



THE HABA LETTER

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

HABA Web Site: www.habairon.org

July 2001 Edition

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AUGUST 18 HABA MEETING – 9 AM TUDOR FORGE

HABA BOARD MEETS! SAME OFFICERS AND NEW BOARD MEMBER, LES COOK

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AUGUST 18 HABA MEETING – 9 AM TUDOR FORGE

The August HABA meeting will take place at Tudor Forge. The start time is 9:00 AM. This meeting will be another workshop type of meeting. Two handy tools will be made. The first is a hold-down clamp for use in the pritchel hole of your anvil. The second tool will be a file vise that is clamped in a post or machinist vise. The file vise holds a small piece at about a 60-degree angle. This change in angle makes filing easier for a lot of things.

Larry Newbern will be leading this workshop. It's going to be another good one!

What to Bring

Bring your safety glasses with side shields. Safety glasses with side shields are required.

Hearing protection, gloves, apron, as you prefer.

A forge, hand tools and fuel.

A 24 inch piece of round stock that easily fits in the pritchel hole of your anvil. (Extra steel to possibly share with someone else.)

A piece of ¼ x 1 ½ x 10" piece of mild steel.

A sack lunch if you want to eat at the shop. (Given the heat you might bring a few bananas too and your favorite drink. We do not want anyone to get sick.) HABA will provide water and soda.

Do not stay away because you do not have a forge. Odds are forge space will be available!

Directions to Tudor Forge

Take 249 NW from Houston. Travel through the towns of Tomball, Decker Prairie and Pinehurst. At Pinehurst 249 changes to 1774. Stay on 1774. About three miles ahead on 1774 look for a Texaco station on the west side of the road. One half mile past the Texaco station, turn left or west on Tudor Way. You will find the forge about a mile down the road.

From the intersection of 1488 and 1774 in Magnolia, go south on 1774 about 4 miles. Look for Tudor Way just after the Country Jamboree building. If you see the Texaco station you went too far.

JULY MEETING SUMMARY

Twenty-eight HABA members and guests drove up to Dobbin, TX and C&S Forge. Charles and Sharon Heathcock welcomed all in their clean and spacious shop. Rogers Collins was the featured demonstrator and did an excellent job of showing us how to make a



Larry Hoff's Candleholder

spring fuller and an attractive and functional candleholder.

A spring fuller was made first from 3/8" or 1/2" round stock. The fuller was then welded to a piece of square

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stock to fit into the hardie hole of the anvil. Rogers used the same fuller to make a candle cup from a 4" long piece of $\frac{3}{4}$ " pipe. The cup was then screwed to a coiled base of $\frac{1}{4}$ " round rod to complete the candleholder.

The exact number of candleholders and spring fullers made at the meeting is not known. People were working steadily in the afternoon heat at nine or so forges.

The highlight of the Show-N-Tell table was a beautiful table lamp that Rogers almost completed. It sure looked done to most of us. It was beautiful. The soft orange light the varnish mica shade put out brought back a few pleasant and long forgotten memories.

Charles and Sharon served everyone lunch who wanted to eat. Lunch was a delicious bean, hamburger and vegetable stew over some Frito's.

It was simple and delicious. Things got pretty quiet when lunch was served.

The July meeting kicked off the HABA Membership renewal season. Larry Hoff, our Treasurer, was busy taking in checks and cash and writing out membership cards. Thanks to everyone

who renewed his or her HABA Membership for the coming year. Let's all welcome two new HABA Members, Brian Bateman of La Porte and Stan Timmerman of Austin. We look forward to seeing you often.



Guests at this meeting included Jim Nachlinger, Jeff Blankinship, Tom Lundquist, Paul Bonner, Jr., Steve Garrett and Johnathan ????. (Sorry Jonathan. You need to come back so we can get your last name.)



Neil Goza, Sharon's dad, made everything run smoothly. Neil was the designated welder for whatever needed to be done. He even managed to work on a new stainless bracket he was making for his motorcycle. Thanks much again for your help Neil.

A Special Thanks also goes to Charles and Sharon for opening their shop and



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inviting Rogers to demonstrate for us.



A Special Thanks goes to Rogers Collins for a really informative demonstration. Everyone had the opportunity

to walk away from that meeting with a very functional tool that can be used for a limitless number of projects and a beautiful candleholder. Even those people who did not finish their projects came away with a much better understanding of what can be done.

HABA BOARD MEETS

The HABA Board of Directors met August 6, 2001. A summary of the business transacted is as follows:

1. The size of the HABA Board increased from four to five members. Les Cook was elected to the board.
2. The HABA Officers were each elected for another one-year term.
3. HABA remains a Texas nonprofit corporation in good standing.
4. HABA has many opportunities right now that require additional leadership to accomplish. These opportunities are:
 - a) Identifying and coordinating a national demonstrator.
 - b) Developing materials to begin and run the proposed HABA Training Progression.
 - c) Pursue the opportunity to develop an iron show. Possible venues are North Harris College and the new Houston Center for Contemporary Crafts.
 - d) The formation of the HABA Advisory Board and related committees.

BALCONES FORGE JULY MEETING

By Dave Koenig

A week after the July HABA meeting I traveled to Kingsland, TX. Randy Kiser, one of our HABA Members, was demonstrating in the shop of Wayne Kirkpatrick. There were several familiar faces there who most of us know, Gary Evensen, Ruth Carter, Helen and Harvey Wise, Stan Timmerman, Jerry Achterburg, Rick Dawdy, Tom Lupton, John Crouchet, Tom Leining, Don Charlesworth, Larry



Crawford and a few more you might remember from past HABA meetings.

Randy never comes to HABA meetings but is most interested in HABA and what we are doing. Randy lives in Paint Rock, TX. That is just East of San Angelo... a 'furrerrr piece' from Houston.

Randy works alone in his shop turning out some beautiful work. I saw

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a few pictures of work he did on a timber frame house. The house is going to be featured in a national magazine called *Timber Frame Homes*.

he used three straps and two sets of wedges to hold the railing in place. Each strap was made from 3/8 by 1 1/2" flat bar.

His work included a 1500-pound bed, gate hardware, handrail decorations, exterior brackets, fireplace tools, a vent hood and many other pieces. The magazine should be out at the end of September.

The same publisher also publishes the magazine *Log House Living*. They were quite impressed with Randy's work and asked for additional examples of his fireplace hardware. He obliged with pictures of a recent fireplace screen and basket. This work will appear in *Log House Living* at the end of September too.



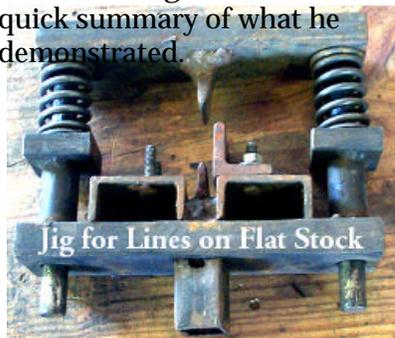
Randy Kiser

First he forged the end clips on the straps that held the wedges. Next the straps were centered in a jig he made for the treadle hammer and a channel was formed. The final operation was to bend the straps over a jig the shape of the square pole.

The ends of the railings slipped into the channels in the straps. The straps were held in place with two wedges on each side of the pole.

A second demonstration was to slit and drift 1/2" square holes in 1/2" square bar stock. Randy had two 4140 'slit-n-drift' tools on hand. While one was cooling in bees wax, the other tool was being used to slit and drift a bar. Each tool slit and drifted the hole in one operation.

Randy's demo was very straightforward and informative. If a person were to put a title on his demonstration it might be called *Making Life Easier*. Here is a quick summary of what he demonstrated.



A railing needed to be installed between two existing square poles. Rather than drilling holes into the poles or welding inside of a building to fasten the railings,

Once one hole was made in each bar, the bars could be passed through each other to form a square. The ends of each bar can

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then be shaped to create a quatrefoil for example.

flat stock.

Randy also showed us three other tools he used under the treadle hammer. One was a jig to bend ½" x 2" flat bar into a brace. The other two cut straight lines in stock. One cut lines in round and round tapered stock. The cut straight lines in



Randy fielded many questions during his demo and showed us several other solutions he used for unique problems. It was quite obvious that Randy takes a lot of pride in his craft and it shows in his work. This was Randy's first demonstration and the

first of many to come.

FOUR LISTS FOR BLACKSMITHS

By: John Careatti

Reprinted from *The Newsletter* of the Blacksmiths' Guild of the Potomac – July /August 2001

10 Reasons Punches Stick

1. Work is too cold.
2. Punching into anvil face (no bolster).
3. Punching too far without removing the punch.
4. Punch shape is too straight.
5. Punch end is larger than shank.
6. Punching hole to final size: no drifting.
7. Deep punching without cooling punch.
8. Punch improperly hardened.
9. Poor quality punch material.
10. Material being punched is tougher than the punch.

10 Reasons Spring Steel Tools Crack

1. It was cracked to start with.
2. It was forged at too high a temperature.
3. It was forged a too low a heat.
4. The forging heat was only at the surface and did not penetrate through the piece.

5. The tool did not receive a packing heat.
6. It was annealed improperly.
7. It was straightened after annealing.
8. It was hardened at too high a heat.
9. It was straightened after hardening.
10. It was improperly tempered.

10 reasons Forge Welds Don't Stick

1. Work too cold.
2. Work burned.
3. Too much air in fire.
4. Fire not hot enough to obtain a welding heat.
5. Poor quality steel. A36 with a lot of Manganese.
6. High sulfur coal.
7. Incorrect scarf.
8. Not enough forging after weld is made. It takes more than one heat to complete a forge weld. After welding comes forging to size and shape.
9. Forging at a low or surface heat after welding.

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10. Quenching a partially welded piece.

10 Reasons To Use Water As A Quenchant

1. It is easy to find.
2. It is low cost.
3. It is the same everywhere.
4. It is non flammable.
5. It is non-poisonous except in very large doses. (Do not inhale.)
6. It does not coat the tool with burnt oil and temper colors are easily seen.
7. It is clear so you can watch the heat leave.
8. It separates the steels that are workable with simple processes from

those that are too complicated to use.

9. The speed of the quench can be controlled. Therefore the hardness can be controlled.
 - a) It is a very fast quenchant. Therefore you can always quench at a slower rate using water.
 - b) The steel does not know what it is being quenched in. It only knows how fast it is being quenched.
10. Using water to cool hot tools that are water hardened will not ruin them.

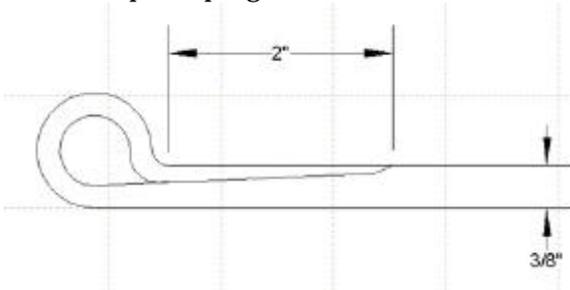
AN ORIGINAL HINGE

By Scott Little
Amateur Blacksmith

(Editor's Note: Balcones Forge in Austin now has a web page: www.balconesforge.org. Scott Little just got it up and running. The site includes some of Scott's door hardware. A door hinge caught my imagination and I asked Scott how he made it. His response is below and is reprinted with his permission.

The picture of the hinge can be found on either the HABA or Balcones Forge web site.)

Well, to make the socket part, I "just" drew down the last 6" or so of the 2 x 3/8" strap, keeping it 2" wide but



reducing the thickness to about 1/8" at the end. I emphasize "just" because I did this all by hand and that's a LOT of hammering!! I then wrapped this thinned part around a 5/8" form pin and banged away at it until the loop was nice and crisp and all on "one side" of the strap. That left about 2-3" of thinned strap overlapping back onto the main strap.

I then forge welded that overlapping bit to the main part. Several heats and lots of banging got it looking pretty seamless. I then folded the whole shebang sharply about 1.5" away from the loop to create the final shape for the strap part.

For the pin part, I tied 3 pieces of 1/2" round rod together (about 8" long) with baling wire (just to hold them together) and heated the ends up to welding temp

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and just banged the three together thoroughly for about 2" of length.

I worked the mass down to about 5/8" diameter round and kept working it until it fit into the strap parts hole nicely.

I then forged a tight fitting thrust washer (visible in the photo) and forced it over the pin as far as it would go.
Cont. P. 9.

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TOM LATANÉ VISE NOTES

Page 2 of 4 Pages.

The full set of notes can be found on the HABA web site, www.habairon.org.

C. Cheeks

Cut 2 pieces of $\frac{1}{4}$ " x 2" x $2\frac{1}{2}$ ".
Bevel top and bottom edges.
Drill and rivet to vise leg $\frac{3}{4}$ " above
or even with bottom bend depending
on space available.

Pickle in vinegar.

D. Bottom bracket screw

Weld $\frac{1}{4}$ " x $\frac{3}{4}$ " collar on $7/16$ " round shaft.
Forge ball end.

OR

Forge 3" - 4" of $7/16$ " round on end of $\frac{3}{4}$ " round bar.

Cut off and forge ball end.

Pickle in vinegar.

File or turn ball end.

Bore for $3/8$ " round toggle.

Make toggle like main screw toggle.

Hold in upsetting jig or wood vise chaps to thread with die.

E. Upper bracket

Fuller end of $3/4$ " square, or use set hammer on anvil edge.

Shoulder third side over anvil edge.

Draw tenon to $1/4$ x $3/4$ x $1\frac{1}{2}$ " long.

Shoulder behind single shoulder.

Cut off bar.

Spread and forge or cut desired shape.

Punch mortise with $1/8$ x $3/8$ " punch.

Bore $1/8$ " holes for teeth.

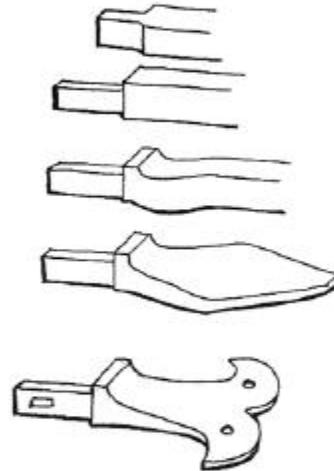
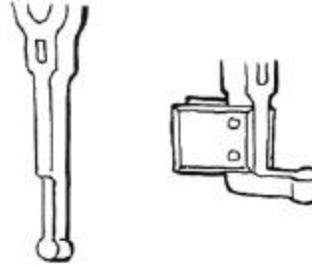
Counter bore or drift.

Forge tenons on $3/16$ " square rod.

File to fit holes.

Cut $1/4$ " long and brad tenons in holes.

Sharpen teeth with file.



III. Front Jaw Hinge

A. Front Leg

Dress depth to match rear leg

Fuller below eye to match rear jaw.

Draw leg width to taper same as rear, allowing it to spread in depth.

Cut off even with bottom of rear jaw cheeks.

Shoulder and upset pivot area. (Shoulder will need to be
higher than finished position.)

Forge leg to even depth from eye to shoulder.

Match length to rear jaw.

Heat cheeks and dress together with front leg.

Bore for $7/16$ " bolt.

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Finally, I spread out the three "tails" into



a somewhat graceful curve and spread their ends for the mounting bolt holes, which I punched hot. It was a lot of trouble to get that

part shaped right in the end. The three "feet" had to sit on the face of the door trim (1 x 4) but the pin needed to lie vertically in a plane somewhat below that surface to reach the desired pivot point close to the door. I had a couple of weld failures here. The weld would let go after all that pounding and stretching, etc. but I finally got a pair of them to come out OK.

I was making it all up as I went along! Glad you liked it.

KNIFE MAKER'S WEB SITE

From: Vance Burns,

On theforge, Bowie, the type-o-matic master, related that the knife makers have a paltalk chat going. I checked it

out and it's pretty cool. You can do real-time typing, voice, and/or video.

www.paltalk.com.

FANTHORP INN IS LOOKING FOR DEMONSTRATORS

Texian Days is coming to Fanthorp Inn on September 22, 2001, 10:00 AM to 5:00 PM. This is always a fun event for the whole family. The Inn will be open and there will be different crafts to observe and do. HABA members demonstrated blacksmithing at this

event for several years and some will be there next month.

If you would like to demonstrate some craft, please contact Cathy Gibbons, 936-873-2633, or catherine.gibbons@tpwd.state.tx.us.

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MEMBERSHIP REMINDER

Did you renew your HABA Membership yet? Now is a good time to do it. The renewal form was in the last letter and is available on the web. Or just send a check to Larry Hoff... address on Page 1.

NOTICE

Pictures printed in *The HABA Letter* can be found on HABA's web site: www.habairon.org. The pictures are included in the PDF version of *The HABA Letter*. Pictures are usually electronically altered to better communicate the message of the image.

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TO MAKE LIFE SIMPLER

Survive a Hotel Fire by:

- ?? Knowing where the exit is.
- ?? Keeping your key and glasses handy.
- ?? Staying close to the floor with key and glasses when an alarm sounds.
- ?? Exiting room with key in hand.
- ?? Exiting the building if possible. If not Return to your room with the key.
- ?? Staying in room for as long as possible.
- ?? Avoiding the urge to jump if above first floor.
- ?? Remaining calm to make good choices.