

# RAM

New date for next meeting! See page 23.

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*Sept. — Oct. 1994*

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NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

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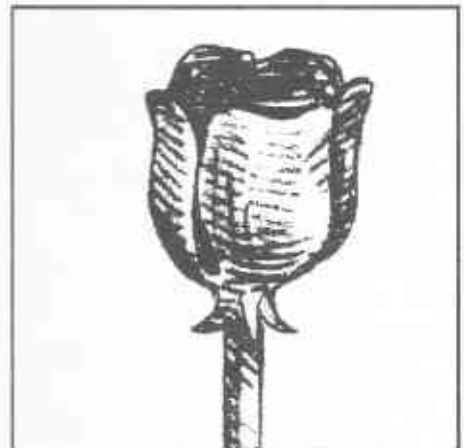
**22** We plan to head for Memphis for a tri-state hammer-in at the metals museum.

## Next meeting

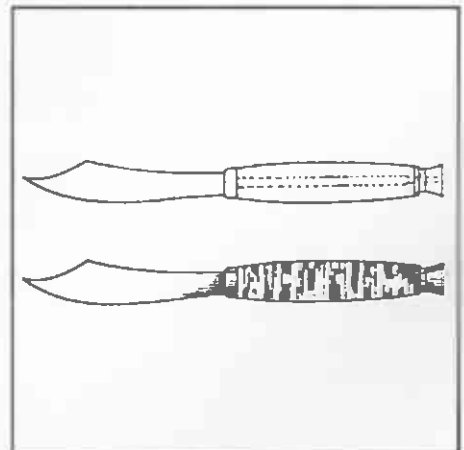
**23** The next meeting date has been pushed back to Dec. 3 to let Hank get ready for the cold.



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**Newsletter of the  
Blacksmiths  
Association  
of Missouri**

*Volume 11 No. 5*

*Our cover:* Ken Markley shows a billet of Damascus to his 50-pound Little Giant at the meeting he hosted in October.

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Emil Bubash

**Artist**

Jerry Hoffmann

**Mailing Labels**

Maurice Ellis

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**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 mai .....\$50 yr.
- Contributory .....\$100 yr.
- Public library.....\$25 yr.

*See reverse*



## Editor's anvil

It's always good to hear from BAM folks once in a while. I like to hear what you guys are up to and I thought the rest of you might enjoy this exchange of information.

I've always been planning to call on Thomas Moroni on one of my many trips to Southeast Missouri. In fact, I just suggested to Tom Clark that he look him up on his way down to Big Oak Tree State Park. Danged if Thomas didn't give me a call a few days later. Must have felt his ears burning!

Anyway, he saw my story on the lighting class I took at the Folk School and wanted to know if there were any books on the topic. Can anyone help him out? Turns out Thomas and I have a mutual friend, and that he lives in Advance, not Oran, which makes it a lot closer for me to pay a visit next time I visit the in-laws.

Speaking of Advance, I got a call from Scott Payne, who joined us at Stanley's meeting. Scott needed a vise, my wife was headed that way, so he has a new vise and I have some money to blow elsewhere. Scott has some big news — he and his wife (we met her at Vernon's) are expecting. Scott, you may as well sell that forge now.

I mentioned Tom Clark. Our past prez did a demo at Big Oak Tree State Park, which is way down in the swamps. Tom said it went real well — they have a lot of crafters and draw a big crowd. Tom and Lou Mueller were on their way to Tannehill for the Big Alabama Forge Council event when Tom got news that his mother had died. Sorry to hear that Tom. That's something we all have to face in our lives.

I missed the Boonville steam show but Pat went and said Tim Underwood was at his usual place beating iron. I know Tim has inspired a number of folks to join BAM, including my neighbor Ron Schaefer, who saw Tim burn himself and said, "I'd like to try that."

This last Rural Missouri had two blacksmiths in it. D. Snellen, a Civil War reenactor, was featured in the

Missouri Sketchbook section. I sold D. a forge and he has it fixed up real nice — wish I'd kept it now. He showed me a beautiful fork he forged out of a railroad spike, must have beat on it all day to draw that tough iron out like he did. D., they sell smaller stock! D. does some incredible leather work, making Civil War era saddles, holsters, etc. for other reenactors.

Also included in that issue was a photo of Torbin Pace at the Christianson Native Craft Workshop. This event is held in August down around Eminence, Mo. Torbin is a teenager but has a lot of blacksmith skills mastered at a young age. Mom says he is mowing the grass to scrape up the funds for a BAM membership. First he's got to pay off his anvil though. Looking for good things out of Torbin.

Just got the Appalachian Blacksmith Association newsletter and inside is a group picture for an advanced blacksmith workshop taught by Dimitri Gerakaris in West Virginia. Pictured in the back row is one Emil Bubash. Is that our Emil? Emil says yes, but the photo was taken in 1975 when he had hair.

Also got a call from Dan Krell who parted with \$20 after watching the demo we did at the state fair. For some reason Dan didn't get his newsletter (he's on the list now), so we got an opportunity to talk on the phone. Dan lives down in Ray Chaffin country (Warsaw) and Ray has been helping him get equipped. If anyone has an anvil in working order Dan is looking for one and a few other pieces. Hope to meet you sometime Dan.

Haven't heard from Bernie Tappel in a while but it is now gigging season so you can guess what he is doing. Bernie is our ace gig maker so if you break yours off in the quest for "yaller suckers" put him to work on it. Haven't forgotten that article you're going to do for me....

Someone else we haven't seen for awhile is Steve Baker. Was that you who was forging at historic Arrow Rock, Steve?

The reason I know is I got a call the next day from a very excited

blacksmith named Bruce Murray from Hallsville who stumbled on "a blacksmith from Monroe City" who told him about BAM.

Like a lot of our founders, Bruce has been forging away never knowing there were others out there. He called to see if there were any other newsletters available besides the one he saw at Arrow Rock. I fixed him up with what I had in stock.

Looking forward to seeing you at the next meeting, Bruce.

Hope this newsletter reaches you before the next meeting. I'm trying to get it back on track — there's one more to do this year. Keep sending me your stuff.

If anyone is attending the hammer-ins around the state, drop me a line and let me know what is happening there. I have been so busy at home I haven't made one in some time.

Gotta beat it — see you at Hank's.

— Jim McCarty, editor

Just one more thing: Just got a letter from the Florida Chapter. They are strongly encouraging ABANA to put the family membership back on the books. That item was dropped recently and at the conference it was said there were no plans to reinstate it. If you have any feelings in this regard drop ABANA a line, or better yet pass it onto our representative Tom Clark.

If you haven't voted for the ABANA Board yet, don't forget to support BAM's own Lou Mueller and our good buddy Charlie Schultz who donated all that iron for the treadle hammers.

I meant two more things!

# Dear BAM

Ed:

Thanks as always for a good issue. Sorry I haven't sent you anything lately. I am thinking about it, really I am, but I've been busy, y'know, things to do, people to see, women to look at, beer to drink. It's a hard life, but it's my life...

If I'm not mistaken that's not the George Dixon I know on p. 15. does look like Doug and Stan though.

Enclosed please find the usual miscellany (thoughtfully decreasing in volume) which finds its way to my mailbox. Take special note of the flier from the Spencer Museum of Art. It is Paley (and others) and it is only 10 bucks, and if anyone needs a little accommodation, Walt Hull is right here in town.

Thanks again,

—Walt Hull, Lawrence, Kan.

*Editor's note: Walt included a greasy fingerprint but I was unable to lift it from the paper, having been made by real good Kansas coal dust and chili dogs. See the BAM News page for more info about the Museum flier.*

Great photos and coverage in both our newsletter and Anvil's Ring. I'd like to see what Manfred Bredohl's garden sculpture looked like. Do you have any photographs or know anyone who might? thanks,

—Bob Woodard, Cape Girardeau

*Sorry Bob, I don't have one. Can anyone else help? Send me a shot and I'll publish it next issue.*

To: All Chapter Presidents and Newsletter Editors

I am pleased to report that our chapter Ring Grill was a tremendous success.

There were two stated main objectives, first was to give the chapters a chance to work together for a common cause. While only 22 of the 40 plus chapters sent a ring, the stories I have heard coming out of some of the chapters are very rewarding. Some chose to have individuals make a

ring, and others forged their ring as a group. Whatever the plan, the rings were a great group of diverse design and workmanship. The second reason was a fund raiser for ABANA's general fund and that too was an overwhelming success.

The grill, with its six rings, sold for \$8,500. The balance sold individually at auction brought another \$2,450. This \$10,950 total represents the best ever special fund raiser in ABANA's history. The grill, which was designed by Jerry Hoffmann, was built and assembled by Francis Whitaker and a team of six other

smiths of his choosing.

They were Fred Crist, Tal Harris, James Honig, Nal Putnam, Pete Renzetti and Bert Smith. A work station was set up and they put on a demonstration of traditional forging for all to see. The end result was a picture perfect grill and just in time for the Friday night auction.

On behalf of the site committee (BAM) and indeed all of ABANA, I want to thank you all for a job well done.

—Tom Clark, Ring Committee  
Chairman

# Pat's place

I'll have to admit I was a bit nervous running the Oct. 1 meeting. But with a room full of friendly blacksmiths it went pretty smooth.

I was impressed with the quantity and quality of the trade items. Everyone should participate in this function.

I look at it as my homework for the next meeting. I might have to do some research at the library to get an idea, maybe learn a new technique or make some tooling to get the project done.

You also get the chance to trade with some of the more famous BAM members. I once got a Bob Patrick belt buckle that I am proud of and wear every day.

If you don't think your skills are up to par yet there is help on the way. We are planning a beginner's workshop in December. We'll start at the beginning with building a fire and cover all the basics. Get your application in early as there's a limited number of smiths we can accomodate.

Have you heard of the idea of using golf balls for file handles? It's a good idea that works well but watch out for liquid center balls as they will spray quite forcefully when you drill a pilot hole in them.

Wear your safety glasses!

— Pat McCarty, president



Pat leads the October meeting at Ken Markley's.

## Forge a log fork the Jim Batson way

LOG FORK - JIM BATSON  
MISSISSIPPI FORGE COUNCIL CONFERENCE  
MAY 28-29, 1994

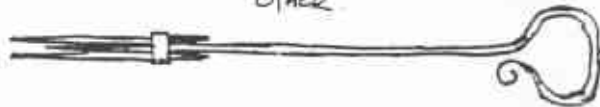
USING A 3' x 5/8" M.S. ROD. DRAW BOTH ENDS TO A LONG TAPER



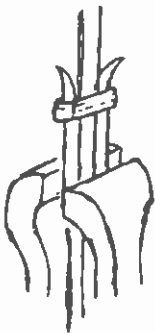
USING THE ANVIL HORN. SHAPE AN OVAL FOR THE HANDLE



DRAW TWO PIECES OF 5/8" x 6" TO 11" WITH A LONG TAPER ON ONE END & SHORT TAPER THE OTHER



FORM A COLLAR FROM 3/4" x 1/4" AND WITH THE MIDDLE TINE 4" SHORTER THAN THE TWO EITHER SIDE, FORGE WELD ALL PIECES AT THE COLLAR



WITH HANDLE UP. PLACE IN VICE & BEND SHORT TAPERS OUTWARD



WITH TINES POINTING UPWARD. PLACE IN VICE. BEND & SHAPE TINES TO DESIRED SHAPE



COMPLETE SHAPING AS DESIRED FOR APPEARANCE & UTILITY

# BAM

## JULY

### MEETING



*A group of about 40-50 made the meeting and intently watched the demos.*

Every couple years we head east of the Mississippi for a BAM meeting hosted by Ken Markley. Too bad we don't make it more often. The drive through Southern Illinois in the fall is beautiful and Ken is a great host.

This time around (Oct. 1) Ken had a big pot of beans bubbling on a wood fire when we arrived. About 40 people showed up, including Jerry Hoffmann, who had car trouble and arrived about the time we were winding down.

Doug Hendrickson got things rolling by forging a slip hook for a chain, something Doug says we should all try because of the variety of skills required. After Doug made the bend in the hook he forged a taper in the outside portion. Tom Clark made him explain his actions, which Doug did in this manner — a business card is easy to bend in half, but try doing it along the thin plane. The same theory works for hooks.

This point alone was worth the two hour drive.

Of course a hook has to have a chain to go with it, so Tom and Doug twisted my arm until I agreed to weld up some links, something I learned to do at the Folk School this summer. This time it had to be 3/8 round links. I had just picked up a pair of link tongs, but they were a little loose so Tom and Doug set out to make them fit while I got the iron warm.

By the time they got done with them the tongs were mostly jawless, teaching me my second lesson of the day! I made do with a pair of Ken's flat-jaws and managed a weld or three and one of the ugliest pieces of chain ever made!

The host lit the gas forge after we ate the entire pot of beans (no connection intended) and he gave the 50-pound Little Giant a workout forging a billet of Damascus steel. Didn't stay long enough to see how this came out.

Ken had a few pieces for us to look at, including a ladder-pattern dagger that everyone but Ken thought looked great.

The trade item (candle holders) was well represented and we had another excellent turn-out for the iron in the hat. This time we could have used

more members to sell tickets to but we managed \$125.

Pat offered to take it to the Casino Queen and see if he could double our money but we were afraid he would stop off at PT's for a different kind of demonstration.

We had a good chance to visit all day long. Thanks Ken for hosting us. I look forward to coming back again.

Trade items were made by Ken Valdejo, Maurice Ellis, Tom Clark, Bert Elliot, John Murray, Ed Harper, Jim Pittman, Pat McCarty and someone who left before we made the exchange. (Call Pat to claim your prize — 314-239-3814.)

Iron in the hat went as follows:

John Lovin flower went to Tim Underwood

Chain from Jim McCarty went to Maurice Ellis

Bob Woodard bracelet went to Pat McCarty

Bob Woodard handle went to John Lovin

Pat McCarty ladle went to Tim Underwood

Randy Barringhaus leather apron went to Maurice Ellis

Tool steel donated by John Murray went to Steve Stumpke

Doug's hook demo went to Tim Underwood (who was threatened)

Bert Elliot candlestand went to Bill Miller

Hot cut from Ken Valdejo was won by Tim Underwood (at this point Tim was lynched)

John Murray candlestand went to Doug Hendrickson, doubling his collection of Murray art

Tom Clark candle stand went to Steve Stumpke (we showed him what happened to Tim)

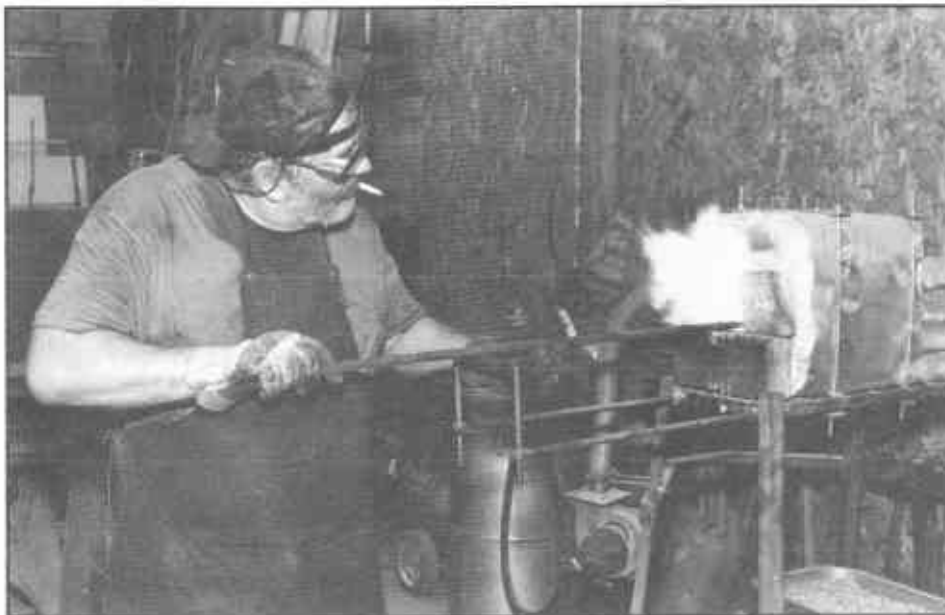
John Medwedeff's leaf went to Doug Hendrickson (who was too big for our rope)

Thanks to all the folks who donated items and those who bought tickets — keep it up!

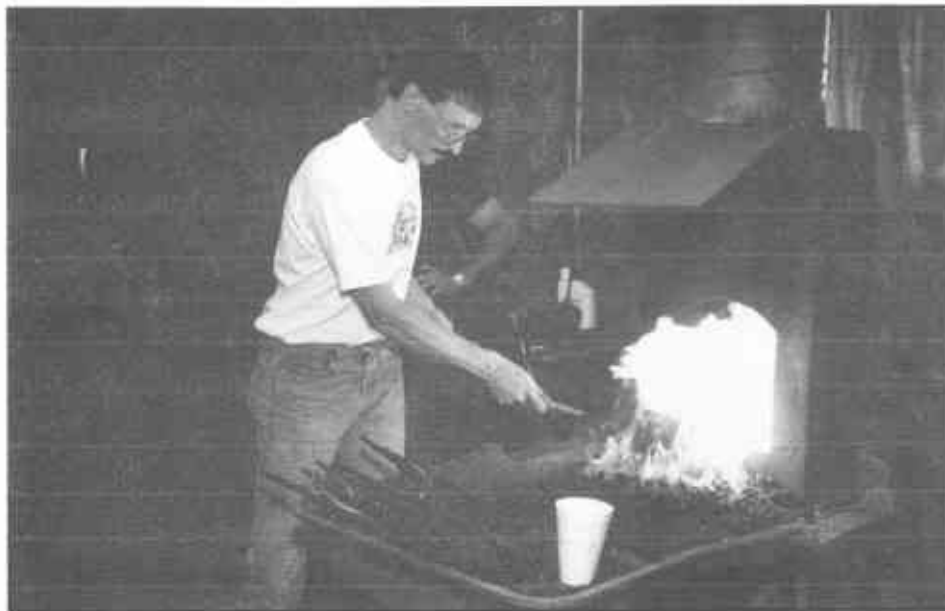
#### Minutes

Meeting was called to order by President Pat McCarty





*Left: Ken Markley answered questions as he heated a billet in his gas forge. Ken hosted the meeting at his shop in rural Sparta, Ill. Below: Doug Hendrickson put together a demo of an item we should all try forging, a chain hook. Below left: Even the editor got into the fire, forging a piece of chain that was too ugly to publish.*



Reading of past minutes dispensed with as they were published in the newsletter

Pat reported that coal is in, \$7.50 per bag.

He read letter of thanks for our work on the ABANA Conference from ABANA President Clayton Carr. Doug Hendrickson mentioned article in American Crafts magazine written by Jim Wallace about the conference. Tom Clark gave out horseshoes to those who volunteered at the conference.

Tom spoke about the 1994 Ozark Conference, which he chairs. Suggested

the following:

- Early Friday set-up, teaching opportunity Friday afternoon.
- Clifton Ralph demo?
- Clay Spencer treadle hammer demo?
- Darryl Nelson demo?
- Jerry Darnell demo?
- Bob Bergman demo?
- Paul Hubler demo?
- Only one demo at a time? 4 hours long.

Doug suggested demonstrators could man teaching stations in off-demo hours.

Logistics of seating people around demo area discussed.

Various ideas on tents, bleachers, etc. were discussed.

More to come, including national promotion.

Jefferson County (Ill.) Historical Society blacksmith workshop Oct 22-23. See John Lovin for more info.

Discussed beginner's workshop at Lou Mueller's shop. More to come.

"Repair days" at the metals museum Oct. 22 and 23 (Memphis).

Pat brought up the possibility of BAM trip to the metals museum this winter. Suggestion was made to make something in their shop to leave behind at the museum. If anyone is interested in taking charge of this call Pat.

Pat announced Tom was unable to continue as second vice president due to personal commitments. Todd Kinikin, who received the second highest amount of votes, was named in his place.

Meeting adjourned to bean soup.



ABANA President's Message  
October 1994

Dear ABANA Chapters,

We are growing! We project that we will have over 4,000 ABANA members by the end of the year! That is great news for all of us. Think about what that means for a moment . . . We can provide more benefits and services for our membership. It promotes larger, stronger Chapters. The Anvil's Ring has a larger membership base to draw articles from. Our ability to market what we have to offer is increased among the public, related architectural, interior design, and metalworking organizations, as well as others. You and I know that artistic blacksmithing is a viable and desirable alternative to other architectural and interior design options — as we grow, the general public is finding that out as well. We are growing because you are helping to make it happen.

As you may or may not know, we have been sending a small survey out with the renewal billings. There is now data from roughly 33 percent of the paid-up members and there are some interesting statistics coming out of this data. For example, over 15 percent of the members who responded said that 70 percent or more of their income comes from blacksmithing. 2.1 percent of the members are female. 44 percent of the members are between the ages of 44 and 59. 52 percent of the members declared a chapter affiliation. We appreciate your taking the time to fill out this survey. Several of the ABANA committees will be using the information to help improve the benefits and services available to ABANA members. A complete breakdown of this demographic information will be available by the end of the year.

This month you will be receiving the ABANA Board of Directors ballots with your Anvil's Ring. Now more than ever, we need you to take an active part in your association by sending in your ballot. By doing so, you help to chart the course that ABANA will follow in the years to come. In last month's Chapter Liaison Letter, you were given a rundown of the board positions coming open and who is currently filling them. Five positions will be open and eight people are running. Three of the eight are current board members re-running. Please remember, take the time to fill out your ballot and send it in.

Thanks and a tip of the hat to Indiana Blacksmithing Association (IBA) President Paul Moffett! He read my September safety message on the use of Ground Fault Circuit Interrupters (GFCIs) to prevent shocks and he had this to add regarding the selection of GFCIs:

"A recent letter in the September Fine Homebuilding magazine noted that the cheaper devices are not as reliable as you might expect. A number have failed testing in the field after installation or have been miswired internally. The magazine response suggested the use of industrial models made by the Hubbell Wiring Div., Hubbell Inc. for solving the problem. Specific part numbers are 5262 for 15 amp. and 5362 for 20 amp. circuits . . ."

Paul's quote was taken from the IBA newsletter Forge Fire. Thanks, Paul!

Warm regards,

Clayton Carr  
ABANA President

# ABANA Liaison

## Who are our members?

President Clayton's accompanying letter outlines some of the information the ABANA Marketing Committee has generated from our membership. If the sample of about 1200 members studied so far remains constant, almost 50 percent of ABANA's members don't belong to a Chapter (at least they aren't declaring chapter affiliation). Your Chapter can participate in our membership list exchange and we'll give you the names and addresses of the national's members in your area who have not joined your chapter.

One other significant statistic is that 14.2 percent of ABANA's members earn between 11 percent and 70 percent of their income from their blacksmithing. If this holds up over the survey of the whole membership, it means that when the 70 percent-plus group (15.3 percent of this sample survey) are added in, 30 percent or more ABANA members are earning all or part of their income blacksmithing.

## What is the trend in the Chapters?

The Chapter Liaison Committee would like all Chapters to please include a survey of your chapter members along with chapter membership renewal forms or print a tear out in your newsletter. Include these questions to compare to our national statistics:

### Year of Birth

- Before 1935
- 1936 to 1950
- 1951 to 1965
- 1966 to present

### Gender

- Male
- Female

### Income Derived from Blacksmithing

- None
- \$1.00 to 10 percent
- 11 percent to 40 percent
- 41 percent to 70 percent
- over 70 percent

In our Chapter calls next spring, we will ask what you found out.

*(Editor's note: I'd like to add the following category — percent of total income spent on rusty old blacksmithing tools.)*

## Fall Chapter Calls

You'll receive calls from an ABANA Board Member between October 1 to October 15 with the same questions as were asked last spring. Be prepared to identify your total number of current members.

## ABANA Board Election

You can't go wrong. In addition to current Board Members — Joe Harris, Toby Hickman, and John Pollins — the slate includes Will Hightower, who spent many darkened Alaska winters voluntarily compiling the only complete index of the Anvil's Ring; Lou Mueller, who chaired the record setting ABANA Conference in St. Louis last summer; Tal Harris, President of our North Carolina Chapter who assisted Francis Whitaker in assembling the Chapter Ring Project grill at St. Louis, and; Charley Schultz, Manager of a major commercial large forging shop as well as organizer of the East Texas Blacksmith Alliance (not yet an ABANA Chapter).

Be sure to vote by sending in your ballot coming out in the fall issue of the Anvil's Ring.

## Change of Officers

Just a reminder to keep those change of officers and address updates coming to our attention for the Chapter contact list. We receive a lot of calls at the ABANA Office from new and potential members looking for a local group to get them going.

*Any opinions expressed in this newsletter are the opinions of Chairman, John Pollins. If you have any comments, please direct them to:*

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



# First Fires

BAM is offering a workshop just for beginners

**N**ewcomers take note! BAM is sponsoring a workshop just for you Dec. 10 and 11. The workshop will be held at Lou Mueller's shop in Valley Park, Mo.

The course will be an intense 16 hours of basic forging. Instructors will assume those attending have little or no forge experience and will start from the very beginning.

There is room for 24 people at the 12 forging stations, so the first 24 registrations received will be the ones who attend. (Those who don't make this class will get the first shot at the next one offered.) An experienced blacksmith will be at each station for individualized attention. The class will start with an hour of orientation, which will include a brief history of blacksmithing, an explanation of the tools used and talk about fuel for fires, coal, coke and gas.

Then we will move to the forge where basic instruction will be done cold, using lead bars for practice. After this the fires will be lit and a good sampling of techniques needed to make many projects will be shown: Tenoning, upsetting, hot cutting, splits, twists and more.

There will be no forge welding or tong work done. No projects will be made, but you will gain enough experience to go home and complete your own projects.

Cost for the two-day class will be \$20, which will cover materials and insurance. BAM will provide all tools necessary. The one thing you must bring is safety glasses.

If you have a favorite hammer or a pair of gloves you like to work with feel free to use them.

For more information contact Lou Mueller at (314) 225-3252. Remember, registration is limited to the first 24 so send your application in now. Course is open only to BAM members in good standing (dues paid).

# LEAF FORGING

Stock: 3/8" square

Tools: Hammer, chisel, tear-drop, ball-tool

1)



Forge a blunt taper.

2)



Neck to establish shoulder.

3)



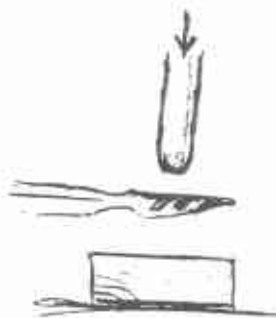
Spread & true-up.  
Refine neck.

4)



Decorate w/ teardrop  
and chisel.

5)



Drive leaf face down,  
hot, into oak block with  
ball tool.

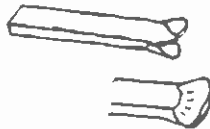
# Colonial Lighting

By Jerry Darnell, From the Hot Iron Sparkle, Notes by David Tucciarone, Drawing by Kim Harris

## LAMP

### 1 Tripod Base: use 3/16" x 3/4"

Piece 1 : cut to length of one leg (your choice). on one end, scarf corners and bring out middle (no more than 1/2" scarf).

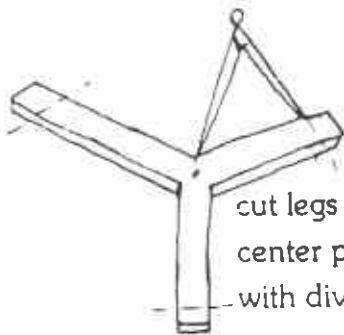


Piece 2: cut 2x's length of piece bend on edge, in center, to 120° scarf outside corner of bend.



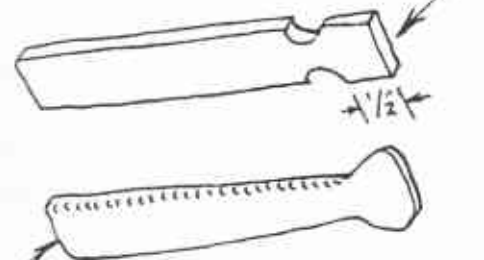
WELD 1 and 2 together.

SHAPE: legs should be 120° apart.



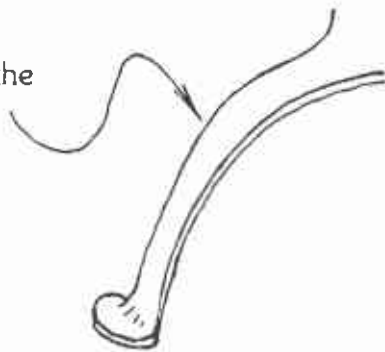
cut legs to equal lengths by center punching then scribe with dividers.

3/8" spring fuller ends



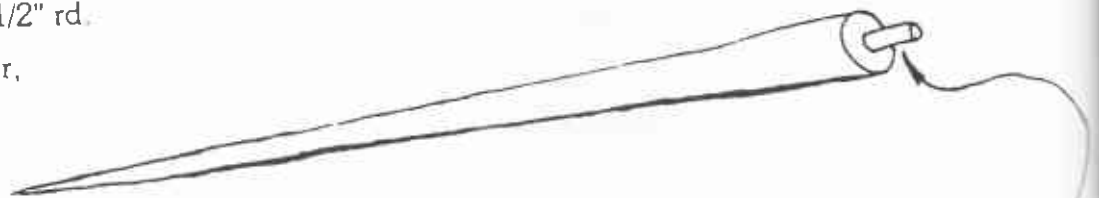
straighten legs, chamfer slightly, work feet into desired shape, (beans, circles, etc...)

Bend legs over the horn, then feet



### 2 UPRIGHT: use 1/2" rd.

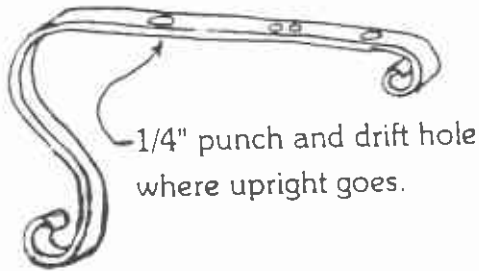
CUT: 14" long, taper, and straighten.



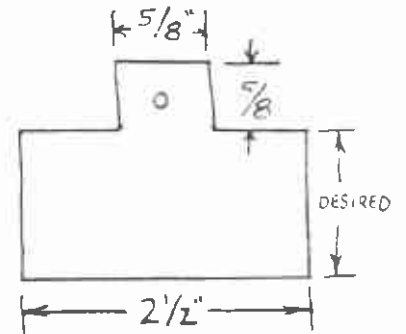
upset one end to 5/8" form 3/8" tenon.

**3 ARM:** layout by eye  
(no set length) use  
3/16" x 1/2" bar.

make ribbon scroil ends.  
bend 3/4 turn scrolls  
to your liking.

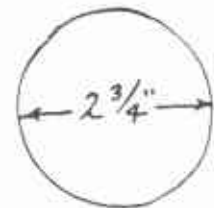


**4 CANDLE CUP:** use 16 or 14 ga  
sheet. layout and cut per drwg.  
mount cup with seam toward  
upright.

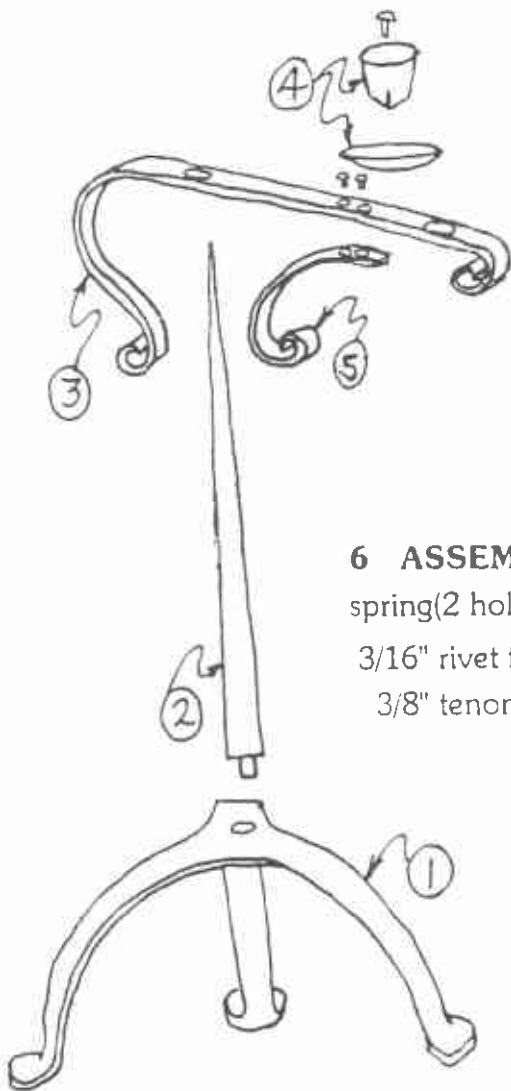


drill 3/16" on bottom tab  
bend bottom over, then shape  
3/4" round cup.

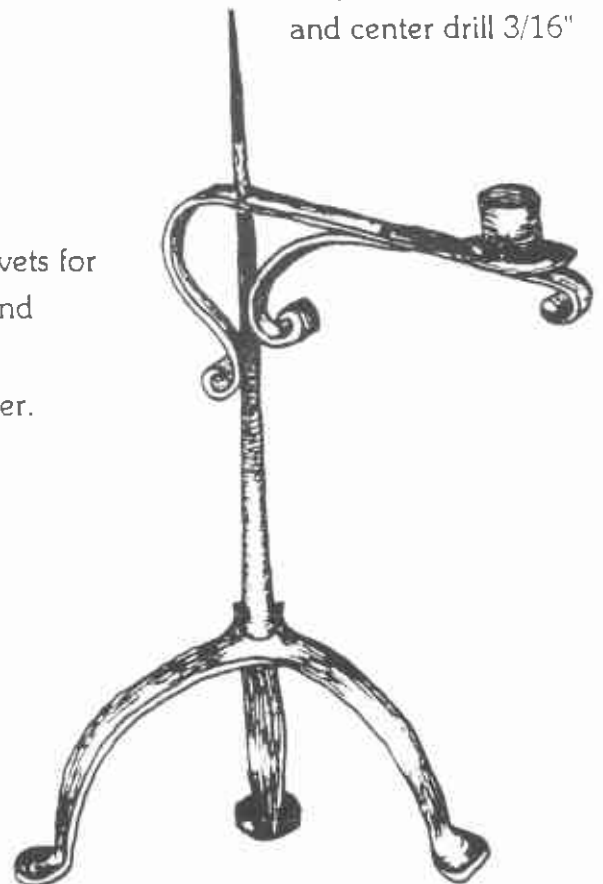
**5 SPRING:** use 3/16 rd. 1055  
flatten out, form 3/4 turn scroll  
and shape end as necessary.  
ALLOW SPRING TO COOL!



shape drip cup as desired  
and center drill 3/16"



**6 ASSEMBLE:** using 1/8" rivets for  
spring(2 holes, attach to arm) and  
3/16" rivet for candle parts.  
3/8" tenon upright to base center.



DRWG. BY KIM HARRIS

# Application for the Tom Clark Fellowship Fund

The Tom Clark Fellowship Fund has been established to assist BAM members who wish to attend out-of-state conferences and/or workshops.

Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_ Zip \_\_\_\_\_

Number of years you have been blacksmithing \_\_\_\_\_

Main interest(s) as related to blacksmithing \_\_\_\_\_

## **Information about conference/workshop you wish to attend:**

Name of conference/workshop \_\_\_\_\_

Location \_\_\_\_\_

Date you wish to attend \_\_\_\_\_

Cost \_\_\_\_\_

Brief description of what is being taught, if you know \_\_\_\_\_

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After attending the conference/workshop, you may be asked to write a short article for the BAM newsletter and or invited to demonstrate at a future BAM meeting.



Heavy duty fry pan blanks (steel), approx. 9 inch diameter with 2 inch sides, 12 gauge (.095) thickness. Has two 3/16 inch holes for your decorative handle. \$6 each or 12 for \$60. Shipping \$3 plus 50 cents for each additional pan. Contact Bob Tuftee, 3855 Aspen Hills Dr., Bettendorf, IA 52722.

Forge welding with Bob Patrick — the video! 108 minutes of demonstration, instruction and tips in color, showing how to forge weld using a coal forge, a hammer and anvil. Other videos and a blacksmithing school on video by subscription soon to be released. Wolfhound productions, HCR 67, Box 176, Everton, AR 72633 or call (501) 427-3274.

Treadle hammer for sale: \$800 or best offer. This is one of the ones made at the BAM workshop with Clay Spencer, probably never used. Possibly some other equipment. Contact John Brandt, 9400 County Road 457, Steedman, MO 65077 or call (314) 676-5668.

25-pound Little Giant, good condition, just needs motor. Metal to metal clutch, old style (made in 1914, I think) \$750. Also I have a heavy duty, very old but excellent Barnes drill press with new Jacobs chuck for modern bits. Originally ran off line shaft but easily converted to electric motor. Drills to center of a 15" circle. This is a well-built heavy-duty drill press. \$250. 120 pound Mousehole anvil, rough top needs John Murray treatment, \$100. (Mouseholes are an old brand, real collectable.) Jim McCarty, (314) 897-4111.

Gallery looking for forged items: Exclusively Missouri, a craft store located in Independence, is looking for blacksmiths to make items for sale in the shop. This gallery specializes in country crafts made by Missouri artisans. Owner Donna Leker travels the state looking for unique items for her shop and would like to hear from BAM members. If you have items for sale call her at (816) 373-5767. Tell her Jim McCarty sent you.

Need brooms tied on your fireplace sets? Contact John and Judy Schoolcraft, HC 65, Box 42, Sullivan, Mo. 63080, (314) 468-5703. The Schoolcrafts are well-known for their broom tying skills. John says the handles need to have some kind of hole in the end. Contact them for details and price. You might have seen them at the Ozark Conference a few years ago.

For sale: Buffalo Forge with Champion Fire Pot, refractory cement bottom. Champion 400 blower, \$175. Call Jim Kendzora, (314) 374-4153.

For sale: Quenching oil and linseed oil. Call Pat McCarty, (314) 239-3814.

Wanted to buy: Large anvils, 200 to 800 pounds. Owns Country Trader Flea Market in Collins, Mo. Buys and sells tools and antiques, has a lot of blacksmith tools for sale. Robin Wood, Junction 13 & 54, Collins, MO (417) 275-4400.

Classified ads are free to BAM members and anyone who has something to sell to a BAM member (which should cover just about everyone). Send your ad to the editor, Jim McCarty, Rt. 1 Box 20, Loose Creek, MO 65054. Ads will be run one time only unless you tell me to run it again.

For sale: Diacro Spartan Roller, Model #4, 24-inch \$350. Niagra 30-inch slip joint brake \$325 or make offer. Home-made 30 inch brake, needs some refinement, \$50 or make offer. Emil Bubash, (314) 892-4086, 3151 Lin-Tel Rd., St. Louis, MO 63125.

For sale: 25-pound Little Giant, completely rebuilt, \$2,000. Jim Hunt, 230 NW 11 St., Warrensburg, MO 64093. (816) 747-7965. Jim knows the whereabouts of a large gas forge. Call him for details.

For sale: Forge, hand crank blower and anvil. This ad came from my Rural Missouri ad. The lady doesn't know what it's worth — make an offer. She sent two photos. Forge appears to be a Champion with round fire pot, rectangular shape with one end round, missing legs. Anvil appears to be a Vulcan,

# BAM

## Bulletin Board

*Got something you need or need to sell? Just jot it down and send it to the editor, Jim McCarty, Rt. 1 Box 20, Loose Creek, Mo. 65054. Be sure to let me know if you want to run it again. All Classified ads are free.*

looks like it is in perfect condition. I'd judge it about 120-130 pounds. Write to Rose Marie Shorner, 12000 NE 120, Kearney, MO 64060. Tell her Jim McCarty sent you.

New Edge of the Anvil: I left out the address in the last issue for the new Edge book by Jack Andrews. Write to: SkipJack Press, Inc., 637 Drexel Ave., Drexel Hill, PA 19026.

Little Giant Parts: In case you didn't know, Sid Suedmeier has parts for all makes of Little Giant Hammers. In fact he bought out the factory. He also occasionally has complete hammers. Sid is hosting a Little Giant rebuilding seminar March 3-5, 1995. At his seminars a hammer is completely gone over. Cost is \$85. To contact Sid write to: Little Giant/Automotive Inc., 420 4th Corso, Nebraska City, NE 68410 or call (402) 873-6603.

# Zimmerrose

1. Under the power hammer the 40 mm bar was shouldered and the stem drawn to a 20 mm round or to fit snugly in a round hole in the swage block.

2. With the large end at a yellow heat the stem is inserted into the swage block and the master/striker dance began. Rotating clockwise around the block, the master leading with his hand hammer, the striker following with his short handled 12 pound sledge, the full diameter end was quickly drawn to about 1/2 its length.



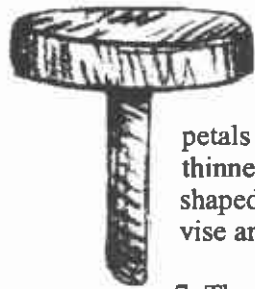
3. With the long disc now heated it was cut with anvil hardy and top cutter around its circumference back to the diameter of the drawn-down stem. The proportion appeared to be 1/3-2/3 thickness wide between the cuts.

4. One more full heat on the large end and back to the swage block for further drawing and inside out tapering of the two discs.

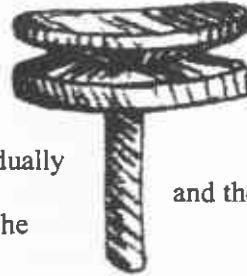
5. At this point the work moved to the post vise and the petal forming anvil. This vise had a steep taper on one end, a shorter taper on the other, a somewhat rounded appearance from side to side and was used as both cut-

ting block and final petal shaping tool.

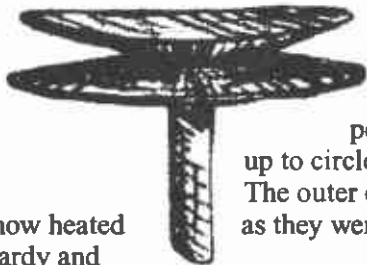
6. Whether by design or because of power failure the rest of the heating for his shaping of the petals was with the acetylene torch. The top thinner disc was divided into 5 sections with a hot cut, the corners nipped off



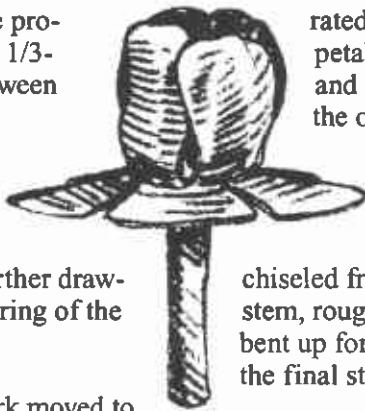
and the petals individually thinned and shaped over the vise anvil.



7. The first petal was tightly curled to form the center of the bud with the remaining petals thinned and curled up to circle the center one at a time. The outer edges of the petal were left as they were formed.



8. The other, thicker disc was similarly separated into 5 petals, thinned and formed into the outer larger petals.



9. Then the 5 hip stems were chiseled from the main stem, roughly rounded and bent up for clearance during the final stem drawing.



10. The stem was drawn down to final size and shaped with a large support stem left at the base of the flower.

11. The signature bud swell mid-stem, and flat ring at the end of the stem were then added.

12. Final shaping was then done with hammer, blunt punch and scroll tongs.

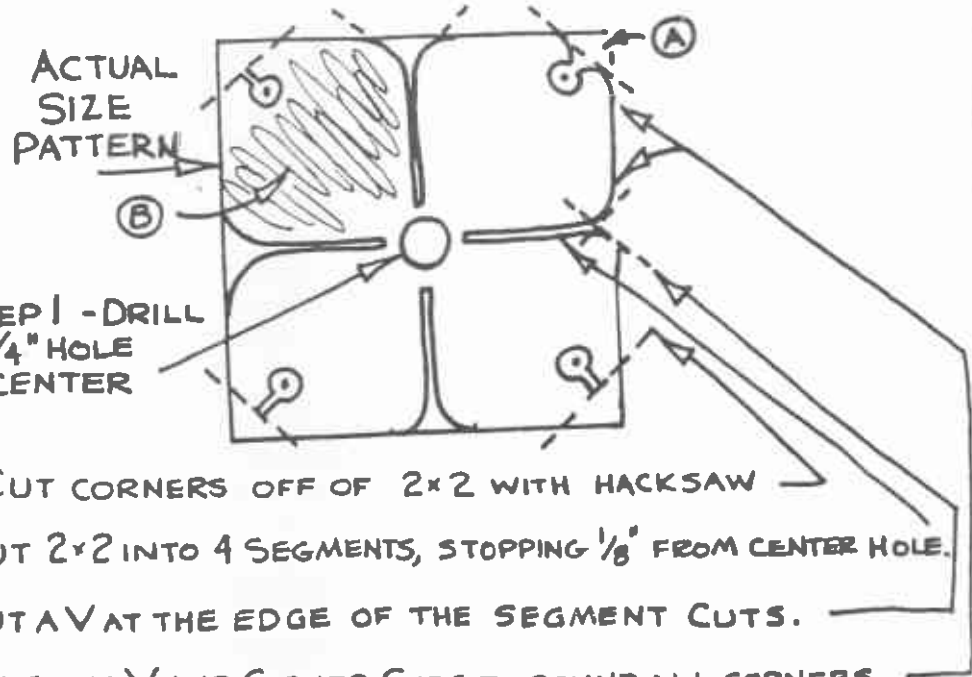
1/3  
±  
+  
2/3

13. Wire brush to remove scale, then brass brush to add the nice golden tone and the one piece rose was finished.

These notes were taken at the 1994 ABANA conference by Tim Underwood and the drawing is by Jerry Hoffmann.

YOU WILL NEED:

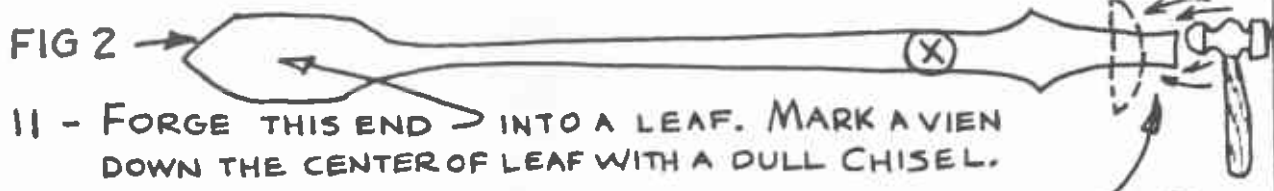
- A 2" x 2" x 1/8" piece of flat mild steel
- A piece of 1/2" round stock about 3" long
- A hacksaw, drill, 1/4" drill bit, 1/8" or 3/16" bit, 3 cornered file, center punch, cross pién and a ball pién hammer, a dull chisel, an anvil and a heat source (torch or forge). A vise and a pair of tongs or vice grip pliers is needed.



\* STEP 1 - DRILL A 1/4" HOLE IN CENTER

- \* STEP 2 - CUT CORNERS OFF OF 2x2 WITH HACKSAW
- \* STEP 3 - CUT 2x2 INTO 4 SEGMENTS, STOPPING 1/8" FROM CENTER HOLE.
- \* STEP 4 - CUT A V AT THE EDGE OF THE SEGMENT CUTS.
- \* STEP 5 - FILE THE V AND CORNER CUTS TO ROUND ALL CORNERS.
- \* STEP 6 - DRILL 4 · 1/8" OR 3/16" HOLES AT LOCATION MARKED © .
- \* STEP 7 - CUT FROM EDGE INTO THE 4 HOLES AND FILE (SEE A).
- \* STEP 8 - HEAT AND TEXTURE WITH PIÉN AS IN B ABOVE.
- \* STEP 9 - SINK CENTER OF FLOWER BY PLACING OVER HARDIE HOLE AND STRIKING WITH BALL PIÉN. (WITH FLOWER FACE UP.)

STEP 10 - FORGE A PIECE OF 1/2" ROUND AS SHOWN BELOW IN FIGURE 2.



- STEP 11 - FORGE THIS END INTO A LEAF. MARK A VIEN DOWN THE CENTER OF LEAF WITH A DULL CHISEL.
- STEP 12 - INSTALL COLD FLOWER ONTO YELLOW HOT STEM END AND CLAMP IN VISE AT X ABOVE. PEIN THE STEM END INTO A BUTTON OR MUSHROOM HEAD SHAPE THUS LOCKING THE FLOWER TO THE STEM. ADD TEXTURE TO THE COOLED BUTTON WITH RANDOM CENTER PUNCH MARKS. FOLD STEM IN HALF AS SHOWN IN FIG. 3. CLEAN WITH WIRE BRUSH THEN OIL.

# BAM

## Shop Notes

*Got a tip to share? Jot it down and send it to the editor, Jim McCarty, Rt. 1 Box 20, Loose Creek, Mo. 65054*

### Anvil repair

Here's the procedure Robb Gunter recommends for fixing an anvil courtesy of the Mid-Atlantic Blacksmiths Association:

1. Grind the area clean.
2. Pre-heat the anvil to 400 degrees. Heat with a large rosebud or for large anvils use a wood fire. Use a 350 degree and 400 degree temperature stick to ensure proper pre-heat temperature. Tempil brand markers are sold by many welding supply houses and Centaur sells them for \$7.25 each.
3. If the cast or forged part of the anvil is damaged, weld with Stoddy 2110 welding rod or equal. If the hardened face is damaged, weld with Stoddy 1105 welding rod.
4. Post heat to 400 degrees.
5. Pack the anvil (while still hot) in a container of vermiculite and allow to cool slowly to relieve stresses.
6. An anvil repaired with 7018 is not well repaired!
7. Grind and sand to desired finish.

### Hot air from Clay

How much blast do you need to heat iron? Bob Patrick had this advice during his demo at the

ABANA Conference: You need enough to blow the coal out of the firepot. But never crank it up that much! For more information than you can ever use on the topic order the July-August issue of Clay Spencer's Bituminous Bits. It has several pages on air for your forge, including hand crank and electric blowers. Cost is \$4 (includes postage) and the address is: Clay Spencer, 208 Metaire Lane, Madison, AL 35758.

### Uncoated bolts

Lots of BAM members have caught on to the fun things you can do with lag bolts. The problem is finding some that are not plated since the stuff that rustproofs also causes kidney problems if you breathe the vapors they put off. Here's a source for un-plated stuff: A & A Bolt and Screw, Inc., 1110 Batavia Farm Rd., Baltimore, MD 21237-0120; (410) 687-8831 or 1-800-638-4540.

— *Blacksmiths Guild of Central Maryland*

### When to quench

New members often ask this question: When should I quench? In many cases the answer is never. A quenched piece can become brittle and snap off either in use or as you forge on the other end. Quenching is useful when you need to hold a piece by hand or when you need to hit a piece in a spot that is already forged to get the right shape in another area. In this case you might want to reheat the quenched piece after the hammering is done and let it cool on its own. For most work this is the best way.

### Third hand

To fuller a piece of flat iron bar on one edge only, place a C-Clamp on the bar and the clamp will act as a brace when the steel is placed on top of the anvil. Now you have both ends free to complete the process.

### Patina on iron

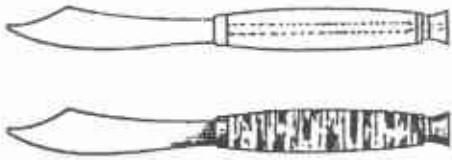
I have recently had a couple of jobs in which the customers wanted a

patina finish on IRON. Boy, what a hassle. The patina is very expensive and comes with virtually no instructions on how to get the effect or how to properly put it on. It became a series of hit and miss and lots of hours of frustration. Finally my trial and error approach payed off. First, you must have your iron as clean as possible (wire brush or sand blasting). Next, the most critical step is getting a good sealer/primer on your iron. Preferably a zinc chromate or epoxy primer. Make sure ALL joints, cracks, and bends are sealed, because the slightest "leak" will cause the patina to rust your iron swiftly! Next, you will need two coats of the liquid copper making sure that all your base primer is covered. Allow to dry thoroughly. CRITICAL: After the two base coats are dry, add a third coat of liquid copper and immediately spitz it down with the patina solution. It is best to spray the patina (I used a plastic spritz bottle), rather than sponge it on. (The solution cannot be used in a spray gun!). To get a beautiful patina finish, you must allow the solution time to develop. This can take anywhere from 3 to 7 days depending on the weather conditions and your shop atmosphere. After the patina has developed to the point that you are satisfied, then the sealing coat can be applied. For this I used a clear coat to finish off the project.

— *Richard Sheppard, Pittsburgh Area Artist-Blacksmiths Association*

### Handles from horn

Artistic handles for hunting knives and carving sets can be made using disks of horn. Get some cow horns from a slaughter house and split them with a saw, using only the large portion of the horn. Heat the horn in an oven, then press between two plates to a flat piece. Then cut the horn into squares of suitable size which are marked and perforated in the center with a hole slightly smaller than the size of the tang of the blade you are going to handle. The tang should be flat and a little longer than the desired handle, with the end forged round and threaded for a nut.



### Cheap rat nose tongs

After breaking the points off a pair of external snap ring pliers (poor, Asian-made type) and not being one to waste anything, I saw a pair of small rat nose tongs in them. Since the metal was high carbon but low hardness, I hardened them by heating about 1 inch on the rein side to the tip to critical temperature (dull orange heat), quenched in water and the tempered at the highest setting on my kitchen oven (500+ degrees to a purple-blue color). Asian-built snap ring pliers are built heavier than quality North American ones and are about the same size and thickness as ordinary needle nose probably to compensate for the soft metal, but they harden up nicely and are a lot cheaper than American ones.

— Marlon Racz, *The Rivet*

### Torch tip

At a scrap yard find a piece of old grating. Place grating on top of an

old steel drum or a steel garbage can and cut work. Most scrap will fall in the can and not on the floor. Safer too. Avoid galvanized grating because of the fumes from burning zinc.

—Indiana Forge Fire

### Emmert vises return

The Emmert Patternmaker's vises have achieved a splendid reputation over the last hundred years of use. Trouble was they were not made anymore. This vise was mounted to the side of a table in such a way that it can be used in nearly any position without reclamping the work. Its jaws will accept wedge-shaped work and an auxiliary jaw will help it accept double compound pieces. A reproduction of this vise is now available from American Machine and Tool for \$249 plus \$20 shipping. To order write AMT, 4th Ave & Spring St., PO Box 70, Royesford, PA 19468 or call (610) 948-0400.

—Indiana Forge Fire

A suitable washer is placed on the tang, which is then heated sufficiently to burn its way through the pieces of horn as they are placed on the tang. When a sufficient number of squares are in place a second washer should be slipped on followed by a nut. Apply pressure by turning the nut while heating the pieces of horn. Repeated heatings and tightenings will force the horn pieces tightly together to form a perfect joint. Apply only moderate pressure.

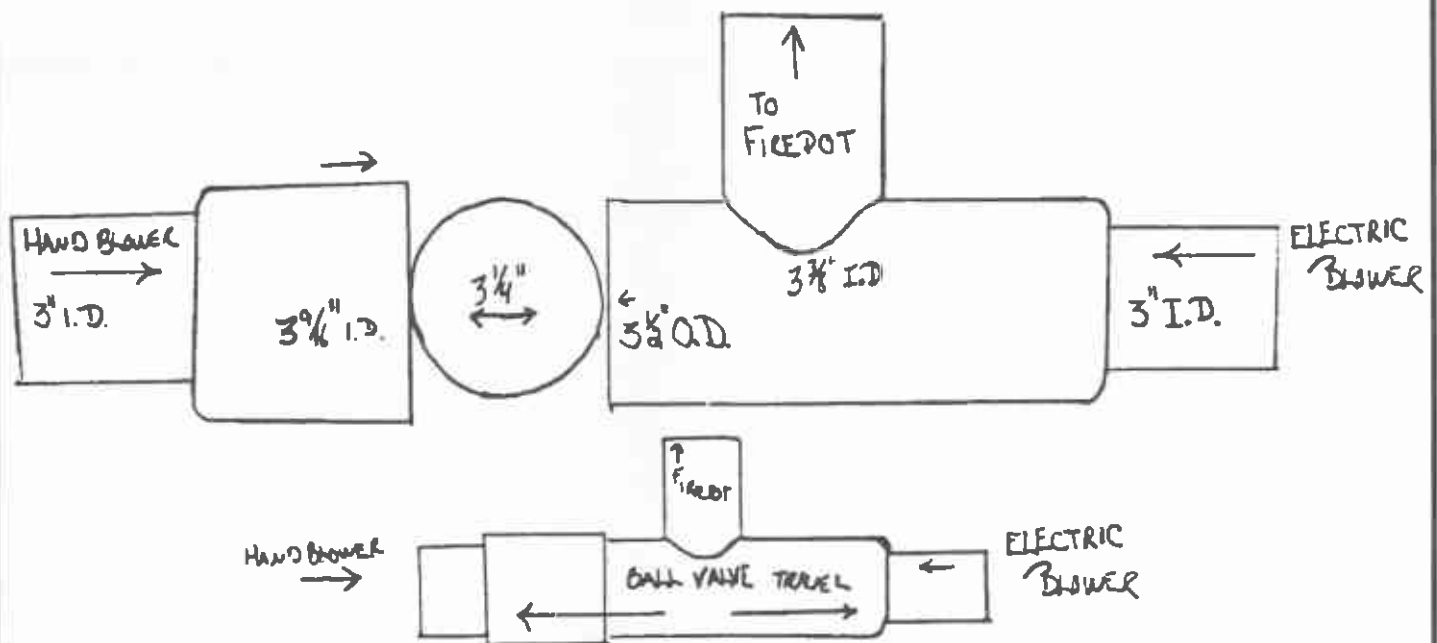
The handle can now be finished to the shape desired on a belt sander and buffing wheel. Try alternating black and colored pieces of horn for the look of agate. The blade and handle can be laquered and the ferrules nickleplated.

—Submitted by Emil Bubash from a book published in 1915

### Double check valve

Below is a double check valve Lester Six made for his forge to enable him to use either a manual or electric blower. Looks like a very good arrangement allowing you to use one or the other with the ball traveling back and forth blocking the other opening.

—Pittsburgh Area Artist-Blacksmith Association



# BAM NEWS

## What's yer 20?

The next issue of this newsletter will feature a roster of BAM members, complete, we hope, with addresses and telephone numbers. You can help make this list accurate by sending any change of addresses or telephone numbers to Maurice Ellis at the address listed on the back page of this issue. Maurice keeps track of addresses and prints our mailing list each time we run a newsletter. Many older members don't have telephone numbers listed — please check the last roster we published and get Maurice that info if yours is missing. Also, a lot of folks are getting into the computer age and have addresses in cyberspace, on the Internet or one of the on-line services. It might be helpful to know this info too.

One other reminder — Maurice is kind enough to print the date your membership expires as the top line of your address label. Please check this issue to see if your dues are due. That's the only reminder you will get other than an empty mail box when the newsletter goes out next time.

Thanks for your help on this.

## Craft in transition

Albert Paley will be one of the featured panelists in the symposium titled "Craft in Transition" to be held November 5 at the Spencer Museum

of Art on the University of Kansas campus in Lawrence. It is held in conjunction with the opening of the nationally touring exhibition "Sculptural Concerns: Contemporary American Metalworking."

The conference will probe the current trends and issues in the field of metals in relation to the social, cultural and economic realities of our times, or so the brochure Walt Hull sent me states. (Walt, do you all you Kansans talk like this?)

Anyway, along with Albert, whose work is included in the show, will be a number of esteemed artists, art critics and art professors who will bring together a lot of knowledge on current trends in metal sculpture. To attend you must register by sending a check made out to KUEA/Spencer Museum of Art for \$10 (\$5 for students who attach a copy of their student ID) to Spencer Museum of Art, At: Lori Eklund, University of Kansas, Lawrence, Kansas 66045.

Walt offers crash space at his place just south of Lawrence. Call him at (913) 865-5771 — that's the shop number.

## Jim Cooper workshop

Put this one on your calendar — on March 25 and 26, 1995, Jim Cooper, resident smith at the Metals Museum in Memphis, will give a workshop on forging tomahawks and

hatchets at the Appalachian Center for Crafts in Smithville, Tennessee.

The rest of the center's schedule is still being set but the events coordinator says Jim Batson has been invited to do knives again in June and Jim Cooper will be back for another round in July.

Seems like the center is pretty close to Nashville and might be a pretty good way to spend some of BAM's scholarship-fellowship fund. Will keep you up to date when the schedule arrives. For more info call Ilene Quall at (615) 597-6801.

## To Memphis for metal

The long talked about BAM trip to the metals museum has just gone from concept to reality. President Pat McCarty says Jim Wallace and company at the National Ornamental Metals Museum in Memphis has given us a date of Jan. 14 & 15 to come to the museum, see the displays and do some forging in the museum's shop as part of a tri-state hammer in. Pat is working on a bus to take us there and back, but we need to give him a head count. The event is open to spouses, and the museum will loan us their bus so they can see the sites while we pound metal. More details are coming in the form of a post card from Pat. Please get back to him ASAP if you plan to attend. His number is (314) 239-3814.

## BAM Schedule

### November Meeting

Hank Knickmeyer, Cedar Hill, Mo., Dec. 3.

### Beginner's Workshop

Lou Mueller, Valley Park, Mo. Dec. 10-11

### Metals Museum Trip

Memphis, Tenn.  
Jan. 14 & 15

### January 1995 Meeting

Jerry Hoffmann, Lonedell, Mo., Jan. 21, 1995

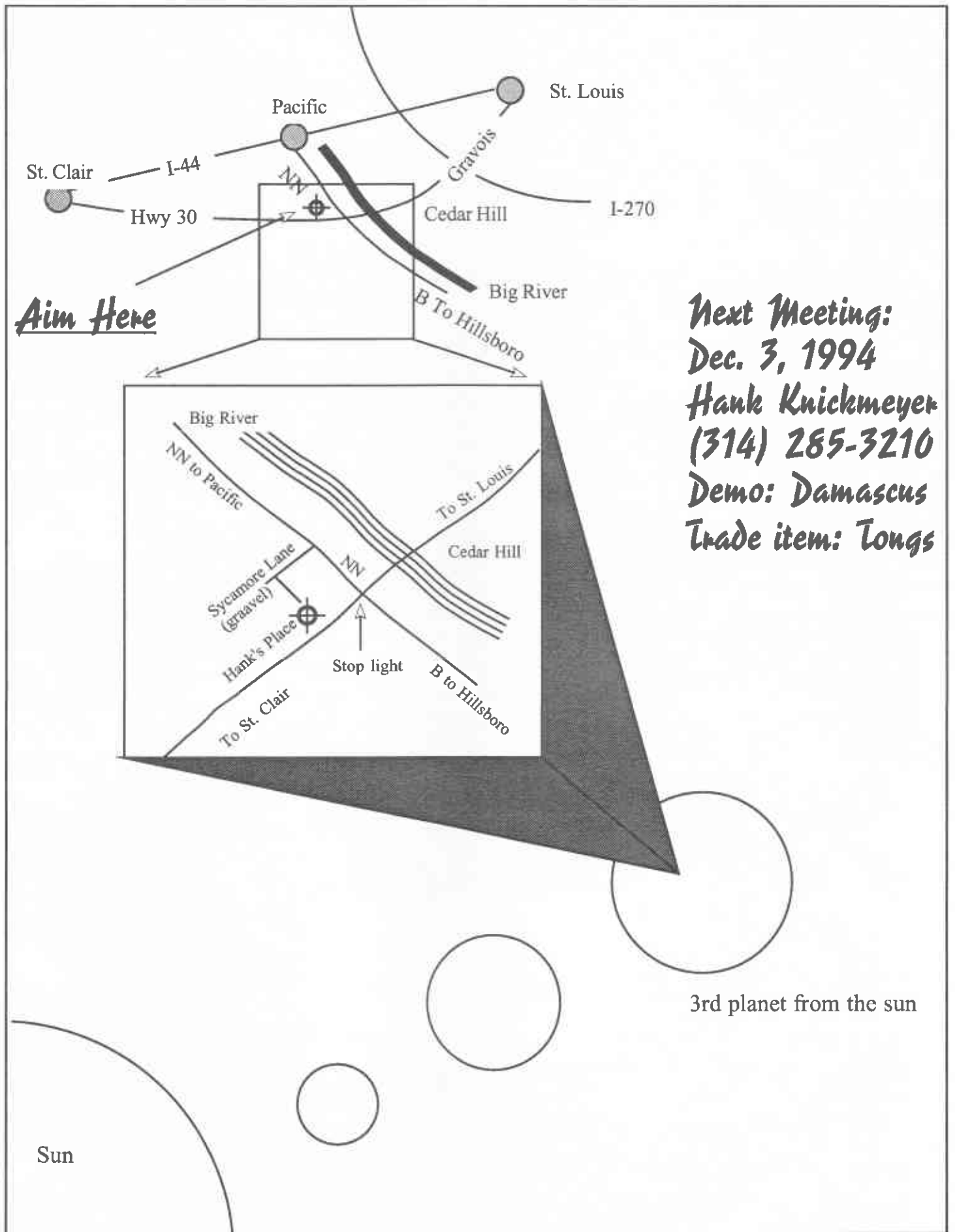
### March 1995 Meeting

Maurice Ellis, Belgrade, Mo.,  
March 25, 1995

Ozark Conference, Potosi, Mo., April 29 & 30

### May 1995 Meeting

Walt Hull, Lawrence, Kansas,  
May 20, 1995



*Next Meeting:  
 Dec. 3, 1994  
 Hank Knickmeyer  
 (314) 285-3210  
 Demo: Damascus  
 Trade item: Tongs*



*Tortbin Pace, left, a teenager from Rolla, shows his skills by making a poker at the Christianson Native Craft Workshop held this summer. Turning the blower for him is Ian Fricker of southern Illinois. Don't you wish you started this young?*

**BAM**  
**Rt. 1 Box 20**  
**Loose Creek, MO 65054**

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**Address Correction Requested**

Please send changes to Maurice Ellis, Rt. 1, Box 1442, Belgrade, MO 63622