

# THE HABA LETTER

The Newsletter of the Houston Area Blacksmith's Association Inc. (HABA)

HABA Web Site: [www.habairon.org](http://www.habairon.org)

June 2001 Edition

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**JULY 21 HABA Meeting – 9 AM**  
**C&S Forge, Dobbin, TX.**

**Candle Holder Workshop by  
Rogers Collins**

**TIME TO RENEW MEMBERSHIP!**

**Membership/Renewal Form  
Enclosed**

# ANVILS, BLOWERS, VISES

## **See For Sale Section**

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## JULY HABA MEETING – July 21, 2001 – 9 AM.

**The July HABA Meeting will be a workshop to make a spring fuller and candleholder.** Rogers Collins will lead the workshop. The spring fuller will be made first. Then the fuller will be used to make a beautiful candleholder from pipe and quarter inch round rod.

Everyone who wants to forge, should be able to leave the meeting with a new spring fuller made specifically for his or her anvil and a new candleholder. (We need to make sure we get a group shot with all of the new fullers and candleholders for *The HABA Letter*.)

Below are some lists of materials and who should bring what. Bring what you can for yourself and others. The idea is to have enough resources for everyone to make the fuller and candleholder. Please do not stay home because you do not have everything on the list. There will be enough of everything!



Following is a list of things you should bring if you have it. Do not let the lack of tools keep you from the meeting!

This is what **you** should bring if you can:

Personal protective equipment like hearing protection, safety glasses with side shields, gloves, apron, etc. Safety glasses are a must!

The measurement of the hardy hole of the anvil on which you want to use the new fuller and/or a two-inch piece of stock to fit the hardy hole.

A six-inch piece of three-quarter inch diameter black pipe.

Quarter inch round stock three feet long.

A twenty-inch piece of three eighths or half inch round spring or mild steel. (Note: If we cannot find enough spring steel for the fullers, the super quench will be used to harden mild steel.)

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A portable forge including anvil, fuel and favorite hand tools.

Rogers Collins will bring:

Quarter inch drills, taps, bolts and all the knowledge to complete these projects.

HABA will bring:

Drinks – Water and Soda

Some additional stock for the project.

Frank Walters will bring:

The makings for a batch of super quench.

Charles and Sharon Heathcock will provide:

Shop facilities.

Lunch in the form of 'Taco Stew'. As before the stew will be available to those who would like to eat at the forge. The cost will be \$3.00 per person. Lunch is also available in the area or you can bring your own.

This is going to be a productive and informative meeting. Come see us!

## **Directions to C&S Forge**

From the North side of Houston, go North on interstate 45 to Conroe. At Conroe go West on state highway 105 about 20 miles. You will go by Lake Conroe and the town of Montgomery. About five miles West of Montgomery you will come to the town of Dobbin. There is not much to see in Dobbin so you need to pay attention about now.

There will be a caution light. Slow down and continue through the caution light on 105. You will be making a left hand turn. Continue up the hill past the caution light to Mount Mariah Road. Turn left on Mount Mariah and go south. C&S Forge will be at the second drive on your left.

From the West Side of Houston, go Northwest on state highway 249 (which turns into FM 1774) through Tomball, Decker Prairie and Pinehurst to Magnolia. FM 1774 wills "T" into FM 1488 in downtown Magnolia. Go right at the 'T' across the tracks and turn immediately to the left and continue Northwest on 1774.

Continue Northwest on 1774 two miles or so to FM1486. Turn right on FM 1486 and go North about twelve miles to 105. Turn left on 105 and go towards the top of the hill. Make a left turn on Mount Mariah Road. The C&S Forge will be at the second drive on the left

## **JUNE HABA MEETING SUMMARY**

There was a light but energetic turnout for the June meeting. Fourteen members came to learn about touch marks from Frank Walters and get caught up on HABA business. Dave Koenig forged a square corner in a lathe tool rest for Jim Wheeler and Tim Bailey forged a mailbox flag from a piece of titanium. The meeting was relatively short. Tudor Forge

closed its doors about 3:30.

HABA would like to thank Clem Jankowski and his son Brandon for coming to the June meeting. It looks like HABA will have a new member. Welcome!



**BUSINESS MEETING**

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The President opened the meeting around 9:30 by thanking Les Cook, Frank Walters, Tim Bailey, Dave Cruvey, Frances Trahan and Tim Cowden again for volunteering their time and equipment at IronFest. HABA coordinated the Public Demonstration area for the successful event. The members again gave their OK to send the HABA mailing list to the new Houston Center for Contemporary Craft. The list was delivered and everyone should be receiving a flyer from the Center about their grand opening in September. The Center will have two galleries a large and small one. It seems that HABA would have an opportunity to use the small gallery for an iron show sometime in the future.

HABA also has an invitation to open an iron show at North Harris College. If we can get one show together, we could possibly move from one location to another. It is an opportunity we all need to be thinking about.

One preliminary thought about a show is to recreate a blacksmith forge/shop as the centerpiece of the show. HABA certainly has the resources to put together a shop in a gallery. Now we need to decide what kind of ironwork should be included. If you have some ideas for the show, please get in touch with one of the board members or tell all of us at one of the meetings.

The idea of the HABA Training Progression is alive and well. Frank



Walters has some ideas about putting together a folder with all the paperwork to get the ball rolling. The idea is that anyone who wants to participate in the HABA Training Progression would get a folder and would be responsible for doing the work and maintaining the paperwork. There may be some minimal charge for the folder and contents to cover the costs of copying it.

At the end of June, HABA's bank account balance was \$4926.80. Two dozen HABA hats and twenty HABA anvil pins are on order. The total cost of these items is about \$230. There are no other extraordinary expenses outstanding. Income will increase near term because of the

2001/02 Membership renewals. Bring an extra \$20 to the July meeting and renew your membership!

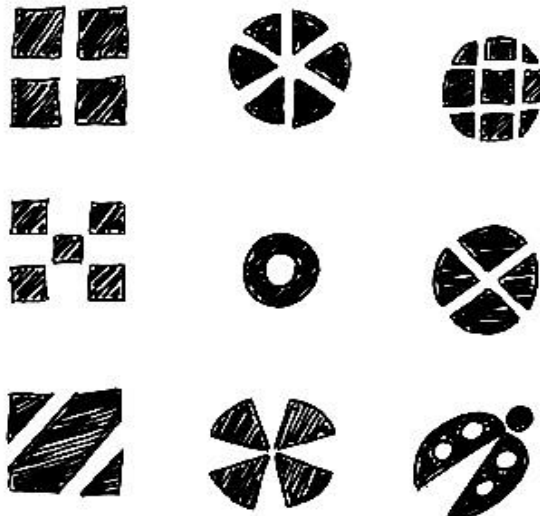
For those of you who are on the fence about joining ABANA, the Artist-Blacksmith's Association of North America, the time is right to take the plunge. Registration forms and a few complimentary copies of 'The

Anvil's Ring' and 'The Hammer's Blow' will be available at the July meeting.

## TOUCHMARKS

Frank Walters then lead a discussion complete with small flip charts about making your own touchmarks.

A personal touchmark is a creative method of signing your work. It is



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relatively simple to make a stamp, either positive or negative. The amount of detail in a touchmark is determined by your imagination and skills. Touchmarks have been used for a long time. Most of us are familiar with touchmarks in silverware and jewelry. Historically most blacksmiths did not seem to take the time to distinguish their work with a mark.

Frank described the different kinds of steel that could be used for touchmarks, oil hardening, water hardening, and air hardening. Even mild steel could be used and the life of a mild steel touchmark could be greatly extended if it was hardened in super quench.

High carbon steel found in punches, drill bits, hay rake tines, springs and railroad spikes marked with 'HC' make good touchmarks. Frank had a fist full of touchmarks he experimented with and Dave Koenig showed two he has. One was commercially made and another he made years ago after a demo similar to Frank's.

One of Frank's flip charts showed nine examples of touchmarks that could be made with punches, a hacksaw and files. Please notice that his examples change depending upon what you see as positive or negative space.

Frank's touchmark is a connected 'OF'. And by way of another example, Frances

Whitaker's was an 'F' in the middle of a diamond. The diamond is the 'W' of his name flipped back on itself.

Frank fielded a number of questions from the group. If I were to guess, I'd say there are going to be some new touchmarks on the Show-N-Tell table on July 21.

And here is a Special Thanks to Frank for taking the time to put together a very informative touchmark presentation for everyone.

**SUPER QUENCH**  
5 GAL. WATER  
24 OZ. DAWN DISH SOAP  
5 Lb. SALT  
8 OZ SHAKLEE BASIC I



### **HABA FAMILY MEMBERSHIP** **2001/2 APPLICATION / RENEWAL FORM**

**HABA Membership is a Family Membership that costs \$20 and entitles the adult members of a family to:**

- 1. Attend all HABA functions at a member's rate.**
- 2. Receive one hard copy of *The HABA Letter* for the family.**
- 3. Receive one Family Membership Card.**
- 4. Be covered by liability insurance at HABA functions.**
- 5. Serve on the HABA Board of Directors.**
- 6. Serve on an Advisory Committee.**
- 7. Serve on Other HABA Committees.**

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**(Note: HABA encourages children less than 18 years of age to attend any HABA function. An adult Family Member must accompany all children.)**

**Please fill out the Membership Application below and send it to:  
Larry Hoff, Treasurer, 8026 Durklyn, Houston, TX 77070-3747.**

Name: \_\_\_\_\_  
\_\_\_\_\_

Address \_\_\_\_\_  
\_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_  
ZIP: \_\_\_\_\_

Home Phone No.: \_\_\_\_\_ Work Phone  
No.: \_\_\_\_\_

E-Mail Address: \_\_\_\_\_ @ \_\_\_\_\_

## **Please Check One:**

\_\_\_\_\_ **Yes, I would prefer to receive *The HABA Letter* through the U. S. Mail.**

\_\_\_\_\_ **Yes, I will retrieve *The HABA Letter* from the Internet at [www.habairon.org](http://www.habairon.org) and save HABA some mailing costs.**

## **Please Check Those Which Apply:**

\_\_\_\_\_ **I am a member of the Artist-Blacksmith's Association of North America, ABANA.**

\_\_\_\_\_ **I am interested in serving on the HABA Board of Directors.**

\_\_\_\_\_ **I am interested in serving on the HABA Advisory Board.**

\_\_\_\_\_ **I am interested in serving on Other HABA Committees.**

**Please take a few minutes to complete this HABA Membership Application.  
Return it with \$20 to Larry Hoff at 8026 Durklyn, Houston, TX 77070-3747**

Your membership is appreciated and important to HABA.

## **HIGH-RELIEF CHASING**

By Dave Koenig  
Part 4 of 4

# **The HABA Letter – June 2001 Edition**

## **Summary of Subjects**

*Part 1 – High-Relief Chasing, Chasing vs. Repoussé and Tools*

*Part 2 – Consumables, Chasing Metals, Chasing Theory*

*Part 3 – The Chasing Process*

**Part 4 – More Than Chasing, Visitors.**

Reading a general description of chasing can be pretty dry stuff because it is taken out of the learning context in which it is taking place. Here is an attempt to add some context to the art and craft skills being taught and experienced at John C. Campbell.

Maybe the place to begin is the location of the school itself. It is in the hills of Appalachia. There is a natural beauty there that can be inspiring to anyone. It is quiet. The daily bombardment of the radio, television, newspaper, computer and telephone is available only to those who seek it out.

The staffs at the school who enhance the natural environment are professional. The grounds and buildings are well maintained and wheelchair accessible. The school paperwork is painless. The food is served family style. It is nutritious and there is plenty of it. There is a first class gallery on

has to be with the students themselves. Everyone is there to pursue a passion and it shows. The majority of all conversations seem to come back to some aspect of an art and craft. Students are encouraged to stop by other studios to see what is going on. With a little luck you might be able to try your hand as something new like creating a watercolor painting with a razor blade.

Each morning before breakfast there is an opportunity to take a guided group walk to a different part of the 340 acres campus. Each morning there is also the opportunity to get the day started with an event that is part mini-concert and part hootenanny. In late afternoon and/or evening there is some kind of event designed to meet others and learn something about another craft.

These activities are all optional of course. They are opportunities to take a break away from the chasing or carving or whatever.



campus that is open seven days a week to students and the public. The gallery pieces are motivators all by themselves. Housing is no frills and comfortable. The studios are spacious and well supplied. That pretty much takes care of a person's physical needs.

Now let's see what goes on to take care of a person's creative needs. The starting point

The time away seems to have the effect of getting a person refocused.

Probably the most inspiration comes from within the individual class itself. Everyone gets to know each other a lot better. Ideas are tossed around. Successes and failures are shared.

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## **VISITORS**

Being all blacksmiths in a jewelry class seemed to draw-in other smiths to see what was going on. For example on Thursday afternoon the knife maker Chuck Patrick stopped by to say hi and look around. That evening Chuck and his wife Peggy came back with their guitar and fiddle and jammed with Doug Hendrickson on banjo. All this music was going on in the constant din of chasing hammers. There seemed to be a couple of times when the hammering carried the song!

That same day LeeAnn Mitchell, ABANA's Executive Director, stopped by with BBQ for everyone! That meant no one left for the evening meal. We worked through dinner and the music until about 10:30. Then we just sat around until almost midnight talking. It was a great evening!

Clay Spencer dropped something off at the school and came by to see how we were all doing too. Clay's wife Jackie was in the enameling class.

## **ABANA**

Below for your ABANA President's all ABANA month. Doug Learn IronFest and success.



Friday afternoon Elizabeth Brim drove over from Penland, NC to say hi. It was like old home week in the jewelry studio.

The week officially ended after the weekly Friday evening concert at John C. Campbell. Bruce Molski, entertained all the students and an overflow local crowd. Bruce was the fiddle instructor during the week. What an entertainer! The music he could produce on a fiddle, banjo and guitar was spectacular.

Since it was Friday evening, many of the remaining students retired to Clay's Corner. Clay's is the local nightspot and gas station in downtown Brasstown with a weekly jam session. The music was good. Clay's was crowded with all kinds of people. Tim Ryan, an ABANA Director, walked in and we talked still more blacksmithing. Microwave popcorn and grape Nehi seemed to be the snacks of choice at Clay's! How can a person top-off a week better than that!

## **LETTER**

information is the Letter that is sent to Chapters every speaks highly of HABA's part in its

HABA was formed with the intention of one day becoming a Chapter of ABANA. How HABA is formed and what it does is greatly influenced by the Artist-Blacksmith's Association of North America. One of the requirements for becoming an ABANA Chapter is to maintain an ABANA membership within the chapter at 25% or more. You will notice that there is a question on the HABA Membership Application/Renewal Form asking if you are an ABANA member. Please check this block if your are.

For those of you who are not members, there will again be membership applications and examples of the **Anvil's Ring** and the **Hammer's Blow** at the next HABA meeting. These are two great ABANA publications.



# The HABA Letter – June 2001 Edition



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June 2001

President's Letter to the Chapters,

Dear ABANA Chapter Members and Officers,

The first IronFest in Grapevine, Texas, June 1-3, 2001 was a great success! IronFest was sponsored in part by ABANA, with the North Texas Blacksmith's Association serving as the host chapter. This is part of ABANA's program of sponsoring off-conference year regional events to promote blacksmithing in different parts of the country. Other chapters involved with the event included: Salt Fork Craftsmen Artist Blacksmiths Association, HABA and the Texas Artist Blacksmith's Association. This regional blacksmithing event had over 175 registered attendees from all over the United States. Lead demonstrations were conducted by Frank Turley, Wendel Broussard, Mike Boone and Jeff Mohr. Other blacksmiths also demonstrated in the public area, including Bill Bastas, Doug Hendrickson, Richard Rumph, and a host of volunteers from the Houston Area Blacksmith's Association. I have seen most of these smiths demonstrate, and know several personally. This was a dynamite line-up and all of us who missed this one missed a lot. Dave Wilson, his conference committee and all the members of these chapters did a great job organizing and executing this conference. Great demonstrators, great weather and great blacksmithing fellowship. This is what blacksmithing and ABANA is all about. Congratulations to all of those who were involved and all those who attended. We look forward to IronFest II!

CanIron III was just held over the weekend and I will report on that event next month. Check out the "Chapter" page on the web site for highlights

as they come in.

On a sad note, Jane, the widow of Emmert Studebaker passed away in March. On behalf of ABANA, I express my sympathies to the families and friends of this man and his wife. On a happier note Judd Nelson is 90 years young. Judd, a founding member of ABANA and still active in life and blacksmithing had a big birthday bash on June 23<sup>rd</sup> at his home in Georgia.

The 2002 ABANA Conference planning is well under way and promises to be a great one. Bill Fiorini and his committee are working very hard to organize a great conference. "Forging Traditions" is the theme of this conference and will feature demonstrators from all over the world. Keep an eye on the ABANA web site, *The Anvil's Ring*, *Hammer's Blow* and your e-mail for more information. We are working on enhancing the ability of the editors to publish information on the 2002 Conference in your newsletters and chapter web sites, and that information will be forthcoming in the next few months.

Please look back at my letter from April, requesting input from the chapters. To date we have gotten very little response. We need your feedback on what and how we are doing. Send those comments to either myself, Bob Fredell, the Central Office or any board member. Thanks!

Safe and productive forging

Doug Learn, President  
Artist-Blacksmith's Association of North America, Inc.

# **The HABA Letter – June 2001 Edition**

## **NEED A JOB**

Joe Pehoski, of Salado, Texas, is seeking a motivated, team-oriented person with an artistic and practical mindset. This person needs to have familiarity with shop tools and procedures, enjoy working in metals and have a passion for quality. Pehoski: Metal Smiths, Inc., founded in 1969 as Pehoski Blacksmithing, is a six-person shop involved in prestigious architectural commissions on a national basis.

Starting salary will be based on experience and ability. Performance is rewarded at

quarterly reviews. Standard workweeks consist of ten-hour days, Monday through Thursday. Employees are covered by Worker's Compensation, a family health plan is available after 90 days of full time employment, a retirement plan is available after two years of full time employment and bonuses are awarded, based on performance, at the end of the year. If interested, contact Margaret Clausen, Business Manager, at (254) 947-5740. Our office hours are 7:00 AM to 5:30 PM Monday through Thursday.

## **EQUIPMENT WANTED**

An e-mail from David Wilson, North Texas Blacksmiths' Association.

"... Please include the request below in your newsletters. It is addressed to NTBA, but I think it should be posted throughout the region... Chuck Stone is at 817/489-3580, [bak2basx@swbell.net](mailto:bak2basx@swbell.net). Chuck & Kathy Stone wrote:

'Will be demonstrating and teaching special projects to more than 1000 boys and 100 adult sponsors in the month of July through Baptist RA Camps. I will be teaching a spiritual application with each project. I anticipate doing more of these in the future. Would like to ask NTBA members if anyone

is interested in donating equipment for the boys/men to use. A short list follows:

lightweight portable forge  
small anvils  
horseshoe tongs  
16 oz ball peen hammers  
24 oz ball peen hammers  
pliers  
small vises  
coal  
new and/or used horseshoes

If anyone wants to contribute, it is tax deductible. And I can pick up the items.'

David W."

## **FOR SALE**

### **BLOWER AND VISES**

Two post vises \$75 each.  
Champion blower - \$75  
Canedy-Otto blower, Western Chief- \$75.

**Contact Pete Schiller – 979-885-2251**

### **ANVILS**

1. 150 lb. Trenton Anvil
2. 100 lb. Fisher Anvil

**Contact Byrom Wehner – 936-931-9254**

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## CUSTOM-BUILT AIR HAMMERS

1. 6# table top model \$1300
2. 20# table top model \$1900
3. 20# floor model \$2200
4. 40# floor model \$2600

Some modifications to the basic hammers can be made to your specifications.

Also custom metal spinning in copper, brass, pewter, and steel.

**Contact Maurice L. Ellis**, Route 1, Box 1442, Belgrade, MO 63622-9709. Phone: 573-766-5346, E-mail: [mbellis@misn.com](mailto:mbellis@misn.com).

## COMPLEX HAND FORGING

By Tom Latané

Part 1 of 4.

Complex Hand Forging Bench Vise By Tom Latané

Below is a picture of page 1 of Tom Latané's class notes for forging a vise. When I was at John C. Campbell in January, Tom was teaching this class. Tom was gracious enough to send the notes after he revised them and chose in *The HABA Letter* and on the web site.

Identical forging procedure for front and rear jaws.

**A. Upper Vise Jaw**  
Upset end of a 1 1/2" and a 1 1/2" piece of 1" square until the ends are 1 1/2" square.  
With 1 3/4" - 2" over edge of anvil shoulder down to 1".  
Spread end over horn and anvil face hammering first on back, then inside.  
Reduce end to 3/4" thick.  
Dress curves with round faced hammer over horn.  
Bend 3/4" of end down over anvil edge.  
Upset and dress over anvil edge and in vise with back-up jig.\*  
Reduce the thickness of the back of the jaw above the shoulder with cross pein.  
Place in vise with jig and draw out lip with fuller.  
Dress shape of jaw in jig and over horn.  
Forge bar below lip to 1" square.

**B. Steel face on jaw**  
Forge some 1045 or water hardening steel to length and width of vise jaw face and 3/16-1/4" thick.  
Chisel barbs into one edge of steel.  
Heat vise jaw and pound cold barbs into it. (Barbs on lower side.)  
Bring to welding heat with steel up in fire.  
Weld into place.  
Dress edges and top of jaw.

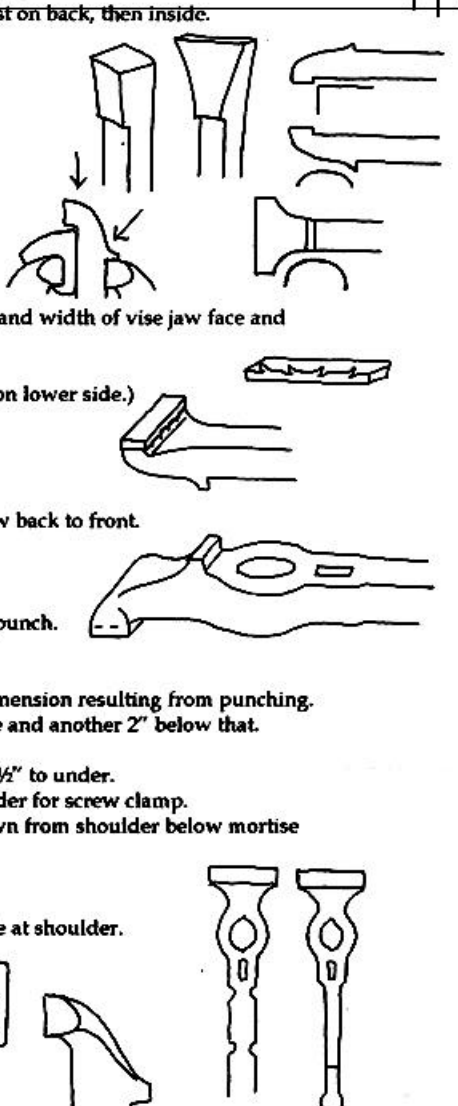
**C. Eye for screw**  
Begin a slit 1 1/2" long 3/8" below the lip through jaw back to front.  
Open and drift to a little over 1" round.

**II. Rear Vise Jaw Components**

**A. Mortise**  
Punch a mortise 3/8" below eye with a 3/16" x 1/2" punch.  
Dress with mild steel drift to 3/4" x 3/4" maximum.

**B. Lower bracket**  
Forge leg below lip to 7/8" deep or to smallest dimension resulting from punching.  
Make a punch mark on side of leg 1/2" below mortise and another 2" below that.  
Fuller on both these marks.  
Draw material between fullers to a taper from over 1/2" to under.  
Cut off over hardie leaving mass below fuller shoulder for screw clamp.  
Shoulder bar on side of jaw face 2/3 of distance down from shoulder below mortise to lower shoulder.  
Reduce from 7/8" to 5/8".  
Forge end into cylindrical shape.  
Bend end of leg away from face of jaw to right angle at shoulder.

**\*Back up jig**  
Shoulder 1 1/4" x 1" and draw down to 3/8".  
Forge a right angle.  
Cut off bar and taper back of 1" end.  
Forge to fit your leg vise jaw.



## ***The HABA Letter* – June 2001 Edition**

For those of you who receive ***The HABA Letter*** via e-mail, the complete set of notes can be found in the Designs section of the HABA web site.

Who has an interest in using these notes to forge a vise? This looks like quite a project. It might be something to start in a small group and then work on in our own shops. We can gather up on occasion or at HABA meetings to compare notes, work through problems and monitor progress. If you have an interest let's talk about it. Dave Koenig, 281-855-2869.

### **SEPTEMBER DEMO**

SEPTEMBER 8 –9 - NTBA HAMMERFEST 2001, Bridgeport, TX. Peter Ross, a resident blacksmith of Colonial Williamsburg will be the feature demonstrator for the 13<sup>th</sup> annual HAMMERFEST. For registration contact Verl Underwood, 613 N. Bailey, Ft. Worth, TX 76107-1005; 817-626-5909, vaunder@aol.com.

### **THE HABA WEB SITE**

The HABA Web Site, **[www.habairon.org](http://www.habairon.org)**, is provided by HostingBox, a Houston company specializing in co-location and related data services. For more information contact Doug Block at: [doug@hostingbox.net](mailto:doug@hostingbox.net).

The HABA Web Master is Andy Walters: [habaweb@wtez.net](mailto:habaweb@wtez.net).

#### **THE FINE PRINT**

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Dave Koenig  
7418 Branch Point  
Houston, TX 77095

### **TO MAKE LIFE SIMPLER**

- ~~☞~~ ☞ Drink lots of water and pay attention to your body to prevent heat related illnesses. It's HOT out there these days!**
- ~~☞~~ ☞ Remember that women invented all bulletproof vests, fire escapes, windshield wipers, and laser Printers.**
- ~~☞~~ ☞ Don't hold the work piece where you intend to hit it!**
- ~~☞~~ ☞ Always add acid to water and have baking soda handy to neutralize spills**