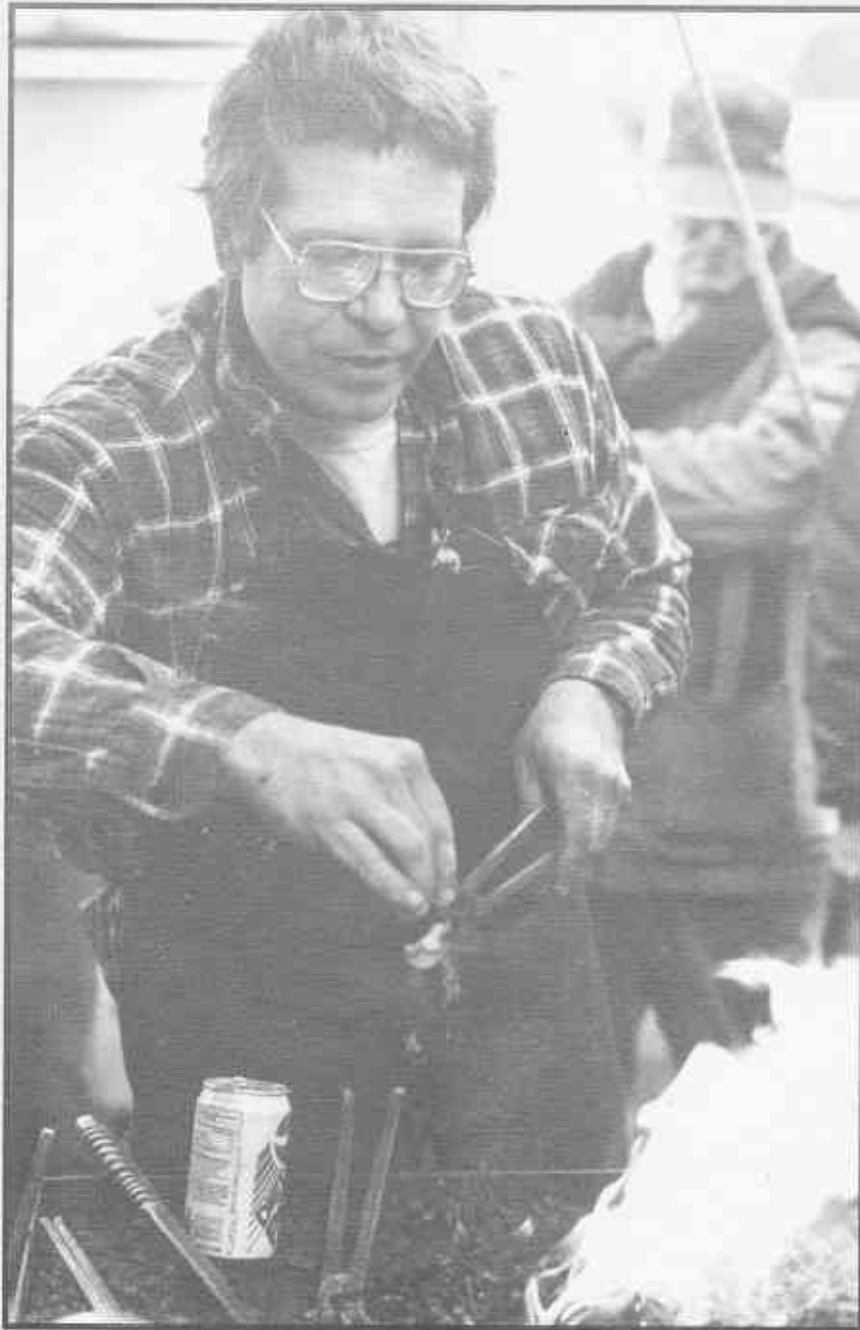


# RAM

INSIDE

*May—June 1994*

May meeting .....	8
Hand grenade twist.....	12
Trip hammer dies .....	14
Ozark Conference review.....	17
Next meeting.....	23



NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

## Contents

### Editor's anvil

**6** Welcome to all the people from other chapters who are reading this for the first time.

### Tom's turn

**7** Tom reflects on BAM's accomplishments during his reign as he makes way for the new prez.

### May meeting

**8** Steve Austin fed us well and hosted one of the best group of demos we've seen in a while.

### ABANA news

**10** Clayton has some welcome news — insurance for our dangerous past time.

### Hand grenade twist

**12** Don Asbee showed this interesting technique at our May meeting.

### Power hammer dies

**14** Here's good advice from the guy who bought the Little Giant factory.

### Ozark Conference

**17** Here's a review of the good time we had in Potosi.

### The new artisan

**20** A thoughtful piece by Jerry Hoffmann about where blacksmithing is heading.

### BAM news

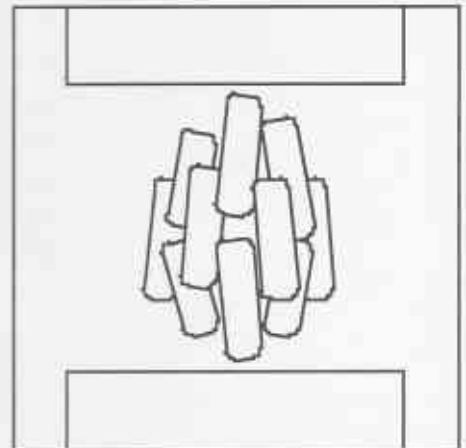
**26** Tim Ryan explains the monster he created and other happenings.

### Next meeting

**23** Vern Fisher wants to concentrate on the less glamorous aspects of knifemaking.



Page 8



Page 12



Page 17

# Newsletter of the Blacksmiths Association of Missouri

*Volume 11 No. 3*

**Our cover:** BAM's founding father Bob Patrick drew a big crowd as he effortlessly made forge welds at the cold and damp Ozark Conference. Photo by Jim McCarty.

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Jim McCarty

### Contributing Editors

Tom Clark  
Sid Suedmeier  
Tim Ryan  
Jerry Hoffmann

### Artist

Jerry Hoffmann

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Maurice Ellis

The Newsletter of the Blacksmiths Association of Missouri is published six times a year and is mailed to members of BAM. The annual fee for regular membership is \$20/year; a portion of this amount is for a subscription to this newsletter for one year. Editorial inquiries should be addressed to: Jim McCarty, Rt. 1 Box 20, Loose Creek, MO 65054 (314-897-4111). BAM membership inquiries should be addressed to: Steve Austin, 44 N.E. Munger Rd., Claycomo, MO 64119 (816) 781-1512). Occasionally some material will be copyrighted and may not be reproduced without written consent by the author. BAM welcomes the use of any other material printed in this newsletter provided the author and this organization be given credit.

MAY—JUNE 1994

## BAM Membership Application

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

Address: \_\_\_\_\_

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

Phone: (    ) \_\_\_\_\_ Zip: \_\_\_\_\_

New Member     Renewal

How did you learn about BAM? \_\_\_\_\_

Memberships are for one year from receipt of dues. Dues are \$20, which includes a subscription to the bimonthly BAM newsletter. Please make checks payable to Blacksmith Association of Missouri.

## ABANA Membership Application

Primary ABANA Chapter Affiliation: \_\_\_\_\_

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

Address: \_\_\_\_\_

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

Phone: (    ) \_\_\_\_\_ Zip: \_\_\_\_\_

New Member     Renewing Member

How did you learn about ABANA? \_\_\_\_\_

- Regular Member .....\$35 yr.
- Senior Citizen (Age 65) .....\$30 yr.
- Fulltime student .....\$25 yr.
- Overseas airmail .....\$70 yr.
- Overseas surface mail .....\$50 yr.
- Contributory .....\$100 yr.
- Public library .....\$25 yr.

*See reverse*

# BAM

*Send this form in an envelope with your payment to:*

**BAM, c/o Steve Austin,  
44 N.E. Munger Road,  
Claycomo, MO 64119**

## **Officers:**

**President  
Tom Clark**

**1st Vice President  
Pat McCarty**

**2nd Vice President  
Maurice Ellis**

**Secretary  
John Murray**

**Treasurer  
Steve Austin**

I \_\_\_\_\_ hereby apply for membership in the Artist-Blacksmiths' Association of North America and enclose \$ \_\_\_\_\_ as my annual membership dues for one year.

MasterCard           VISA           Check/Money Order

Card Number 

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Exp. Date (Required) 

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Checks must be in U.S. currency

**SEND RENEWAL TO:**

**ABANA**

**P.O. BOX 1181, NASHVILLE, IN 47448 (812) 988-6919**

**Dues Distribution:**

**1 year subscription Anvil's Ring: 68.5 % \$24**

**Adm. offices & other ABANA projects (Conferences, etc.): 31.5% \$11**

The Blacksmiths' Association of Missouri is a chapter of the Artist Blacksmiths' Association of North America, and is devoted to the preservation and advancement of blacksmithing and to communication among blacksmiths in Missouri and surrounding areas. BAM's newsletter's goal is to support these aims. Letters to the editor, tech tips, tools for sale or anything else which furthers these ends will be considered for publication.

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## Editor's anvil

Assuming I get this thing done on time, this issue will be a part of the registration packet put together for the ABANA Conference. So I guess it would be in line to say welcome to Missouri to the members of other ABANA Chapters who are seeing our newsletter for the first time.

BAM is a pretty progressive bunch of blacksmiths for a bunch of hoot and holler hillbillies. We put on a nice conference every spring. We've held workshops to build side draft forges and treadle hammers, we keep ourselves supplied with coal and we have a stable full of top-notch blacksmiths who aren't shy about showing their skills at our meetings.

If you like what you see in this newsletter why not join us? There's an application included in this book and the cost is just \$20 per year.

How did you all like the Ozark Conference? We had a good turnout in spite of the nasty weather and the demos were great. My only complaint was I wanted to be in many places at one time. It was a real honor to be one of the demonstrators.

I wasn't the only new face in the crowd — Phil Cox did his thing (rather nicely too) and this was the first time I saw Andrew MacDonald at the forge.

The May meeting was a good follow up to the conference. I think it was the best meeting we've had in a long time at least as far as the demos went. We had people lined up all morning sometimes two deep at the forge, then Jerry Hoffmann capped the day with a hammer forging. It was a truly cosmopolitan crowd, with folks from Nebraska, Oklahoma and Kansas in attendance.

Along the way we elected Pat McCarty president, and I had to drive back to Loose Creek with his swollen head in my truck. Newcomers take note: When I first started going to these meetings Pat was a novice. He hung out in the back of the crowd and wouldn't go near the forge.

He took good notes though on what he saw and when he found the time he practiced a lot. For the past

year or so Pat has been doing his share of the demos, he's making a little money on the side and he's a regular Picasso with a railroad spike.

It seems fitting that the guy who works for the phone company and gets a discount on his bills should be our next president. My guess is he will slow things down a bit so we can catch our breaths and will work to make our meetings more meaningful for the variety of folks who make up BAM.

Let's all give him our support and keep this thing growing. As Clay Spencer would say, "Blacksmithing is ALIVE in Missouri."

Many thanks again for the scholarship presented to me at the conference. I think I've come a long way in the past two years but lately nothing has been going right. I could sure use a refresher and may get it the week of July 4. I would like to venture back to the folk school for Jerry Darnell's Colonial Lighting Workshop.

Will let you know how that one turns out. For the rest of you scholarship winners, don't forget part of your pay is an article for the newsletter!

My *Rural Missouri* travels led me to another BAM member recently — Preston Williams. If you get *Rural Missouri* you got to read about Preston and his dad, who are two of the last remaining people who can build a carriage from the ground up. They had several fine examples of their work to show me.

I was most impressed with the tools they have to work with. Preston's the only one I know who uses a micrometer to do woodworking!

I think we should rope these two into building a wheel at the next Ozark Conference. If you haven't seen it done, you will be amazed at all the steps that are required. The part I missed was the fitting of the iron tire. How about it Preston?

I also got to say hello to Vernice Stevens from Dexter at the Ozark Conference. My inlaws are within spitting distance of him, and I've been meaning to give him a call after I've

done my duty and made small talk with the kinfolk. Vernice said come on over so I will.

Hope you all enjoy the ABANA Conference. Let me know what impressed you there for the July-August issue.

One final thing before I give it a rest — thanks to all of you who got your new addresses to Maurice and your dues to Steve. If you haven't been getting your newsletter those are the two obvious reasons why.

Last month I had five newsletters returned by the post office. Since it was a bit late getting out I know those folks missed the meeting. Please get your dues in (see your mailing label on the back cover for the expiration date) and get your correct address to Maurice if it's not right on this issue.

It will sure make my job a lot easier if I don't have to find the post office this time around.

—Jim McCarty, editor

*Dear Jim,*

Dick and I had such a good time at the conference — Dick urged me to drop you a line about my thoughts as an observer. (However the demos were so fun and interesting, maybe I'll become a "doer" instead of an observer!)

Anyway, if you'd like to use these notes, here's some "stuff" for the newsletter.

*Under the Spreading Chestnut Tree  
The Village smithy stands  
The smith a mighty man is he  
With large and sinewy hands*

These words from the well-known poem came to mind as we embarked upon the third annual BAM conference recently.

Last year my husband and I ventured to Potosi for our first visit to the BAM Conference. Having no idea of what to expect we were like a couple of children anticipating our first circus. We were not disappointed! The demonstrations were very interesting and educational. Everyone was very hospitable and we felt right at home and had a great time. I must admit, however, I was somewhat surprised to learn my husband wanted to fill the trunk of our car with coal. I was assured that in order to turn out wonderful projects he had to have that coal! And so he got it.

We looked forward to this year's conference with great anticipation. And, once again, we were in for a real treat. The demonstrations were excellent, the hospitality shown by everyone was warm (the weather wasn't) the food was wonderful and the auction once again had us rolling in the aisles!

As an innocent bystander, I heard bits of "blacksmith wisdom" during some of the demonstrations, such as Doug's observation that "all men are created equal while standing waist deep in cold water."

This year we didn't load the truck with coal — it was a forge! My husband had been in touch with Lou making arrangements to pick up a forge made by Lou and friends. And, of course, we had to fill any empty places in the truck with books, tools, shirts, mugs and a couple of real nice

items from the auction.

So now we're back home — crabby this week cause we have to go back to work instead of being in Potosi. My husband has ideas galore of wonderful projects to make as a result of the demonstrations from the conference. He's excited to try out

the new forge.

We appreciate all the work put in the conference by everyone and will look forward to next year's conference to once again renew old friendships and make new ones.

*Sincerely, Joann Nietfie*

## Tom's Turn

The last weekend in April is usually some of the most pleasant weather you could wish for. However, for the last three years the Ozark Conference has been rain, cold weather or both. What can you say, "Next year will be back to normal?" Even though it was cold and wet the spirits of those in attendance was high. Chairman Stan Winkler had five demo stations going full blast and there were very few people milling around.

Thanks to everyone who donated items and to Tim Ryan for graciously placing those items in the hands of eager buyers. Our auction was a success, enough in fact to pay all the cost of an otherwise free conference. A big thank you Tim and those who donated or bought those pieces of art.

I was so pleased to get Pat McCarty's trunk. It now has a permanent home at the foot of my bed. Pat said he made it big enough to hold all my money. Thelma said the now empty trunk would have been about right if I'd quit buying "rusty stuff".

Hank Knickmeyer donated two pieces of his mosaic Damascus and they were very popular (brought a couple of hundred bucks each). Thanks Hank and to everyone else who donated.

Jim Ryan (no relation to Tim) editor of the Hammers Blow was kind enough to accept our invitation to come and cover the event for ABANA's two publications. He has written a good accounting of the activities that will be in the next Anvil's Ring. Thanks for coming Jim, we enjoyed your visit.

Each year we have tried to do things a little different with the Ozark and next year will see some new things as plans are already being made, so mark you calendar now for the last weekend in April of 1995. It will be here before you know it, so make the commitment now.

Our May 21 meeting at Steve Austin's was well attended, 45-50 people (small by BAM standards) but good for a meeting so far away from the population center. There were great demo's all morning and a good

business meeting, with lots of discussion on the subjects of how far east and west we can go to have regular meetings. While there is no restraints with regard to geographic boundaries for chapters, spreading out too far imposes a hardship of travel when we go to the extreme east or west. None the less, we have strong ties to our long time members in western Illinois and eastern Kansas. Future support will be given to those people as if they were in the geographic center.

While BAM officers are generally elected at our July meeting changes were made to have them elected at this meeting. The main reason was so the new president elect would be known at the ABANA conference.

The afternoon at Steve's continued late in the day with more good demos. It was my pleasure to again strike for Jerry Hoffmann. He made a handled hot cut, and what a nice one it was. Two years ago he made a hot cut from Bethlehem non-tempering tool steel that has come to be my favorite cutter. I've rounded the top or struck end and use it for shaping leaves and other hammering requiring a round head.

This issue will end my term as president of BAM. It has been a quick term wherein a lot of water has run under our bridge. The changes that come with any new president can never be accepted by everyone and to the members of the old guard that wanted things to stay the same I make no apology. You see anything, be it human or other matter, that remains unchanged grows stagnant. I have often been called a person that likes to stir things and to that I plead guilty. You see I am a gardener and I love to feed my garden rich compost. Life can be like a compost (full of manure) but if stired at the right time and for the right reasons you get a rich product with only a pleasant smell. However, if something comes along that stinks and is left alone the end product will be just another pile of manure.

BAM has grown from well under 100 members to over 300, has established one of the nation's best regional conferences, started an aggressive scholarship program, and is hosting

what promises to be the largest and hopefully the best ever ABANA conference.

For the most part a lot of people have grown closer together and most of the old guard that didn't want to see change are now in the thick of things. My best wishes to Pat McCarty our new president to be. He's a likable guy and he will have my full support.

The more an organization like BAM or ABANA wants to do, the more it has to tax its membership. It's how that taxation is done that makes the difference. While the dues part is important it is not possible to get enough people to join if those dues are too high. Generally speaking annual dues are based on actual cost of basic functions, newsletters, mailings, and supplies.

But if you want to go beyond the basics and have real activities that foster learning more funds are needed. I call this volunteer taxation. It happens when people are motivated to give of their time and money. When one gives an item for iron in the hat, a piece for an auction or an hour of your time to prepare for an event, work at an event, write an article for the newsletter, and the list goes on.

For the most part people are satisfied with just paying their dues and attending events when convenient and that's OK, but the few who are always there and have something or some time to give reap the real rewards.

This year's ABANA Conference has put to the test the commitment of those BAM members who have decided to get involved. The demands on their time have been heavy. The results of their efforts will be unfolding as you read this.

BAM has decided to print enough of this issue to include one in the registration packet. Additional information about the conference will be included as well as regular BAM activities. We hope everyone attending the conference enjoys it. It's a small thank you for helping make the St. Louis Conference an event to remember. Thanks for coming.

— Tom Clark

# BAM MAY MEETING



Above: Steve Austin did a rare demo with his leaf veiner. He makes hundreds of leaves for use on his gates and railings.

It's hard to remember when we had a meeting so full of demonstrations as the May gathering at Steve Austin's Claycomo forge. Things just seemed to fall into place. No one was shy and the demonstrators lined up, sometimes using both of Steve's big anvils as a crowd of 40 or so looked on.

Don Asbee started things off by forging a trade item (anything with a leaf). Don showed us how to make a big leaf on a handle and then bent the leaf over on itself so that it formed a hook to hang the handle on.

When Don was finished the host pulled a laser cut leaf from a 5 gallon

bucket full and showed how he finishes these up for use on gates and railings. Steve draws them out wide and fullers them with the cross pein for veining, then pounds them under a top and bottom die for a quick bit of realism.

Don Asbee wasn't done, however, and he joined Stan Winkler at the forge for another demo. Stan made a quick patch knife and flint striker out of a file, leaving a few file teeth to show what it came from. Don put Tom Clark to work striking while he ran a fuller down all four sides of a piece of 1 inch tubing. We could only guess what Don was up to.

With the piece collapsed into a flower, Don let it cool and then notched the piece all the way around at about 3/4 inch intervals. Then he got it hot and stood it up under Steve's Beudry hammer to collapse it that way. The result was a neat twist that Dr. Iron named the maggot/hand grenade twist.

Tom Clark joined the fun with his classic rendition of a poker with twisted handle and a leaf pointing the way towards the business end. Then Jerry Hoffmann took over and showed us what to do with channel iron, forming a nice scroll forge welded to a piece of 1/2 inch square. Jerry dropped the 1/2 inch on the way to the anvil and still got a good weld out of the heat! He also showed the rivet demo from the *Journal*. Pretty fancy, but simple, stuff.

Pat McCarty had a turn too, showing another wizard out of 1 inch stuff using a matched set of Steve's punches that looked like a comma for the face. It turned out pretty good, showing there's always something new to be learned.

Jerry wasn't done. He came back in the afternoon and teamed up first with Don Asbee and then with Tom Clark to forge a pair of hot cuts.

Before the business meeting we pigged out on Steve Steffens barbecued chicken and roasted corn on the cob and Kelly's pasta salad and strawberry shortcake.

It was tough staying awake for the business meeting, but we managed to cover a number of items (see minutes) and then elected new officers.

Pat McCarty will be the new president, Maurice Ellis moves up to first vice president and Tom Clark stayed on the board as the second vp. Both Steve Austin (treasurer) and John Murray (secretary) were voted back in to their jobs.

There was a good turnout for the trade item. Pat made a railroad spike flower and leaf. Walt Hull did a bamboo shoot and leaf. Both Jim Kendzora and Ed Harper showed they've been practicing leaves. There was even a rare John Murray piece that was made out of small stock. Doug had a trade item but it had no leaf on it — he probably broke his off on the last hit! Phil Cox made a nice plant hanger he learned at the Ozark Conference. And Don Asbee turned his leaf demo into a dandelion killer. Could have used that one.

Thanks Steve for one of BAM's better efforts.

## Minutes

Coal situation discussed — The flood hit the coal pile located at Lou's shop. We talked about how much was needed for the ABANA Conference and decided there was more than enough there. We also considered a new site for the coal. The location would need space and a fork lift for unloading. Nothing decided.

Pat reported on the conference in Lou's absence. He said 334 were registered including 84 spouses.

Tom mentioned the new ABANA insurance policy for conferences and meetings. Details to come in near future. Corporation status for BAM came up. Steve to do more research to see where we are.

Tom brought up topic of having another Illinois BAM meeting or moving the Illinois meeting from Ken Markely's shop to Mt. Vernon, Ill.

Jim McCarty reported on plans for the state fair. Tom Clark offered his portable shop, as has Ray Chaffin.

Tom mentioned Jim Ryan's article on Ozark Conference in the *Anvil's Ring*.

Meeting adjourned to election. Results went as follows: Pat McCarty nominated for president. No other nominations so he wins by acclamation. Maurice Ellis nominated for first vice president. No other nomina-





*Above: From right, Marty and Phil Cox, Pat McCarty, Doug Hendrickson and Dan Siglar contemplate new uses for Don's twist and decide that it's OK to use power tools.*

tions so he wins by acclamation. Lou Mueller, Tom Clark, and Todd Kinikin nominated for second vice president voting went as follows: Todd, 7, Lou, 5, Tom, 8. Tom elected by 1 vote. Steve Austin nominated for treasurer. No other nominations, wins by wild acclamation. John Murray reelected secretary in similar fashion.

Elections closed.

Tom discussed possible changes in bylaws to keep president from making uncontrolled wild decisions. Phil Cox suggested change in bylaws to keep past president on the executive committee.

Tom brought up local hammer-ins in the future (after the conference.) Doug Hendrickson and Don Asbee will probably sponsor a skillet making workshop in the early fall.

Meeting adjourned to trade items and iron in the hat.

#### **Iron in the hat**

- Don Asbee, hand grenade twist (2)
- Stan Winkler, knife from a file
- John Murray, bowl
- Sid Suedmeier, tongs
- Phil Cox, plant hanger, pencil holder
- Ed Harper, fork
- Jerry Hoffmann, scroll demo
- Pat McCarty, wizard, leaf and flower
- Tom Clark, poker
- Jim Kendzora, towel holder



*Left: Stan Winkler travelled all the way from Ste. Genevieve to show us how to make a knife from a file. Here's a wild thought — what if Longfellow would have spied Stanley under the spreading chestnut tree when he wrote his poem?*

## ABANA President's Message June 1994

How long have we all been waiting for an ABANA Insurance Program? Wait no more, because several days ago (as of the time of this writing) the ABANA Board approved a group insurance plan that has been seven months in the making! This plan will not cost the ABANA membership one red cent more in membership dues — those who want this cost effective coverage can pay for just exactly what they need. The plan, which will be available to both the Chapters as well as any individual in ABANA who owns a blacksmith or metalworking shop, will be unveiled at the June ABANA Conference. If you are not going to the conference, make sure that those who are going get all the particulars for your Chapter. Representatives from Aetna, who underwrote the program, and Industrial Coverage Corporation, who worked with us to come up with the plan, will be there. We are proud and excited to be able to provide this badly needed service to our Chapters and members. Certainly, this plan will also be a breath of fresh air to our professional members as well, who will benefit greatly from the low group rates.

So why is insurance for Chapters so important? It is simple to understand why the professional members require insurance — it is a matter of survival and protection. The same holds true for the Chapters, and perhaps to an even greater degree. There are more hobbyists and amateurs in the Chapters. There are a wider variety of situations that the Chapters find themselves in, and most of those situations involve exposing more people to hazards than a professional would; although that exposure is for shorter periods of time than a professional is exposed.

Our new ABANA Insurance Program is the latest in a series of moves designed to provide our membership with more of the services they need. We have upgraded our Scholarship Program. We added a second publication for our North American members, the *Hammers Blow*. We had our first-ever exhibition for ABANA members outside of a conference, at the National Ornamental Metals Museum, and are planning another. We started the National Endowment Trust for Artistic Blacksmithing, which may be used as a safe and effective method for those who wish to make donations or bequests to promote Blacksmithing in the future. Very shortly, we will announce some changes and additions to our ABANA Video Library that I'm sure you will appreciate. How are we doing so far? Let us know at the ABANA Conference, we want to hear it from you!

All this has been possible because ABANA is growing. We very much appreciate the confidence you have shown in your support of our organization. Spread the word! ABANA is already the largest blacksmithing organization on the planet; and with your help and support, you will be amazed at what we can accomplish together.

Insurance does provide you with protection. But our Chapters that are incorporated enjoy an extra measure of protection that those who are not incorporated cannot have. If your Chapter is sued, and you are not incorporated, the complainant can go after your officers, your members, and the family dog. If you are incorporated, they can only go after the assets of the corporation. Which spot would *YOU* rather be in? Board member Hans Peot will have information on Ohio incorporation at the Conference. Of course, all states are not the same, but it will give you an idea of what is involved. Please, consider incorporation for your Chapter. It is a small price to pay for peace of mind.

See you at the Conference!



Clayton Carr  
ABANA president

# ABANA Liaison

## Atta' boy!

To Lou Mueller who has given a year and a half of his life and livelihood to Chair the ABANA Bi-Annual Conference in St. Louis in June through literally flood, famine and pestilence —and to the membership of the Missouri Chapter (BAM). This is a labor of love!

## Product liability

Nearly every state has adopted 402A of the Restatement, Torts 2nd in one form or another. That basically means that you are the "Guarantor" of the safety of your product and you will have to pay for any damages caused by a breakdown whether you were negligent in its forging or not.

Example: You accept an order for a damascus muzzle loader barrel for a friend. After the pistol he builds blows up blinding him while using it, the metallurgical labs diagnose a microscopic weld fault in one of the 1200 layers and sell their opinion to your blind ex-friend's lawyer that your barrel was dangerously defective.

You're "absolutely" liable! Worse news, your homeowner's insurance will almost certainly deny coverage because you sold the barrel and they don't cover business enterprises. Even if you do have a small-business endorsement rider, it probably doesn't include "Products Liability". Check your insurance and don't sell anything that could be conceivably dangerous if it breaks until you're covered.

Plan to attend the Legal Liability Seminar scheduled in St. Louis at the ABANA Conference.

## Insurance through ABANA

Last night (May 12, 1994), the ABANA Board approved a package from Aetna Insurance Company for ABANA Chapters and for ABANA members' private shops. We expect savings of up to 50 percent on individually purchased coverages. It is a modular package, allowing members and Chapters to opt into various coverages. Every Chapter will want Public Liability (somebody's hurt by a loose hammer head at a Chapter event) and Medical Pay (pay anybody's medical expenses who is hurt at a Chapter event, whether it was anyone's fault or not).

Chapters who own forges will want to opt in on Property and Equipment coverage for theft, fire, etc., including a choice of cash value or replacement cost. It has an option for Products Liability and even a manufacturer's policy to protect the vendors of ABANA members who have big production operations.

There will be a table with descriptive materials, rates and someone to answer your Chapter or private shop questions at the Conference in St. Louis.

The ABANA Central Office will probably not have the materials to send out until after the ABANA Conference. If you don't have anybody going to St. Louis — send your interest to the ABANA Office for a waiting list and Janelle will send out the information when she has it.

Now! Ask me, "What has ABANA done for me lately?"

## Thank you

Thanks to all the ABANA Chapters who faithfully reprint these important messages for the national office. We rely on your newsletter editors to get the word out whenever possible.

Change of Officers? If you have a change of name and/or address for your President or Editor, please drop us a postcard with the information so we can update our list.

John Pollins III  
Chapter Liaison Committee Chairman  
RD #5 Box 154, Greensburg, PA 15601



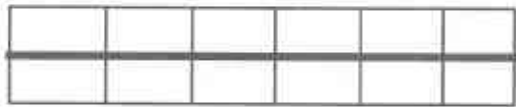
# Don Asbee's Hand Grenade Twist

Don showed off this unique twist at the May BAM meeting. It would make a neat handle or a balluster or maybe even a salt shaker if the center was drilled out.

1. Start with a piece of 1" tubing long enough to hold

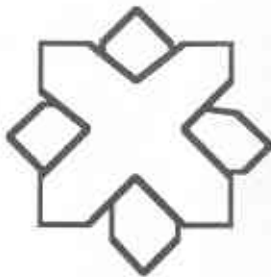


2. Fuller all sides until it looks sort of like this



3. Let it cool and then cut at 3/4 to 1 inch intervals to an even depth with a hacksaw or chopsaw on all four sides to isolate rectangles. Don't cut too far!

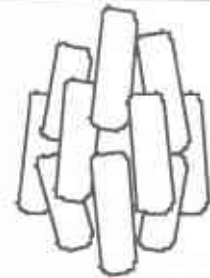
4. Clamp in a vise and twist every other segment until points are 45 degrees off center. Cut off the longest length that will fit under the power hammer. (2-3 ")



Note: All work is done hot except for step #3.



5. Now heat and squash under the power hammer until the segments slide past each other



Darrell Clymer is looking for a 25-50 pound Little Giant hammer, condition not important but a reasonable price is. Call (816) 539-2667 or (816) 930-3498.

For sale: small forge, complete with hand crank blower. Excellent condition, completely restored. This would be a good size to move in and out of the garage. \$95. Contact Joe Wilkin-son at (314) 943-6779.

Preston Williams is looking for a very large wagon tire bender. He could also use a Delta Unisaw or similar table saw. He can be reached at Box 272 A, Madison, MO 65263 or call (816) 291-8740.

Large Winner sheer, with arm. Similar to Edwards. \$100 or trade? I also have a post vise for \$40, a Champion 400 blower for \$45 (perfect) and a champion fire pot for \$40. Contact Jim McCarty (314) 897-4111.

For sale: Quenching oil, linseed oil and way lube, super sticky stuff for lubing machinery ways, great for power hammers because it won't fly off. Call Pat McCarty at (314) 239-3814.

For sale: 25-pound Little Giant hammer, completely rebuilt, \$2,000. Jim Hunt, 230 NW 11 St., Warrensburg, MO 64093 or call (816) 747-7965.

Tom Clark will have his warehouse supply of hammer handles available at the ABANA Conference. If you can flag him down ask him to show off the new thin line of handles.

*The following ads came in response to the ad I am running in Rural Missouri. If you contact them mention you heard about it from Jim McCarty.*

For sale: Champion Blower, No. 400, marked Lancaster Forge Co., Pat. 1902. Contact Larry Allison, Rt. 5, El Dorado Springs, MO 64744. Don't know what it's worth, make offer.

Champion Post drill restored to mint condition, \$75. Richard Smith, Rt. 4 Box 510, Salem, MO 65560.

## SIU Gallery *These pieces were forged by students at the nation's only blacksmithing university*



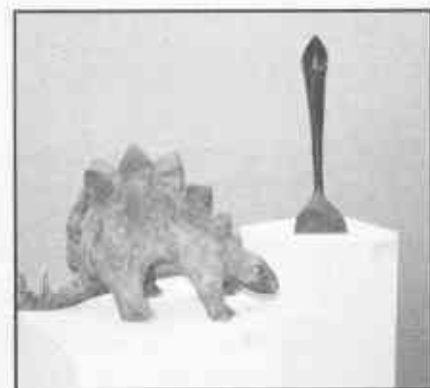
*Table made by Andrew MacDonald. rings were forged by fellow students.*



*Above: Large piece by John Medwedeff shows his bold, free-form style. Right: Dinosaur by Michael Saari, sculpture by Neil James.*



*Above: Ball and chain, dragon by Larry Lustfeldt. Fireplace tools by Jorgen Harle. Sculpture by Neil James*



# Power hammer die keys

*Do it right the first time and your dies will stay where they're supposed to for a long time*

by Sid Suedmeier

Before I get started into this subject, I want to make one thing very clear. What I am going to share with you is not, or never will be, the final word on die keys, but we have to start someplace. This information has been accumulated from working with Fred Caylor, practical experience and from talking with many of you who work with these machines. All of my experience has been with Mayer Bros/Little Giant but will still pertain to many other brands of power hammers.

To begin with, the old key and die need to be removed. This in itself can present some real problems, depending on what previous methods have been used to keep the die in place. We will discuss only the standard single key as the alternatives that have been tried are a whole story in themselves.

To remove a standard key that is not all battered up, we use a long chisel that has been ground thin to reach behind the die. The end needs to be squared off to present a good contact for the driving area. After you have the chisel ground to suit you, give the small end of the key a good hit with a medium size hammer, 4 to 6 pound.

Do not tap with a small hammer as this tends to swell the end.

The use of penetrating oil and heat can also be very helpful. I have seen some dies that defy all methods and have to be literally blown out with a cutting torch. Once the key and die have been removed we are ready to check the dovetail and die for any repairs or modifications that may have to be made to insure proper fit.

At this point we need to check the condition of the dovetail and floor the die sets on. The floor needs to be flat. Many times the die will be hammered into the bottom. This needs to be corrected. For minor erosion, flat filing will take care of it, but for major damage, other methods will be needed which can include welding and machining.

The sides of the dovetail can generally stand some shaping up, again a good flat file can be utilized. Care should be taken to not modify the angle of the dovetail. You want to achieve a good straight, smooth surface so as much contact as possible can be obtained between die, dovetail and key.

At this point we need to measure the dovetail to check for taper from end to end. The factory machined 1/8th inch per foot of taper into the dovetails. It is generally set up with the small end to the left and the large to the right. It needs to be checked and verified. The saw block could have been turned on

models so equipped causing it to be the opposite.

The dovetail in the rams is generally not tapered from side to side.

The die also needs to be checked for the same taper. On the new dies that we make the ends are marked W for wide and N for narrow. Set the die into the dovetail with narrow end into the wide end. This creates a natural taper into which the die key will be fit.

The die is usually positioned to the front of the dovetail with the key going into the rear. Variations of this are found on some machines. It can also be changed in order to position some dies for proper relationship to each other.

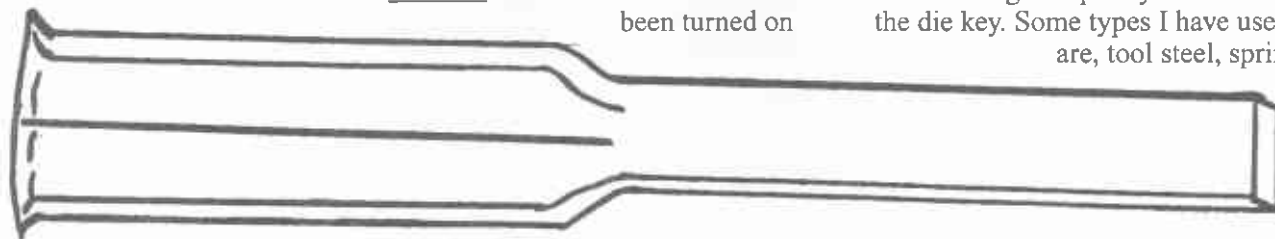
Check the corner of the die for proper radius so it does not keep the die from seating squarely. The angle at the point where the die contacts the front of the dovetail should be compared with the angle of the die, they should be the same. This creates two parallel surfaces that should contact each other squarely. Minor corrections can be made with the file or small grinder. Proceed slowly with corrections — this fit is very important.

Move the die to the key side and check for the same fit. The angles should be the same or it can be a little wider at the bottom. It can not be wider at the top as this will cause the key to "squirt" up out of the dovetail as it is driven in.

If the floor of the dovetail has been lowered in the truing up process, the ledge of the die dovetail needs to be checked to make sure it does not hit the top of the dovetail before it is setting squarely on the bottom. Grinding for additional clearance will correct this problem.

Once you are satisfied that you checked all the above, we are now ready to start on the key itself.

Select a good quality material for the die key. Some types I have used are, tool steel, spring



**Long Chisel**

Grind long blade to reach behind die. Keep end square to prevent swelling of end of key.

steel, or other comparable types. It should not be too hard as it needs to conform to the minor irregularities. Measure the opening the key will fit into. Let's say the small end is 3/8 and the large end is 5/8. Start with material that is at least 5/8 inch thick and the width to cover the dovetail/die face. I always make it at least twice as long as needed for ease of handling and trimming later. I shape the taper to the key with a belt grinder with a 50 grit belt.

They can also be forged to a rough shape before grinding. Once you get enough taper to start fitting, coat the two surfaces the key will be contacting with Prussion Blue. This is used in many close tolerance fitting applications in machine shops and garages.

The Permatex brand is part number 35V. Most auto parts stores should be able to order for you if they do not have on hand.

Insert the key into the opening and tap in lightly, drive key back out with chisel and notice the contact area as indicated by the blue left on the key. These are the high areas that need to be removed by grinding. Make corrections in both the long taper and the top to bottom dimension. The goal is to achieve at least a 70 percent to 80 percent overall contact area. Take it slow, stop to check often. I always mark my key so it is certain that the same side is always up, also good for later reference when changing dies.

Continue to check and grind until the key will extend to at least the far end of the die. Watch the contact area closely. I have seen dovetails broken because of small contact area exerting all the force into a very concentrated spot. Extra time here can save you time later.

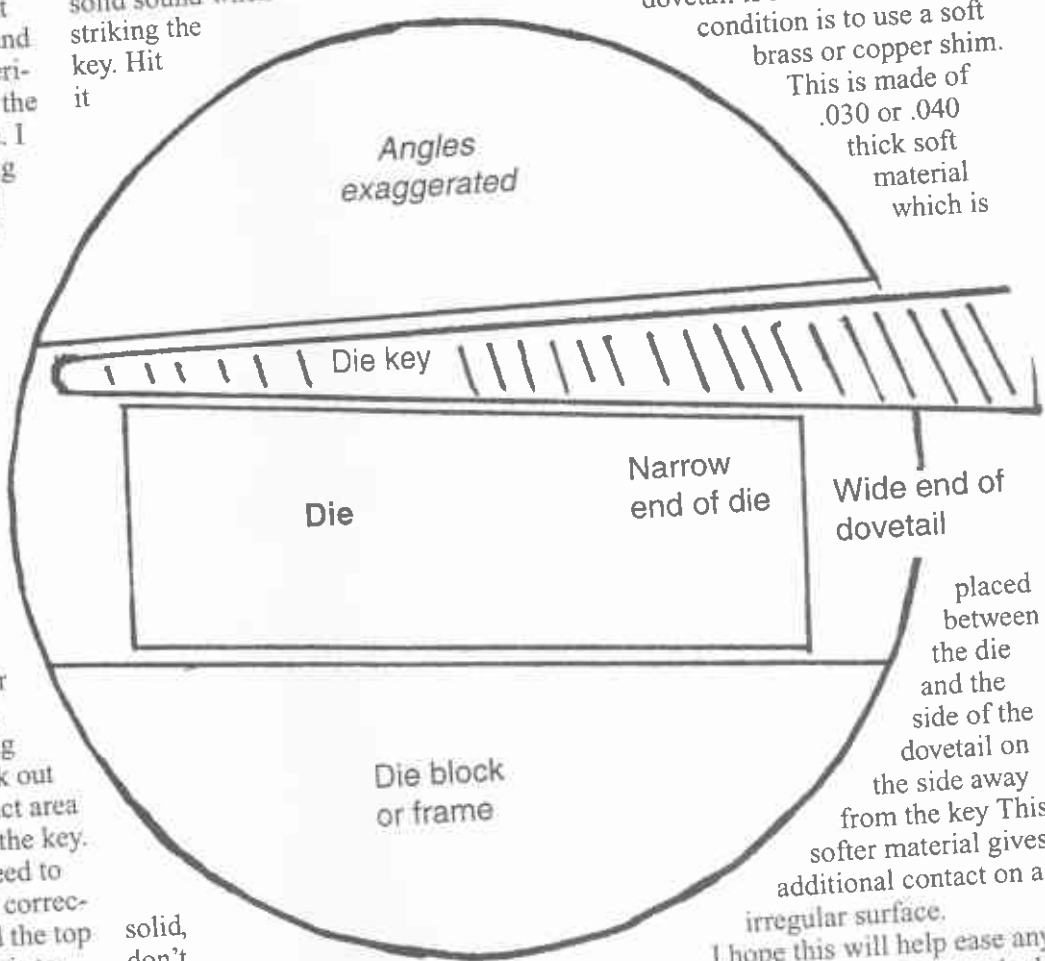
Trim the key to length, leaving some on the large end to allow the key to be driven in as the key conforms. Chamfer the end generously, especially the small end, so it does not swell up when driven.

Drive the key in,

again using a 4 to 6 pound hammer. If properly fit it should drive to a certain spot and you should get a definite solid sound when striking the key. Hit it

minutes of operation the key should be seated and need very little attention for quite some time.

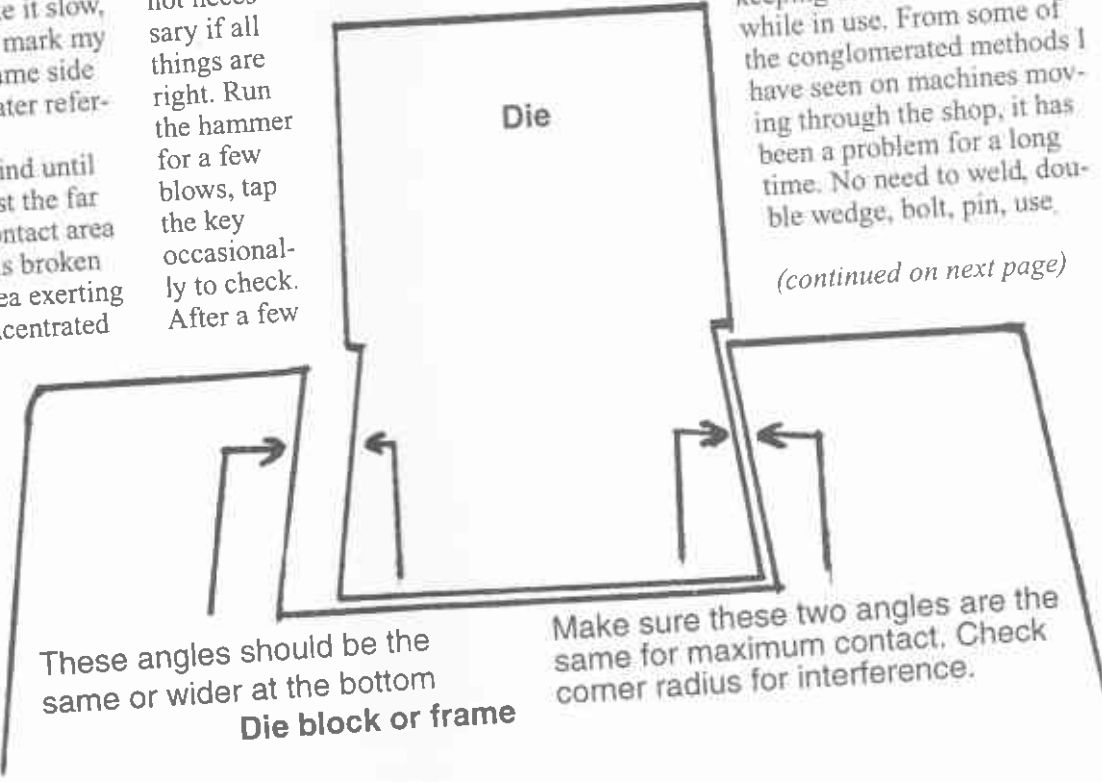
Another little trick if the side of the dovetail is not in real good condition is to use a soft brass or copper shim. This is made of .030 or .040 thick soft material which is



solid, don't overdue it, it is not necessary if all things are right. Run the hammer for a few blows, tap the key occasionally to check. After a few

I hope this will help ease any problems you may have had keeping dies from moving while in use. From some of the conglomerated methods I have seen on machines moving through the shop, it has been a problem for a long time. No need to weld, double wedge, bolt, pin, use.

(continued on next page)



## Last of the 100 pound Little Giants

So you thought all the Little Giants were gone, leastwise the bright shiny new ones fresh from the factory.

Well guess again — Sid Suedmeier, the man who bought all the Little Giant spare parts, has done it again.

Sid bought four 100 pound Little Giants at a U.S. Army surplus sale held in Rock Island, Ill. He says there were nine hammers total at the sale.

His four have never been used. Three were still in the crate. One had the end panel off so you could see what was inside. The other two are complete mysteries.

The one that was unpacked never had the dies installed and has never been used. But true to army form, it already has its second coat of paint.

You can be in on the grand opening of one of the 100 pounders if you attend the 1994 ABANA Conference to be held in St. Louis June 14-19. Sid has offered to bring one of the rare finds to the conference, unpack it and set it up for use at the conference.

If you want to buy one of these hammers, there are two still for sale at \$6,800. (Sid is keeping one and one has already been sold.) Until he opens them he is not sure what year they were made in.

For more information contact Sid at Little Giant Automotive, 424 Corso, Nebraska City, NE 68410 or phone (402) 873-6603.

Incidentally, I asked Sid what he liked to forge and he said he's not a blacksmith! Guess he just likes his heavy collection.

*(continued from previous page)*

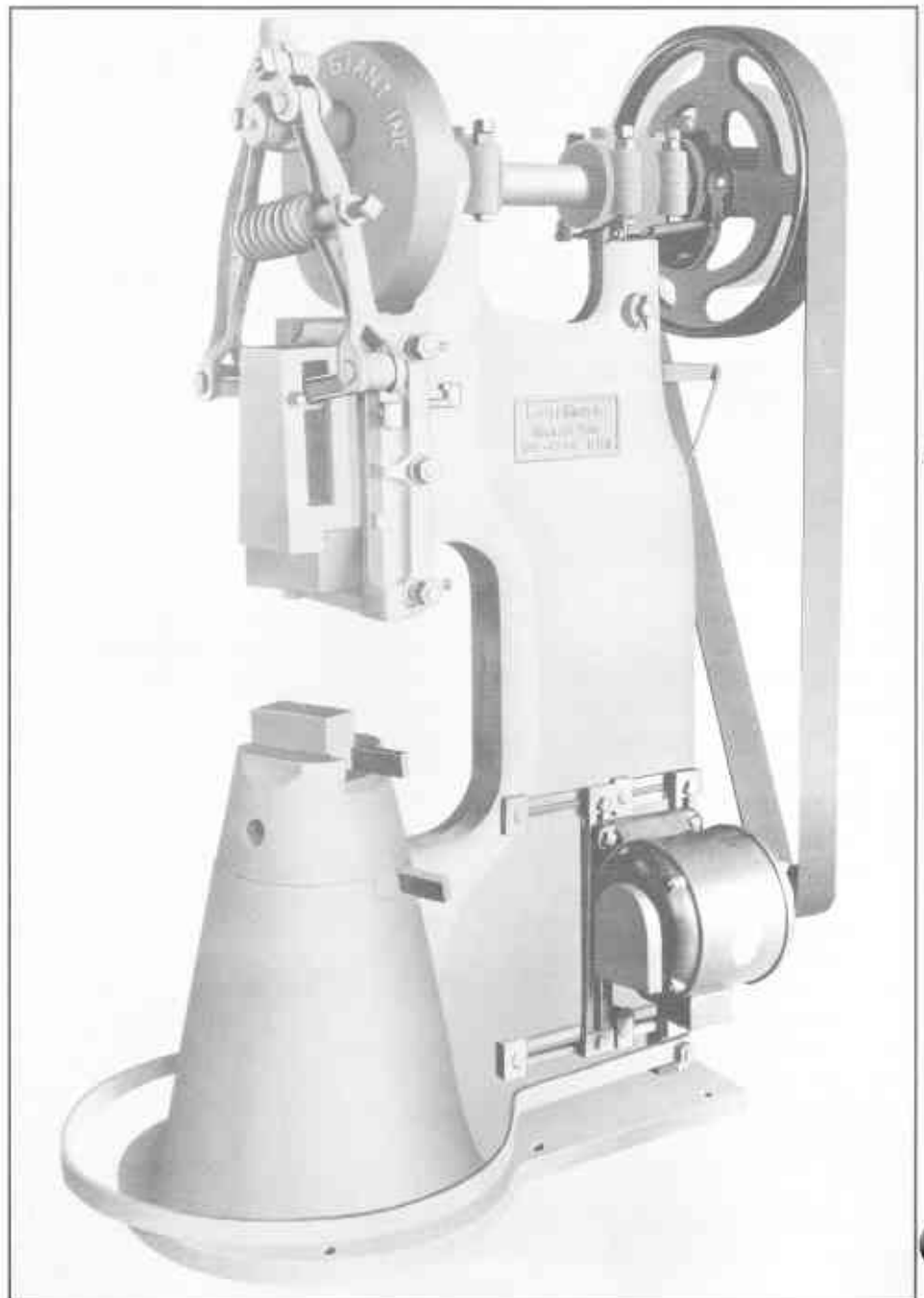
witchcraft or any of the many methods if the time is taken to do it right the first time.

One little after thought is the key on the upper 251b. Little Giant. It is a double taper key, meaning it not only tapers from left to right but also across the width. This presents no special problems, it still has to be fit carefully for good contact. All above procedures apply.

You will notice the words generally and usually have been used. The rea-

son for this is, about the time you think you have seen it all and have found a fix for them all, a variation pops up that you had never thought about. Keep an open mind, think it through and try to do it right the first time.

*Editor's note: This article and the drawings were printed with the permission of Sid Suedmeier. For reprint rights contact Sid at Automotive Inc./Little Giant, 420 4th Corso, Nebraska City, Neb. 68410 or call (402) 873-6603.*



*The 100-pound Little Giant is featured in this factory advertisement photo.*



# 1994 Ozark Conference

*Our fires were hot but we were not!*

Once again our Ozark Conference was an unqualified success, due in large part to a motivated chairman who knew how to get the most out of a determined bunch of cold, wet blacksmiths.

The rain fell by the bucketfull, and the cold wind whipped under the tents forcing us all close to the demonstrators, who were doing their thing in three areas outside and two inside.

If there was one thing wrong with our conference it was the fact that you needed to be in more than one place at the same time. Under the main tent outside you could climb to the top of the bleachers and see two demos at once.

Then it was a short walk to the knifemaker's corner, where more than blades was covered. I especially liked V.J.'s demo on making sheaths — an often overlooked subject.

Inside we had our big names — Jim Wallace, director of the Metals Museum in Memphis; Russel O'Dell, who showed us metal spinning in copper and aluminum; and BAM's own Hank Knickmeyer, who really wowed us with his Damascus.

There were far too many demos to cover in the space and time I have for this newsletter. One of my favorites were Nana Showalter, who makes a beautiful rock and iron candlestand.

Nana not only showed us how she does it, she showed us how to have fun while you work. She also was game enough to scale Tom's bonfire (understand this one set a new record) and touch the thing off.

It was interesting to see John Murray forging something without the help of his big hammer. And it was real nice to see two BAM old timers at the anvil — Don Asbee and Bob Patrick.

Two others I had never seen demo were Phil Cox (he made a neat pair of spurs) and Andrew MacDonald, who made the kind of hinges you and I would have burned up in the fire.

Everyone went away with some things they "gotta try." For me it was John Lovin's dogwood blossoms from tubing.

When the dust had settled (mud?) I think everyone in the group did a demo except the chairman, who once again rode Tim Ryan's anvil into space. We did real good on the gate and picked up many new members.

Tim Ryan was his usual self, one minute shooting anvils and the next wringing hard-earned dollars from our wallets at the auction. We brought in \$4,586 including \$665 earmarked for the new Tom Clark Fellowship started by Tim. (See page 22 for details.)

While it's always amazing to see how much Tim can get for our items,



*Above: Jim Wallace took care of his ears when he worked on the air hammer loaned to us by Centaur Forge. Below: Russel O'Dell turned some beautiful pieces on his lathe, something a lot of us want to try someday.*



I think the cake went to a piece of yellow paper donated by Doug Hendrickson and sold to Lou Mueller by the crafty auctioneer.

We also made a few big announcements: First of all, the Bob Patrick Founder's Award went to two members, Treasurer Steve Austin and ABANA Conference Chairman Lou Mueller.

The winners of the scholarships were Andrew MacDonald, Bob Alexander, Jim McCarty, Tim Reynolds and David Hoopes.

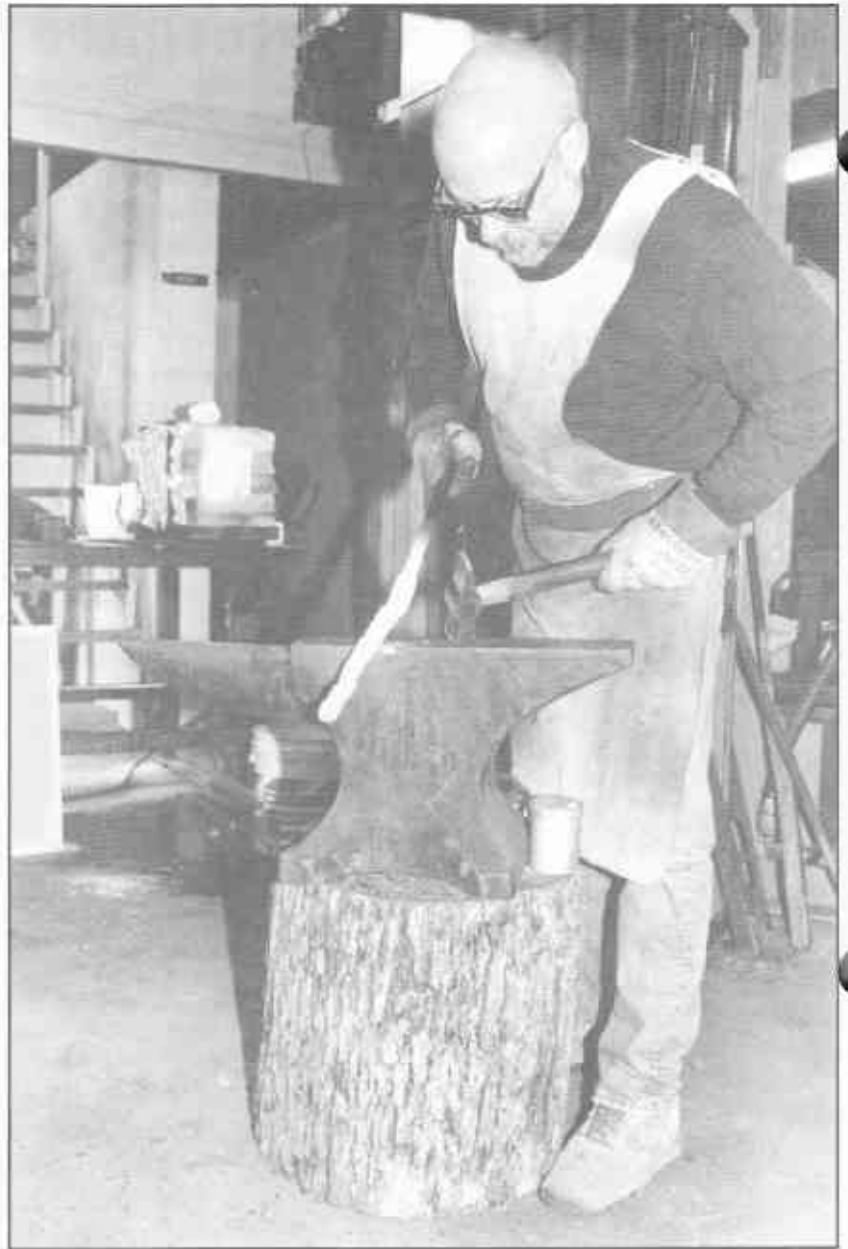
Here's a look at the conference for those of you who missed it. I'm going to make this a picture story for now in the hopes of getting this issue out in time for the ABANA Conference but look for a big issue full of tips and projects that came out of the conference in the next issue.

Like a lot of you I'm looking forward to next year's conference, come rain, snow, sleet, hell or high water. Good Job, Stanley! I think you deserve a round of applause from everyone who went.

# Ozark conference



*Above: Tom Clark carefully finds his way down after lighting the bonfire. Below: Tim Ryan is calm as he walks away after lighting the fuse on the anvil shoot. This was just before chairman Stan Winkler climbed on. At right is what happened when the fuse reached the charge.*



*Above: Hank Knickmeyer gives up some of the secrets to his Damascus work. Two of his pieces brought the top dollar at the auction. Below, right: Maurice Ellis showed a traditional blacksmith item, nails.*





*Left: Bob Woodard touches off the charge in his well-crafted 'tater gun. Bob's design represents the final evolution of the traditional Ozark shooting match.*

## Ozark conference



*Left: Nana Showalter does her famous candleholder, which she summed up as "six tapers, three wraps and a fish." Above: Jim Waller, right, helps Phil Cox make a pair of spurs.*

# The New Artisan

by Jerry Hoffmann  
publisher, *Blacksmith's Journal*

The influence and the scope of the work produced by blacksmiths throughout history cannot be understated. They worked directly, forming tough resilient “black iron” into items that enabled the creation of other things. Particularly significant were tools made to carve wood, cut stone and plow fields—all made by blacksmiths. Impressions cast by these tools marked the essential nature of his craft, signifying the harmony of his mind and body, as evidenced in each hammer blow. At the heart of blacksmithing is this directness, this essential creative quality that makes it seem magical. Magic that is in the fire, the glow of hot iron, its workability and the blacksmith’s skill. No other process can produce the same results. There are no limits to the creative possibilities or to the level of precision and skill a blacksmith may attain.

The revival of blacksmithing as a late 20th century process may seem odd given its much celebrated demise earlier in the century. The blacksmith’s slow methodical process of making tools and items of utility is no match for the precision and speed of machinery designed to satisfy the needs of growing populations. Ignored but not lost were all the intricate details found, not only in his tools, but in the great architectural artistry that the blacksmith and his black iron, embodied. His demise was considered total, every aspect of his work could be replicated by machinery. Hidden, however, was artistry overshadowed by utility. The artistry could not be replicated. There is no process separate from blacksmithing that can capture its essential nature. It’s the realization of this fact that has fostered the craft’s recent resurgence.

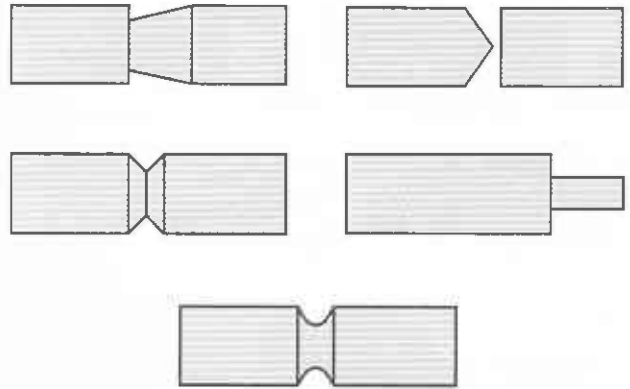
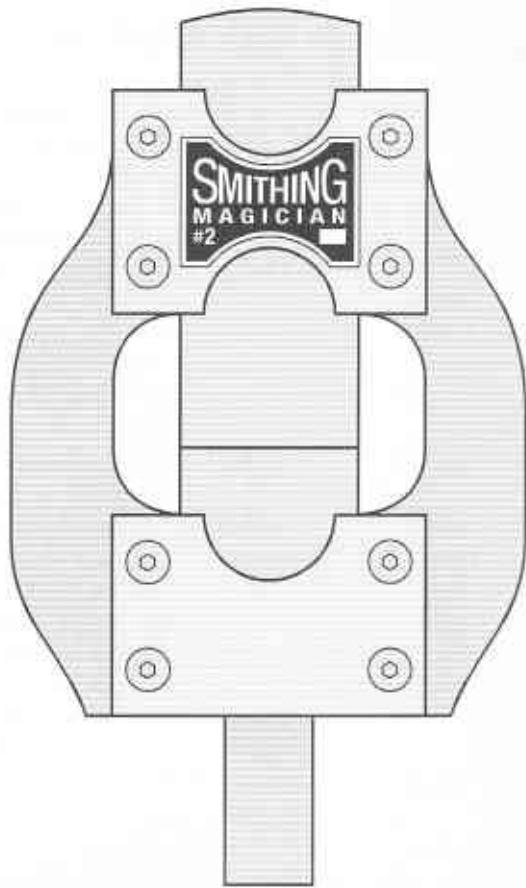
Two factors give this resurgence a character that sets it apart from the roots from which it sprang. Artisans and designers using other techniques continued to evolve while the evolution of blacksmithing stood still. It is these people who have again realized the creative potential of the technique, and who have used hammer and anvil to create work that transcends not only

forged work of the past, but modern work in other mediums. In addition, modern tools and machinery once thought to replace blacksmith’s techniques are now being used to enhance the same techniques.

The focus of the new work encompasses a wide spectrum of metalwork and sculpture. Unlike ironwork of the past, easily recognized by its intrinsic patterns and shapes, today’s work is highly diverse. Its cohesiveness comes from the technique itself. Its hand-formed character (much like modeled clay) permits less rigid organic shapes that set it apart from other techniques. This, combined with the evolutionary insight of today’s artisan, marks the beginning of a new era of blacksmithing.

Ironically, some of the machines that replaced blacksmith’s techniques have now become welcome companions to those techniques. They serve to enhance traditional methods and save time without compromising the quality of the work. The most obvious example is the use of arc welders. Arc welding is used by blacksmiths to strengthen or replicate a traditional way of joining parts. The time saved enables the blacksmith to explore more creative possibilities thus contributing to the overall artistry of his work.

The revival of blacksmithing is the reawakening of a need to introduce quality into ironwork that blends artistry with utility. The technique stands alone as an essential outgrowth of the inherent qualities of the medium. The new styles and uses reflective of these qualities signal a new genre in blacksmithing—one that’s been long overdue.



Examples of common top and bottom tool operations made with the Smithing Magician`

A precision top and bottom tool guide that uses 3/4" x 2" die stock off the rack. Permits top and bottom tool operations without the aid of a striker and with greater precision. Can also be used in a treadle hammer. Sold with one tool blank and 1" hardy stem.

The Blacksmith's Journal now offers the "Blacksmiths Helper" Assembled and ready to use. Return this form and a check or money order to: Blacksmith's Journal, Rt.1, Box 189, Lonedell, MO 63060.

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# BAM NEWS

## AMANA metal show

September 1994 will see a new event for metal enthusiasts in Iowa's Amana Colonies when the Eisenfest (All Metal Fair) opens for the first time Sept. 16-18. The three day festival in Main Amana will feature all kinds of exhibitors and demonstrators in metal fabrication from Aluminum to Zinc.

The sponsors are looking for more participants. For information contact PWP, P.O. Box 193, Amana, Iowa, 52203 or call (319) 622-3100.

## LAMA Conference set

August 12-14 is the date for the first annual Louisiana Metal-smiths Association Conference to be held in Covington, La., which is just north of New Orleans. Frank Turley, Grady Holley and Chris Marks will share time at the anvil for this event.

The legendary Tim Ryan will conduct his own entertaining brand of auctioneering. Conference cost is \$35. For more information contact David Mudge at (504) 735-0049.

## Source for swords, etc.

It's pretty hard these days to go down to your local swordsmith and order up a weapon unless you live in Conyers, Ga. Here Museum Replicas Limited stocks a wide range of swords, daggers, etc. There is more, but ask for their catalog before you go to battle. Museum Replicas Limited, A Division of Atlanta Cutlery Corp., 2143 Gees Mill Rd., Box 840, Conyers, Ga., 30207. Phone 1-800-883-8838 or FAX (404) 388-0246.

—*The Indiana Forge Facts*

## For Tom's a jolly good fellow . . .

by Tim Ryan

Sometimes one has to be creative to accomplish one's objective and within the parameters imposed by circumstance. Not that Tom Clark fits into the category of mere 'circumstance' more like 'act of God' or 'force of nature.'

At any rate Tom has stated repeatedly that he did not want his name in consideration when honors were to be handed out. This year as in past years he laid down the law that BAM's highest awards should be given to someone else.

This is typical Tom Clark, and in keeping with his notion that there's no limit to what you can get done if you don't care who gets the credit. Tom believes in giving credit where it is due, as long as there is none due him.

The members and officers of BAM respect Tom too much to cross him on this; after all they are the ones who would have to take the heat if they went against his wishes. But BAM has out of state members too. One of them is a fly-by-night auctioneer who doesn't have to hang around and hear it when Tom gets upset.

Since said auctioneer doesn't actually fly to Potosi every year, he had six hours driving time to consider the objective and formulate a solution. The objective was to devise a way to honor retiring BAM president, Tom Clark, without giving him an award.

Eventually the Colonel had a brilliant idea. Develop a new BAM award and name it in honor of Tom Clark. This way Tom would never get an award, someone else would always get it. But everytime the award was given Tom Clark would be honored.

It remained to talk with BAM's officers and design a special award worthy of bearing the prestigious TC mark. BAM has recently instituted an ambitious scholarship program. Five full scholarships were announced at the 1994 Ozark Regional Conference. Something like a scholarship would be appropriate — but Tom Clark is no scholar, so we decided to call it a Fellowship because Tom's a jolly

good fellow. The Tom Clark Fellowship Fund was initiated in the middle of the 1994 Ozark Regional Conference Auction. \$665 was donated to the fund during the course of the auction, and other funds will be raised through special donation and at future auctions. The purpose of the Fellowship is to provide BAM members and officers with funds to attend out-of-state blacksmith conferences. In most instances the fund would only pay the conference fees but travel expenses could be included in special cases.

New members are especially encouraged to apply for funds from the Tom Clark Fellowship. They will benefit immensely from visiting blacksmith conferences in neighboring states, the Quad-State Roundup, the Southeastern Regional Conference, etc. New members need inspiration and tools and both of these commodities are readily available at workshops hammer-ins and conferences all across the country.

Officers need to travel afield too. They will benefit from seeing how other chapters operate, who the best demonstrators are and observing other conference formats.

Even members don't take advantage of the Tom Clark fellowship to travel to distant conferences will benefit from rubbing shoulders with those who did, from reading reports in the BAM newsletter and from sharing the largesse of one of tools and demonstrators imported as a result of these journeys.

Neighboring chapters will also benefit from the Tom Clark Fellowship Fund. You can bet a van full of BAM members will go a long way toward assuring the success of any blacksmith get-together. (And maybe improve the take at your blacksmith auctions too.)

Guidelines for administering the Fellowship will be addressed at a BAM meeting soon. Put your thinking cap on folks! Be creative and make this another way that BAM is one of ABANA's most innovative chapters.

*Next meeting  
July 23 at  
Vernon Fisher's forge*

Vernon Fisher will be hosting BAM'S next gathering at his Lake of the Ozarks forge.

The July meeting is always designed to give us a chance for some fun in the sun and this year will be no exception.

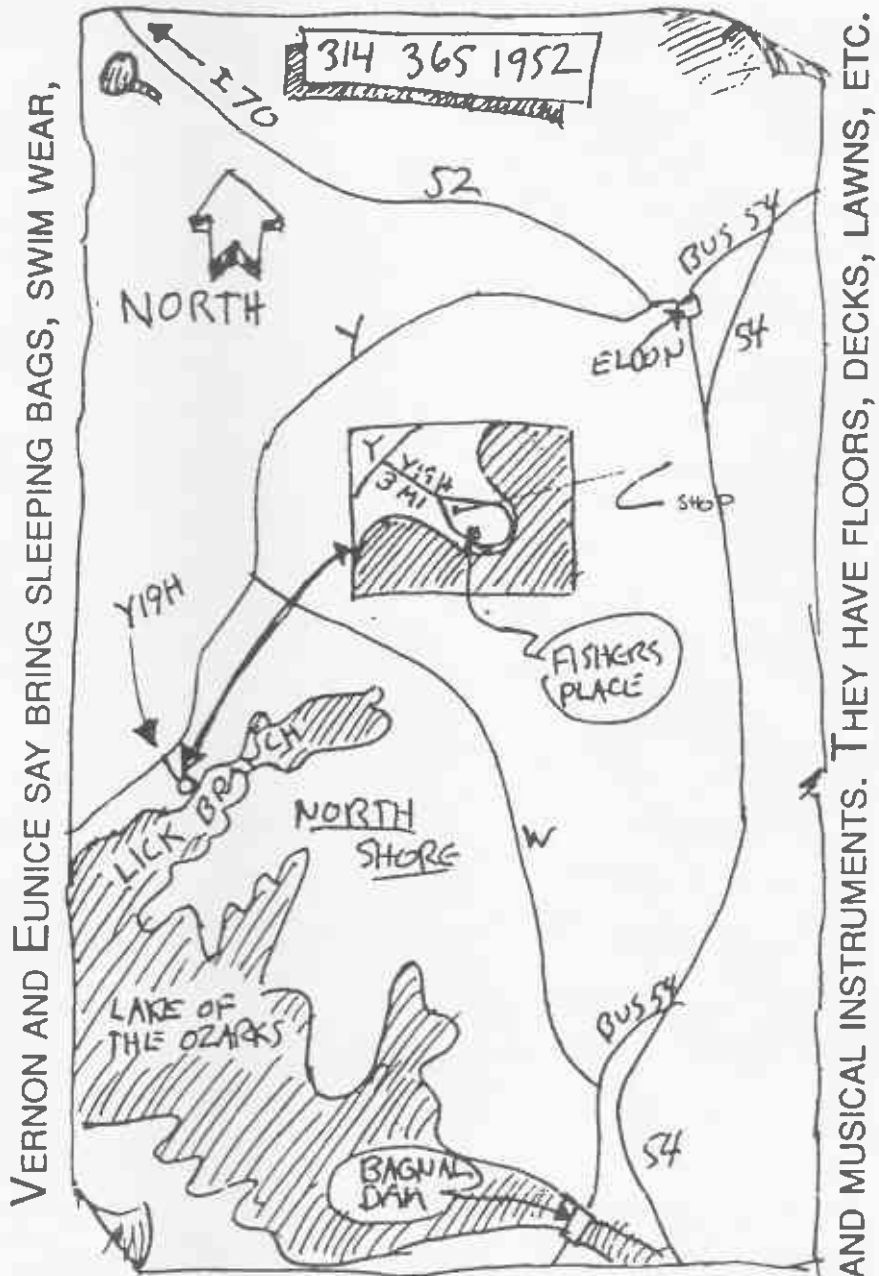
Vernon promises a good day so bring your swim suits along. He says he bought some more land since our last meeting there and there is ample room for campers if you want to pitch a tent.

For demos Vernon wants to lean towards knife making, particularly the phase that takes place at the grinder. He offers his new Baldor grinder if one of our knifemakers will oblige.

The trade item will be anything made from a railroad spike, so you can pick up those practice pieces from the Ozark Conference and you are set.

Follow the map at right for directions and give Vernon a call if you get lost.

Don't forget to bring something for the iron in the hat — either something you forged, a tool or a blacksmithing related item. Bring some cash too and you might get lucky.



VERNON AND EUNICE SAY BRING SLEEPING BAGS, SWIM WEAR,

AND MUSICAL INSTRUMENTS. THEY HAVE FLOORS, DECKS, LAWNS, ETC.

*Sept. meeting:*

Ken Markley is the host for BAM's September meeting, which actually will be held on October 1.

Ken lives east of the Mississippi near Sparta, Ill. His specialty is knives, so count on some Damascus being forged. Last time we also had a good demo by Dr. Iron.

## BAM Schedule

**September Meeting**

Ken Markley, Sparta Ill., Oct.

1

**November Meeting**

Hank Knickmeyer, Cedar Hill, Mo., Nov. 5.

**January 1995 Meeting**

Jerry Hoffmann, Lonedell,

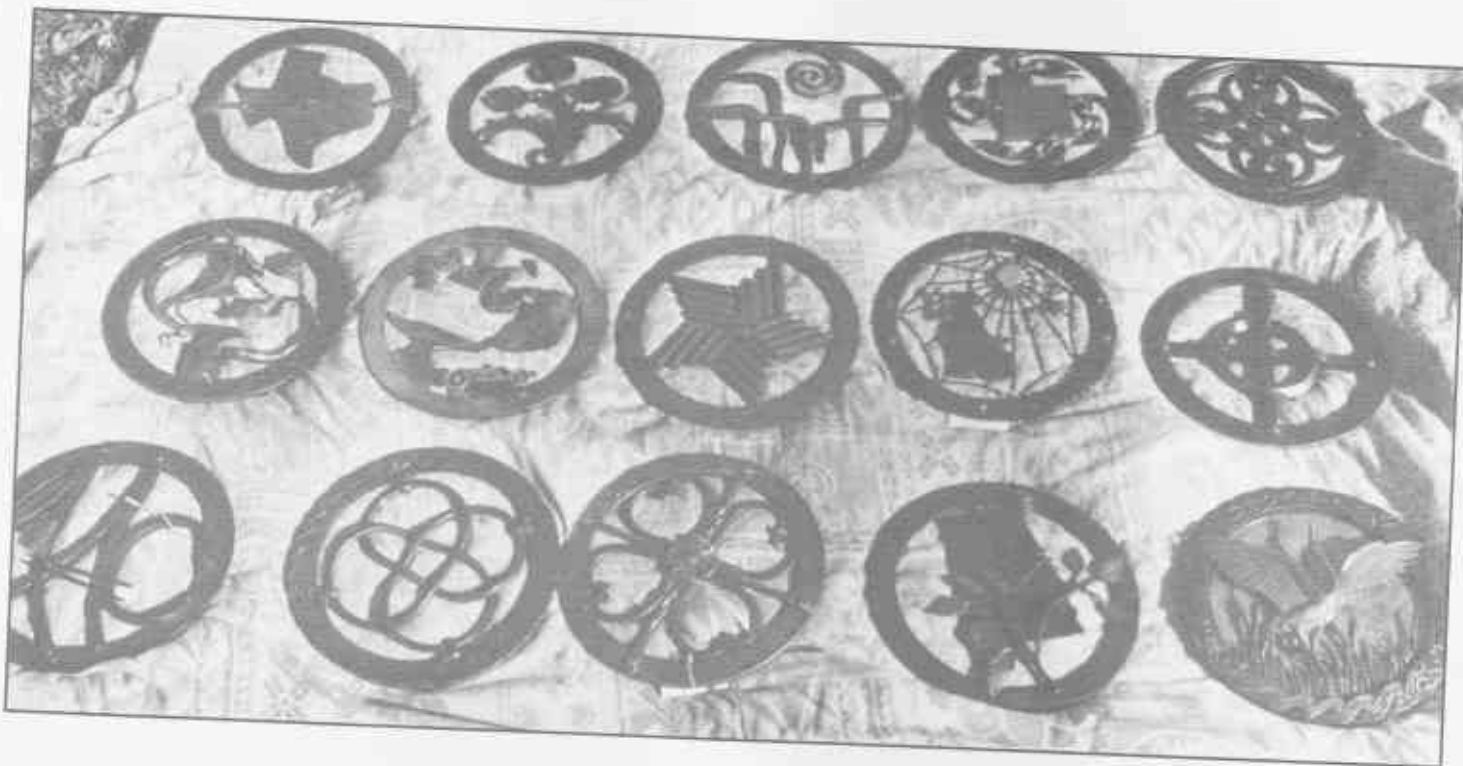
Mo., Jan. 21, 1995

**March 1995 Meeting**

Date and location up for grabs

**May 1995 Meeting**

Walt Hull, Lawrence, Kansas, May 20, 1995



*This was the first batch of rings sent in for the ABANA Conference Ring Project. BAM's ring is in the upper right hand corner and was made by Jerry Hoffmann. The rings will be selected and assembled at the site by Francis Whitaker.*

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