



The Upset

Official Publication of the
MISSISSIPPI FORGE COUNCIL
September 2007

Ricky Wynn's shop, after an electrical fire, leaves us much to consider. See story on page 14



Top photos are Lyle Wynn making a copper rose for our August meeting. There is Tommy Ward and Bill Pevey. New bowl by Ardell Hinton and some shop wrens.

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President's Message

It is always good to reflect on something positive. As I sit here today several good things come to mind, one of them being our 2007 conference. I think that it was one of the better meetings that we have had. There are several reasons for this.

Steve Williamson, our guest demonstrator certainly did his part. He not only did a tremendous job of showing us how a dragon can be created from 1 in. square stock, but other smaller animal heads were also shown.

Those of us who took the Thursday and Friday class really had a great time and learned a lot of different techniques for manipulating hot steel.

The auction was a success because so many of you took the time and energy to make and donate items. As usual, our auctioneer, Anthony Goodrum did a great job and we appreciate his expertise.

Thanks also go to Patti Mitchell for a great looking poster and brochure. We really do appreciate your efforts.

Christine Norquist, as always did a wonderful job on the food, We appreciate you very much.

I want to personally thank Terry Vandeventer for his entertaining and informative presentation on snakes. I think this was the first time many of the group had seen a show like this.

Last but not least, thanks go out to all of you who helped in many other ways to make our conference happen.

We are already planning for Conference 2008. Our demonstrator will be Lorelei Sims from Charleston, Illinois. I saw her at the LAMA meeting in March and I can assure you that you will enjoy her demonstration as much as I did. Steve Williamson will be back to teach a class on animal heads on Thursday and Friday.

We will be having a business meeting in the near future so be thinking about who you want to nominate or what you want to run for. Let me know what your ideas are on this.

This is your organization and the more you get involved the more you will get out of it. One good way to participate is to demonstrate at one or more of the activities that we attend at the Ag Museum. If you are interested, talk to me at the next meeting. I'll be glad to help you get started.

We have quite a few new members so let's go out of our way to help them as much as we can.

Our newsletter is getting better with every edition. The color really sets it apart from all of the others that I have seen. Thanks go to Jim Pigott for his efforts in producing our Upset.

Our July meeting was enjoyable, thanks again to Jim. He showed us several ways to manipulate twists that we can use on our tool handles.

Bill Pevey

Of Interest to Members

We had a great conference thanks to the contributions of so many active members of the Mississippi Forge Council. This level of involvement of membership creates any number of opportunities for the future.

Think about the position we are in. We have money in the bank, a great location, a shop full of enough equipment to allow ten forges for classes, 20 tons of great coal and a treasure of great talent in our members including a Master Bladesmith. We got it goin' on.

Now, let's do something with all this starting with input from membership. Where do you want to go with your metalwork? Do you want to see more classes? Do you want to see more blacksmithing techniques, sculpture, copper work, repousse', chasing, bladesmithing? What can we do to make this experience more rewarding for you? We are in a great position when you think about it. We can draw from the talents of membership and we can afford to bring in the best teachers in the country and teach us whatever it is we want to pursue. Not a bad deal.

Get involved with the group, volunteer your ideas and your time and help direct us where you want us.

Jon McIntosh, Treasurer, has met with our attorney, John Dongieux, and is getting the ball rolling so we are in compliance with new IRS regulation dealing with non-profit annual reporting. We will be updating the By-Laws and Charter and will have to have a business meeting with elections of officers. Here is where you can help.

We need some involvement in the positions on the Board of the MFC.

Bill Pevey is willing to remain as President for another year. Bill has done a great job as president and has done so for about five years now. It is time for new blood though, any group needs turn-over in leadership, new energy is required for growth. Consider taking a turn at the helm, you will not be alone, there is good help out there. Maybe you will start as Vice-President for a year then move up next year, come on in, the water is fine.

Jon McIntosh needs someone to work with him in the Treasurers' office. With him getting married and all I am afraid he might get a little distracted. Besides, he agreed to do this job for a year and it has been two years now. If we have two people working this end we will be in good shape. Will you help?

There are four positions of Board Members at Large. They will help with setting up our monthly demonstrations for the meetings, planning and coordinating the conference and planning the classes we want to have.

I will remain as editor and web thingy, unless of course someone out there would like to take a turn at this role.

The bottom line is, we sure could use folks in these positions so we can keep the momentum going. The more members that help the more we can accomplish. Contact Bill Pevey or Jim Pigott and tell us where you will help.

Bill Pevey will be setting up a business meeting pretty soon, after Jon gets the information we need from the attorney. We need your support, attendance and input at this meeting.

On another note I would like to start a 'sell, trade or wanted' section in the newsletter, this could include any announcements you want to make. If you have such a need send me the information by email, jpigott111@comcast.net. Is there anything you would like to see in the newsletter or on the web? Let me know, I could use some new ideas, you should be pretty bored of me by now so help this old guy out.

"WHEN THE CHARACTER OF A MAN IS NOT CLEAR TO YOU, LOOK AT HIS FRIENDS"

Japanese proverb

MEMBERSHIP RENEWAL

ALL MEMBERSHIPS IN THE MFC RENEW ON
JANUARY 1 OF EACH YEAR. IF YOU HAVE
NOT RENEWED YET PLEASE DO SO. WE WILL
BE PURGING THE MAILING LIST AFTER THIS
NEWSLETTER AND WE DO NOT WANT TO
LOSE YOU OR YOUR
SUPPORT.

Send your check to:
Jon McIntosh
PO Box 320744
Flowood, MS 39232

Meeting Demonstrators / Demonstrations

Note: Unless otherwise noted; the Mississippi Forge Council meetings are held at the Agricultural and Forestry Museum on Lakeland Dr. Hwy 25, in Jackson, MS. on the second Saturday of each month, except June. Meetings start at 9:00 am. We never know how long we will be there so be prepared to feed yourself if necessary. Snacks are available at the General Store.

If there are new members or visitors interested, we will generally have a 'green coal' beginner's class after the demonstration. This usually lasts about 3 hours. Be sure to check out the MFC schedule on the web site www.msforgecouncil.com any late changes in the meeting plans will be announced there.

**ALSO: IF YOU ARE NOT GETTING OUR EMAILS PLEASE CONTACT
JPIGOTT111@COMCAST.NET AND LET US GET YOU ON THE LIST.**



These pictures are of the fountain and tree classes taught by Bob Tomson.

A BLACKSMITH'S GROCERY LIST

by: Tommy Ward

When grocery shopping with my wife I sometimes amuse myself by searching for common household substances that might be useful in metalworking. Here's what I have come up with. If you have a favorite blacksmith's "recipe" using materials found in a supermarket let us know and we'll publish it in a future issue.

aluminum foil - Melts at about 1220 F. Thickness of household brands is around .0007" or less. In addition to its obvious insulating and reflective properties, aluminum foil can be used in mechanical work as a shim stock for adjusting the clearance of bearing or mating surfaces.

ammonia - A general household cleaner that can also be mixed with various other materials to alter the color of copper and steel.

baking soda - (sodium bicarbonate) Can be used to neutralize acids. Mix with water to form a paste, or add to water to make a dilute solution. Don't confuse with baking powder, which combines sodium bicarbonate with other additives.

beer - Useful both in and outside the shop to improve or alter the disposition of the metalworker. Most any brand can be effective.

beeswax - Used as a "finish" on ironwork. Usually rubbed on the metal while hot. Also makes a good dry lubricant for drill bits and saw blades.

borax - "Twenty Mule Team" brand borax is widely used as a flux for forge welding.

camphor - When placed in tool chests the vapors emitted by camphor blocks help to prevent rusting of fine tools. May not be available in grocery, but better pharmacies should have it.

catsup - "Gentle" cleaner for brass. Mix 50/50 with water and immerse small items from two hours to overnight. Leaves a soft, matte finish. To avoid damage, don't leave items in the solution for long periods, as acid in the catsup will attack the zinc in the brass.

cheesecloth - A lint free open weave fabric. Fold into a small pad, load with an appropriate solvent, and wipe surfaces for a lint free preparation to finishing. A small pad is ideal for the lint free application of stains to surfaces. Also use to strain paint or other liquids. Use to make a "tack rag" for wiping dust from surfaces prior to painting (dip a piece about 12" square into clean water and squeeze dry. Mix 3 tbsp. varnish with some paint thinner and sprinkle onto material. Knead the cloth until it's saturated with the mixture. Don't overdo it. A tack rag should be tacky enough to pick up dust but not stick to surfaces).

citric acid - A mild acid present in many fruits, vegetables, and carbonated beverages (the highest concentration is in lemons and limes). May also be found in concentrated form in the baking or canning sections of the grocery. Can be used to remove rust from tools. Mix with a little alcohol (rubbing alcohol is fine) and a dab of detergent and apply to rusted surfaces. Heavy rust may require immersion overnight. Rinse and scrub off with a fine Scotch-Brite pad. Surfaces should be clean of oil before applying the solution.

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club soda - To improve their performance, substitute club soda for water when mixing soluble oil type cutting fluids used in drilling or machining.

coco butter soap - Can be used as a lubricant in metal spinning.

dishwashing liquid - ("Dawn Blue" preferred). An ingredient used in making Robb Gunter's "Super Quench" formula for hardening mild steel. For details go to: <http://www.cvbg.org/tips/superquench.PDF>

eggs - Use to test a brine quench for proper salinity - toss a couple of uncooked eggs into the water as salt is added. Eggs will float when proper salt level is reached.

hand soap - A bar of soap makes a good lubricant. Dry rubbing some on sliding surfaces will improve the operation of threaded fasteners, nails, saw blades, drawer and window slides, etc.

hydrogen peroxide - Commonly available in a diluted solution of about 2.5% to 3%. It is a weak acid and strong oxidizer. Primarily used as a disinfectant but also can be used to remove certain stains and to bleach certain materials. Used in metalworking to color some metals and to remove rust from iron. Several formulas for its use can be found on the Internet.

kitty litter - Can be used in place of "oil dry" to absorb liquid spills.

lard - An effective cutting lubricant for drilling and machining - particularly with "tougher" metals. Use straight or mix with 30 wt. nondetergent motor oil.

lye - Also known as sodium hydroxide or caustic soda. Makes a very effective paint and "grunge" remover when restoring machinery. Lye is getting hard to find due to concerns over its use in making illegal drugs. However it can sometimes be found in stores packaged as "Roebuck Heavy Duty Crystal Drain Opener" which is 100% lye, or "Drano Kitchen Crystals" which contains about 54% lye. Mix one can of Drano Crystals with 3-5 gallons of water and immerse parts in the solution. The Roebuck product may require less due to its higher concentration of lye. Rinse parts thoroughly immediately after removal from the solution. For ferrous metals only - don't use on aluminum or brass. Lye is reactive and dangerous, so appropriate caution is advised.

mothballs - Can be used in a toolbox to prevent rust - see camphor.

oil soap - Can be used as a lubricant in metal spinning.

paraffin - Use to make a lubricant for metal spinning. Heat (carefully - use a double boiler) and mix together 3 parts beeswax, 1 part paraffin, and one part toilet bowl sealing wax. When cooled, a paste is formed that can be applied to the work face of objects in the metal spinning process. Also can be used as an "indoor" finish on iron. Apply alone or mix with other substances to create a finish. Makes a decent lubricant for drill bits. Use melted paraffin to coat fine tools and prevent rust during long-term storage,

peanut oil - Has the highest flash point of the commonly available vegetable oils. Sometimes used as a quench for oil hardening steels. Also useful as a "gentler" method of heating parts when shrink fits are called for in mechanical work. Be advised that vegetable oils will eventually become rancid, while mineral oils will not.

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petroleum jelly - A highly refined light weight lubricant. Insoluble in water, but can be dissolved by some solvents. Commonly used as a topical dressing for scrapes, burns, and chapped or dry skin. Rubbing some into the hands before beginning dirty tasks will make cleanup easier upon completion of the work. Coat fine tools with petroleum jelly to prevent rusting.

pine sol - "Friendly" and effective grease remover and cleanser for machinery and other surfaces.

potato - Use to test a brine quench for proper salinity. Toss a few uncooked potato chunks into the mix as salt is added and the potatoes will float when proper salt level is reached.

rubbing alcohol - Rubbing alcohol contains a concentration of 70% - 90% isopropyl alcohol mixed with water (some brands may use ethyl alcohol). Primary use is for first aid (alcohol should not be used on open wounds, but to clean areas around the wound - use hydrogen peroxide on the open wound). Also effective as a cleanser or degreaser for metal. Good for a painting prep since it evaporates quickly and leaves no film on treated surfaces.

salt - Mix with water to improve its quenching ability. The backyard rule of thumb is between 5% and 12% salt in water. Also can be added to vinegar to make a brass, copper, or iron cleaner.

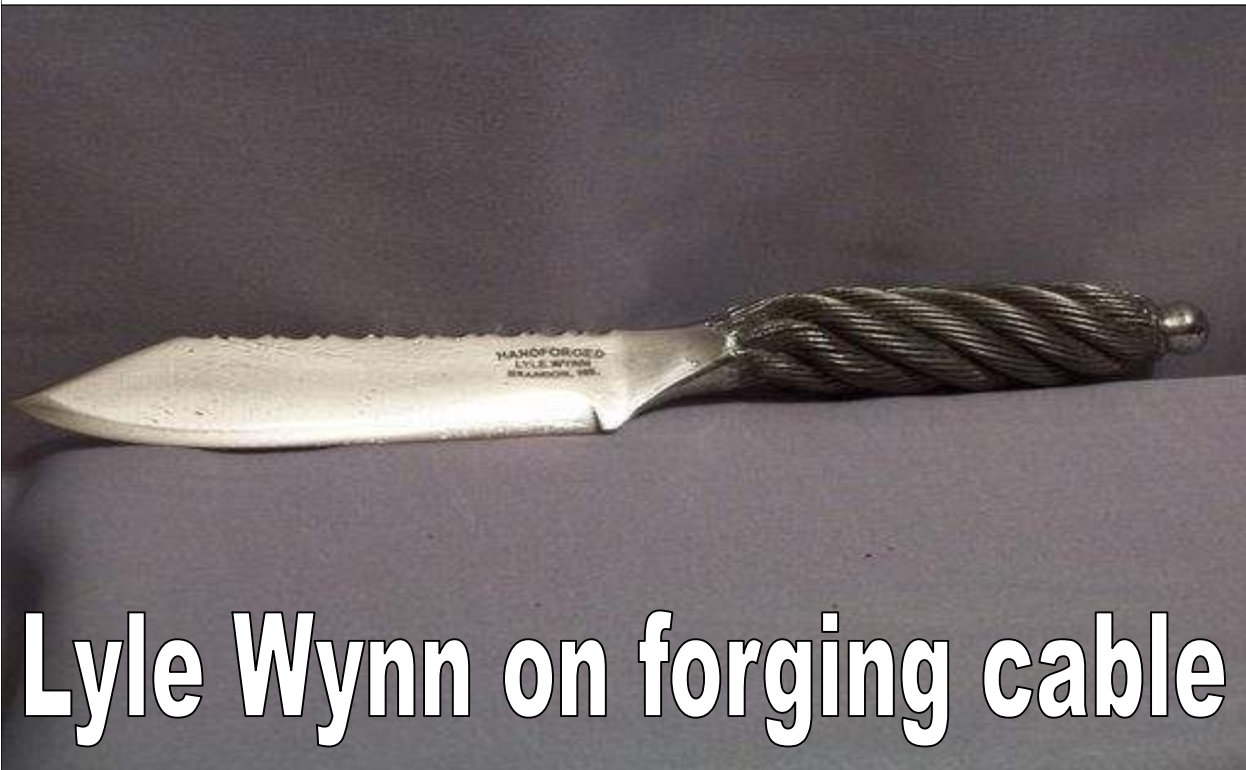
swimming pool pH balancer - (sodium bisulfate) Use to make a dip for cleaning copper after working, soldering, or brazing. Usually available in stores in 5 lb. containers labeled "pH reducer or pH negative". Mix one to two pounds of chemical with eight gallons of water in a plastic container such as a trashcan. Submerge items in the solution for thirty minutes to an hour then rinse thoroughly with water. The solution can also be used to clean steel, but use a separate container - don't contaminate the copper bath with other materials.

toothpaste - Use an old style paste type for a very fine polishing compound. Thin with water if needed.

vinegar - Common vinegar is about 5% acid and can be used to remove rust from steel and to clean oxidation from copper and brass. Adding some salt improves its effectiveness. Will attack the zinc in brass, so to avoid damage don't leave brass items in vinegar too long. A number of formulas for its use in metalworking can be found on the Internet.

washing soda - (sodium carbonate) Available in some stores as "Arm & Hammer Super Washing Soda". Mildly caustic. Used to prepare the electrolyte for an electrolysis rust removal process. See following link for details on the electrolysis technique:
<http://www.rowand.net/Shop/Tools/Electrolysis.htm>

Note: As concerns for liability increase and consumers demand "easier to use" products, some of the listed substances may no longer be available in your grocery. However they should be stocked in better pharmacies and home improvement stores. Some of these materials can be toxic, cause skin damage, or create toxic fumes; particularly when mixed with other ingredients. The author and the MFC claim no expertise in the use of chemicals and strongly encourage users to familiarize themselves with proper handling techniques and the potential hazards that may be associated with these materials. Always provide adequate ventilation and wear appropriate safety gear when handling chemicals.



Lyle Wynn on forging cable

I have been forge welding cable for about 6 years now. It gets easier each time you do it. Forge welding cable is no different than forge welding anything else other than the fact that the individual pieces are already being held together for you, therefore the only critical element you have to get correct is the fire. People have said you cannot get good cable anymore and in some cases that is true. A lot of cable is imported and does not have the carbon content desired to make a good knife. Generally the cable I use is new, picked up from a local supplier. According to them, there are two cable manufacturers left in the US, and both of these make a high carbon cable that is sufficient for making a good quality knife. I checked with a technical person at one of the manufacturers and he assured me the cable I was using had at least .7 per cent carbon. I have read articles about cable that say; due to the time it takes to forge it together you will lose a percentage of your carbon in the forge welding process. I do not doubt this but the thicker the cable is the less that percentage is, and the fewer heats it requires to weld the cable will affect the percentage as well. The larger cable also has a more appealing pattern. I like to use the mid-sized $\frac{3}{4}$ " to 1" cable with the larger strand wires. I have read where you have to burn the grease out of it before you start welding it but I have never done this, I figure that by the time it takes to get it to a welding heat, surely the metal has had time to clean itself.

Usually when I weld cable I build a cave type fire in the forge and keep plenty of coke in the bottom of the cave. This allows you to have a window to see the end of the cable and still be able to heat to a forge welding temperature. If you will heat the end of the cable to a red color then flux,(I have always used 20 Mule Team Borax) You can then heat to an orange color and bring it out to the side of the step on the anvil so you can start tightening the last 1 inch or so of the cable. While you are heating (and hammering) on the cable you have to turn it in the direction as if you were tightening the cable strands. This will keep the heat even and prevent you

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from burning the individual wires.

After you have tightened the end of the cable and removed a large portion of the air space within the cable, the last inch or so will reduce in size a noticeable amount. You are now ready to heat the end to a welding heat, the end will be the same color as the bright yellow, hottest part of the fire. The borax will be bubbling, and when you take it out of the fire it will have a white almost clear smoke or vapor rising from it. If it is too hot, and sparking, wait till the sparks stop then start hitting it on the step of the anvil, (by hitting on the step each blow is actually hitting the cable on three sides) turning the cable after each blow until you have it rounded and welded all the way around. As it welds your hammer blows will start bouncing some rather than just making a thud.

Once you have the tip welded you can then put the tip in the vise and twist the cable to open it up. Once opened, remove it from the vise and put borax all the way around for the next three inches or so. You can now tighten the cable back up by putting the tip back in the vise and twisting it in a tightening direction. You are now ready to heat the cable to a good red orange heat and tighten the next three inches or so, on the step of the anvil, to remove the airspace. Once this has been done, I usually re-flux the cable and bring this area up to the bright yellow hottest color in the fire heat, (while turning to keep from burning the wires) and bring to the step of the anvil to hammer on until it welds thoroughly. It only takes 4 to 6 inches of welded $\frac{3}{4}$ " or 1" cable to make a decent sized blade if you plan to use the cable as the handle. If you want a cable handle just cut the cable (easiest with an abrasive chop saw) at the back of the handle, be sure to leave an extra inch to allow for the end to be welded. Weld the end the same way as you welded the end when you started on the blade. Once this end is welded, you can dress it up on a belt sander. If you want a full welded handle you will need more cable welded.

Once you have hammered out your blade and sanded it down you will need to etch the blade to reveal the pattern that made you want to start with cable in the first place. I heard it described by Terry Vandeventer best referring to the pattern as having a dragon fly wing appearance. When you get ready to flatten the rounded welded cable to start shaping the blade be sure and flatten at a welding heat this will help make sure you do not have any flaws in the material, a lot of times when you start this flattening process you will hear the distinct sound of a forge weld taking place.

If you will take the cable blade to a 1000 grit finish then etch with a 60-40 mixture of PCB etchant (ferric chloride) from Radio Shack, and white vinegar, this seems to work best for me. (Because cable is made of the same metal it does not etch the same as true Damascus) Cable requires a deeper etch to get the detailed appearance. I usually submerge the part I want etched for 10 minutes at a time then rinse in water then neutralize in a mixture of baking soda and water. After rinsing, if the etch is the depth you want, you can dry it with a hair dryer then spray it down with WD-40, if it is not as deep as you want, just put it back in the etch again. If the blade does not look as good as I think it should, I will buff it lightly with a fine polishing compound. After you etch the blade it is usually rough along the cutting edge. I talked with Bobby Howard about this because, I almost hate to sharpen it in fear of messing up the finish, but it is a knife and you want it sharp therefore, you can come back and sharpen it with a little less angle to get a good cutting edge and still have a good clean blade finish with only a minimal amount of material being removed and get the desired cutting edge.

The Backyard Blacksmith
Traditional Techniques for the Modern Smith
Author: Lorelei Sims
ISBN # 1-59253-251-9
By Bill Pevey

For those of you that are just getting into blacksmithing, and even for you who have been doing it for some time, this book would be a good one for your library.

The author starts by talking about setting up your work space, safety considerations, which all of us know are very important, and then she goes on to discuss many of the major tools that the blacksmith uses, anvil, vise, tongs etc. Fire building, fire tending, tool usage and forging techniques, forge welding, and other assemblage techniques are covered in the first six chapters. Chapter 7 is very useful because it covers the making fourteen different tools that are crucial to the work that the blacksmith does.

Chapter 8 gives us 17 projects to do that start with beginner skills and progresses to advanced levels for those that want to try their skills at a higher level. Starting with a drive hook and moving on to a door pull, a leaf letter holder, a camping pot rack, a camping tripod, barbeque fork, pot and utensil rack, with a lot of information in between, this is a lot of information in a chapter that will give any of us plenty of exercises to practice on.

This book, unlike many you have seen, has photographs that let you see what is going on instead of some kind of murky representation of who knows what.

I think you will enjoy this book as much as I did. It can be ordered from the author for \$25.00 postpaid

Order from: Lorelei Sims

315 4th st.

Charleston, Illinois 61920



Kathy and James Watts, of Brandon, are the winners of the Fountain raffle.



Steve Williamson's dragon class prior to the conference.



MY SHOP

Memorial Day, 2007, while most people were barbequing hamburgers, look what was cooking at my house. To name a few: chop saw, band saw, scroll saw, jig saw, table saw, router, drill press, belt sanders, wood lathe, sanders, grinders, buffers, clamps, fixtures, jigs, tools and templates. Plus many more.

You can see for yourself at: <http://picasaweb.google.com/rjgwynn/BurnedShopUpdatePictures>

I asked “Mr. Fire Investigator” what he was going to put in the report as the cause of the fire. The response was “electrical fire caused by a squirrel or a rat”. I had an alibi named Bill Pevey. I was with him when I got the call from a neighbor: “Ricky, are you in town? Yes. Are you near? Yes, I am at the new Craftsman Guild building. Can you come home, NOW? Yes, what’s up? Your house is okay, but your shop is in blazes and the firemen and police are here. I will be there in one minute.” I got to go Bill, my shop is on fire.

The blazes burned the tops of the pecan, pine, oak and cedar trees in my back yard. You could see blazes over my roof top as neighbors lined the street. There were explosions, and the firemen were wearing oxygen masks and tanks on their backs. This was one of the hottest fires they had combated in a while; hotter than their test run the month before. Afterwards, they all had breathing and blood pressure tests in my back yard. I told them, while they were taking the tests, they might need to check me out.

Keith Winstead, one of the firemen, asked “where’s Vickie (my wife). I said “on the way back from Pensacola”. He asked what time will she arrive home; I said about 4:00. He said he would come back; he wanted to be there when Vickie drives up. He didn’t come back, she did. “Thank goodness the dog was okay and the house didn’t burn. Are you okay honey?” I love you too, sweetheart.

DO YOU HAVE A LIST OF WHAT IS IN YOUR SHOP? You need one. Do you know when you purchased or acquired your equipment? You need to know. Do you know how much you paid for each of your tools or equipment? It is important to have that. Do you have receipts? Do you know the model and serial number of each item? Do you have pictures? Is your memory as good as it used to be? Close your eyes (read this first) and mentally do an inventory of all the files, chisels, hammers, screw drivers, open-end and closed-end wrenches, sockets and allen wrenches you have. What different grit sand-paper do you own, and how many teeth-per-inch are the band-saw, table-saw and hand-saws that you own. Tomorrow you will think of something you left off the list.

Where do you keep your patterns? If your shop was on fire, what would you try to save first? A lot of my patterns were made from 26-gauge galvanized steel and from 16-ounce copper. I was able to find many of them. The paper patterns are history. It might be a good idea to make two patterns, one for the shop, and one for the vault in the house (is it fire proof).

A fire is no fun. But, it is a learning experience. I hope you never have to go through one, and have learned something from my experience. Is your insurance adequate to cover what you could lose?

Ricky J.G. Wynn
Member of: MS Forge Council

Editor’s note: Ricky is pouring the slab for his new shop, a smile does cross his face when he talks about how he is planning the new layout.

“Out of the ashes”



Various conference photos

KAYNE & SON

**Blacksmithing & Metalworkers
TOOLS - EQUIPMENT - SUPPLIES**

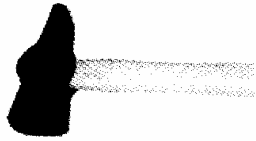
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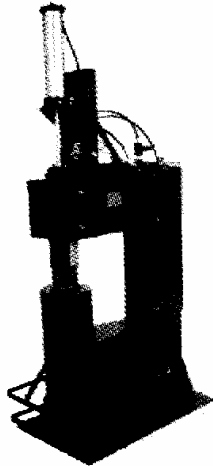


BIG BLU

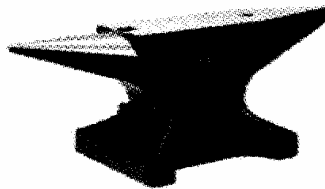
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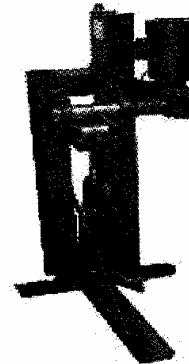
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NEED STEEL SUPPLIES?
Give Nicky Wynn, at O'Neal Express, a call. He has been most helpful when it comes time to re-stock the steel supplies. There is no minimum order and the variety of 'drops' is changing daily. O'Neal Steel and O'Neal Express Aare located in Pearl, off Bierdeman Road. Nicky always seems to have time to help us with the smaller orders, larger ones too. Tell him the MFC sent you.

Neologisms

Once again, The Washington Post has published the winning submissions to its yearly neologism contest, in which readers are asked to supply alternate meanings for common words.

Last year's winners:

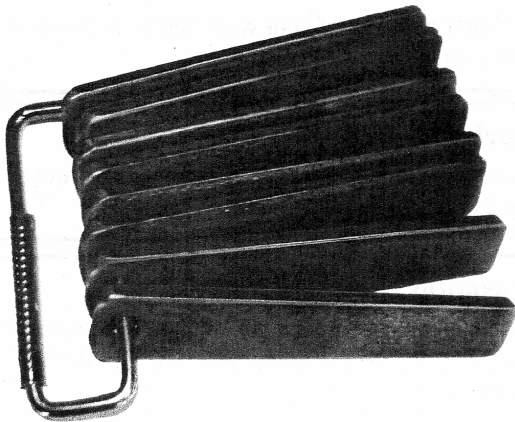
1. Coffee (n.), the person upon whom one coughs.
2. Flabbergasted (adj.), appalled over how much weight you have gained.
3. Abdicate (v.), to give up all hope of ever having a flat stomach.
4. Esplanade (v.), to attempt an explanation while drunk.
5. Willy-nilly (adj.), impotent.
6. Negligent (adj.), describes a condition in which you absentmindedly answer the door in your nightgown.
7. Lymph (v.), to walk with a lisp.
8. Gargoyle (n.), olive-flavored mouthwash.
9. Flatulence (n.) emergency vehicle that picks you up after you are run over by a steamroller.
10. Balderdash (n.), a rapidly receding hairline.
11. Testicle (n.), a humorous question on an exam.
12. Rectitude (n.), the formal, dignified bearing adopted by proctologists.
13. Pokemon (n), a Rastafarian proctologist.
14. Oyster (n.), a person who sprinkles his conversation with Yiddishisms.
15. Frisbeetarianism (n.), (back by popular demand): The belief that, when you die, your Soul flies up onto the roof and gets stuck there.
16. Circumvent (n.), an opening in the front of boxer shorts worn by Jewish men.

The Washington Post's Style Invitational once again asked readers to take any word from the dictionary, alter it by adding, subtracting, or changing one letter, and supply a new definition. Here are this year's winners:

1. Bozone (n.): The substance surrounding stupid people that stops bright ideas from penetrating. The bozone layer, unfortunately, shows little sign of breaking down in the near future.
2. Foreploy (v): Any misrepresentation about yourself for the purpose of getting laid.
3. Cashtration (n.): The act of buying a house, which renders the subject financially impotent for an indefinite period.
4. Giraffiti (n): Vandalism spray-painted very, very high.
5. Sarchasm (n): The gulf between the author of sarcastic wit and the person who doesn't get it.
6. Inoculatte (v): To take coffee intravenously when you are running late.
7. Hipatitis (n): Terminal coolness.
8. Osteopornosis (n): A degenerate disease.
9. Karmageddon (n): It's like, when everybody is sending off all these really bad vibes, right? And then, like, the Earth explodes and it's like, a serious bummer.
- 10 Decafalon (n.): The grueling event of getting through the day consuming only things that are good for you.
11. Glibido (v): All talk and no action.
12. Dopeler effect (n): The tendency of stupid ideas to seem smarter when they come at you rapidly.
13. Arachnoleptic fit (n.): The frantic dance performed just after you've accidentally walked through a spider web.

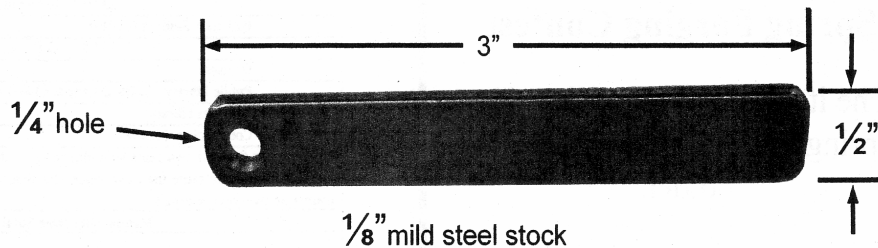
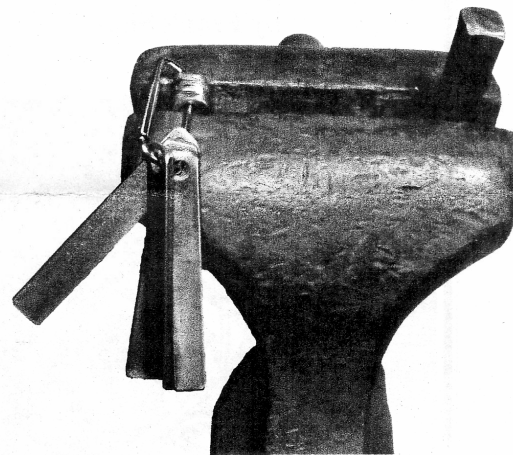
Adjustable Vise Tool

By Carl Davison, *Northeast Blacksmiths Association*



Having spent numerous times searching the shop for small scraps of metal to balance out the vise jaws I recently decided to prepare a dedicated set of shims that would always be ready. I wanted them to be compact and easily hung next to the vise.

My first plan was to find and cut pieces of stock in every size up to 1". Keeping all the different sizes together so none got displaced was a concern to be considered but I decided this could be worked out once I collected all the sizes. As I was searching out stock the first size I located was a number of short length scraps of $\frac{1}{8}$ " x $\frac{1}{2}$ " next to the bench shear. Looking at those short scraps I realized 8 pieces of $\frac{1}{8}$ " thick material would do the trick if they could be held in some convenient way. A 50¢ slip sleeve key holder from the hardware store seemed the ideal holder. The slip sleeve holds the shims in place and the unused shims can be either left to one side or draped in front and in back to even out the weight.



Horseshoe Nail Cross

by Bill Clemens, Hammer & Tong, March-April 2007, Maryland

I was asked by our minister to repair a cross pendant that he always wears. It appeared to be made of horseshoe nails, but close examination revealed that it was cast of some soft alloy. In preparing to solder the cross back together, I decided that I would first try to make a replacement cross from actual horseshoe nails just in case I couldn't repair his cast cross. What follows are the steps I took to make a cross pendant by forge welding four horseshoe nails together. So far, I've only made three crosses, and I've learned something with each one. If you make one, I'd love to hear about it and any refinements to these instructions you may discover.

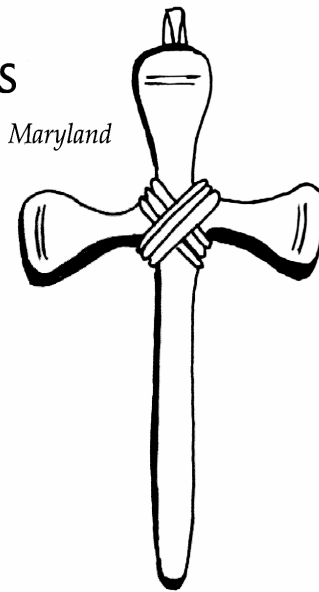
I started with four number 16 Mustad horseshoe nails. Three nails make up the cross, and a fourth one, with the head removed, makes the loop for hanging it. Begin by cutting the head off one of the nails and forming a taper/scarf on the end. Since the nails are tapered along their length and you'll be placing this nail upside down behind the central nail of the cross, you'll need to taper it to match and thin the head end.

Turn the nail over and form the loop. Forming the loop before forge welding it to the back of the central nail gives you a means of positioning the two nails for welding and protects the tapered point while in the forge. Place the loop tightly against and behind the head of a second nail. After the cross is completed you can reposition the loop slightly so that it is not tight against the head.

Hold the nails by the head and loop. I used a pair of round bit farrier's fire tongs that have domed bits that accommodate the head and loop while holding the two nails firmly just below the head. I used a tong clip to hold them securely. You will need a small clean fire and a slow air flow. Place the nails in the forge and heat to orange; brush and flux. After fluxing, insure the nails are in contact along their length. Return to the fire and heat slowly, rotating them to insure uniform heat. At welding heat remove from fire and tap gently. If done right, the pieces have actually welded in the fire, and your gentle taps are just to make sure the weld is complete, any small gaps are closed and any remaining flux is expelled from the weld joint. This is fire welding as opposed to hammer welding, in which the two pieces to be joined are heated separately in the forge fire and joined at the anvil with hammer blows.

Once welded, remove the tongs and place the head and loop end in the fire to complete the weld on the remainder of the shank and at the head. Take care not to burn the thin loop or to distort it with a misplaced hammer blow. These welds exercise both fire management and hammer control. Lay this piece aside.

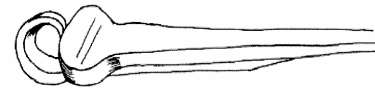
Take the remaining two nails and place them back to back. You might want to practice placing them in a vise (2A) like this



1A



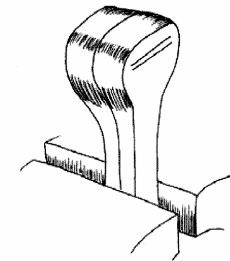
1B



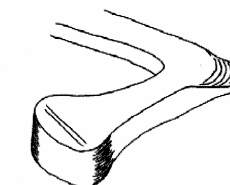
1C



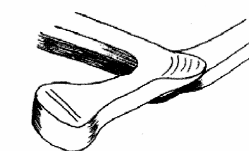
2A



2B



2C



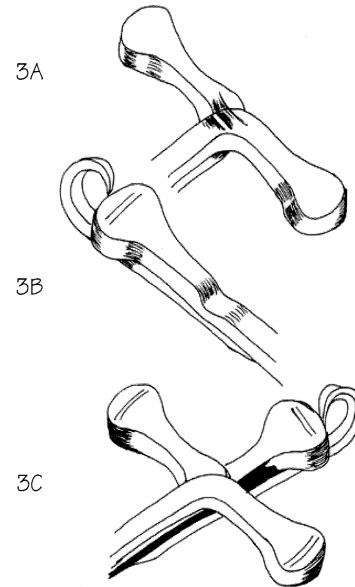
Horseshoe Nail Cross

while still cold. You want about 1" protruding above the vise. With a hammer, form a 90° bend in both nails. By placing them back to back in the vise, you are ensuring that both arms of the cross will be the same length. Square up the bend on each nail independently making the inside corner as tight as possible, but be careful that the length of both arms remains the same. Forge a scarf at the bend of each nail as shown in 2B, with one scarf face up and the other face down, so that when the nails are placed together, both face up with their shanks on top of each other. Their scarfs will overlap, as indicated in 2C. Place the nails in tongs, and weld the points first, following the same procedures as for the central nail and loop.

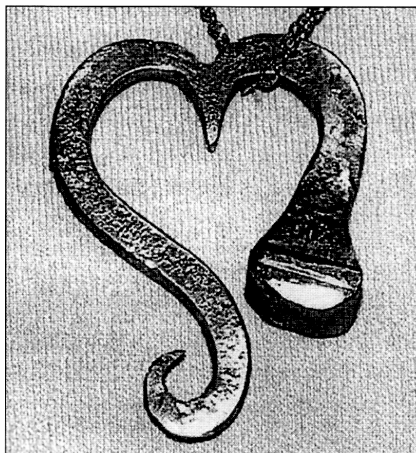
While completing the weld on the top of these nails, forge a scarf from the backside as shown in 3A. First make sure the thin tops of the arms are flush on the front, and then thin the shaft below the arms, leaving a bulge on the lower half of the arms.

Align the arms on the central nail and forge a slight indentation to accept the bulge on the arms. With the arms and central shaft positioned, repeat the forge welding process one last time to join the two parts of the cross together. Again after welding, thin the central shaft of the cross below the arms while maintaining the proper width and cleaning up the sides.

Trim the bottom of the cross to $2\frac{3}{4}$ ", and then upset the bottom end, leaving only a slight taper (if any) in the width and thickness of the bottom of the cross. I think it looks better with a slight swelling at the very bottom. ♣



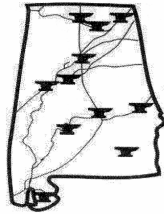
Horseshoe Heart Pendant



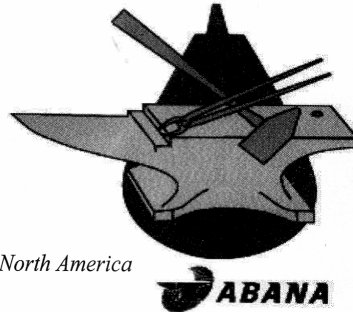
This little heart appeared without fanfare in Hammer and Tong. It seems to be made out of two horseshoe nails, tips forge-welded together, with head removed from one of the nails. Try this with one forge weld before advancing to the cross with three forge welds. ~ Ed.

Bituminous Bits

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A THOUSAND MARBLES

A few weeks ago, I was shuffling toward the garage with a steaming cup of coffee in one hand and the morning paper in the other. What began as a typical Saturday morning turned into one of those lessons that life seems to hand you from time to time. Let me tell you about it: I turned the dial up into the phone portion of the band on my ham radio in order to listen to a Saturday morning swap net. Along the way, I came across an older sounding chap, with a tremendous signal and a golden voice. You know the kind; he sounded like he should be in the broadcasting business. He was telling whom-ever he was talking with something about "a thousand marbles." I was intrigued and stopped to listen to what he had to say, "Well, Tom, it sure sounds like you're busy with your job. I'm sure they pay you well but it's a shame you have to be away from home and your family so much. Hard to believe a young fellow should have to work sixty or seventy hours a week to make ends meet. It's too bad you missed your daughter's "dance recital" he continued. "Let me tell you something that has helped me keep my own priorities.

" And that's when he began to explain his theory of a "thousand marbles."

The older I get, the more I enjoy Saturday mornings. Perhaps it's the quiet solitude that comes with being the first to rise, or maybe it's the unbounded joy of not having to be at work. Either way, the first few hours of a Saturday morning are most enjoyable.

"You see, I sat down one day and did a little arithmetic. The average person lives about seventy-five years. I know, some live more and some live less, but on average, folks live about seventy-five years. "Now then, I multiplied 75 times 52 and I came up with 3900, which is the number of Saturdays that the average person has in their entire lifetime. Now, stick with me, Tom, I'm getting to the important part. It took me until I was fifty-five years old to think about all this in any detail", he went on, "and by that time I had lived through over twenty-eight hundred Saturdays." "I got to thinking that if I lived to be seventy-five, I only had about a thousand of them left to enjoy. So I went to a toy store and bought every single marble they had. I ended up having to visit three toy stores to round up 1000 marbles. I took them home and put them inside a large, clear plastic container right here in the shack next to my gear."

"Every Saturday since then, I have taken one marble out and thrown it away. I found that by watching the marbles diminish, I focused more on the really important things in life. There is nothing like watching your time here on this earth run out to help get your priorities straight." "Now let me tell you one last thing before I sign-off with you and take my lovely wife out for breakfast. This morning, I took the very last marble out of the container. I figure that if I make it until next Saturday then I have been given a little extra time. And the one thing we can all use is a little more time."

"It was nice to meet you Tom, I hope you spend more time with your family, and I hope to meet you again here on the band. This is a 75 year old man, K9NZQ, clear and going QRT, good morning!"

You could have heard a pin drop on the band when this fellow signed off. I guess he gave us all a lot to think about. I had planned to work on the antenna that morning, and then I was going to meet up with a few hams to work on the next club newsletter. Instead, I went upstairs and woke my wife up with a kiss. "C'mon honey, I'm taking you and the kids to breakfast." "What brought this on?" she asked with a smile. "Oh, nothing special , it's just been a long time since we spent a Saturday together with the kids. And hey, can we stop at a toy store while we're out?"

I need to buy so me marbles

This was sent to the editor by a special 'mush head.'

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Dick Nietfeld
Shady Grove Blacksmith Shop

Hey guys,

I wanted to send y'all this in case you have an email list of "blacksmith" folks that might need a post vice. I was at the antique/flea market complex on 49 south of Florence this past Sunday and someone there had a 5" post vice for sale. Price was \$100 and it looked to be in good shape. I go to antique shops/flea markets quite often in the area and don't run into blacksmith equipment vary often other than hammers and horse shoeing tongs.

Thanks,
 Steven.Walker@its.state.ms.us

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