

THE HABA LETTER

FEBRUARY 2003 Edition

The Fine Print - Page 12

A QUICK WORD FROM THE PREZ

I was late in getting a letter out for February, so in retrospect a big thank you to all those who attended and made the knife workshop a success.

Thanks to all that turned out to attend the meeting at Dave Koenig's Tudor Forge. Despite the bleak weather forecast, there were about 21 brave folks that showed up. Dave, thanks for a great demo. We can all identify with your sharing about the trials and tribulations of starting with a concept and ending up with a product.

The HABA board met on February 12. It worked its way through a fairly extensive agenda. James Porter was nominated and he accepted a board member position. James also became HABA's Treasurer. Long time Treasurer, Larry Hoff was nominated and accepted the job of Assistant Treasurer.

HABA is still growing and is a very vibrant organization. There are plans and ideas for many events and activities with new opportunities developing all the time.

There may be a total of 21 on the HABA Board of Directors. We presently have 5 board members. Some of these folks served since the inception of HABA, continue to do a yeoman's job and would like to step down. To maintain the pace and quality of HABA's programs, we need more folks to be involved. Please consider becoming a Director, or a Committee Chairperson.

Les Cook

SUMMARY OF UPCOMING EVENTS

March 22

Welding workshop hosted by Lincoln Electric

April 4-6

Hammerfest at Oldenburg

James Porter is chairing this event. If you can help in any way contact

James at 281-337-5384 or e-mail hotartmetal@cs.com

May

Treadlehammer/Flypress Tool Workshop

THE HABA LETTER

FEBRUARY 2003 Edition

We need to find out how many folks are interested. John Crouchet will be leading this workshop. Date and kinds of tools still need to be firmed up.

Please let Les Cook know of your interest preferably by e-mail at: anvil@flash.net or by phone at 281-481-2457

THE MARCH 22 HABA MEETING

NOTE: THE MARCH HABA MEETING WILL BE ON THE FOURTH SATURDAY OF THE MONTH AND NOT THE THIRD!

The March HABA meeting will be a welding workshop for those who never had a chance to weld and an opportunity for experienced welders to learn about the latest welding technology.

This workshop started out with Robert Killbuck and Bobby Tedder and Les Cook talking up the welding workshop idea. The workshop was added to HABA's meeting agenda where Ed Malmgren read about it. Ed is on the board of the American Welding Society and contacted Lincoln Electric to see if they had any interest in hosting a HABA meeting.

Lincoln's manager Tom Angelino was very interested so the March welding workshop got expanded from a workshop for just beginners to a workshop for the beginners and an opportunity for the experienced welders to learn all about the latest welding technology.

This is a very good example of how a simple meeting idea can turn into a remarkable opportunity. Members are stepping forward to contribute their time and ideas more and more within HABA

and it shows the strength of this growing organization

Lincoln Electric is located in Suite 585, 770 Bradfield, Houston, 77060. This is located in the NW quadrant of the intersection of Beltway 8 and Hardy. Lincoln's phone number is 281-847-9444 and our hosts are Tom Angelino, Manager and Dan Hernandez Assistant Manager.

The schedule looks like this:

- 08:00: Sign in, donuts and coffee provided by Ed Malmgren
- 08:30: The first classroom session starts with up to thirty people.
- Part of the agenda will be a plasma cutter demo and hands on with the cutter.
- Welding and forging begin after the first class if there are less than thirty people.
- Begin a second classroom session if needed.
- 12:00: Break for lunch. Bring your own lunch or visit a local eating establishment.
- Continue welding and forging after lunch.

THE HABA LETTER

FEBRUARY 2003 Edition

- o 4:30: Wrap up

What to Bring

Bring your own welder as long as it is self powered. (No John. Your welder does not need to be a Lincoln. Your Bobcat will be welcome.)

Bring your hood and gloves if you have them. There will some hoods and gloves available for folks who do not have them. Bring your safety glasses with side shields and wear a long sleeve shirt, long pants and work shoes. Please Note: NO

SNEAKERS, SANDALS OR ANY TYPE OF OPEN SHOES WILL BE ALLOWED

Bring your forge if you have one. Our hosts would like to see some forge welding and to try their hand at it. This is also an opportunity to do general forging like at any other HABA meeting.

This is going to be a great meeting, an opportunity to learn all about the latest in welding technology, do some plasma cutting and practice welding with a stick.

FEBRUARY MEETING SUMMARY

Dave Koenig demonstrated how to make hinges, pintles and a Suffolk latch at the February meeting. The demo got started about 9:30. The weather was not good the few days prior to the meeting and was still raining a little when the meeting started. The liquid sunshine did not turn away 21 people who came to learn more about smithing.

Erik the Smith and A.J. Garrett attended the meeting after a long absence. Erik made a nail header from a railroad spike during lunch and A.J. showed us his latest production line of metal sculpture from found material.... small motorcycles with animal riders. They were as creative as ever! Well done A. J.!

Tee Hines and Ken Kellow both of Magnolia came to the meeting for the first time and are now new HABA Members. We welcome you both and look forward to seeing you at many future meetings.

Dave's demonstration included basic forging techniques of drawing out, spreading and upsetting, riveting, hot punching and cold cutting on the treadle hammer, forge welding....and burning up some work while talking! The demonstration ended about 4:30.

THE HABA LETTER

FEBRUARY 2003 Edition

HAMMERFEST 2003 **HAMMERFEST - SPRING 2003** **APRIL 4-6, 2003** **OLDENBURG, TX**

OPEN TO THE PUBLIC - No Charge

FOR SALE

The first of two inline, solid ram, Clay Spencer Treadlehammers HABA owns will be offered for sale at Oldenburg. HABA's hammers were made along with 28 others during a workshop in March of 2002. The workshop was supervised by Clay. Each of the hammers made at this workshop has its own brass plaque showing Clay's touch mark, date and serial number. The hammer offered for sale is Number 14.

DATES- Friday, April 4 - Sunday, April 6
PLACE: Highway 237 - Oldenburg The Hammerfest site in Oldenburg, TX is located at the intersection of highway 237 and Bauer Road. The site is on the north end of town on the East Side of Highway 237. Oldenburg is located about eleven miles north of La Grange and about 5 miles south of Warrenton.

Kennie and Susan Hall host this event for all blacksmiths.

Come See Us! We have a grand time regardless of the weather!

PURPOSE :

To give blacksmiths an opportunity to sell their work to the public.

To share blacksmith techniques with the public and other blacksmiths.

To provide blacksmith tools (anvils, forges, hand tools) for sale.

To visit with HABA members and smiths from other clubs.

To raise funds for HABA through donated items which are resold to the public.

CAMPING - Friday - Sunday:

Camping is available in the field behind the demonstration area.

No charge to members, their families and their guests (donations will be collected to help with expenses).

Portable toilets, water and electricity are available.

SALES TENTS - Friday - Sunday:

Club Fundraising Table - Handmade items donated by members for sale to the public.

Members Sales - Opportunity to sell your excess tools (anvils, forges, hand tools), supplies, hand made items to other members or to the public.

Tools for Sale include - blowers, anvils, hand tools, forges, Clay Spencer treadle hammer.

DEMONSTRATIONS - All day - Saturday:

THE HABA LETTER

FEBRUARY 2003 Edition

James Porter

Treadle Hammer Tools
Railroad Spike Knives
Square nails
Mouse - 2 man job w/striker

Larry Hoff

Texas Longhorn

Richard Boswell

Heifer Head

Frank Walters

Raising Twelve Inch Maple Leafs
Several Twisting Jigs

Les Cook

Trivets

Others Smiths

David Koenig

Strap Hinges
Kinetic Sculpture

Please call James Porter (281-337-5384) if you can demo or bring a forge setup.

FORGE WELDING A KNOB ONTO A ROD: NOTES AND INTERPRETATION FROM THE ROB LYON DEMONSTRATION: 11-16-02

David Bailey

Welding a knob onto a rod is a useful and relatively easy forge welding process. It can be used for producing knobs of various shapes for handles, finials, bolt heads, and other applications requiring a mass on the end of a rod (see figure a). It involves forging a collar onto the rod and then forging the collar to the desired shape. A collar formed of half-round stock (prepared on a swage) will produce a sphere and a collar formed of rectangular stock will produce a cylinder, a cube, or a bolt head (figure b).

For smaller stock, heat and scroll the end of the appropriate collar stock so that the inside diameter of the scroll is a tight fit on the receiving rod. Mark the collar stock with a chisel to the apparent length

needed (at an angle so that the outside circumference will be larger than the inner), heat, and cut off on a one-bevel hardie (figure c). Flux both pieces, drive the collar onto the end of the rod, and complete the bend around the rod. At this point, the collar should make a tight friction fit all around and there should be a gap between the ends of the collar. If there is no gap and you hit too hard as you weld, stretching the collar, you'll be welding at one point and forcing the collar away at another. Flux again, bring to a welding heat, and weld using a light hammer and a half-round bottom swage. Forge into the desired shape.

Be careful in the final heat not to let the collar fall into the fire when removing the

THE HABA LETTER

FEBRUARY 2003 Edition

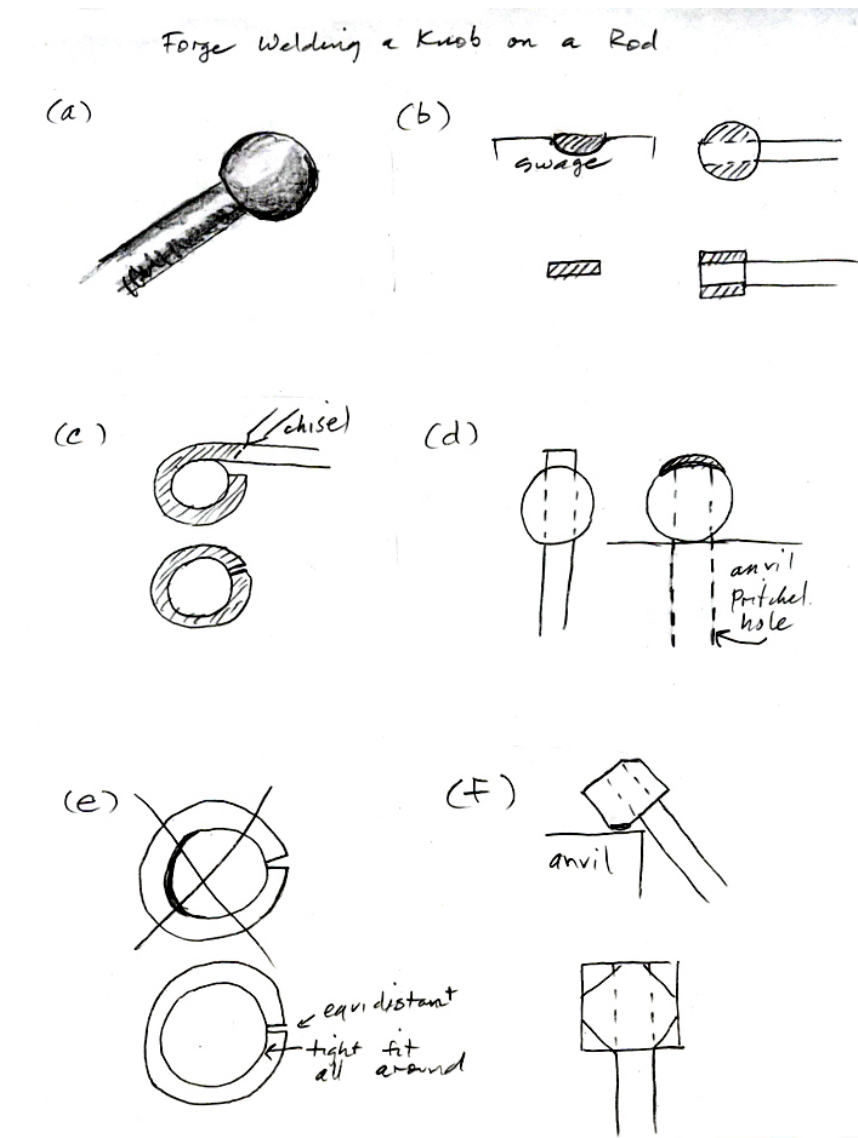
parts. Lift the end up rather than sliding it out. If the collar should slip down either in the fire or in preliminary welding, simply drop the rod into the pritchel hole or an equivalent after the initial weld and flatten the rod end, welding it to the ball (figure d).

For larger stock you need to calculate the collar length more closely. Make the length of the collar the diameter of the bar times 3 (not quite pi) plus the thickness of the collar stock. This will produce a collar not quite meeting when bent and slid over the rod. The gap

allows for some stretching during the welding process. Cut the collar ends at an angle such that the outer and inner circumferences will be equidistant at the joint (figure e).

In shaping the knob, the spherical and rectilinear shapes are intuitive. The faceted cube involves forging a cylinder into a cube, placing a lower corner of the cube onto the anvil and hitting the opposite top corner, thereby flattening those two corners, rotating the cube to the next set of corners and repeating the process.

Alternating this faceting with



THE HABA LETTER

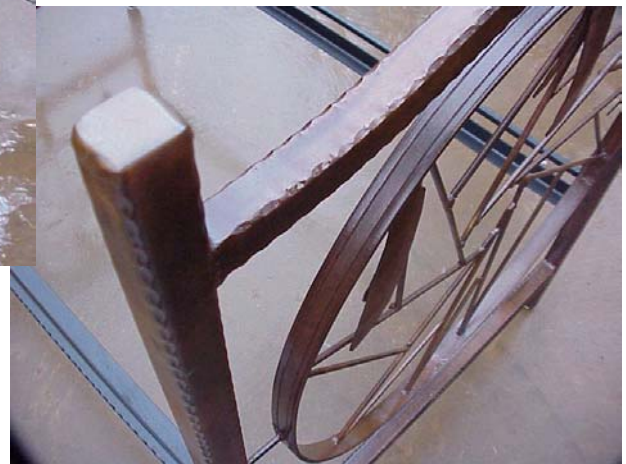
FEBRUARY 2003 Edition

dressing of the original flats will produce a sophisticated, appealing shape. You may leave the corner facets smaller than the original faces or enlarge them to the

size of the flats. Additional shapes could be achieved using swages or treadle hammer dies.

BABY BED BY ROBERT KILLBUCK

Robert recently completed a baby bed that was donated to the American Heart Association. All of the forge work was done with his flypress.



THE HABA LETTER

FEBRUARY 2003 Edition

FLYPRESS TOOLING

An E-mail From John Crouchet

Following is a series of e-mails with pictures describing several different kinds of flypress tooling by John Crouchet. Please see the February 2003 for John's first e-mail.

Here are a few John's words about flypress tooling. "Fortunately, it is not very hard to build tooling for those babies. I mostly stick to plain old blacksmith tools, like fullers and chisels, etc. which are much less complex than doing dies and blanking punches. My experience is that the fancier and more specialized you make a tool, the less it is good for."

BENDING

This set up consists of two bars, each ground to a bread-loaf shape and welded to a 1/2 by 3 inch bar about twenty



inches long. It fits across the big plate you saw bolted to my flypress and I clamp it down with a couple of small welding clamps. Another bread-loaf bar is welded to a stem for my top tool. These bread-loaf bars are all just mild steel.

This is a wonderful tool for straightening cold bar stock ~ much better than standing at the anvil pounding away. It will also do a good job of bending circles

or partial circles. For a full circle taller than your press opening, you will need to change out the top tool for one that extends out past the front of the press. I will send that picture in the next email.

John

TEARDROP

I use these teardrop shape punches - and several similar, but bigger or smaller or more curved- to put the relief into thick



iron leaves. Some of these punches down each side of an oak leaf really make a world of difference. They are made from H-13, since I always use them on hot iron.

John

BALLS

These tools are made by welding large ball bearings onto mild steel support bars. By sizing the gap between the balls properly for a given size flat bar, you can just tap your way down the flat bar, quickly giving it a nice even "scaloped" edge on both sides. The single ball

THE HABA LETTER

FEBRUARY 2003 Edition

bearing is used to just do one side of a bar and you will need to set up a fence on the other side to keep it from skittering away with every hit.

These ball bearings are about one and a quarter inches in diameter. They are available at hardware stores or most big supply companies. They are not expensive.

All of this tooling has been tig welded, but a mig (or stick) would do just as well, but would of course need more cleanup after welding. Actually, all of the force is straight down, so I would not be surprised if you could hold these tools on with superglue or bubblegum and spit. I make most of my tools just like the

regular hammered-on version, but I cut them off about an inch long and weld them to a stem. It's not too high-tech, but it's fast and it gets the work out the door.

John



OFFICIAL FEBRUARY WORKSHOP SCHEDULE FOR FLAMING PEARL METALWERX

FRANCES TRAHAN PROPRIETOR

Hey Folks! Please excuse the slight tardiness of FLAMING PEARL METALWERX's March Workshop Schedule. Here's a brief run-down of what's going on this month. DO NOT BEWARE THE IDES OF MARCH!!! Come on down! LOST WAX CASTING, BASIC STONE-SETTING, and SILVER SOLDERING will be offered!

LOST WAX CASTING - 15th & 16th (noon - 4pm)

BASIC STONE-SETTING - 29th & 30th (noon - 4pm)

SILVER SOLDERING - (ONE DAY WORKSHOPS) -

8th - 1pm to 4pm: 12th -- 6pm to 9pm: 22nd -- 1pm to 4pm: 26th -- 6pm to 9pm

The weekend workshops are \$120 plus a \$30 supply fee. The one-day workshops are \$50. The silver soldering workshop is a chance to either understand and practice the technique

THE HABA LETTER

FEBRUARY 2003 Edition

or learn a few new tricks. I will be covering solder distribution, basic solder joints, plus special problems like findings, bezels, small to large objects and thin to thick objects. Reserve your seat today! Feel free to reach me at 713-863-PERL or perlwerx@yahoo.com. Frances

RIVER BLUFF FORGE COUNCIL PRESENTS **FORGING ON THE RIVER** **MARCH 28-29-30, 2003**

Demonstrations start at 7:00 PM Friday and at 9:00 AM Saturday and Sunday. The location is The National Ornamental Metal Museum, 374 Metal Museum Drive, Memphis TN 38106. The Featured Demonstrators are: Chad Gunther, Corky Storer and Doug Hendrickson

For more information contact Richard Carr 901-872-4009 or Ray Tanner 901-682-9771

SALTFORK CRAFTSMEN HOSTING **WHEELWRIGHT DEMO - DOUGLAS, OK**

The demo is coordinated through the Saltfork Craftsmen, Contact Tom Nelson (580)862-7691

The demonstrator is Mike McGilvray of Woodrow, CO. The demonstration will be held in Douglas, OK (35 miles North of OK City). It is a two day demo March 21 - 22nd, 2003. Cost: \$35.00 Saltfork members, \$45.00 non-members. Tom

wants phone calls from interested parties to get an idea of the number of attendees. The demonstration will be to build a complete wagon wheel. Pre-registration is required. For more information on registering you can contact Jim Carothers. 1 (580) 336-9213 colonel@fullnet.net

HAMMERFEST SEPTEMBER 2003

The North Texas Blacksmiths' Association invites Corrina Mensoff to Hammerfest '03, Sept 13-14. Corrina's ironwork is of excellent quality and

original designs. For more information about Hammerfest '03 see the NTBA home page at <http://www.flash.net/~dwwilson/ntba/>.

THE HABA LETTER

FEBRUARY 2003 Edition

HABA TREADLEHAMMER FOR SALE

HABA is selling one of its two solid ram inline treadlehammers made a year ago as part of a HABA treadlehammer workshop conducted by Clay Spencer.

The hammer will be available at Oldenburg, April 4 -6, 2003. The price of this 500 pound hammer is \$1,200.

NAVASOTA PARADE, DEMO, SALES APRIL 26, 2003

The Navasota Merchants Association is introducing the Festival of Flags. Bring a flag and your anvil and parade down Main Street. Contact Kippy Havis for more information at, 936-825-2666. \$30 for all the space you need.

THE FINE PRINT

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Dave Koenig
7418 Branch Point
Houston, TX 77095



Art by Frank Walters.