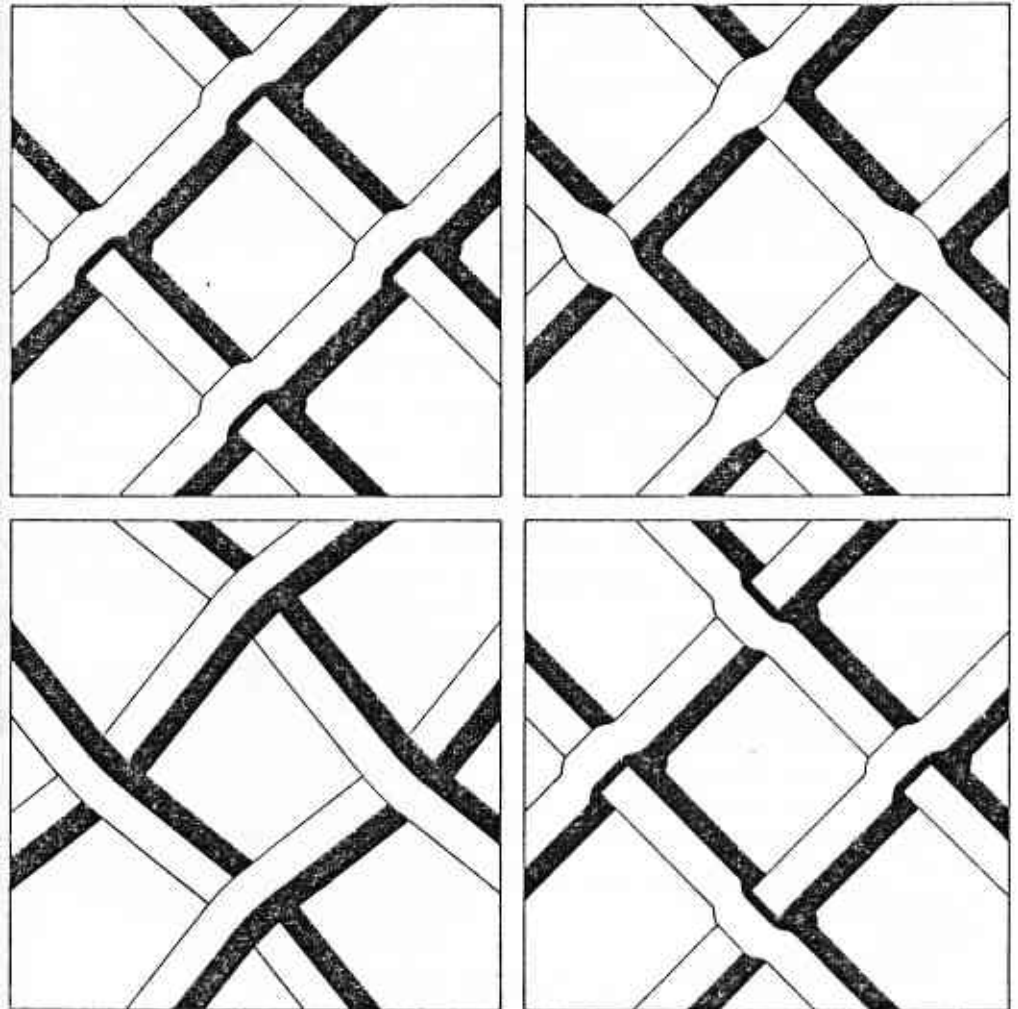


OCTOBER - NOVEMBER 1987

Newsletter of the Blacksmiths Association of Missouri



NEWSLETTER OF THE BLACKSMITHS

ASSOCIATION OF MISSOURI

OCTOBER - NOVEMBER 1987

VOL. 4 - NO. 5

The Blacksmiths' Association of Missouri is a chapter of The Artist-Blacksmiths' Association of North America. This organization is devoted to preservation, advancement, and communication between blacksmiths of Missouri and surrounding areas. BAM's newsletter's goal is to support these ideas. Letters to the editor, tech tips, tools for sale, or any ideas which further these ends will be considered for publication.

BAM welcomes the use of any material printed in this newsletter provided the author and this organization be given credit.

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Telephone: _____:

New Member: _____: Renewal: _____:

Memberships are for the calendar year, January 1 to December 31. Dues are \$15.00, which includes a subscription to the bimonthly BAM newsletter.

Please make checks payable to Blacksmith Association of Missouri

SEND CHECKS TO: Steve Austin

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Nashville, IN 47448

CHECK MUST ACCOMPANY APPLICATION

FRANK TURLEY

SIUE; NOV. 7&8

The Frank Turley Workshop will be held in Tom Gipe's sculpture studio at Southern Illinois University at Edwardsville on November 7th and 8th. The title of this two day event is BLACKSMITHING: THE PHYSICAL AND THE METAPHYSICAL. For several years Frank has been dealing with the "Dance of Work", movement and meditation and it's relationship to blacksmithing. This workshop will surely be educational, inspirational and entertaining. Frank has been teaching blacksmithing at his school in Santa Fe for close to 20 years and has been one of the major forces in the advancement of our craft.

FRANK TURLEY WORKSHOP SIUE 1987

Registration Form

Name : _____ :

Address : _____ :

_____ : Phone : _____ :

() \$25.00 for Sat., Nov 7 only or Sun.,
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() \$40.00 for Sat. & Sun., Nov. 7 & 8

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LOST VALLEY LAKE

FORGE FEST

With such perfect weather, how could we fail? The Friday set up went smoothly with the steady accumulation of equipment. By early Saturday morning, the aroma of green coal wafted through the demonstration tent. As the fires and smith warmed sufficiently, work commenced. The staccato rhythms of double striking rang out periodically indicating than in spite of BAM'S fun loving nature, we meant business. Our mission--make as many items as possible to sell at a BAM benefit auction on Sunday afternoon.

Jerry Hoffmann and Bill Miller hammered out a fine set of pitching horseshoes. Lookie yonder, Velda, they are makin' horseshoes! Skillets, too, were the rage that day, with two sizes in production. That was an entertaining half hour exhibit of roaring torches and the blur of wild, ambidextrous hammering. Four or five pans got started, some yet to be completed.

In addition to a wild array of imaginative coat hooks and other household items, we managed to crank out some pieces that were never quite identified. No matter... The fires burned far into the clear Saturday night. We forged on, partied hearty, and our satisfaction grew fuller.

The hammering began to slow by late Sunday morning and forges were allowed to cool for dismantling. After loading, we discussed alternatives for selling our wares since the benefit auction had to be scrapped. Doug Hendrickson's generosity prevailed as he offered to sell the work at his shop at Peola Valley Forge. Thanks, Doug!

The best part of the LVL function was the comraderie of our diverse group of iron enthusiasts. It is appparent that our membership is growing. The new faces in the crowd are a welcome sight. We need all the input we can get, and with all our combined experience and expertise, there is much to draw on.

A FAMILY AFFAIR

by PATTI TAPPEL

It was one of the last summer days with a gentle breeze blowing, yet the sun was warm when I attended another BAM meeting. The place, Lost Valley Lake. Sounds of many hammers and anvils were heard ringing. Only four wives were in attendance and two of us brought our children. These meetings are excellent opportunities for spouses to come out to watch their husbands and to take time away from the regular routine.

Another meeting I attended was on the Black River, it was so enjoyable I couldn't wait to go to another one. No I don't smith but I enjoy the change of scenery, visiting with others in the organization, eating someone elses cooking, and not having to do dishes!

Next time ladies try to make the meeting. Make it a family project. Bring a book, your lawn chair, needlecraft, or just come. You'll enjoy it.

President's Report



It was good to see so many new faces at the Lost Valley Lake Meeting. That meeting was a great weekend of teaching, sharing, and learning. Unlike some of our meetings, where only two or three guys demonstrate and the rest watch, everyone got involved to one degree or another. We also had several new members sign up on the spot.

Special thanks to Ruth Hull, who did a great job of supervising the display tables, answering onlookers questions, and just assisting in general.

Doug Hendrickson reports that he has sold several of the items that we turned out. This will be a welcome addition to our bank account.

A reminder, if you haven't already done so, get your money to Steve Austin for the Turley workshop. There is an application form elsewhere in this newsletter.

Our apologies to John Wilding, seems his membership got lost somewhere in the great paperwork shuffle. Maybe we'll get it right this time John!

See you at the Turley workshop.

Dear ABANA Members,

I'm so excited I can hardly write! The executive committee is happy to report that ABANA is now financially solvent and is coming in under budget for the year. This was no small feat but was well worth the time, effort, and expense put forth by the board members to haul the downward plunge that we all found ourselves in. A special thank you goes out to the families of this dedicated board who continue to absorb the staggering phone bills, travel expenses, and stamp money, etc. that these board members have incurred. One also turns over valuable personal and family time to serve on the ABANA Board. The families always take the brunt of this, and we owe you all a great thanks.

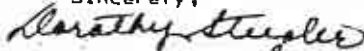
The audit committee is finishing up the audit and it was a monumental task. The reports will be run for the years 1987, 1986, and hopefully 1985, for the winter issue of "The Anvil's Ring". The '88 Conference Committee met with Bill Manly in Birmingham, August 15. Mike Bondi represented the board and is pleased to tell us it is a well organized and efficient committee. The demonstrators are great, the costs are low, and the family programs are terrific. The food is being handled by a carefully selected catering service. Keep your eye on "The Anvil's Ring" for more detailed information, including an agenda for the general membership meeting to be held at the conference.

The board is planning a meeting in November at Bill Manly's home in Tennessee to set the 1988 ABANA budget. This will allow easy access to the 1988 Conference Committee to address the board first hand.

One thing we want to discuss is the role the chapters play in ABANA. Some chapters have lots of ABANA Members and encourage their members to support ABANA. Other chapters have very few ABANA Members. We invite all chapter presidents to this November meeting to help us understand how we can change this trend. We want to support each other.

Well, it certainly has been a bumpy six months, but ABANA is back on track and moving ahead once again. This balanced budget is music to our ears, and now all we need is more members and the sky is the limit. Please join up now if you aren't already signed. ABANA needs you!

Sincerely,



Dorothy Stiegler
ABANA President

DS:jrg

cc: ABANA Board Members
Robert Owings

FORGE WELDING

THOUGHTS FROM VARIOUS SOURCES

Chances are we all can get a forge weld to hold. But to hold is just not good enough for many of the forms modern blacksmiths choose to explore. Can you twist your weld? Can you draw it? Upset it? Punch it? Or can you just make it stick? Read the following words of wisdom from several turn of the century authors on the sticky problem of forge welding. Each author has his own way of describing the process. Maybe one of these guys will tell you just exactly what you're ready to hear.

Bob Thompson, in the California Blacksmith's Association newsletter, quotes from John Lord Bacon's 1914 book Elementary Forge Practice:

"The fire must be clean and bright, or the result will be a 'dirty' heat; that is small pieces of cinder and other dirt will stick to the metal, get in between the two pieces and make a bad weld."

"If the pieces are properly heated (when welding wrought iron or mild steel), they will feel sticky when brought in contact. This is a welding heat."

"The only way to know how this heating is going on is to take the pieces from the fire from time to time and look at them."

"The scarf tips particularly must be watched, and it may be necessary to cool them from time to time in the water-bucket to prevent the extreme ends from burning off"

"A welding heat is when the iron is so soft that if another piece of iron heated to the same point touches it, the two will stick together."

"Just before taking the pieces from the fire they should be turned scarf side down for a short time, to be sure that the surfaces to be joined will be hot."

Al Bart comments on a 1935 revision by Carl Johnson, in the California Blacksmiths Association Newsletter:

"The fire must be thoroughly clean, vapors from copper, zinc or lead may coat the coke and remain until the dirty coke is consumed, most of the time not until the next day."

"Heat quickly, but not so quickly as to burn the iron, most new smiths heat so slowly that scale tends to form quite heavily before the metal reaches welding heat. The fire must be mobile, in other words if heating long narrow pieces the fire should be brought in on the sides and front and back pulled apart. For wide pieces the fire should be widened and made shorter. We normally consider the center of the forge as being the hottest, but forges differ and may have the greatest heat to one side or other."

"NEVER, NEVER, NEVER take the work out of the fire until ready to weld. Never dip any part in water. The work, after fluxing should always be kept enveloped in the fire using the poker to make an opening in the bank of red coals to observe the progress of heat. Now to keep the thin scarf tips from burning, push them through the center of the fire and place the thicker part of the work in the greatest heat. With dissimilar sizes, it may
con't. p.12

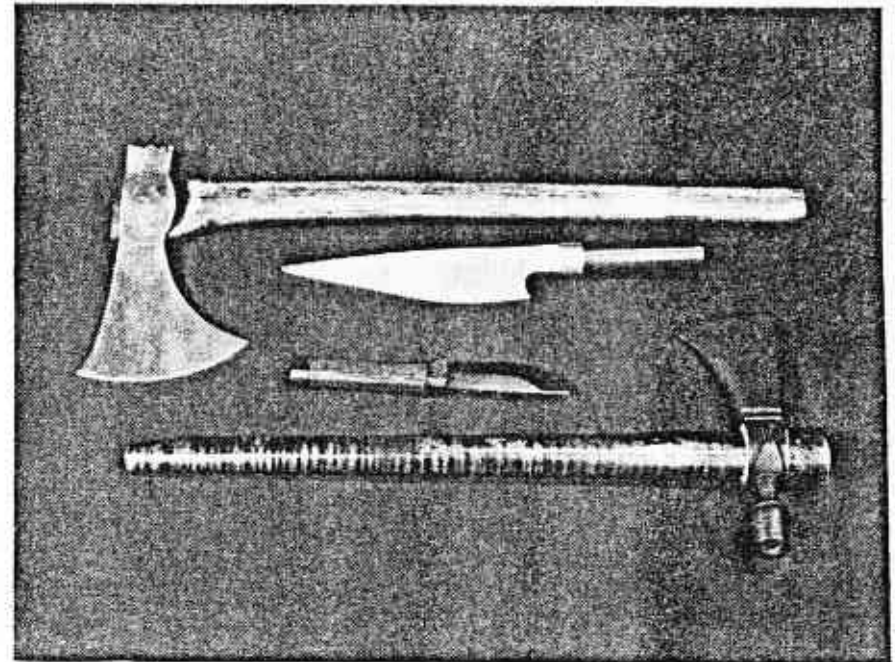
In our Aug./Sept. issue we published that you could get a monogram stamp from the Evers Co. for \$16. Mr. Ellis, of Florissant Mo., tried to take advantage of this offer and it proved to be false. The best price he could get for a 1/4" stamp was \$64.

PORTFOLIO

RECENT WORK BY BAM MEMBERSHIP

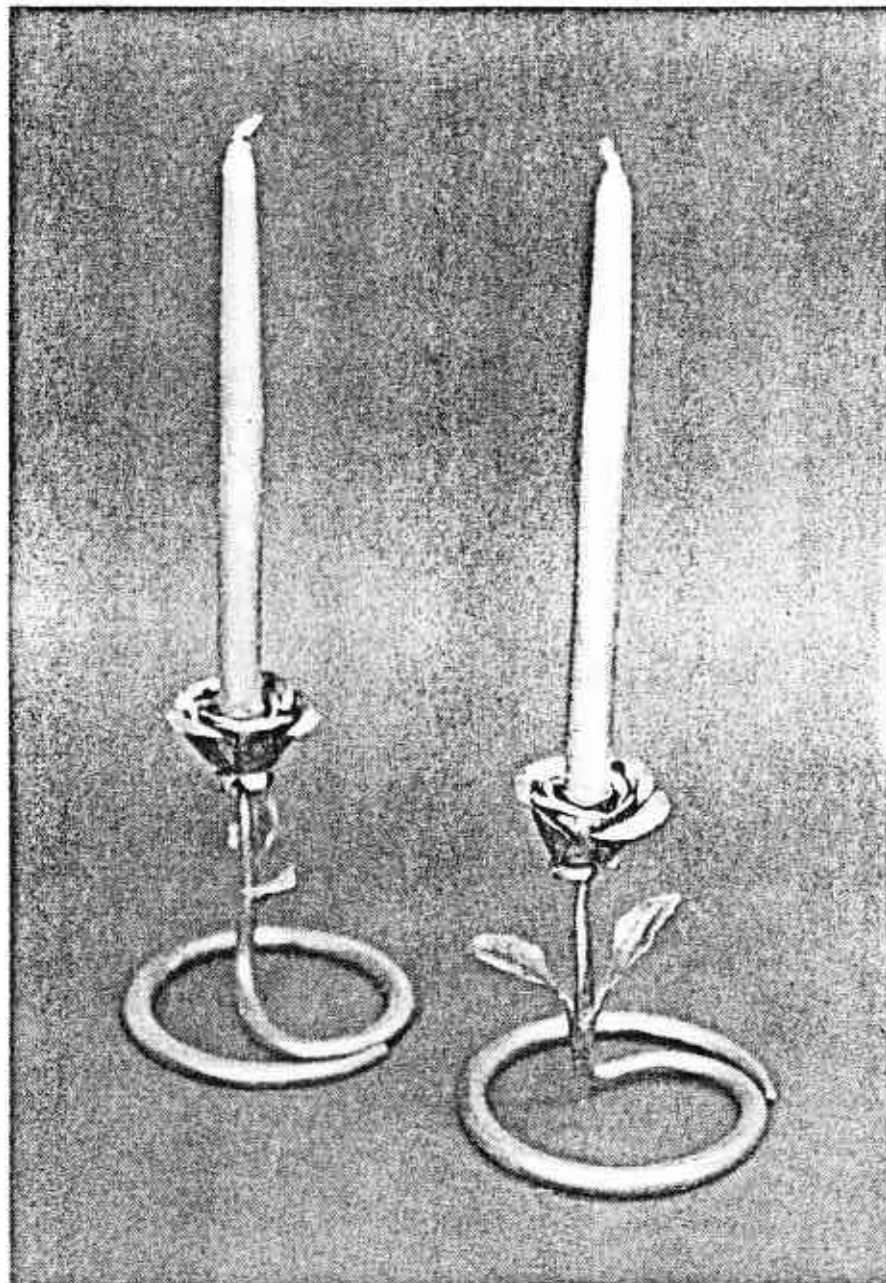
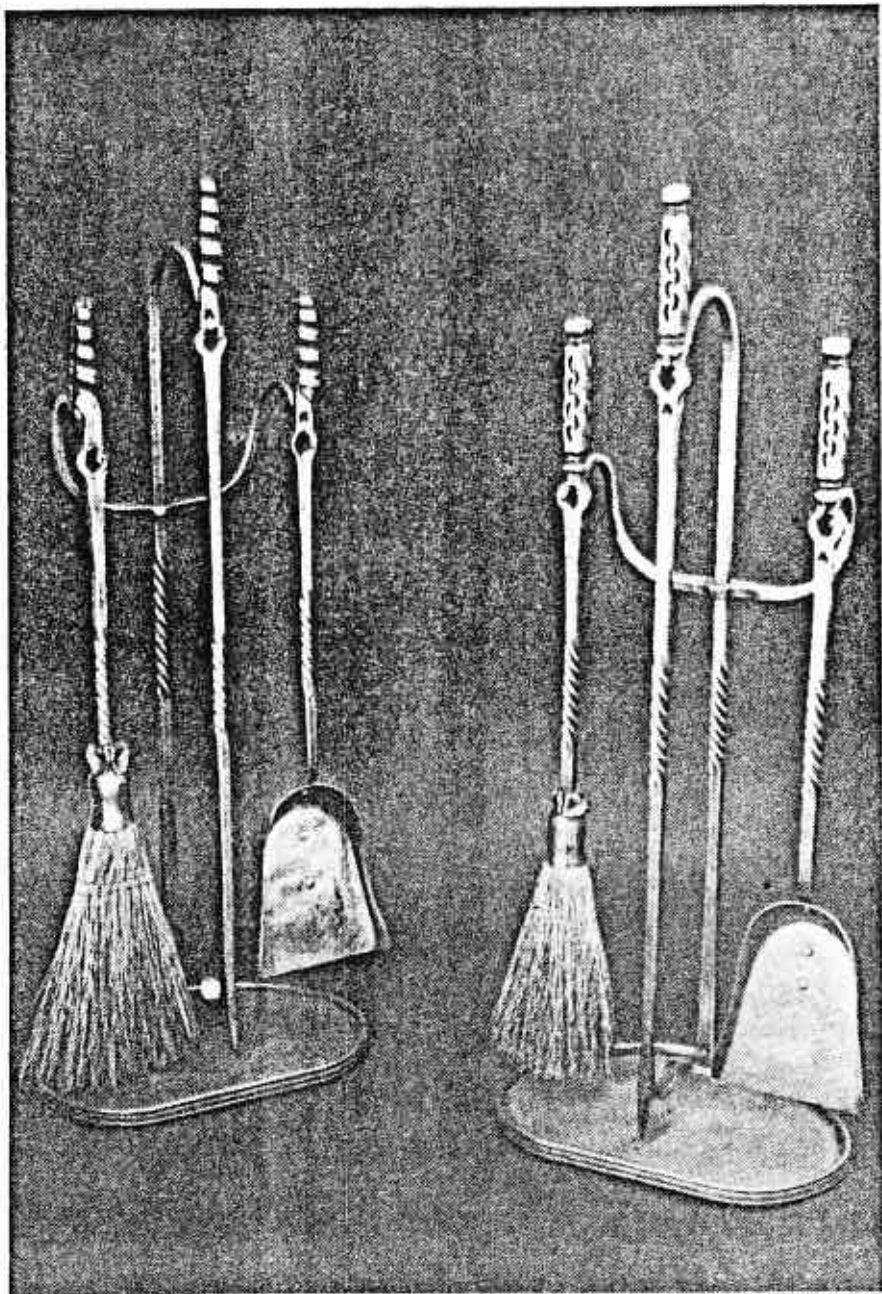
Stanley Winkler

Ste. Genevieve, Mo.



Don Asbee

Bland, Mo.

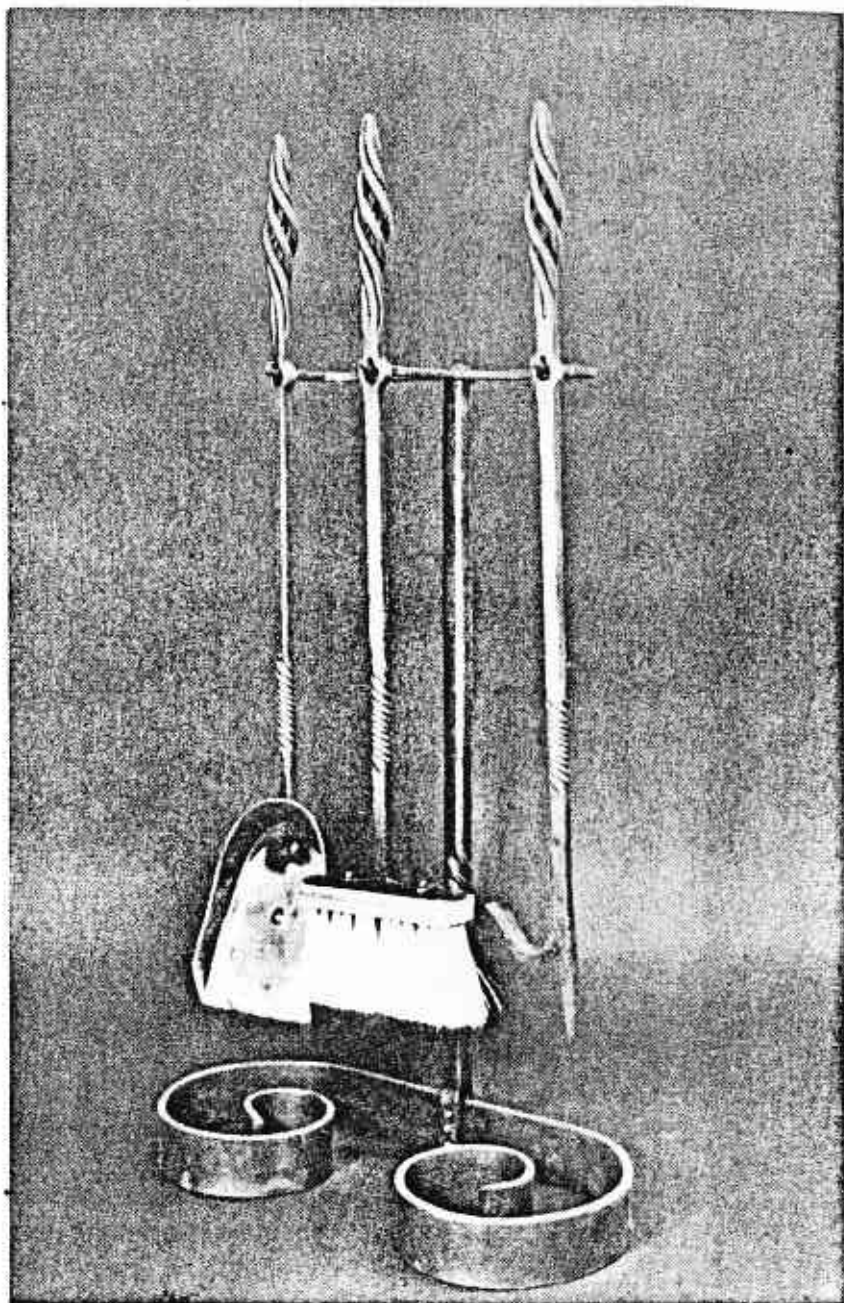


Bill Miller

St. Louis, Mo.

Bernard Tappel

Henley, Mo.



Beyond the Valley of the Anvils

by Terri Digusto



In August of 1987 two BAM families flew a red and white Bronco west across the Kansas plains to attend the 3 day Western States Blacksmith Conference. The following is an account by one of the flight attendants. Most of the names have been changed to protect the guilty.

Day One of the flight of the Bronco: As we passed the world's largest ball of duct tape, outside of Junction City, Kansas, past the boarded up Stuckeys and converted spindle-roofed A & W's, Bonnie and I began our in-flight service of the beverage of our choice - Corona. Coronas for breakfast. Captain Dr. Iron maintained cabin pressure except for some turbulence we encountered at 4100 feet but he changed lanes for smooth sailing. As we flew across Kansas we consulted our Book of Inside Information--and memorized the major phobias and manias--so we hit our first stop, Ellis, Kansas, the

boyhood home of both Walter Chrysler and Walt Disney. At our first brochure stop we realized that we missed the 8000 pound prairie dog and the Garden of Eden in Lucas, Kansas because we picked up the brochure too late--"The most unique home for living or dead on earth" and "The first flag ever made of concrete". At last we're on the edge of Kansas and the Bronco is spitting gas--but we fly into Colorado to Byers before we of course break down in front of the Longhorn motel. So we drank scotch, watched the tube, and had the rest of our broasted(a Colorado specialty) chicken from the Chuckwagon in Burlington.

Day Two--looking for vistas: Driving through the mountains with a thirty minute delay in Glenwood Canyon, Bonnie and I resumed our in flight service. We exited the Bronco to do a little disco dancing on I-70. Basalt KOA campground, then to Aspen - a pristine Victorian jewel - we began our night, trolling for blacksmiths.

Day Three: Bonnie dropped Steve and Captain Dr. Iron off at the conference. We headed for Aspen to do some aerobic shopping. Then that afternoon to the Glenwood Springs mineral pool fed by the local hot springs. As Bonnie and I tried to take the cure in the therapy pool we realized that there was nothing visual that would indicate that this was 1987. And there must have been a field trip from the order of the sisters of cellulite. After our out of time, out of body experience, we drove back to the conference for the evening activities. Bonnie and I attended a slide lecture that was far more aerobic than our shopping had been. Jerry Coe, a blacksmith-adventurer from Berkley, mesmerized us with his story of the search for the yellowcamelia through

Tibet and Mongolia.

Day Four: Captain Dr. Iron took us up to 12000 feet through Independence Pass, Mt. Albert, and the Continental Divide, where we all agreed that there probably isn't a town named Bland in Colorado. So we stopped at every point of interest and scenic over or underlook in search of the perfect blue spruce. On to Lyons, Colorado, to stay with our captain and head stewardess's friends, a house situated on a Cadillac farm, Cadillacs with sculpted heads emerging from trunks, even a Cadillac used for target practice. Great people, great stopover.

Day Five: Strausberg, Colorado. For the first time during the trip we let our captain choose a restaurant for breakfast. It's the Tea Pot Cafe. Our waitress approached wearing a poly blue and white tuxedo jacket with a 24" orange # 7 applied on the back. Lela May Norwood is not a minute under 86 and lives for Elway the quarterback for the Broncos. She's standing at the coffee machine like a mad chemist. Doug orders biscuits and gravy and he and Lela strike up a sassy rapport while the rest of us rate the food a "2", the ambiance a "5", as we stare at the cat clock with two white kittens hanging over the cabbage patch doll, dressed like good ol' # 7. So it's the last stretch back through Kansas. As we grimaced along through the state, the in-flight service was upgraded and there was a cosmic grey cloud all day, like the clouds that created the mutants of the fifties sci-fi films. As the Coronas poured, I became convinced that we would emerge from the Bronco and the Incredible Shrinking Blacksmiths and Flight Attendants from Lushterville.

Oh--there was one last stop in Oakley,

Kansas, to see the 8000 pound prairie dog--it was closed.

forge weld con't.

be necessary to place the smaller, thinner piece nearer the side away from the center of the fire. In successful welds the heat is brought up as quickly as possible without too much dawdling and with enough time to let the heat soak clear through the work"

"I turn the work over and place the scarf side down and increase the air slightly for a few seconds. This raises the heat where they are to be welded and also would burn anything on the scarfs. Now, another important thing is to raise the work straight up out of the fire. Too many have developed the habit of dragging the pieces out of the fire across the green coal and thus contaminating the scarf or welding surfaces."

In Holford's 1912 edition of The 20th Century Toolsmith and Steelworker we read the following tips on welding:

"Welding is the process or art of joining two pieces of steel together so as to form one solid piece, and which forms a very important part in steel working or toolmaking. There are several errors made when welding steel, some of the most common ones being, the want of the proper knowledge concerning the nature of the steel, a green or unclean fire containing sulphur and other foreign matter, which is dangerous to hot steel, the absence of the proper welding heat, and improper ways of uniting the pieces together. For the benefit of those who have not had much practice and those who have been only partly successful, I will give these instructions, which, if followed closely will insure success. First of all the welding point in the steel that is to be welded must be known, as there are several kinds of steel, some will require a higher heat to weld than

FRANCIS WHITAKER

SUMMER '87

It was not what we anticipated. It began with the accidental discovery of a tumor in Portia's lung. Weeks of radiation followed, at St. Mary's Hospital in Grand Junction. We were able to come home for the weekends, but the summer was cut short. A final examination a month later showed that the fight against cancer had been won.

This was followed by emergency surgery on August 24th, on a severely blocked artery in Francis' neck. The operation was successful, and after most of the summer in Grand Junction, we are home, looking forward to the fall color, the football season, and another ski season.

I will be limited to light work for some time, and I hope to catch up on correspondence, photos, and filing and editing tapes. Portia will be busy canning and freezing from our wonderful garden.

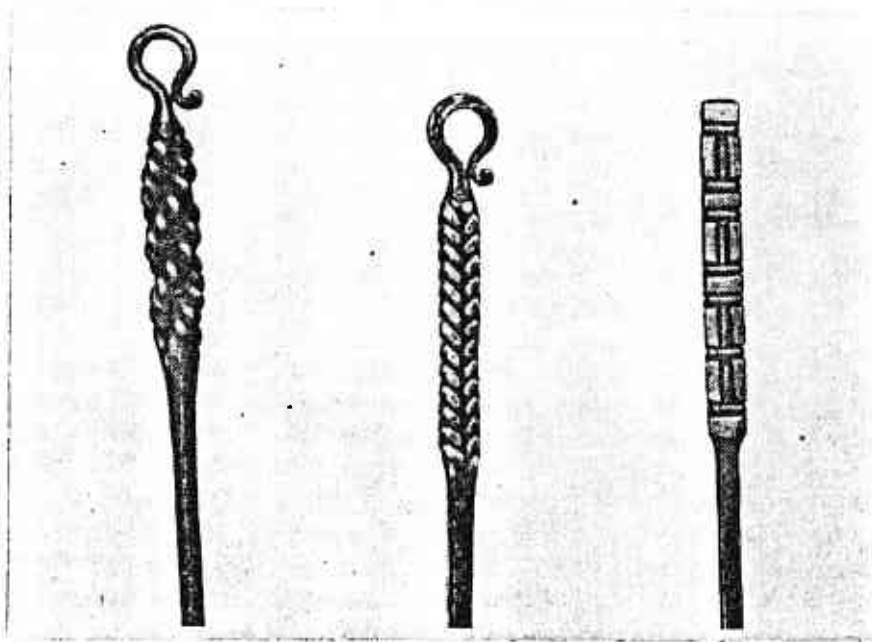
Cheers,

Francis

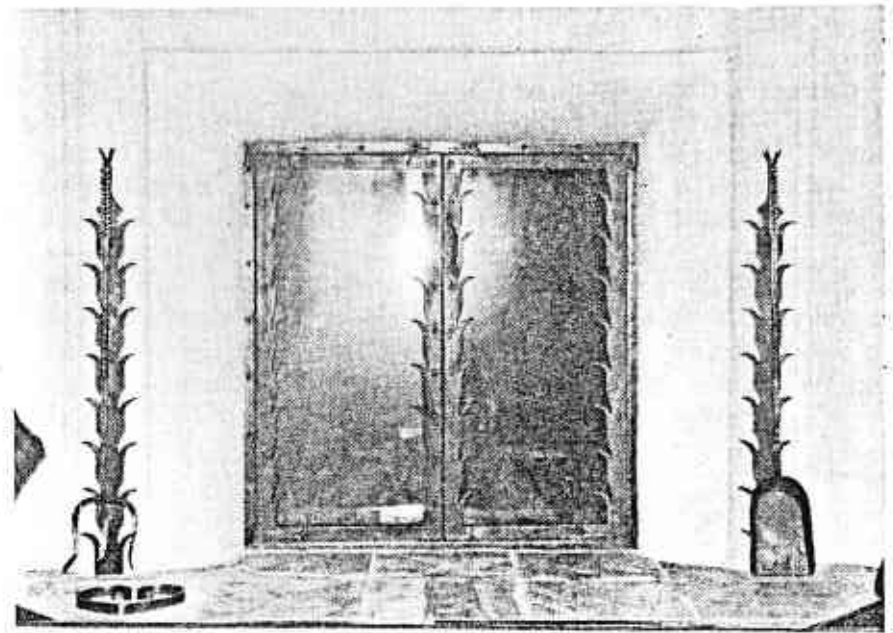
I thought my Missouri friends might like to see what I had been up to until I was laid low. Some notes are on the back. The triple twist for the firetool handle is made of three pieces of 1/4" round, doubled back, end welded, and then twisted tight. After forge welding to the handle, the four pieces are welded and drawn out to form the eye. finally, one turn reverse twist makes the pattern complete.

The quad twist is made of four pieces, two twisted right, two twisted left, although there are a lot of variations. Forge welded to the handle, and then very lightly forge welded into a square. I use Crescent Flux for the last weld, then to help remove any scale, soak overnight in a 10% muriatic acid solution. That really helps clean it up.

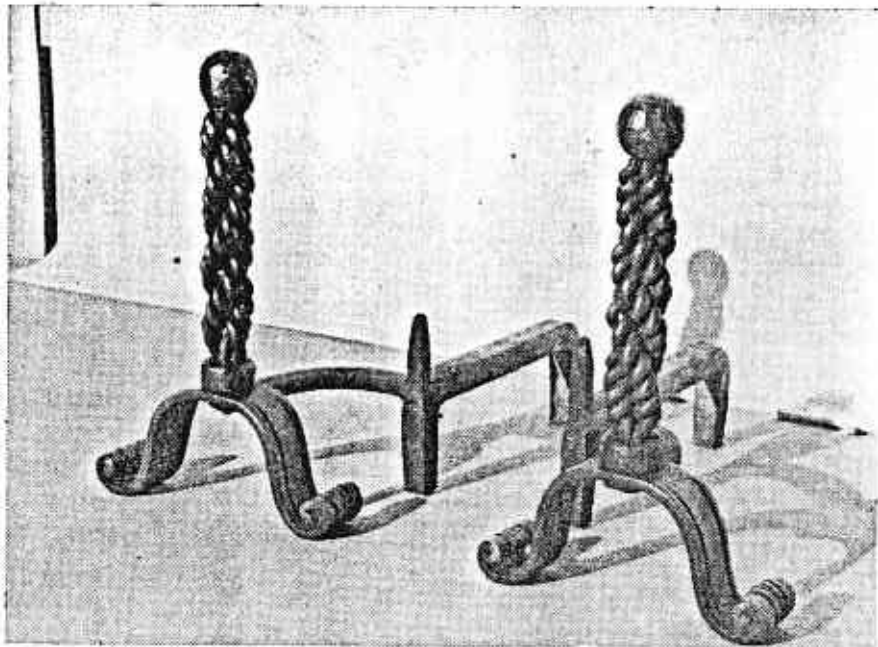
The andirons were of 7/16" round, the table legs of 3/8" round.



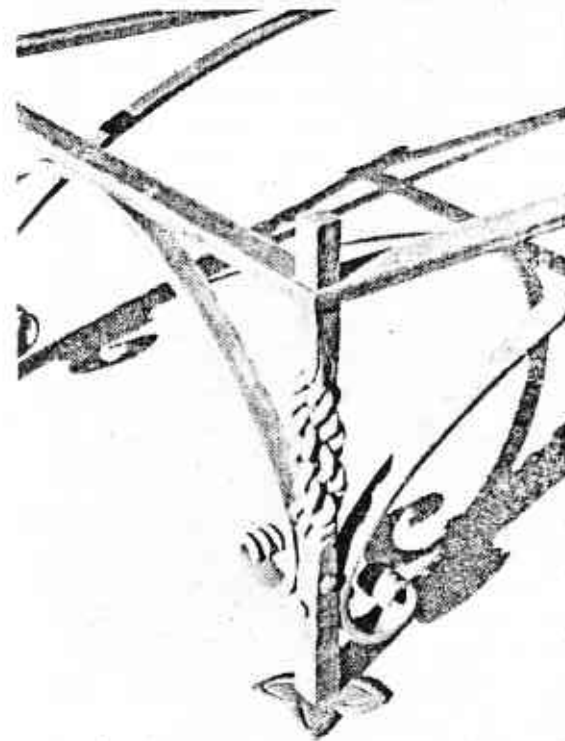
Left: Triple twist fire tool handle
 Center: Quadruple twist handle
 Right: Unique use of grooving tool



Fire doors and tools.



Triple twist andirons



Detail of triple twist
 Base for glass top table

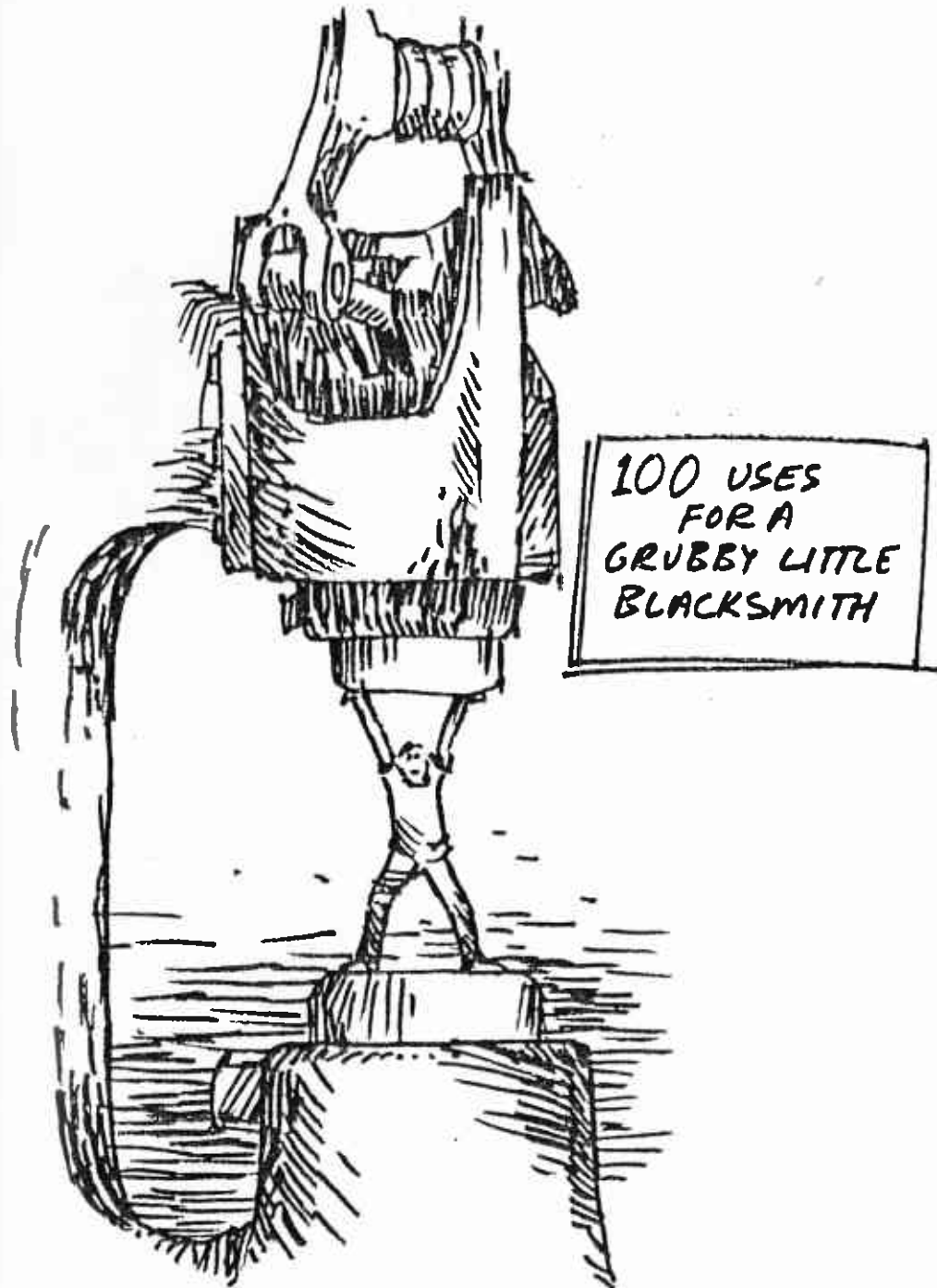
forge weld con't.

others, the heat varying according to the hardness of the steel."

"For illustration, we make a weld by uniting two pieces of steel together and we have had good success, as the weld represents one solid piece. Now we proceed to make another weld, and in exactly the same way as the first weld, the same welding heat is used and the same fire, but this time we do not meet with success for as soon as the hot steel is struck with the hammer, to form the weld, the steel flies to pieces (I hear the reader ask the reason, why), because the steel was heated to a higher heat than what the steel would stand, and the consequence is all the labor has been lost, the fault lies in not knowing the welding point."

"We could take wrought iron and make every weld at the same heat, but not so with steel, on account of it varying in hardness. And so in cases when the mechanic is in doubt as to the hardness or welding point in the steel, use this rule. Take a piece of the steel that is to be welded, heat it to a yellow heat, then place it over the edge of the anvil and strike it a light blow with the hammer, if the steel does not crumble or fall to pieces, keep increasing the heat until it does, this will enable anyone to test the steel for hardness, and so find the welding point or just how high a heat the steel will stand before crumbling or flying to pieces when making a weld."

"But although the welding heat is well understood, there are other things to consider, as we must have a clean fire with the coal well charred and all gas, sulphur, clinkers, ashes, etc., must be taken from the fire, to insure a solid weld."



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