



N.J.B.A. Newsletter

Volume 5, Issue Number 1

Spring is here!

Well, Spring has "sprung"! We've had a couple of meets since the last newsletter. In February we were making chains and t-shirts at Marshalls and in April we visited the Mercer Museum in Doylestown, Pa, for a tour accompanied by the curator. We then finished the day with the hospitality of Doug Learn at his home nearby home. We now have T-shirts for sale at \$15 apiece, with Josh Kavett being the contact person (Buy one for everyone in the family). So for those who have been idle this last winter, dust off the anvils and heat things up!

Upcoming events for 2000;

May; Meeting at **Alex Parubchenko's Shop** in Trenton on Sunday May 21, from 10 am-1 pm. See details on this page for directions. **Elections**

will also be held, so come to vote or get involved

June; The meeting will be held at **Cold Spring Village**, Cape May, NJ on June 17 from 10 am—4 pm, see pages 1 and 2 for details and directions.

July; We will be meeting on Friday night, July 28th starting 7PM at the **Monmouth County Fair**. The fair runs July 26th through July 30. We will have demonstration space available to members and a display area for members work throughout the week of the fair.

August; A **Smithing Magician Workshop** will be held at **Marshalls** shop on Sunday, August 27. See details and directions on page

November; Possible meet in Peters Valley.



Larry Brown, Editor Tim Suter, Assistant Editor

May Meet at

Alex Parubchenko's Shop

In Trenton

The meet will be on Sunday May 21st from 10 am - 1 pm. We will try to meet for lunch at a local establishment after the meet. Alex Parubchenko will demonstrate the forging of hammers and (ornamental) crosses at his shop, "The Blacksmith of Trenton." A #2 Nazel power hammer will be used for some of the demonstration. Alex also has anvils and leg vises for sale.

Elections for our Board of Directors will also be held this day, so come out and vote or put your hat into the ring and get involved

Directions: You can get to Olden Ave., Trenton, from US Route 1 (Trenton Freeway) or from Interstate Route 295 or via Arena Drive from Interstate Route 195. From US 1, go SE about 1/2 mile to the shop. From I 295, go NW about 2 miles to the shop. From I 295 go NW about 2 miles, where Arena joins Olden, and then about 2 miles NW on Olden to the shop. The shop is at 334 N. Olden Ave. There is a vacant lot next door where you can park. (Phone: 609-396-9583)

June Meet in

Cold Spring Village

In Cape May

The New Jersey Blacksmith Association will hold a general meeting and demonstration at Historic Cold Spring Village in Cape May New Jersey. The meeting will take place on Saturday June 17th

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July Meet continued;

There will be demonstrations on both Saturday And Sunday so if you can't make Saturday come out Sunday. The meeting will coincide with HCSV's Tractors, Tools and Tackle event. HCSV is a 19th century village so period costumes are encouraged. NJBA members not wearing costumes are encouraged to wear NJBA t-shirts. Demonstrators should be in costume or be wearing a NJBA T-shirt. All members in costume will receive free admission and may bring one guest. Lunch on both days will be provided to NJBA members in costume.

We need members to bring portable forges and anvils for the demonstrations. Members bringing forges and other equipment should be there an hour earlier at 9 am. If you are interested in being a period demonstrator or have any other questions contact Steve Rhoades at (856) 697-4144 or hotiron1@juno.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.

July Meet at Monmouth County Fair East Freehold Park NJ

General Meeting Friday 7 PM July 28th
NJBA members will be providing a blacksmithing demonstration in conjunction with the Longstreet Farm Exhibit during the County Fair running July 26th – 30th. The general meeting will be held Friday Night starting 7 PM at the NJBA demonstration booth. Look for the Longstreet Farm Exhibit. Blacksmiths are encouraged to submit some of their work for a display at this venue on Friday night. All work will be displayed at the exhibit. This is a great opportunity for us to advertise NJBA and individual members. We can distribute business cards, brochures and talk to the public regarding our work. A forge, several anvils, some tools, stock and coal will be kept at the fair site for demonstrators.

Directions to East Freehold Park ,NJ

- ◆ From Garden State Parkway:
Garden State Parkway to Exit 100, Hwy. 33 west. Follow Hwy. 33 to Kozloski Rd., turn right. Follow signs to Park.
- ◆ • State Hwy. 9 to Hwy. 33 east, south of Freehold. Follow Hwy. 33 to Halls Mill Rd. North exit. Follow Halls Mill Rd. north to intersection. Road name will change to Kozloski Rd. Follow Kozloski Rd. to Park on left.
- ◆ From Rt. 18
Rt. 18 to Exit 22, Rt. 537 west. Take Rt. 537 west to Kozloski Rd., turn left. Follow to Park on right
- ◆ It has also been recommended that to avoid traffic approach from Rt. 537

For more information contact David Macauley 732-206-1568 or drmacauley@att.com.

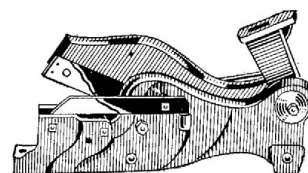
Free passes will be available for demonstrators, but we need to know who wishes to demonstrate by June 30th, 2000. For general information on the fair call: (732) 842-4000.

August meet; Smithing Magician

Workshop

Preparation for Workshop at Marshall's
Open Forge Meetings.

Bruce Freeman and Marshall Bienstock are requesting assistance in preparing for the Smithing Magician Workshop to be held on Sunday, August 27. Help is needed mostly in cutting stock, and perhaps with grinding and drilling operations as well. We will be doing this work Monday evenings, simultaneous to the open forge meetings at Marshall's Forge. (See announcement elsewhere.) Contact Marshall at 732-780-0871 or Bruce at 609-716-2827 for more details.



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February Meet At Marshall's

This was a two part meet, the front of the shop was making chain for the ABANA conference chain project. Links were made by experienced smiths and first time chain makers. The back of the shop held the T-shirt production line.

Report on the T-shirt project by Josh Kavett:

The board of NJBA decided to go ahead and make our own T-shirts this year. After much discussion of color, style and logo design, a consensus was reached. I took the lead in coordinating the job, which was made possible by our own member, David Potts. Dave is the graphics and internet expert at my school, Northern Burlington Regional. Dave did the final development of the logo, and created the screens. He also laid out the money and ordered the shirts.

We set the printing and heat lamp equipment in Marshall's back room, and did a home-brewed screen printing operation. The morning was devoted to printing the front pockets, and after a break for lunch and IITH, the back logos were printed. Thanks to all of the members that participated during the day.

We made 72 pocket-t shirts. To date, we have sold about 30. They are \$15/each, and will be available at all NJBA events. If anyone wants to order by mail, send \$15 plus \$3 shipping to J. Kavett, 471 Casino Drive, Farmingdale, NJ 07727, and I will send one out. Available in M / L / XL / XXL. All sizes are available as of this writing, but are going quickly. All profits benefit NJBA programs.



NJBA Board of Directors

Marshall Bienstock, June, 2001
663 Casino Dr., Howell, NJ 07731
732-938-6577 732-780-0871
mbienstock@worldnet.att.net

Larry Brown, Editor, June, 2001
90 William Ave., Staten Island, NY 10308
718-967-4776
lnbrown@con2.com, brownln@hotmail.com

Bruce Freeman, June, 2000
222 Laurel Place, Neptune, NJ 07753
732-922-8408, 609-716-2827
freeman@monmouth.com,
freemanb@pt.cyanamid.com

Jon Folk, Director until June, 2001
P.O.Box 143, Old Bethpage, NY 11804
(516) 625-5667.

Bill Gerhauser, Director until June, 2000
415 Hutchinson St., Hamilton, NJ 08610
609-394-1817, bgahow@earthlink.net

Josh Kavett, June, 2001
471 Casino Dr., Farmingdale, NJ 07727
732-431-21 52, jakavett@aol.com

Bill Ker, June, 2001
Box 14, Allenwood, NJ 08720

732-223-4188, KemoKimo@aol.com

Doug Learn, June, 2001
121 Pebble Woods Drive, Doylestown, PA, 18901
215-489-1742 doug.learn@Primedica.com

David Macauley, Director June, 2000
4 Patricia Ct., Howell, NJ 07731
732-206-1568, 732-949-8422
drm@anchor.ho.att.com

Jeff Morelli, June 2001
234 Rahilly Road, Wrightstown, NJ 08562
609-723-5990

Nate Pettengill, June, 2001
24 Byron Rd., Short Hills, NJ 07078
npetteng@motown.lmco.com

Steven W. Rhoades, June, 2001
513 Harding Highway, Vineland, NJ 08360
856-697-4144, hotiron1@juno.com

Bruce Ringier, June, 2001
201-652-4526 346 Rt.565 Wantage, NJ 07641

Tim Suter, June, 2000
1112 Ladner Ave., Gibbstown, NJ 08027
856-423-4417

Andy Vida-Szucs, June, 2001
osan@netlabs.net

Greg Phillips, Director until 2002
(914) 457-5671, Acorn Forge, 937 Route 17k,

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Open Forges

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)

Monday Night Open Forge

In Orange County

Greg Phillips will be hosting an open forge in his shop in Orange Co. NY. For more information Contact: Greg Phillips, Acorn Forge, 937 Route 17k, Montgomery, NY 12549, (914) 457-5672, Suresign@frontiernet.net

Tuesday Night Open Forge on L.I.

On Tuesdays, an open forge will be available at Jon Folk's shop in Central Islip. The forge is open to all N.J.B.A. members only every Tuesday from 3:00 pm to 8:00 pm. For information and directions, call (516) 625-5667

Blacksmithing

Workshops and Classes:

Peters Valley Craft Education Center

19 Kuhn Rd., Layton, NJ 07851 (973)948-5200
pv@warwick.net [Http://www.pvcrafts.org/](http://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

Unclassified ad:

Wanted for my collection, eventually to be displayed with the Fisher & Norris archives:
Any Fisher & Norris anvils or vises.
Will buy outright or trade for post vises.
Over 20 post vises to choose from.
Contact Joshua Kavett
732-431-2152 E-mail: jakavett@aol.com

Report on Bob Bergmans

Demonstrations At The

Furnacetown Blacksmith Guild /

NJBA Meet and the NJBA April

2nd Meet At Dan Cruzans

Bob Bergman demonstrated his power hammer the Kickass 75. He demonstrated tooling and techniques that he has developed for this hammer. Bob can be contacted for more information at;

Postville Power Hammers

N 8126 Postville Road

Blanchardville, WI 53516

1 888 535 6320 Fax 1 608 527 2494

This report has been provided by **Anton Holdstrom:**

Bob Bergman's KA 75 Air Striking Hammer
Designed for low air consumption, Low weight, and low cost

Flat dye style forging

Designed to duplicate man with sledgehammer.

If a lot of long tapers are needed, this is not the machine.

Designed like old time steam hammer. Cylinder moves and ram is stationary. Most cylinders are stationary and the ram moves. One cylinder the air comes in above the ram to move case up, the other the air enters from below and the cylinder moves down.

For cold work, drop pressure down.

ATF fluid lubricate every 4-5 hours / wash WD-40
Cylinders are 2.5" id x 2 = 5 @ 100 psi = 500 LB?

Mass times velocity squared

Longer the tools, less speed of head so less power.

Punching hammer has tendency to roll so keep tools short.

Continued on next page

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Bob Bergman and Dan O'Connell continued;

Safety

- 1) When hammer is up, it is on
- 2) Don't lean against hammer.

Seven (7) Basic Processes

1) Tapering - drawing

Any taper - establish the point first, so you can control the length.

A bird's mouth will always happen if start tapering too close to end.

Start back 1/2 the thickness of material. If going to perform and blunt taper, take a few Hits back to pop the center out, then start taper. Don't go round and round when tapering, only work square, octagonal or edges.

Power hammer - tapering in steps then use flatter to remove steps.

Solid sound indicates bottom so move in or out.

Taper - towards you - back edge of dye
-- away from you - front edge of dye

2) Upsetting - making thicker

Don't use too heavy of a hammer

1:3 Rule— Diameter : maximum distance that may be upset without problems (1/2" : 1 1/2")

3:1 Max force from top to bottom to meet in center, 4:1 starts to fold

Upsetting - 3:1 width to length ratio, if greater the object will bow or fold

The fold or shut never goes away. If keep hitting, the shut will go deeper.

Corollary to 3:1 rule; if working longer stock must control heated area to prevent bow. Steels

1) H 13 - cutter

1750 - 1800 air harden, heavier material use fan

High chrome - hot working

2) 4140 - dies Not very high in carbon but is tough.

3) 5160 - snapper, cutter,

Also truck springs

No heat treat, air cool enough

4) A 36 & super quench

5) 8260 track pin

6) S-7 some jack hammer bits

Jackhammer bit - 20 degree taper with 80-degree bevel on very end.

3) Punching

Hit and wiggle, can use graphite grease or coal dust for deeper holes. 20 degree taper prevents sticking. Final drift can be made from mild steel and Gunther quench. Faster than drilling and nice swelling around hole.

Slitting - circumference = $3.14 \text{ and } 1/2 = 1.57$ " and slit 75%.

4) Fullering or Grooving

The groove sets off the twist. Rounding corners, grooving and twisting looks like rope. Chamfer corners cold, example railing.

5) Twisting

Go past stopping point and come back.

6) Cutting

Marks cold and cuts hot.

Cut on alternate sides for a full cut, if rotate 90 degrees only cutting half material.

7) Welding

Does not use flux, very little scale is generated if welding heat is reached fast.

Too long and clinker sticks to metal and scale is generated to prevent weld.

Important Notes

1) Volume - Area - Resistance - Force

2) Cut stock 120" / handles 16" / spring handles 30" and make 10 or 15 at a time.

3) Offset tenon - very easy to do Blacksmithing. Hard if machined.

4) 30 degree taper Max - or shoots out.

5) Walter - blue plastic backing for grinding wheels

6) Handles - 1/4" x 1" nice

7) Ball peen hammer - point the peen and use for punch

8) There seems to be a size like when I was doing the springs that the thickness about 1/8"

Seems to be the thinnest. Maybe due to cooling effect.

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Bob Berg and Dan O'Connell continued;

Dies

Cutting - back bevel the cutter 2 degrees to keep cutting straight. No bevel - cutter will tend to roll.

Hard stop to prevent edges from touching.

Turn dies over to omit the chilling effect.

Dye must be chamfered to allow metal to flow out.

Snub End Scroll

If too tight a bend - crack can start from shut. Roll away clockwise.

Leaf

1/4" x 1" flat and cut end on 45 degree heat and than center the point.

Veining chisels very steep angles and can do cold.

Rusted Texture

Hard surfacing rod and dye grinder. Go back over again but stop before all flat is gone.

Wood Grain

Take flat stock and bend in the shape of "S". Fuller with cold cutter. Straighten flat stock.

Fish from Horseshoe;

- 1) Use ball to start mouth, round hot cutter to open mouth.
- 2) Eye - ball peen punch
- 3) Gills - same round hot cutter.
- 4) Heels - flair out and use flatter

Hand Wheel

Make a ball and flatten

Hold in jaws and drive down to offset with hammer

Punch hole for mounting

Preparing the scarf for welding

Bend about 1/2" back onto itself. Work to taper and than point.

This makes a large upside down thumb profile.

If bring to welding heat very fast, than don't need flux because very little scale is generated.

Tongs - Quick & Regular

- 1) 90 degree with 1/2 face blows to start jaws. Turn towards the hand, which is going to hold it.
- 2) 45 degree with 1/2 face blows to start eye
- 3) 90 degree to set eye size and start reins

Bob made a block with recess to prevent eye from getting too thin.

Quick tongs are made using 5/16" or 3/8" rod to set eye area.

Heat and twist for jaws. The twist does stress the area

Auction tid bits from Josh

Article 1: Auction news

I follow and attend many auctions and recently saw reports of three items that may be on interest to the blacksmithing community. Last week on Ebay, a hammerhead that was provided by Bill Gitchner to Francis Whitaker for reworking, then stamped with his touchmark, and given back to Gitchner was sold. It brought about \$135. No handle included. A recent sale of Arts & Crafts items in Lambertville, NJ saw a Yellin piece sold. It is described as a "wrought-iron floor lamp" and it sold for \$25,000. Also in Ebay news, a one pound sample anvil marked "Hay-Budden Manufacturing", Brooklyn, NY on one side and marked with a name of a company in New Zealand on the other side sold for about \$565. Not a bad price per pound. One can see another of these mini's in Postman's anvil book. More on auctions next newsletter.

Josh Kavett's

Fisher&Norris Project

Just a brief update on my FN project. I have applied for a grant from the NJ Historical Commission to help finance expenses in writing the book on the history of Fisher&Norris Anvil Works. I will hear about the grant around June 1, I will begin actual manuscript work after my Flagstaff trip. I am also planning to finish a room off in my shed for my museum of Fisher&Norris anvils and patterns. This work will start this summer and hopefully will be done before winter. This work will involve insulating, wiring, sheet rocking and painting. I have not decided what to do about the floor yet. Any volunteers will be welcome and appreciated. Give a call any evening for information. I eventually hope to put up a large building dedicated as my museum of great stuff.

April Meet at the Mercer Museum and the Home of Doug Learn

On 15 April, under intermittent rain and in competition with the first day of PA trout season and Spring Fling, a total of 27 members of both NJBA and PABA met at the Mercer Museum, Doylestown, PA. Curator Corey Amsler led off the tour with a brief history of Henry Mercer, his museum, and his works. Corey then guided us through selected areas of the Museum, explaining the reasons for the arrangements of the artifacts and his perceived mission of those artifacts. We were then allowed into a storage area for woodworking tools and allowed to look and inspect the collection of tools there. After a close inspection of the tools, Corey then left us to roam the Museum at will. Henry's collection of artifacts is truly amazing, a snapshot of obsolete technology, preserved by one man with a vision.

A majority of the visitors then repaired to my house for lunch, a tour of some of my tools and artifacts, and most interestingly, a discussion by Josh Kavett on his attempts to preserve the history of the Norris and Fisher anvil company in Trenton. Josh brought the foundry pattern for one anvil and explained the process of casting the anvils. He also gave a brief history of the Company and his contacts with the heirs of the family, the last years of the company, his efforts to salvage as much of the company's information as possible, and his efforts to start a Museum to chronicle this part of Trenton's industrial heritage and its contribution to blacksmithing. After a short IITH, the visitors dispersed. I would like to continue this joint meeting at my house as a yearly event.



International Preservation

Trades Workshop

The 4th annual International Preservation Trades Workshop (IPTW 2000) will be held November 13-15, 2000 at the Pennsylvania Farm Show Complex in Harrisburg, Pennsylvania.

IPTW 2000 will explore the theme "Convergence: Architecture and Craft" through demonstrations, presentations and round-table discussions. Preservation trades people will demonstrate a variety of skills and traditional crafts as well as the application of new techniques and technologies in the preservation of historic structures. Other presentations will focus on training for the preservation trades and how those engaged in the preservation trades can work more as a partner with those in the design professions. What makes IPTW unique and different from other preservation conferences is the opportunity to see, and participate in, actual hands-on demonstrations of preservation crafts and trades.

The Pennsylvania Historical and Museum Commission is hosting IPTW 2000 in conjunction with the Preservation Trades Network of the Association for Preservation Technology International. A local organizing committee has been working since September to make IPTW 2000 the best such event ever. The Pennsylvania Historical and Museum Commission will be holding its annual maintenance conference in conjunction with IPTW 2000.

The Pennsylvania Farm Show Complex offers an exciting new venue for the IPTW. With 16 acres under roof and 60 acres of parking, it is one of the largest exhibition facilities in the east. The 28,000 square foot Large Arena will be the home of IPTW 2000 that will provide ample room for the dozens of demonstrations and presentations as well as many exhibitors of products and tools of interest to those in the preservation industry.

Contact Barry Loveland at 717-783-5407 (bloveland@phmc.state.pa.us) or Preservation Trades Network, P.O. Box 257, Mastic, NY 11950, info@ptn.org for additional information.

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This letter of appreciation was received from Allaire Village:

**WM. H. KER
P. O. BOX 114
2246 RAMSHORN DR.
ALLENWOOD, N. J. 08720**

Larry Brown - Editor
NJBA Newsletter
90 William Ave.
Staten Island, NY 10308

Dear NJBA,

As I sat at the recent NJBA directors meeting listening to the plans for upcoming events I was embarrassed to remember that it has been several months since the last anvil repair workshop. I was embarrassed because as chairman for the Historic Allaire Village Blacksmith Guild I had neglected to recognize the generous efforts of the membership of the NJBA.

As a gesture of good will the NJBA was kind enough to include one of our very abused donation anvils as a part of the anvil repair workshop. The anvil had been donated to the Village by a local resident and had been part of the family farm in Kentucky. It migrated north and remained a sentimental lawn ornament for years until its donation. The ravages of time and severe abuse would normally have qualified its only viable use as that of a boat mooring.

The anvil was resurrected and transformed by the skilled crafts persons of the NJBA. With its new crisp corners, filled in sections, and beautifully finished face and horn, it has become a functioning addition to the tooling in the Allaire Village blacksmith shop.

We at Allaire Village offer a belated but sincere thanks for your donation of time, materials, craftsmanship, and spirit of good will.



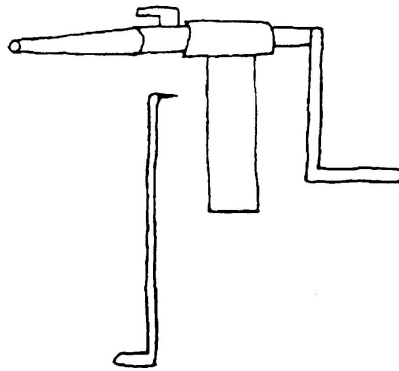
With sincere appreciation,

Wm. H. Ker

Wm. H. Ker - Chairman
Historic Allaire Village
Blacksmiths Guild

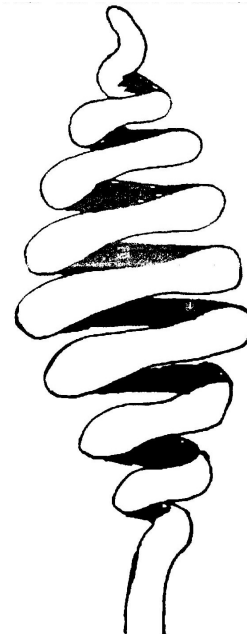
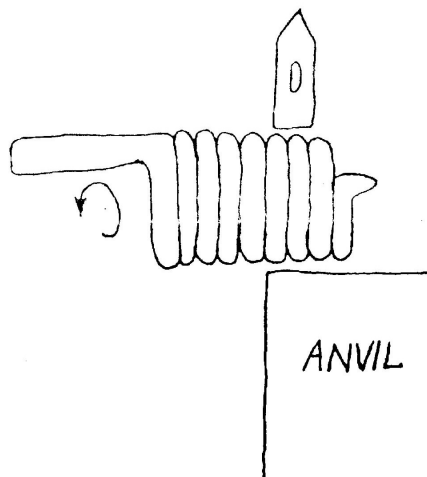
TAL'S TENDRIL TOOL:

During the class at the Folk School, my project required four tendrils to be made. After making a couple the hard way, I came up with this gadget.



The stock was 1/4" round x 16 1/2" long. Forge a short taper on one end. Bend the ends as shown. Take a long heat, stick the end with the short taper under the hold-down finger and crank the handle until you run out of hot stock. Two heats should get you to the end. If you crank the handle backwards the stock will release from the jig and slide off the tapered end.

After this step take a heat and close up the ends of the tendril using the step of the anvil. If you turn the piece as if you were 'unscrewing' it off the anvil and keep hitting with the edge of the hammer in fine with the edge of the anvil, the ends will make themselves. All of this is much easier done than I can describe it.



Reprinted from the Hot Iron Sparkle