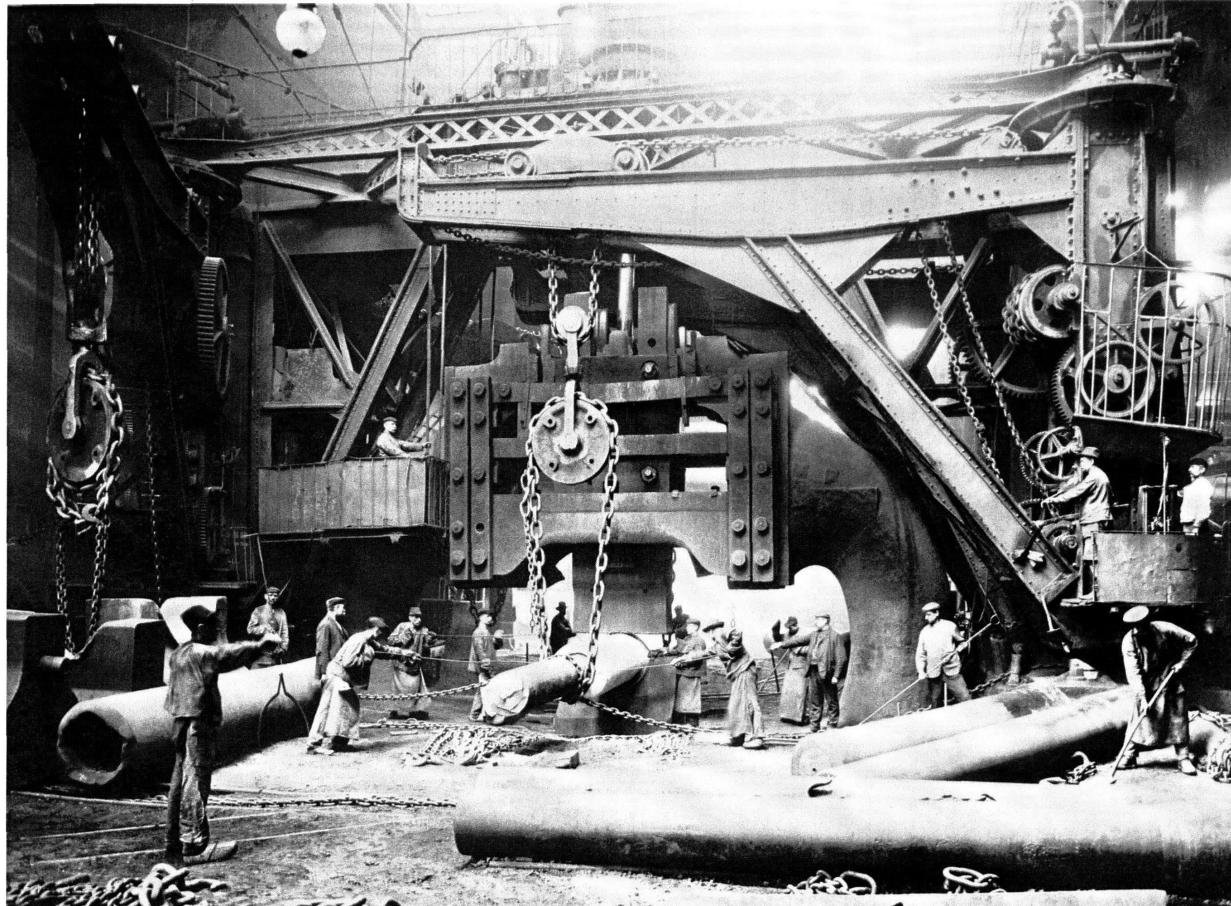
Pieces of scrap leather placed in a vise make a quick and effective method for holding work pieces that are irregularly shaped or might be damaged by the jaws. Leather is flexible and tough, and will withstand a reasonable amount of heat and a surprising amount of pressure. Threaded objects, saw blades, tools, soft materials, and items that are round or tapered are just a few examples of things that leather pads can protect from damage in a vise.

I got mine from a flea market vendor, but old leather belting would work as well. Try and find material that is at least 1/4" thick and around 6" or so square. Punch a hole in a corner of each piece and hang them on a nail near your vise for ready access. Cut scrap pieces of leather to the width of your vise's jaws.

MISSISSIPPI FORGE COUNCIL



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STEAM HAMMER

Answers for the Welding test on Pages 10 and 11

1-c	6-c	11-b	16-d	21-b
2-b	7-a	12-c	17-b	22-b
3-b	8-b	13-b	18-b	23-c
4-b	9-a	14-b	19-a	24-a
5-a	10-c	15-b	20-b	25-a

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Tongs the Alfred Habermann Way

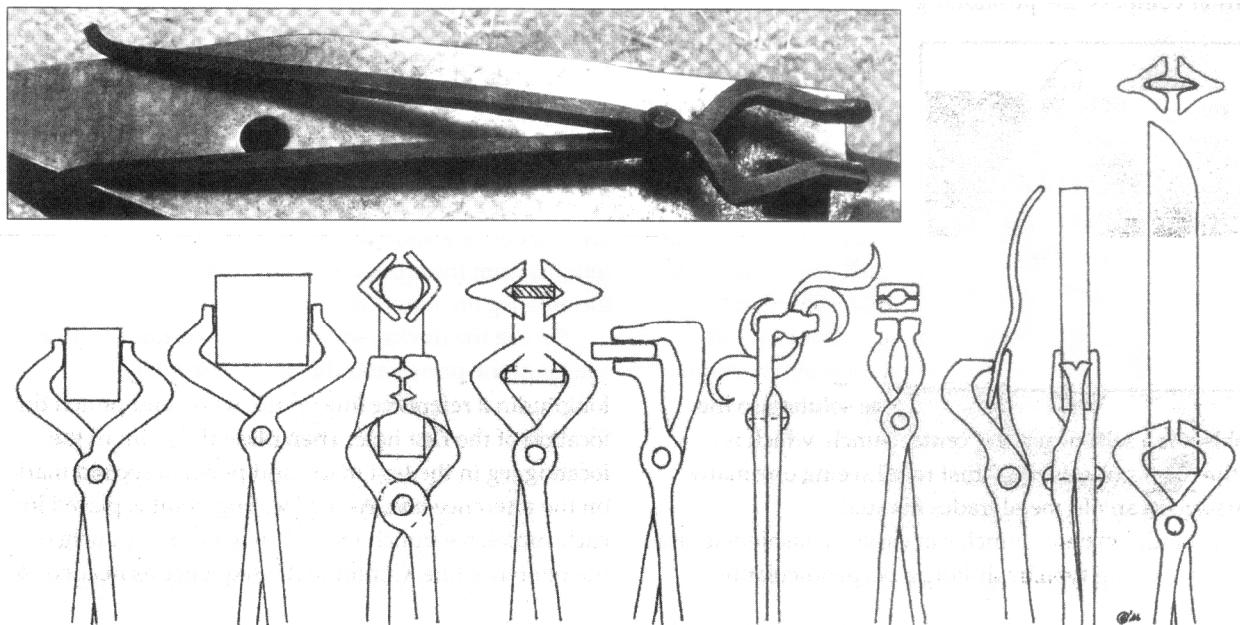
by Brian Brazeal, Ybbsitz, Austria

Prof. Habermann has developed quite an interesting and efficient approach to making tongs. He has many different designs for holding all types of stock but uses the same basic approach for most of them; he makes them out of a 1/2" coil spring. Of course, a larger spring is used to make tongs that will hold the heavier material and vice versa.

To make pick-up tongs for making hammers, begin with two pieces of coil spring about 12" long. (Refer to the first two illustrations below).

1. About 4" to 5" from the end of each piece, split and then drift a 5/16" to 7/16" hole for the boss.
2. Take a heat in the boss and jaw area, insert the drift, and with a striker holding the sledge near the boss on the rein side, make a 135° bend just above the boss on the jaw side.
3. Take a heat on the jaw area, and make a 90° bend.
4. To add strength to the bend, heat the 90° bend area and draw out the corner with a cross peen. This bend is the most notable part of the tongs. Habermann equates it with the physics of holding something out in front of you with bent arms as opposed to straight arms. It is one of my favorite of his techniques since it can be used in many situations for both structure and ornamentation.
5. Forge out the holding tip of the tong, bending 135° (in the opposite direction of the last 90° bend) over the near edge of the anvil, flattening about 5/8" to 3/4" of the material.
6. With a small 1/8" to 1/4" fuller, fuller in the center in line with the reins.
7. Draw out the reins, and bend the ends slightly to receive tong clips.
8. Match both pieces and rivet them together.
9. Free up the tongs by heating the boss area, and adjust them to fit the stock you will be using.

I have spent the better part of the last two years here in Europe, mostly with Alfred Habermann, himself, taking some of his classes, but mostly working with him on several projects in his shop. Last year my brother, Ed, and I also worked with his son, Alfred, Jr., in the Czech Republic, where we also completed a project of our own. (see California Blacksmith, September/October 2005) It has been a very interesting and stimulating time that would not have been possible without the support of the blacksmithing community, in particular the CBA. Upon my return to the U.S., I plan to demonstrate more of what I have learned. This one page article is reprinted from the California Blacksmith November/December 2006



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Join ABANA or Check out other area chapters!

Northeast Blacksmiths Association

Northeast Blacksmiths holds its meets twice a year at the Ashokan Field Campus in New York State.

The Ashokan campus is located in Olivebridge, N.Y., several miles west of Kingston, N.Y. The meets are held the first weekend in May and in the first weekend in October every year. The main demonstration is in the blacksmith shop and there is a "Hands On" workshop for beginners. A main demonstrator is brought in for each meet, food and bunk-house style lodging are provided as part of the cost of the weekend long meet.

Contact : Tim Neu

to register for hammer-ins
or subscribe to the newsletter;
Tim Neu, The Ashokan Center,
447 Beaverkill Rd.
Olivebridge, N.Y. 12461 [914]657-8333
For more info check out the web site;
<http://www.northeastblacksmiths.org/>

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New Member Renewal

Do you have any particular skills (welder, accountant, carpenter, doctor) that may be helpful to the group or membership?

Suggestions for PABA demonstrations

What is your skill level?

Beginner Intermediate Advanced Professional
Membership paid by Cash Check # _____

Send your completed application with \$ 25 (one year dues) to;
PABA Treasurer, Jeff McComsey
124 W Franklin St. Strasburg, PA 17579
(make Checks payable to PABA)

PABA Membership Application

Membership is from Jan. 1 — Dec. 31

New Jersey Blacksmiths Newsletter

NJBA Board of Directors Election

The NJBA bylaws were recently amended to provide for a mail-in ballot for electing NJBA directors. Elsewhere in this newsletter, you will find your ballot and renewal notice. Please fill out your ballot and return it with your 2011-2012 membership dues. (Note that NJBA elections are not, nor ever have been, by secret vote. Your name is on your ballot so the board can confirm you are a member in good standing and that your vote should be counted – which you can insure by returning your ballot with your dues.) Ballots will be counted 30 days after this newsletter is mailed, so please be prompt in your response.

Our Thanks.

The NJBA Board wishes to express its sincere thanks to outgoing directors John Chobrda, Tim Suter, and Tom Eden for their many contributions over the past years. John and Tom have resigned and are no longer on the board, and Tim's name does not appear on the ballot, on his request.

John was the originator of the picnic at the Red Mill (the next rendition of which is scheduled for 11 Sep., 2011), and remained active in that until he moved to Delaware. We expect he will continue his activity with NJBA, especially at the Delaware City Day, Tuckerton, and Washington Crossing Engine show.

Tim has been a contributor for a long time, and you'll find his name as author of many articles and tips in past newsletters. Tim also has been very supportive of our meetings, and is renowned for introducing many of us to Joseph Fazzio's, Inc., in Glassboro. Tim has also been an active member of our sister group, PABA.

Tom introduced many of us to knife making, and we watched with awe as he tested his creations in cutting and bending tests. In the past year or two, unfortunately for NJBA, Tom had to limit his participation due to his need to devote his attentions to his business.

We wish all these contributors to NJBA all the best, and hope to see them and hear from them in the future.

The NJBA Renewal and Board of Directors Ballot is on the next page. Please fill this out and send in as soon as you can.

The date of your last renewal is on the mailing label!!!

If your date is 2009 or older this is your last newsletter!!!

NJBA Ballot and Renewal

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[] My check is enclosed for **\$20** (membership) or **\$40** (business membership).

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Please check a box for each nominee.

You should vote on all nominees.

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Larry Brown [] [] Tom Majewski [] []

Eric Cuper [] [] Mark Morrow [] []

Dave Ennis [] [] Dan O'Sullivan [] []

Bruce Freeman [] [] Bruce Ringier [] []

Bruce Hay [] [] Eric Von Arx [] []

Nominee

For Against

Send To:

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