

# RAM

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NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

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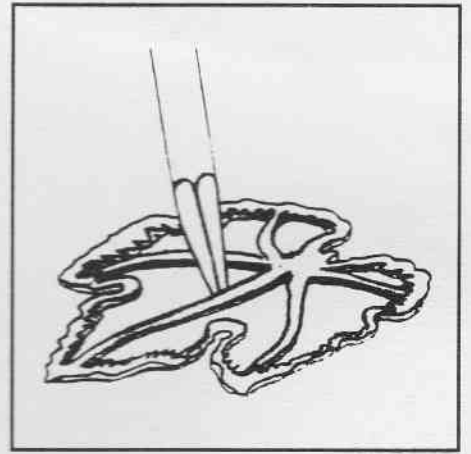
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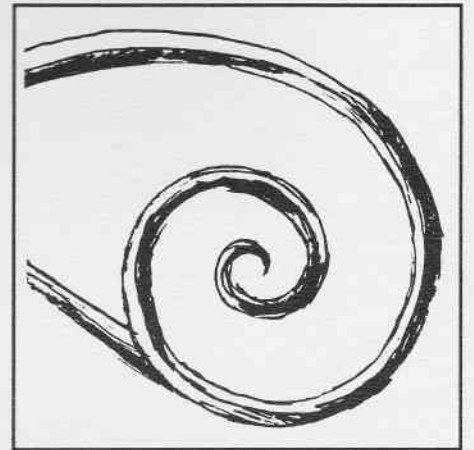
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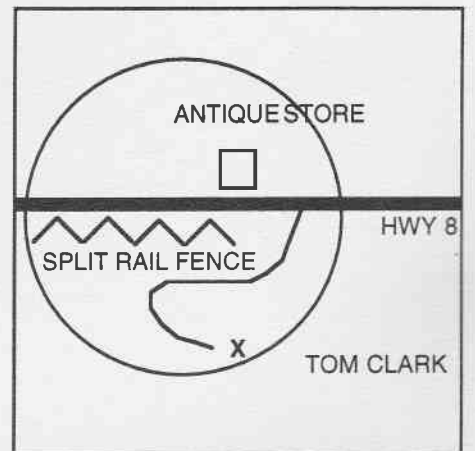
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**Newsletter of the  
Blacksmiths  
Association  
of Missouri**

**September — October  
1997**

*Volume 14 No. 5*

**Our cover:** Tom Clark uses his Hofi hammer to put the point on a nail at BAM's September meeting held at Joe Wilkinson's Hope Forge.

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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, 5821 Helias Dr., Jefferson City, MO 65101; (573) 395-3304. BAM membership inquiries should be addressed to: Maurice Ellis, Rt.1 Box 1442, Belgrade, MO 63622, (573) 766-5346. 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.

**BAM Membership Application**

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

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

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

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

New Member     Renewal

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

Do you need any tools? \_\_\_\_\_

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*



As I write this one last day of Indian Summer is blowing away with an approaching cold front and it looks like the weekend might bring some snow. That would suit me OK as it has been too hot to forge for too long.

There's been a bunch of happenings and I had to miss them all. Sure wish someone would drop me a line with the scoop on some of the past events. I'm thinking of the get together at SIU, the Tom Latané workshop at Mt. Vernon and Tom Clark's Event of the Century auction. Also the Upper Midwest Regional in Pontiac and the SOFA Conference.

I'm sure we had members at all of these and those of us who couldn't make it would like to hear your tale.

I did get a report on Tom's auction from Tom himself. He was a little disappointed at the turnout but said he met his goal. That means he has the funds to finish his Ozark Blacksmith School.

The first classes will be in May. He will again have the Hofi class similar to last year's and will add an advanced class for those who took the intro.

Back to the auction, there were some real bargains to be had and some stuff that folks just went nuts on. Sounds like your typical auction. Can't believe that was all from Tom's stash. Bet if we scrounged around some we would find enough for another sale.

I've been on a tool buying binge lately. I bought a big swage block and a bridge anvil from Ed Cowan. Ed also made me quite a deal on a pile of tongs and hammers.

Ed lives in Mountain Grove and has been a BAM member since moving to Missouri from the Northwest. He's been earning his living at the forge but had to give it up due to a bad case of asbestosis. Too bad, because he was doing some fine work.

I also picked up a 650-pound Peter Wright anvil and a monster machinest vise. Both came from the Frisco sheds. When they closed them down three monster anvils were going to the scrap yard. This one fell off the truck, so to speak.

Apparently not enough of our

members voted in the ABANA election because Lou Mueller was not re-elected to the board. That leaves ABANA without a president, likely the first order of business when they convene in November at the Metals Museum. Sorry to see you go off the board Lou.

I thought Lou did a good job of balancing the various factions and maintaining the order in the tough president's job. On the plus side, now he's got more time to devote to BAM stuff!

Don Asbee and me teamed up to show off at the Hartsburg Pumpkin Festival in October. We had one of the BAM side draft forges and drew a big crowd, especially when Don picked up the striking hammer and we made the anvil ring. People really like to watch a striking demo and no one seemed to notice when we messed up.

Brother Pat manned the forge at Luxenhaus Farm for their big event and I understand he did super. He had plenty of merchandise to sell and the crowd was buying.

Somehow Pat got the Washington newspaper to do a full page story on him in their feature section. It never mentioned how we taught him all he knows. Think I'll write a rebutal

Before that we had Joe Wilkinson's meeting. Sorry the newsletter didn't arrive on time (I got mine the day of the meeting.) There's no reason this one shouldn't have been out on time as it went to the printer Labor Day.

I tracked down the problem. Turns out it was being printed on the day I asked for it to be mailed. That also happened back in August at Doug's meeting. I think I have them straightened out.

Also, you will find the dates for the next three meetings posted in this issue. Hopefully you can make plans now to attend these meetings.

Getting the newsletter out has been a real struggle for me lately. I am doing two other magazines besides this one and Emily is taking a lot of our time. It would help a lot if I had plenty of material to choose from. Please see if you can send me something for the next issue. My



files are getting pretty thin.

Special thanks to Walt Hull and Stephen McGehee for their major contributions.

Until next time,

— Jim McCarty



Sorry to have to report that our good friend Big E, Earl Hawkins, died Oct. 17 after a long struggle against a variety of ailments. Big E was a long-time member. Several years back he had us out at his place.

He suffered from MS and the doctor made him quit driving his pick-up. Undaunted, Big E bought a Cadillac limo and kept driving.

More than once he shared a sample of some of his gourmet cooking with us at one of our gatherings.

## Goodbye Big E

That guy could do steak!

Big E was quite a character. He had a horse that was famous for his taste in beer. E would give him a Stag and he would spit it out. Then he would give him a Michelobe and the horse would slurp it down.

He was also the guy who coined the name "Blood Alley" for Highway 21. One of those killed on the dangerous stretch of road was Earl's

son, Matt. He posted signs on the highway that read:

"Danger: You are driving Blood Alley — Highway 21."

Those who attended his wake were greeted by a photo of Big E wearing a cowboy hat, holding a Bible in one hand and a gun in the other.

That's him, all right.

We'll miss you Big E. Thanks to Emil Bubash for sending me the article in the St. Louis Post-Dispatch on Big E.

## Job Opportunities in Agriculture

Dear Mr. Secretary,  
US Dept. of Agriculture

My friend, Joe Wilkinson over at Hope, Mo., received a check for \$1000 from the government for not raising 50 hogs. So, I want to go into the "not raising hogs" business next year.

What I want to know is, in your opinion, what is the best kind of farm not to raise hogs on, and what kind is the best breed of hogs not to raise? I want to be sure that I approach this endeavor in keeping with all the government policies. I would very much prefer not to raise Razorbacks, but if that is not a good breed not to raise, then I will just as gladly not raise Yorkshires or Durocs.

As I see it, the hardest part of this program will be keeping an accurate inventory of how many hogs I haven't raised.

My friend, Joe, is very joyful about the future of the business. He has been raising hogs for twenty years or so, and the best he ever made on them was \$422 in 1971, and this is until this year when he received your check for \$1000 for not raising 50 hogs.

If I get \$1000 for not raising 50 hogs, will I get \$2000 for not raising 100 hogs? I plan to operate on a small

scale at first, holding myself down to about 4,000 hogs not raised, which will bring in about \$80,000 the first year. Then I can afford that airplane I've been wanting.

Now another thing, these hogs I will not raise will not eat about 100,000 bushels of corn. I understand that you also pay farmers for not raising corn. Will I qualify for payments for not raising any corn to feed the 4,000 hogs I am not going to raise?

Also, I am considering the "not milking cows" business, so please send me any information your department has on this program, too.

In view of these circumstances, you understand that I will be totally unemployed and will qualify for unemployment compensation and food stamps. Be most assured that you and the President will have my vote in the coming election.

Patriotically yours,

Ed Harper

PS Would you please notify me when you plan to distribute more surplus cheese?

*Editor's note: This sounds better than Maurice's "Put Money in Can" franchise. Wonder if we can get EPA to pay us not to burn coal? Good luck Ed in your new endeavor. Thanks to Willie Calhoun for sharing this.*

## Best of the Newsletters

The Arizona chapter of ABANA has put together a nice book of plans, tips and advice from the chapter newsletter exchange. Dan Jennings was kind enough to give me one at the Caniron Conference. I set it out at the demo I did in Hartsburg and it gave folks a good idea of what blacksmiths can make.

To get "Most of the Best From ABANA Chapter Newsletters" send \$30 (\$25 for the book + \$5 for mailing and packaging) in check or money order to:

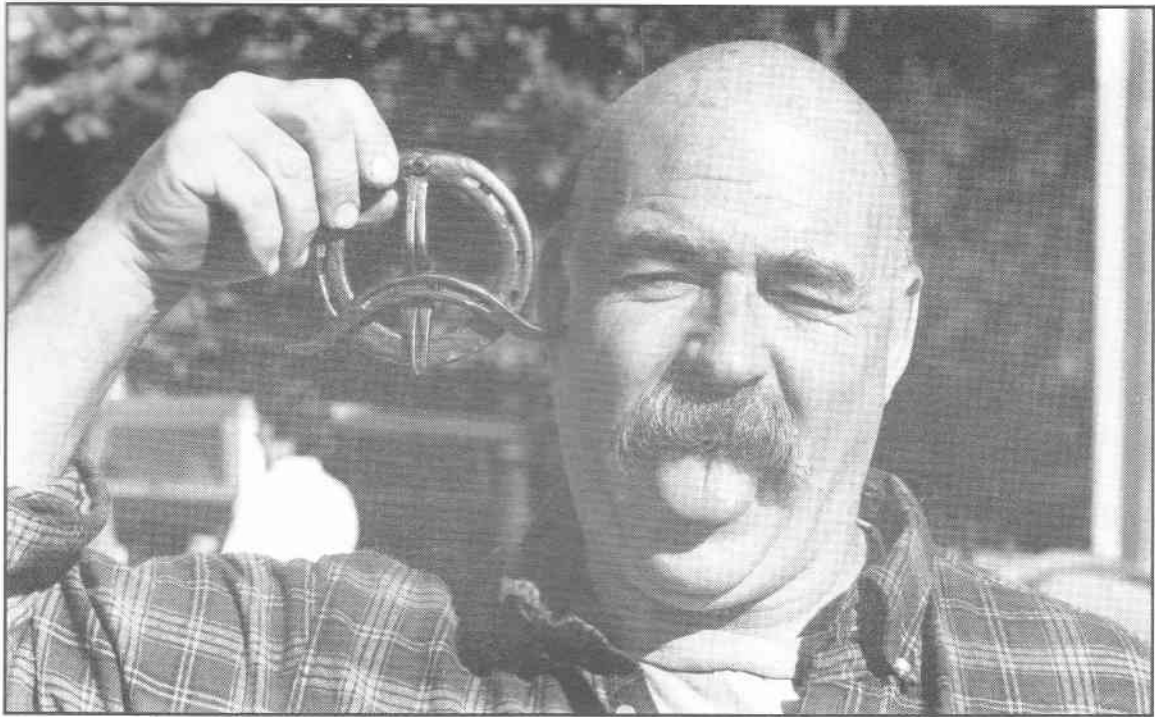
Dan Jennings  
2522 W. Loughlin Dr.  
Chandler, Arizona 85224

The format is 8 1/2 x 11 in a 3 ring binder. They are planning to make supplements periodically, but you can add to your book at any time.

There are 12 sections dividing the content so you can find what you're are looking for. The sections are: General info, techniques, finishing, tooling, tongs, forges, bending and twisting, knives, axes, hawks and choppers, flowers and leaves, hooks, fireplace tools, misc. projects, hardware, animals and wizards.

There's a lot of work from the BAM newsletter, a real compliment to our members. This puts it all together in a form you can take to the shop.

Thanks AABA for your efforts!



## Unusual Creature Lives On Lobster Lips

### Newly Discovered Animal Resembles Nothing Else Known To Science

Compiled From News Services

**COPENHAGEN, Denmark** — Danish biologists have discovered a tiny creature living on the lips of lobsters that is so unlike any other known animal that it does not fit into any of the broad classifications into which the animal kingdom is divided.

The bottle-shaped creature resem-

discovered ones are added to the list every day. But they 'all belong to about 35 recognized categories, or phyla.

A phylum is a broad classification embracing organisms that share certain basic characteristics. Humans, for example, are members of the phylum Chordata, the pigeonhole hous-

The creatures sometimes grow so thickly around their hosts' mouths that they resemble chalky fuzz.

The discoverers, Peter Funch and Reinhardt Moberg Kristensen of the University of Copenhagen, have named the new phylum Cyclophora, from the Greek for "wheel bearer," for the creature's circular maw.

asexual mode, the adult produces internally a bud that is a genetic duplicate of itself. Periodically, the parent sheds its upper half, including the nervous system and a disintegrated mouth and gut, and like the objects that flew out of Pandora's box, the larva escapes to begin life on its own.

Meanwhile, the parent grows a

I'm looking to purchase a LARGE firepot similar to Buffalo Forge's Railroad model. It measured 14.5 x 17 inches.

Centaur no longer carries them (the price was outrageous anyway) so I tried Buffalo Forge themselves.

Interesting info I recieved.

Buffalo Forge no longer makes blacksmithing equipment, but in their storage area, they apparently have a lot of parts still sitting NEW!!

Although the guy I spoke with couldn't find the firepot I was interested in, they do have enough parts to build some blowers and such yet. The problem they have, is no one

## Bring back the Buffalo!

there nows what goes with what part to complete a unit.

They seem to have just part numbers and maybe a part name.

Apparently, the company has been bouncing around the idea of building blacksmithing equipment again, they are just unsure on the demand.

They do still have most of the patterns though. So if anyone is in need

of a part to get a Buffalo Forge item working, it wouldn't hurt to try this number. (716) 731-8380. The name of the fellow I spoke with was Tim.

Also, if you would like to see them manufacture blacksmithing items again, let them know.

— Claude, Calgary

*Editor's note: This came from an e-mail sent to theForge, ABANA's e-mail list. Sounds pretty interesting, never would have guessed they were even in business still. If we all call them twice a day for a week, you never know. . . .*

# BAM

## September MEETING



*Above: Don Asbee does something he doesn't do in his own gas forge equipped shop — tend the fire.*

by Jim McCarty

V.J. McCrackin was the star attraction at BAM's September meeting, held Sept. 20 at Joe Wilkinson's Hope Forge. Last time we met at Joe's V.J. showed us how to forge a blade. This time he finished the job, demonstrating heat treating.

V.J. started by showing some of the steps he had to go through to earn his ABS journeyman and master designation. In both levels the bladesmith must do the following:

- Cut through a hanging piece of 1 inch rope in one swing.
- Chop a 2x4 in half.
- Still shave the hair off his arm.
- Bend the blade 90 degrees without it cracking.

With his knife he did all but the bending part, as that pretty much destroys the blade. He did this part later with a blade he heat treated.

He brought two blades along that were pretty much finished. The first one was forged from 5160, the same stuff truck springs are made of. The other was 52100, a touch more exotic.

He showed us two ways to heat treat — one with the entire blade tempered the same and the other differentially treated, so that the edge had a different temper than the rest of the blade. He did his quenching in a

mix of motor oil and transmission fluid.

V.J. took us up to lunch with his demo and the inevitable question and answer session. Then we lined up for BBQ sandwiches from the Rough Riders Saddle Club.

We had a small showing for the iron in the hat but the crowd really came through, netting \$71 which we voted to give to the saddle club. As

usual the Williamsons were winners. I'm going to let them drop my tickets in next time.

With Bob Alexander unable to attend, Pat did one more turn as president. We set the location and date for the November meeting — Tom Clark's Ozark Blacksmith School on Nov. 22.

We talked about the state fair demo and tossed around some ideas for next year. I took some notes for John Murray and if I ever find them will post the rest of the minutes.

After that mercifully short business meeting (Bob, take note) Tom Clark and Don Asbee stepped up to the forge. This unlikely combination soon had a big fire roaring and with Tom talking and Don cranking Joe's Champion 400 we got another interesting demo.

First Tom knocked out a few nails, showing us how he taught the Southeast Regional how to make nails. Tom has a real nice nail header, made under the tutelage of Uri Hofi during the time he spent in Potosi. Tom's header lets the nail come out with ease.

Just so we could do it ourselves Tom and Don teamed up to forge a new one. Don swings a pretty mean sledge hammer, though the consensus of the crowd was it would be a lot easier to weld the handle on than to let Don draw it out.

When I left rain was spitting and Don had played out, leaving the sledge hammer for Tsar Sadan, Uri's helper on loan to Tom until he can get his shop bolted together.

Rumor has it these two have a whole line of products being produced down in Potosi.

Will sneak in with my camera and give you a glimpse.

As usual, we swapped some rusty iron and Randy Barringhaus took Joe's "little" No.2 Beverly shear home with him. Joe no longer needed the No.2, having robbed some estate of a No.3 Beverly, which he had mounted in the middle of the shop for all to see.

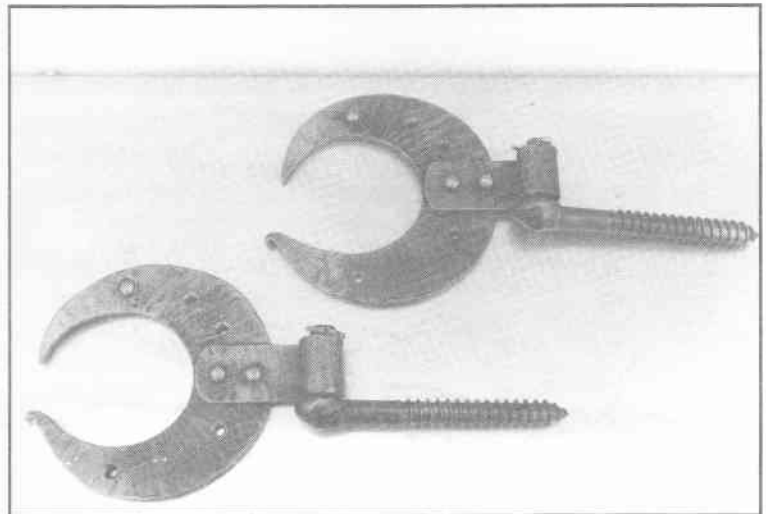
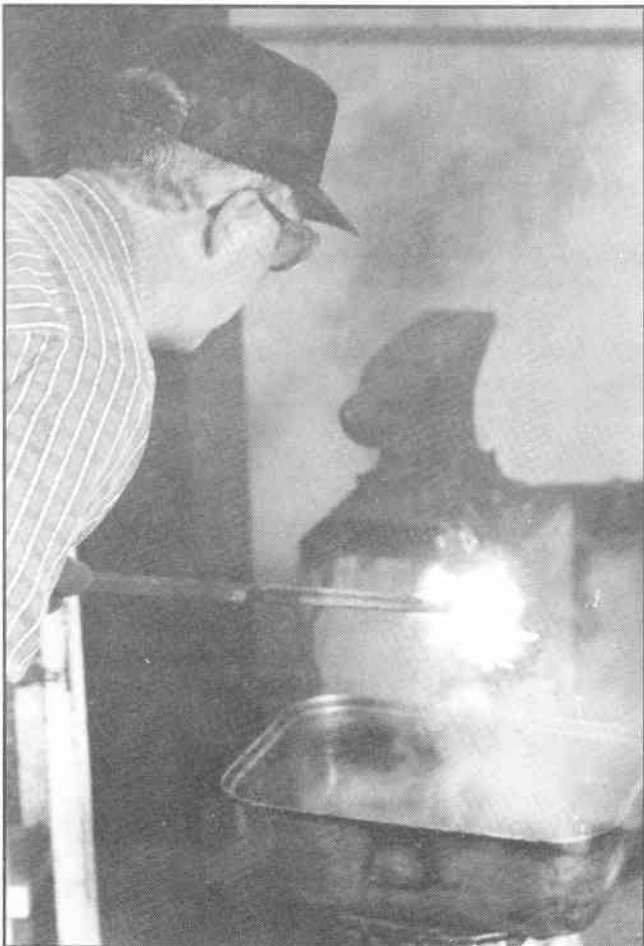
We found the Hope Forge in pretty nice shape, with everything laid out nicely and lots of storage for Joe's stuff.

Thanks a lot to Joe and Phyllis for





*Above: Our host Joe Wilkinson keeps a close eye on Don Asbee and Tom Clark. Don looks a bit rusty at turning a hand crank blower.*



*Left: V.J. McCrackin showed us how to temper a knife blade two different ways. Above: Trade item hinges by Randy Barringhaus were much admired by all. How'd he forge those threads?*



# ABANA

PO Box 206 - Washington, Missouri 63090 USA  
Janelle Gilbert, Executive Secretary

Artist-Blacksmiths' Association of North America

Office Hours 9:00am - 5:00pm CST  
Voice/Fax (314) 390-2133

## PRESIDENT'S MESSAGE to the ABANA Chapters

November 1997

Dear Chapters,

### HAMMERIN' ON THE HOOCH

March 1998 will be 25 years since Dimitri Gerakaris sat up all night and scribbled (as he calls it) a proposal for the founding of what was to be called ABANA. In the morning he re-read the proposal, made some revisions, and at breakfast presented the idea to Alex Bealer, Ivan Bailey and Brent Kington. The rest is history.

There were approximately 47 blacksmiths at that first meeting. And in 1998 we will be edging close to 4,700 members. This past 25 years has seen a lot of ups and downs, I think the organization has become what our founders had in mind. We have established communication through our publications, central office, internet and chapter liaison which reaches the entire world. There are conferences, large and small, library, archives, demonstrators, equipment, liability insurance for all our activities, scholarships, exhibitions, finance (seed money) and a trust fund. These are all in place and operational.

The coming winter conference, Hammerin' on the Hooch, at Columbus, Georgia in March of 1998 is a good example of the support that ABANA can give. Dan Tull and David Cornett are putting a program together for Board approval, whereby ABANA will accept all responsibility both financially and legally, issue seed money and advertise in the *Anvil's Ring* and the *Hammer's Blow*.

I feel we are now entering a new phase where ABANA can use its resources to help support chapter programs.

*Thought to Ponder:* If you don't where you're going, you'll never get there.

Sincerely,

Lou Mueller  
ABANA President



## CHAPTER LIAISON NEWSLETTER

ABANA - PO Box 206 - Washington, MO 63090 phone/fax (314) 390-2133

Nov  
1997

### 1998 ABANA CONFERENCE

As the leaves start to fall, I find myself sitting next to a warm wood fire and thinking about the 1998 ABANA Conference in Asheville, NC (June 17-20 1998). Conference Chairman, George Dixon and his team have put together what promises to be a great program.

Our biennial conference gives us the opportunity to learn, share our knowledge, and give our time. Items are needed for the auction and Iron-in-the-Hat programs that provide much needed income for keeping ABANA alive as well as for special programs. All of the auction proceeds go to off-set the conference and to the general fund.

This year's committee is making extra efforts to attract people outside ABANA to come to the auction and see what is available from today's artist blacksmiths. A special auction brochure is being prepared and distributed in nearby major market places. The spring issue of the *Anvil's Ring* (the one out just before the conference) is going to feature items for sale in the conference auction. In order to meet this schedule, you need to send a photo of your donation to the editor, Jim McCarty by early January 1998. Contact Jim at (573) 395-3304.

The 1998 Iron-in-the-Hat will again feature tools. Sid Suedmeier (Little Giant) prepared a completely rebuilt twenty-five pound Little Giant power hammer.

Pat McCarty (BAM's past president) is donating not one but two "BAM boxes". Both will be filled with tools donated by our membership. One will be sold in the live auction, the other will be in the Iron-in-the-Hat. Your donation of items for the Iron-in-the-Hat are needed. Tools that are not put in the boxes will be put in the Iron-in-the-Hat. Remember, all proceeds from the Iron-in-the-Hat go to ABANA's Scholarship Fund.

### 1998 RING PROJECT

Chapters: don't forget about the Ring Project. This year's ring grill (designed by George Dixon) signifies the touch mark of Francis Whitaker. Francis and his team of six, headed by Clay Spencer, have been working on the details of this grill since May. It is going to be a beauty. Please help this program by sending a ring from your chapter. Rings not chosen for the grill will be put in one of the auction programs.

The 1994 Conference Ring Project and the 1996 Iron-in-the-Hat programs were very well supported and very well received. Please help this year to make these programs better than ever.

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*The content of this month's Liaison Newsletter,  
submitted by*

Tom Clark  
ABANA Director  
1998 Conference Committee

### *Note from the ABANA Office:*

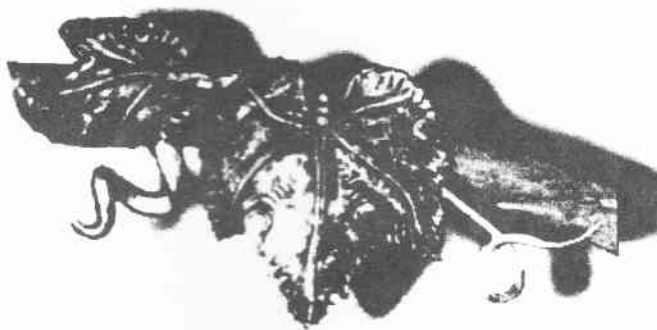
The August, September and October mailings of the ABANA President's Message and Liaison Newsletter were never published. We appreciate the interest that ABANA chapters have shown in wishing to obtain these. We should be back on track now with this November mailing.

# Motif:

## Cold Chased Leaf

Stock: 1/8" sheet metal.

Tools: 1st and 2nd pass Butchers, Flatter, Curved and Straight chisel, elliptical section chasing tool.



**Wear Your Safety Glasses**

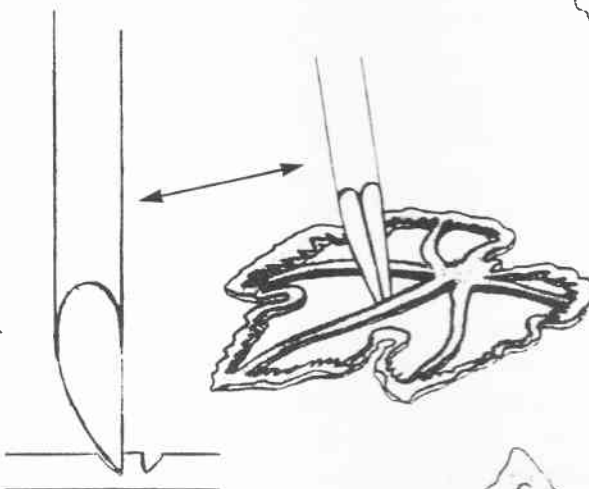
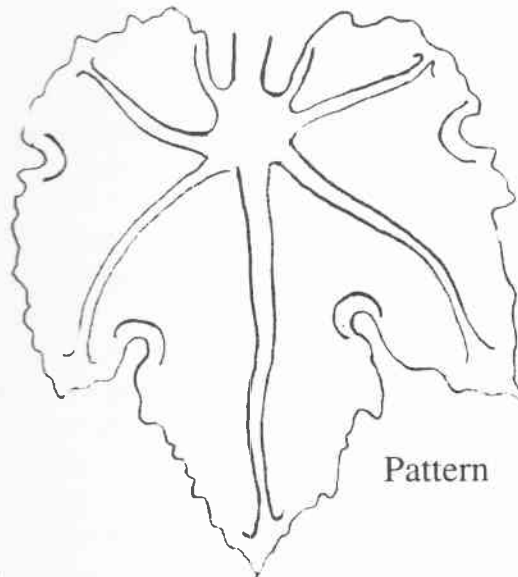
Texture the 1/8" sheet metal by bringing the metal to a high forging heat in a coal forge. After a layer of scale appears, remove and brush the metal clean. Replace in the forge and take a second high heat. After a pronounced scale pattern has occurred, brush the cooling metal until it drops below scaling temperature. The last wire brushing will make the subsequent hand sanding much easier. Do not quench the metal, that both cinches the scale down and slightly hardens the plate which makes the cold chasing more difficult. This process will give the metal a marbled pattern that becomes apparent when it is hand sanded. Hand sanding comes after the processes that follow are completed.

For a more pronounced pattern, lightly forge the hot, scale covered surface with a crown-faced hammer. This drives the scale into the surface and makes for a more variegated surface when it is hand sanded, again, after all processes are completed.

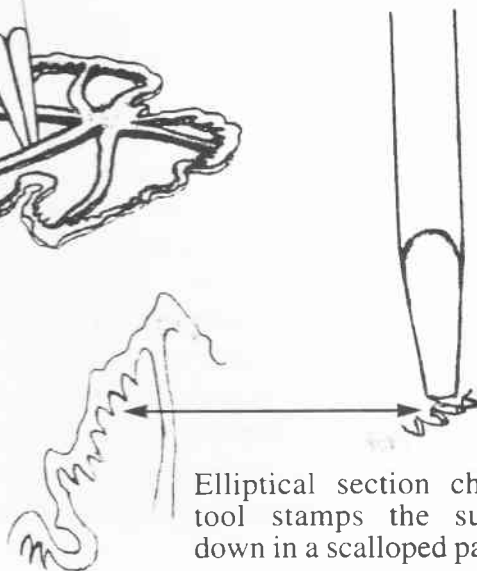
Glue the paper pattern to the textured 1/8" sheet metal after it has cooled. Use chisels (or a jewelers saw) to cut the leaf blank out.

Take the first pass butcher (the steeper angled butcher of the standard two butcher set) and cut through the pattern to transfer the vein layout to the metal. The butcher should have its vertical face towards the vein.

Once the veins are incised, take the elliptical section chasing tool and stamp a scalloped border around the inside of the perimeter of the leaf blank. The first pass will establish the pattern to be followed in repeated developing passes. Be sure to pay attention to tool placement so the scallops blend seamlessly into the ends of the veins as they touch the perimeter of the leaf blank. Pay attention to where the back of the tool is to prevent marring the veins behind the tool as the scallops are developed by the front of the tool.



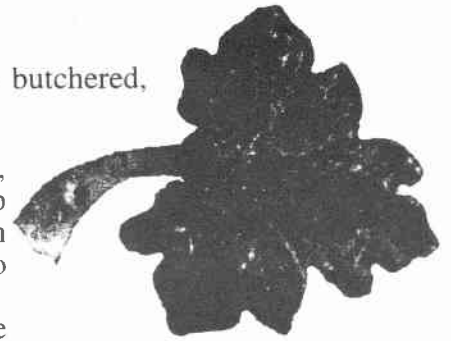
The first pass (steeper angled) butcher.



Elliptical section chasing tool stamps the surface down in a scalloped pattern.

# Motif:

Picture showing surface butchered, scalloped and chased.



Alternate between the butchers, 1st and 2nd pass configurations, and the chasing tool to both set-down the metal along the veins and stamp in the scallop pattern to the same depth. That depth is about  $3/32$ ", which sounds slight but it takes a lot of force applied through repetitive passes to move cold metal with the control that an intricate pattern requires.

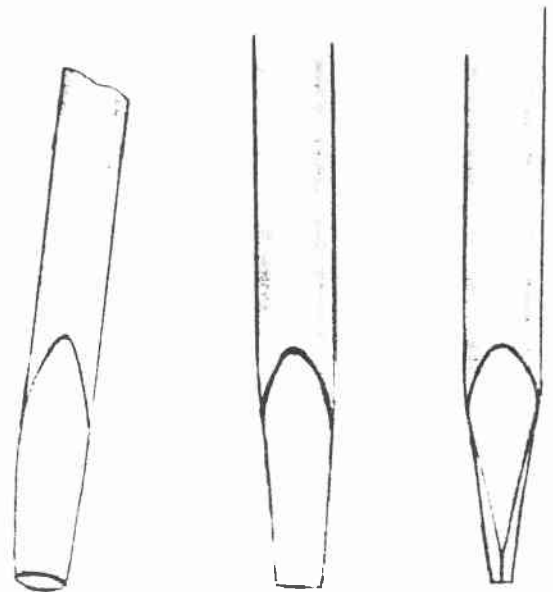
Once the pattern of veins and border is well established, use the same elliptical chasing tool to compress (chase) the cold metal in the 'field' bounded by veins and border down to the same depth everywhere. It takes some care to use a small tool to chase metal down to a common depth while avoiding irregular tool marks. There is a difference between tool effects that texture the surface and random, unequal marks that come from working too fast with too little attention to developing the effects. It takes some care to keep the finished surface even using a small tool. However, the smaller tool fits into the tight spaces between scallop and vein, plus a smaller tool face conducts the force of the driving blow more efficiently than a larger tool face.

After the entire surface inside the scalloped edge is chased down, take a small, square flatter and dress any rough areas as needed. In all cases of tool use be sure to keep continuous contact with the surface while moving and striking the tool. This not only minimizes the chance of setting the tool on an edge as it is struck, thus marring the effect, it also gives a smoother result than setting and striking the tool. See the **Apprentices Notebook** for a more detailed review of tool shape and use.

The last step in forming the leaf is to take a heat, place the leaf face down onto a block of hardwood and drive a ball tool or ball peen hammer into the back of the leaf. This forces the hot metal down into the wood which burns out under the tool pressure while the wood around the point of pressure supports the leaf. The result is a domed leaf form. One last heat is used to turn the tips of the leaf up in opposition to the down-thrust of the dome, giving the leaf some visual tension and grace. Hand sand and coat with a clear coating.



The elliptical section chasing tool that both scallops the edge and compresses (chases) the surface of the leaf.



Perspective view showing the face of the tool.

Front view.

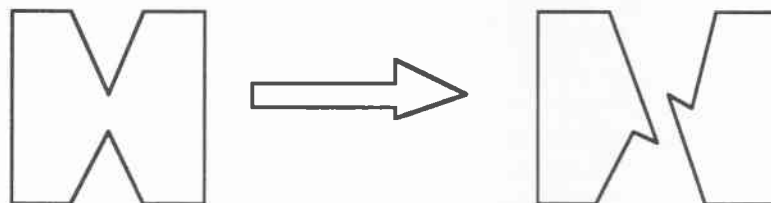
Side View.

Closeup of the finished leaf. Curved chisel cuts are used to accent the indentations along the edge of the leaf.



# Tips from the Branching Scroll Research Dept.

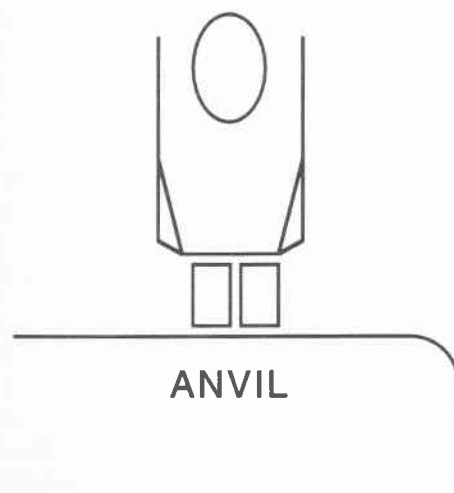
When you split stock on the anvil, you often end up with a ragged inside edge:



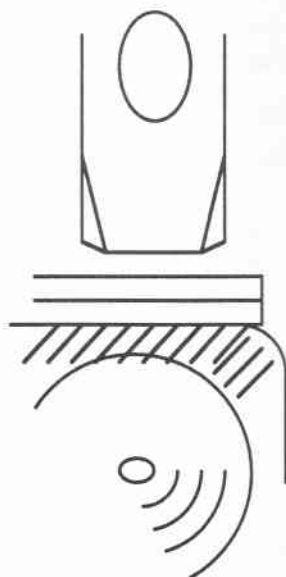
To avoid this, first mark the sides carefully about 1/4 way through from each side. Then stand the piece up in the



vise and split down. The chisel will follow the marks with a minimum of steering, and there will be less rag.



Works for weenie forks, too.



Next, draw out the two pieces together, turning frequently to keep them even. If one gets ahead, trim it before separating for final taper and dressing. The inside will be nice and smooth

by Walt Hull  
Illustrations: Jim McCarty

For sale: Two commercial hydraulic presses. Raycene electric operated adjustable hydraulic valves, 5 inch cylinder, quick change dies not included. Not equipped with pump. \$350 each. Guy McConnell, LaPlata, Mo. (660) 332-7354.

For sale: Treadle hammer. Clay Spencer design made at BAM treadle hammer workshop, \$850. 50 pound Little Giant converted to air hammer. Huge dies, needs 5 hp compressor, \$2,500. Contact Maurice Ellis, (573) 766-5346.

Jim Kendzora has the following items for sale: Electric paint shaker, gallons or quarts, \$50. Abrasive blast cabinet, 22 inches wide by 18 inches deep with extra window liners. Cost \$150, take \$100 or trade. Tumbler, commercial double barrel. Old but runs good. \$200 or trade. Blacksmith coal, 50 pound bags \$7.50 each. (573) 374-4153.

For sale: Hydraulic forging press, 24-ton, 5 horsepower electric, \$2,500. V.J. McCrackin, (314) 677-6066.

BAM members, time is money. I have a CNC plasma cutting system in my shop in Columbia and will offer my services to BAM members at a 10 percent discount. I will cut anything you desire. Flowers, leaves, custom designs. CNC plasma cuts parts fast. From art to parts I do it all. Call (573) 474-8749 and ask for William Irvin for more details.

For sale: Port Huron Sawmill, with 48 inch inserted tooth blade. 40 feet of track, runs on a 6 cylinder Continental industrial engine. Excellent condition. \$3,000 or trade for 100 pound Little Giant. Pat McCarty, (314) 239-3814.

Hammers, tongs, fullers, flatters, cutters, chisels, punches, swages & blocks, cones, firepots, hand vises, pliers, coal and more. The finest smithing tools in the world. Tool list available upon request. We ship and accept Visa and Mastercard. Steve Kayne, 100 Daniel Ridge Road, Candler, NC 28715. (704) 667-8868 or

665-1988 or fax (704) 665-8303 or e-mail: kaynehdwe@ioa.com

The editor has a homemade forge with a Cannedy-Otto Royal Blower on a stand for sale, \$100 for the pair. Also I have a small post vise, \$40, might have more junk by the time you read this. Call Jim McCarty, (573) 395-3304, evenings.

Want to swap for 50 pound Little Giant or bigger hammer: Blue porcelain enamelled Moore's parlor stove, coal or wood. 4-1/2 feet tall, 2 feet square, 300 pounds. Includes delivery and pick-up. Stephen McGehee (501) 643-3299.

New source for coal: Andrew MacDonald called with a new source of coal on the east side. It's loose coal, good stuff. They have a loader. Call (618) 684-3166 for more details. This is a trial run so go buy some so they will keep it up.

Heavy duty frying pan blanks, steel, approx. 9 inches diameter with 2 inch sides — 12 gauge (.095) thickness. Has two 3/16 inch holes for your decorative handle, \$7.75 each, \$7 for 5-9, \$6 for 10 or more pans. Shipping \$2.50 plus 50 cents for each pan. Bob Tuftee, 3855 Aspen Hills Dr., Bettendorf, IA 52722.

Lee Quaintance, BAM member from Kansas, wants to let folks on that side of the world know he has a source for bulk coal at \$75 per ton. You can reach Lee at (913) 893-6797 for more details.

Pass that rusty iron around! If you're not using it let someone else. Send your Bulletin Board items to the newsletter or load up your truck and bring it to Tom Clark's meeting November 22.

Bob Alexander always has nice rebuilt anvils for sale and occasionally a forge and other neat stuff. Bob's at (314) 586-6938.

Need something or got something for sale? Contact the editor at (573) 395-3304 or fax it to (573) 395-3201 and I

# BAM

## Bulletin Board

will get it in (or talk you out of it.)

Jere Kirkpatrick's Valley Forge and Welding has many items of interest to blacksmiths including fireplace shovel blanks, brooms for your fire sets, treadle hammer kits, tongs, belt sander plans, brash brushes, candle cups, rose cutouts and much more. For a catalog give him a call at 1-800-367-5373.

Mike Williamson discovered this source for handles down in the Current River country: Beamer Handle Co., PO Box 159, Van Buren, MO 63965. (573) 323-4241. Manufacturer of ash and hickory tool handles.

I found a lot of brand-new Heller Bros. cast steel hot-cut hardies produced for the War Department for WWI or WWII. There's a shipper, but it's not dated. The mil. spec is: 3/4" Str. Hardies #97 Square Shank, Type VII GGG T 561 Stk. 41-4626.5-07 These hardies stand a full 3.25" tall above the anvil. Blade width is 1.875". No rust — original black paint. The 3/4" square shank is 2" long. (I used a piece of 1" square tubing to fit one to my 7/8" hardie hole). I'm selling them for \$20 ea (I can mail them for \$4 each for postage and envelope). I'll eat any CA tax due. If you want one call Andy at (626)798-6588 or write to me at 2197 N. Allen Ave, Altadena, CA 91001.

SCROLLS NEVER SEEM TO GO AWAY. YOU SEE SCROLLS OR RELATED CURVES IN MODERN AS WELL AS TRADITIONAL IRON WORK AND ON THE SIDES OF HOTRODS AND PETERBILTS BECAUSE THEY ARE AN OBVIOUS AND NATURAL ANSWER TO THE PROBLEM OF WHAT TO DO WITH THE END OF A LINE! CURL IT DOWN TO A THEORETICAL VANISHING POINT. A WORK I'VE BEEN WORKING WITH LATELY IS THE SCROLL ON THE DIAMOND. THE SHADOWS ON THE STOCK SET OFF THE CURVE DRAMATICALLY!



BRANCHING SCROLLS ARE VISUALLY INTERESTING BECAUSE THEY DEMONSTRATE THAT JUST BECAUSE YOU KNOW WHERE A CURVE HAS BEEN DOESN'T MEAN YOU KNOW WHERE IT'S GOING. REMEMBER THAT THE NEXT TIME SOMEONE GIVES YOU "THE" MATHEMATICAL FORMULA FOR SCROLLS:



IF YOU SPLIT SQUARE STOCK ON THE DIAMOND YOU GET TWO PIECES WITH TRIANGULAR CROSS-SECTIONS. TO GET TWO BRANCHES WITH DIAMOND CROSS-SECTIONS, YOU HAVE TO PUT THEM TOGETHER. HERE'S AN EXAMPLE:

CUT A PIECE OF  $\frac{1}{2}$ "  $\Phi$  BAR  $16\frac{1}{4}$ " LONG. MARK WITH A CHISEL AT  $8\frac{1}{4}$ " FROM ONE END AND DRAW EACH END TO  $\frac{1}{4}$ "  $\Phi$  SO THAT ONE END IS  $1'-0"$  FROM THE MARK AND THE OTHER  $1'-1"$  FROM THE MARK. FLATTEN EACH END ON THE DIAMOND THUS:



AT THE CHISEL MARK, LAY THE PIECE IN A V-BLOCK AND FLATTEN ONE SIDE (ON THE DIAMOND) FOR ABOUT  $1"$  EITHER SIDE OF THE MARK:



(2)

I ALSO LIKE TO BREAK THE CORNERS SLIGHTLY WITH THE HAMMER THE FULL LENGTH OF THE STOCK FOR TWO REASONS: I LIKE THE LOOK, AND IF IT IS NECESSARY TO STRIKE THE CORNER IN FORMING OR LEVELING THE SCROLL IT WON'T SHOW AS A DING OTHERWISE SHARP CORNER.

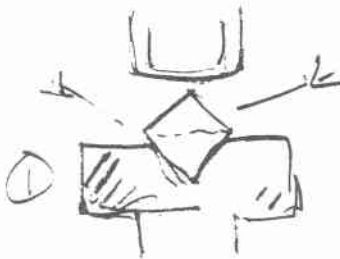


OR IN AN

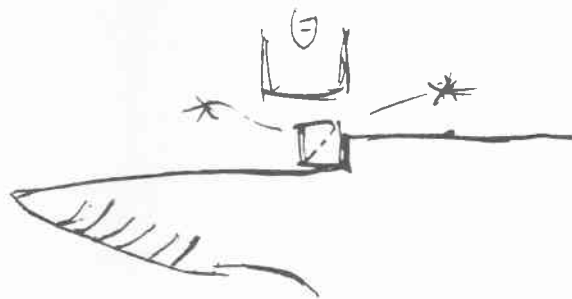
NOW CHISEL IN AT THE MARK AND FOLD THE TWO FLATS TOGETHER. TAKE A HEAT AND WELD:



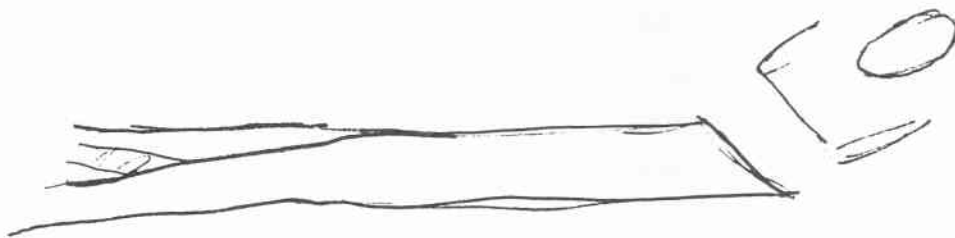
WHEN I WELD THESE I FIRST TAP THEM A COUPLE OF TIMES IN THE V-BLOCK TO GET THEM STUCK AND THEN MOVE TO THE STEP AND WELD ON THE SQUARE:



(2)

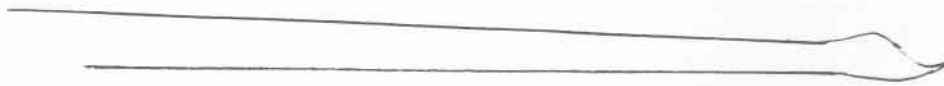


ONCE YOU'VE DONE A FEW YOU'LL FIND IT EASY TO MOVE TO THE FACE AND SCARF IN THE SAME HEAT. IGNORE THE FACT THAT THE BRANCHES ARE ON THE DIAMOND, AND SCARF ON THE SQUARE:



3

TAPER AND SCARF A PIECE OF  $\frac{5}{8}$ " # TO MATCH (WORK ON THE SQUARE - DON'T LET THAT DIAMOND STUFF CONFUSE YOU AT THIS POINT) AND WELD ON YOUR OTHER PIECE.



YOU SHOULD END UP W/ THIS:



WORK THIS TRANSITION SMOOTH AT WELD. HEAT

NOW YOU CAN SCROLL. NOTE THAT YOU HAVE 2 CHOICES AS TO HOW YOU BRANCH:



OR



ACTUALLY, YOU HAVE TO DECIDE CLEAR BACK THERE WHERE YOU FLATTEN THE ENDS, BECAUSE THE FLAT MUST BE AT 90° TO THE PLANE OF THE SCROLL

SCROLL THE LONG BRANCH FIRST

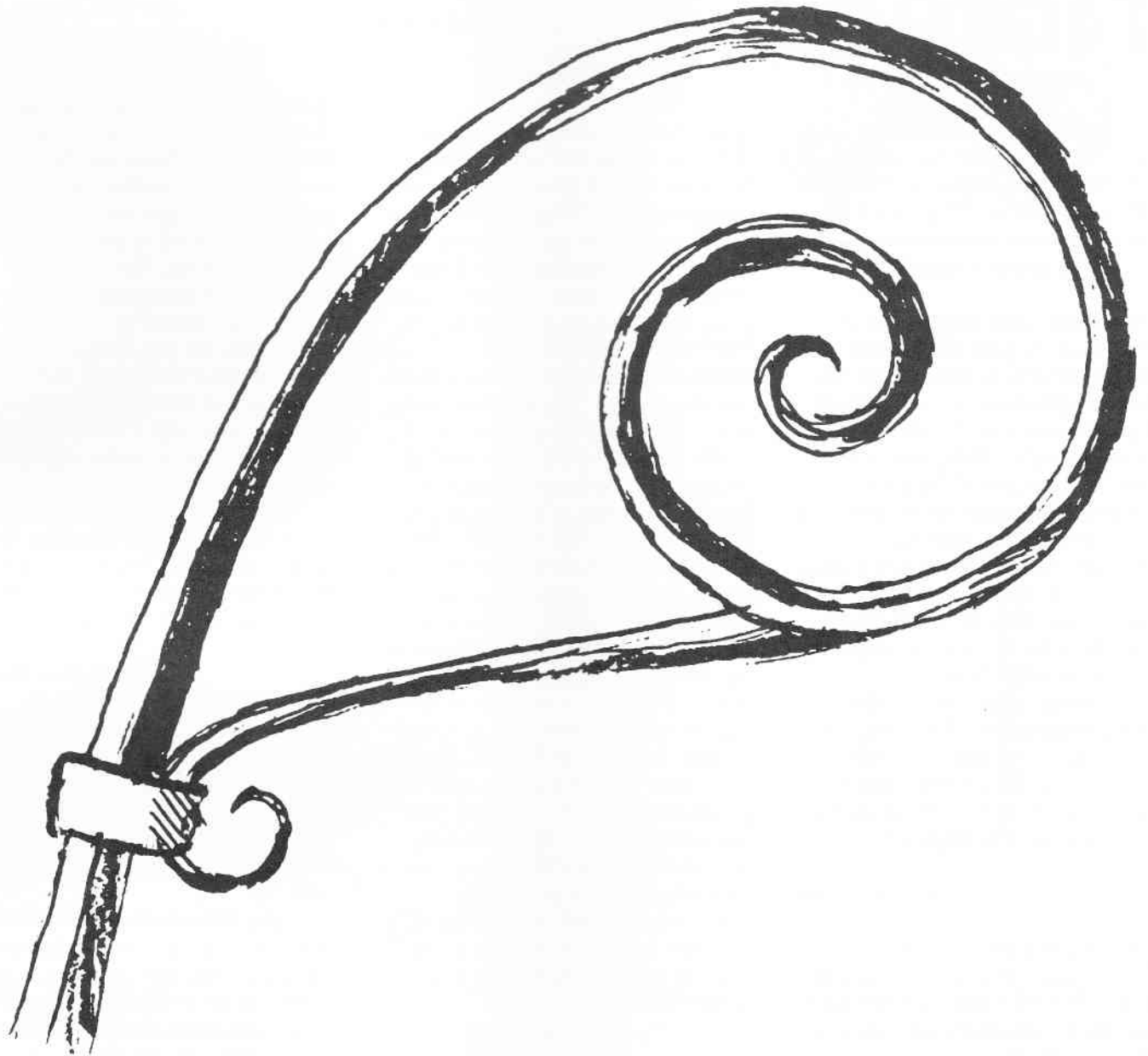


THEN THE OTHER, AND THEN THE COMMON PART. BE ESP. CAREFUL AT THE PART WHERE THEY JOIN, LEST YOU GET A KINK WHERE THE THICKER MATERIAL PROVIDES GREATER RESISTANCE. WORK HOT. IT IS MUCH EASIER TO DO THIS ON A FORM. IF YOU DON'T HAVE A FORM FOR THE SCROLL YOU WANT, MAKE IT. USE A SCROLLING WRENCH TO PULL THE MAT'L TIGHT TO THE FORM. BE CAREFUL TO STAY ON THE DIAMOND. TWIST IS EASIER TO PREVENT THAN TO CORRECT.



④

HERES WHAT I ENDED UP WITH, BUT THE POSSIBILITIES  
ARE LITERALLY INFINITE



# BAM

## Shop Notes

*Got a tip to share? Jot it down and send it to the editor, Jim McCarty, 5821 Helias Dr., Jefferson City, MO 65101 or FAX to (573) 395-3201*

### Vice mount question

I would like some suggestions on setting up my post vice. I have seen a number of setups, on the edge of a bench and standing alone in the middle of the work area. I prefer the vice to stand alone, as this allows easy access to all angles of the piece. I have seen many methods of mounting the vice, scrap 2x4s hammered together and driven into a dirt floor, I-beam with a wooden top attached to a large circular plate that allowed the vice to be moved, a similar setup bolted to the concrete floor, etc.

I plan to get more into carving and chasing metal so I need a stable platform on which to bash my metal. I also will have (hopefully) concrete floors in my workshop. What do the experienced smiths suggest?

— Stephen Deppen

Stephen, My favorite way to mount a multitude of vises and fabricating tables and devices is to bury an 18-24 inch, 3/8 wall 6"x6" square tubing into the floor and use your concrete floor as an anvil and the tube like a hardy hole tool, because 1/2" x 5"x5" tubing will slide right into that and you can put anything you want onto that and it will not move. If you find the slop of 1/16-1/8" unsatisfac-

tory you can drive some metal wedges into the seam between the two and it will be very stable. This works well putting it in before you've poured your floor obviously. Good thought to keep when building a shop.

My portable leg vise is mounted on that steel plate with the I beam in the middle that you mentioned, and I used Mark William's idea to put a plate behind the vice for all the bending jigs to fit in . . . thank you Mark.

— Ralph Sproul

### Little Giant tips

I just finished using my Little Giant 25 pound hammer after putting a brake on it. If I'd known how nice it was going to be I'd have done it long ago. A really nice modification, I highly recommend it. I have a sheet metal shield to keep any little pieces of spring out of me if it ever breaks. That thing acted as a sound board and you could hear my Little Giant all the way downtown. (7 miles away, well you could almost hear it that far.) It would vibrate the ear protectors right off of you. I got the bright idea of coating the inside of the shield with foam insulation that you buy in an aerosol can. It really quieted the shield down. But getting it in place is another story. I got it on my hands, on the floor, on my welding table and on my shoes. I even got a little bit in my pocket. But it did a nice job of making the shield quieter. Another modification I made a while back was to put grease fittings at all the lube points, even on the ram slides, you just have to be careful that nothing will hit them. I don't have to grease it very often and I'm getting better lubrication than by using oil. I just have to be careful not to stand too close after greasing as it tends to sling a little.

— Dan Cruzan

### Metal superstore

Metal Mart is a good source for small quantities of alloy steel and other materials. Here's the

address:

(Chicago)  
Metal Supermarkets  
1675 Tonne Road  
Elk Grove, IL 60007  
1-888-metal01

(Atlanta)  
Metal Supermarkets  
184 Selig Drive  
Atlanta, GA 30336  
1-888-metalnu

— Steven O. Smith

### Copper clad vises

I recently took a class in making fantastic creatures in metal that required a lot of carving. The instructor put copper sheathes on the vises in the class. Copper clad vice jaws held the hot work so much better than unsheathed vises. The copper cladding also prevented the piece from being marred by the jaws of the vice. Also, if I was bashing on a piece of metal in the vice and missed the piece and hit the vice (I am a rank beginner after all), I would usually hit copper and not the more expensive and important vice.

So, interesting shop tip . . . 1/4 to 1/2 inch thick copper sheathes for the jaws of your vice. Much thanks to Ray Spiller, the teacher of the class and proponent of this practice.

— Stephen Deppen

### That new steel look

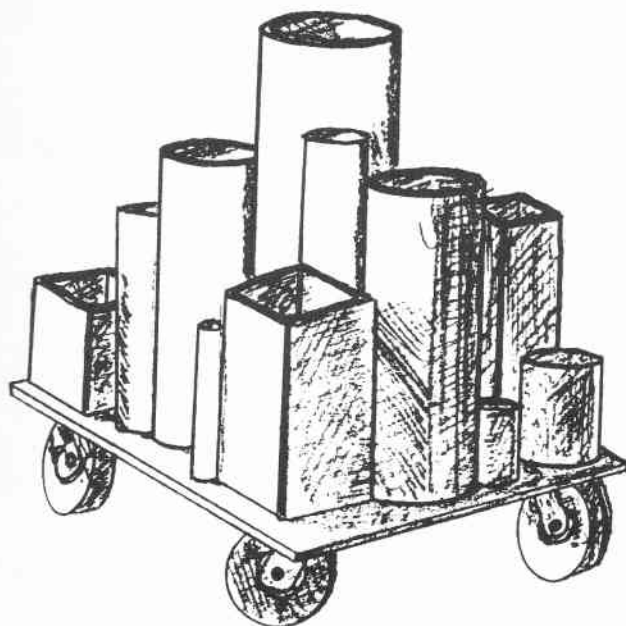
Ralph Sproul was looking for paint that would match the gray of mill scale that new steel has. Here's a response from theForge, ABANA's e-mail list:

If hardware store paint would work, you can take them a sample of the steel. They use a scanner to read it and duplicate the color. The sample only needs to be about 1 inch square. I've used this to exactly match my custom house paint. Should work on oil based enamel also. One gallon minimum order though. Good thing about this method is that they give you the color settings, so to later remix the exact color is easy.

## Tips from the shop of Roy Plumlee

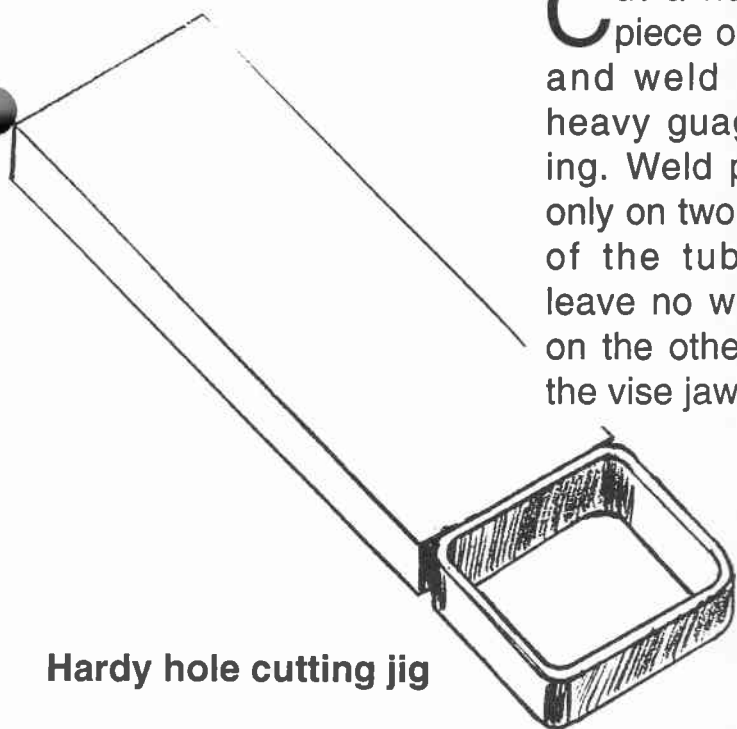
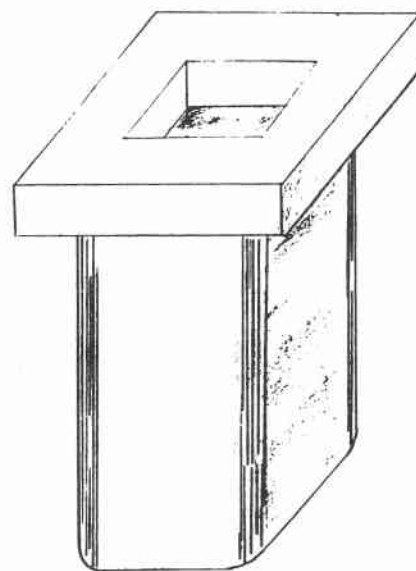
### Scrap caddy

Scrap pieces of tubing and pipe are welded together on a piece of plate to neatly store small lengths of stock. Four crazy wheels allow it to be moved out of the way in a small shop like mine. Smaller versions without wheels hold files punches, etc. on the work bench.



### Vise hardy hole

**C**ut a hardy hole in a piece of 3/4 inch plate and weld to a piece of heavy gauge 2 inch tubing. Weld plate to tubing only on two opposite sides of the tubing so as to leave no weld obstruction on the other two sides for the vise jaws to grip.



### Hardy hole cutting jig

**U**se this jig when attaching hardy stems to tools such as scroll jigs and bottom tools for the treadle hammer. Cutting a square hole in a die plate through which a square hardy stem is inserted and welded makes for a stronger attachment than welding the stem to the surface. My torch tip works just right to cut a clean square hole when I use this piece of 1-1/2 inch thin-wall tubing as a guide. The piece of bar stock welded onto one side lets me clamp it to the work piece.

# BAM NEWS

## New book from Francis

Francis Whitaker has a new book. It's called "Beautiful Iron," and if you have ever seen any of Francis' work you know the name is appropriate. "Beautiful Iron" is spiral bound, not too fancy and just full of photos depicting work from the master over 75 years.

In many cases Francis was kind enough to photograph a piece before it was assembled so you can see all the pieces that go into making the finished product. Even more useful are cut lists for some of the projects.

Where he had the records, he includes the time it took him to create the piece. He also tells some of the background that went into the design of the work, including some of the advice that came from the customer.

There is work from several periods in Francis' life, including the time he spent with Julius Schramm in Germany and with Samuel Yellin in Philadelphia.

There are candle holders, gates, fireplace tools and screens, signs, hardware, weathervanes, grills, handles and more than a few tips and techniques.

This book is a wonderful companion to his two other books, which include *The Blacksmiths Cookbook* and *My Life as an Artist-Blacksmith*. All three are available from the author. Details follow:  
*Blacksmiths Cookbook* — \$31.50  
*My Life as an Artist-Blacksmith* — \$42.50  
*Beautiful Iron* — \$42.50

All prices include postage. Send check to Francis Whitaker, C/O Colorado Rocky Mt. School, 1493 Coun-

ty Rd. 106, Carbondale, CO 81623.

## Book from the Blow

For those who may be interested in a compilation of information printed in back issues of *The Hammers' Blow*...

"The Best Of The Hammers' Blow, Vol 1" is now available at the ABANA office (314) 390-2133 and can be had for \$14, shipping included. It is 40 pages of how-to's, a section of basic blacksmithing (the Fundamentals of Blacksmithing) as well as intermediate projects and an extensive section on tool making (chisels, punches, fullers, chasing tools, etc).

It is packed with graphics (195 of 'em!) of project how-to's and step by step explanations. It is also a commemorative issue celebrating ABANA's 25th year (1973-1998).

The Best of the Blow was put together by its editor George Dixon. Hat's off to George for making this work available, as many of the early Hammers' Blows are extinct.

## WHAT! You didn't join ABANA?

Recently I did a search on the ABANA database, sorting out the ones with Missouri in their state field and I was stunned to find not all of our members belong to ABANA.

Are you guys crazy or something? Don't you know that ABANA membership gets you not one, but two magazines, *The Anvil's Ring* and *The Hammers' Blow*?

Didn't anyone tell you that your membership keeps the craft alive? That it helps sponsor the biennial ABANA Conferences like the one coming up in Asheville this summer, and the mini-conferences like the one in Arizona last winter? That you can access the ABANA library, chock full of videos from the masters of the trade? That ABANA has plans for air hammers, treadle hammers, gas forges and more that you can get free or real cheap? That your dues keep our executive secretary Janelle from turning to a life of crime?

Holy cow! Tear out that application form in the front of this newslet-

ter and get it off to Janelle post haste! Don't tell anyone, but dues go up to \$45 in January. If you hurry you'll save \$10...

## Send me your @

BAM is getting a good number of blacksmiths on line. Even technological laggards Walt Hull, Ed Harper, Roy Warden and Pat McCarty have access, and there are rumors that even Maurice Ellis, who runs a wood-burning computer, may someday have e-mail.

It would be real helpful to me to have your e-mail address and there's an easy way to get it to me. Just type in [jimmac@socketis.net](mailto:jimmac@socketis.net) in the address field and hit the send key. That's all, no need to find a stamp or an envelope, much less put on the jacket and trudge to the mailbox.

Once I have a list I can get the word out fast when we have new events going on in between newsletters.

While you're at it, check out the BAM web page at:  
<http://www.advertisnet.com/bamsite>

## BAM's officers

Last month I listed the new officers for BAM. Paul Moffett, our good friend from Indiana, suggested I list their phone numbers in case anyone needs to get in touch. Here goes:  
President — Bob Alexander, 14009 Hardin, DeSoto, MO 63020. (314) 586-6938.

1st vice president — Mike Williamson, PO Box 462, Warrensburg, MO 64093. (816) 747-2356

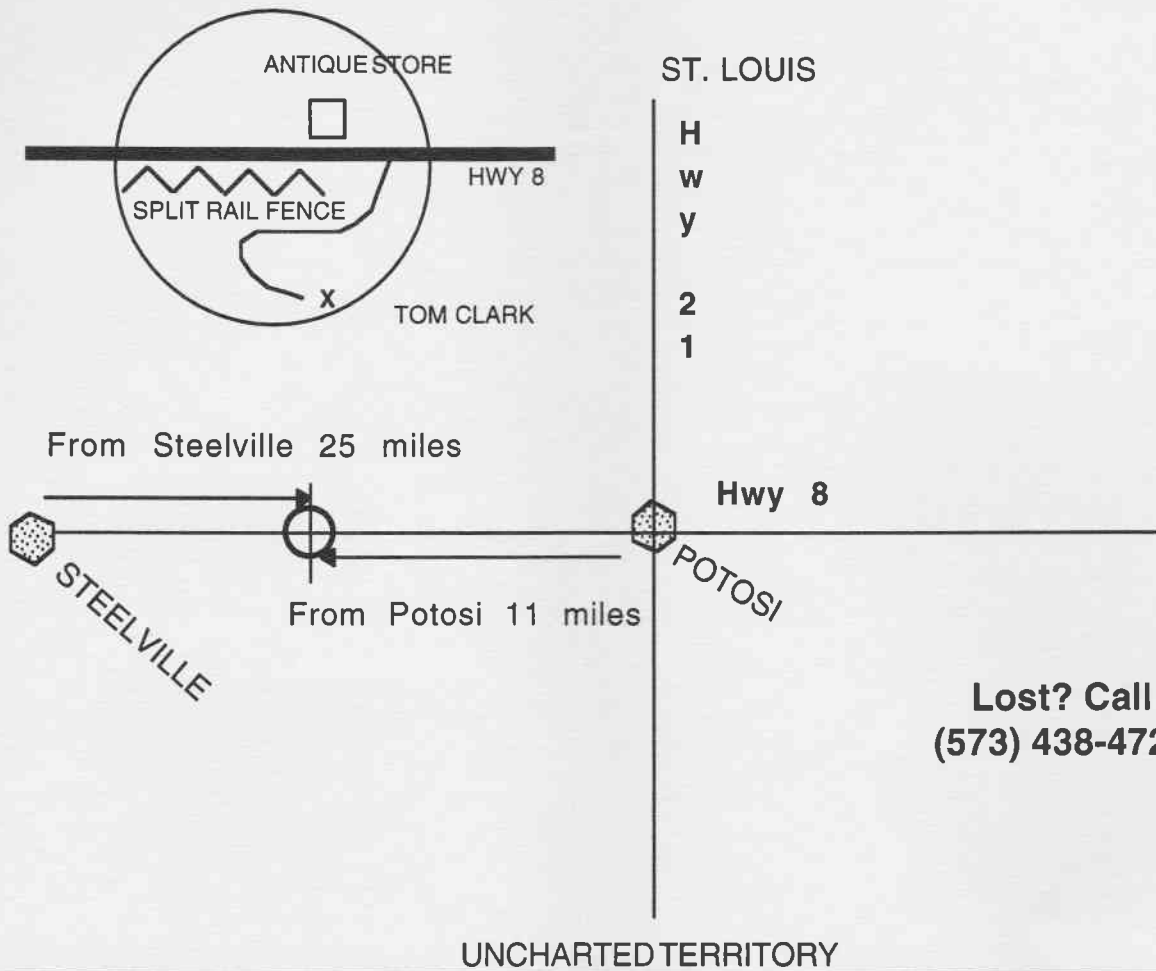
2nd vice president — Phil Williamson, PO Box 462, Warrensburg, MO 64093. (816) 747-2356  
Secretary — John Murray, Box 103, New Melle, MO 63365. (314) 398-4640.

Treasurer — Maurice Ellis, Rt.1 Box 1442, Belgrade, MO 63622 (573) 766-5346.

Newsletter editor — Jim McCarty, 5821 Helias Dr., Jefferson City, MO 65101 (573) 395-3304. FAX (573) 395-3201

Let them know what a good job they are doing.

**Next BAM Meeting Nov. 22, 1997**



**Lost? Call  
(573) 438-4725**

This month we get to see what Tom Clark has been up to lately, which is building a new shop that will henceforth be known as the Ozark Blacksmith School. This will give Tom a deadline so he will actually get the thing done and if there is a little wet paint and no electricity we will understand.

From the photos I've seen the place is well designed and should be fully equipped with all the needs of a modern-day smith. If Tom has all the forges in place perhaps we can all get a turn in the fire.

Tom will be paying BAM back for his scholarship. Most likely he will be putting some of the trade items to work (a nail header) as nailmaking seems to be his calling. He's also going to forge tongs.

No doubt we will also line up more talent for the meeting. Let's see, who haven't we seen in awhile?

Make a nice trade item and don't forget something for the iron in the hat. We have had some real nice shows for both and need to keep it going.

Hope to see everyone at Potosi Nov. 22.



## 1997—1998 Schedule

### November meeting

Tom Clark  
Potosi, Mo.  
Nov. 22

Trade item: Nail header

### January 1998 meeting

Bob Alexander  
DeSoto, Mo.  
Jan. 24

Trade item: Flower

### March 1998 meeting

Webster University  
St. Louis  
March 28

Trade item: Sculpture



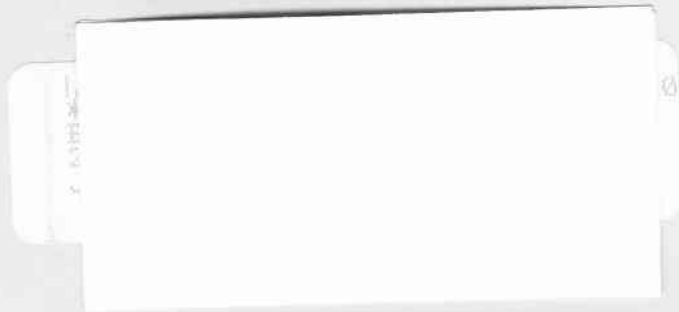


*Tom Clark wields the sledge hammer while Don Asbee keeps the hot iron turning during the demo the two did at the September BAM meeting at*

*Joe Wilkinson's forge in Hope, Mo. The two teamed up to create a nail header, like the one Tom used to demonstrate nailmaking at the meeting.*

**BAM**  
**5821 Helias Dr.**  
**Jefferson City, MO 65101**

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**Address Correction Requested**

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