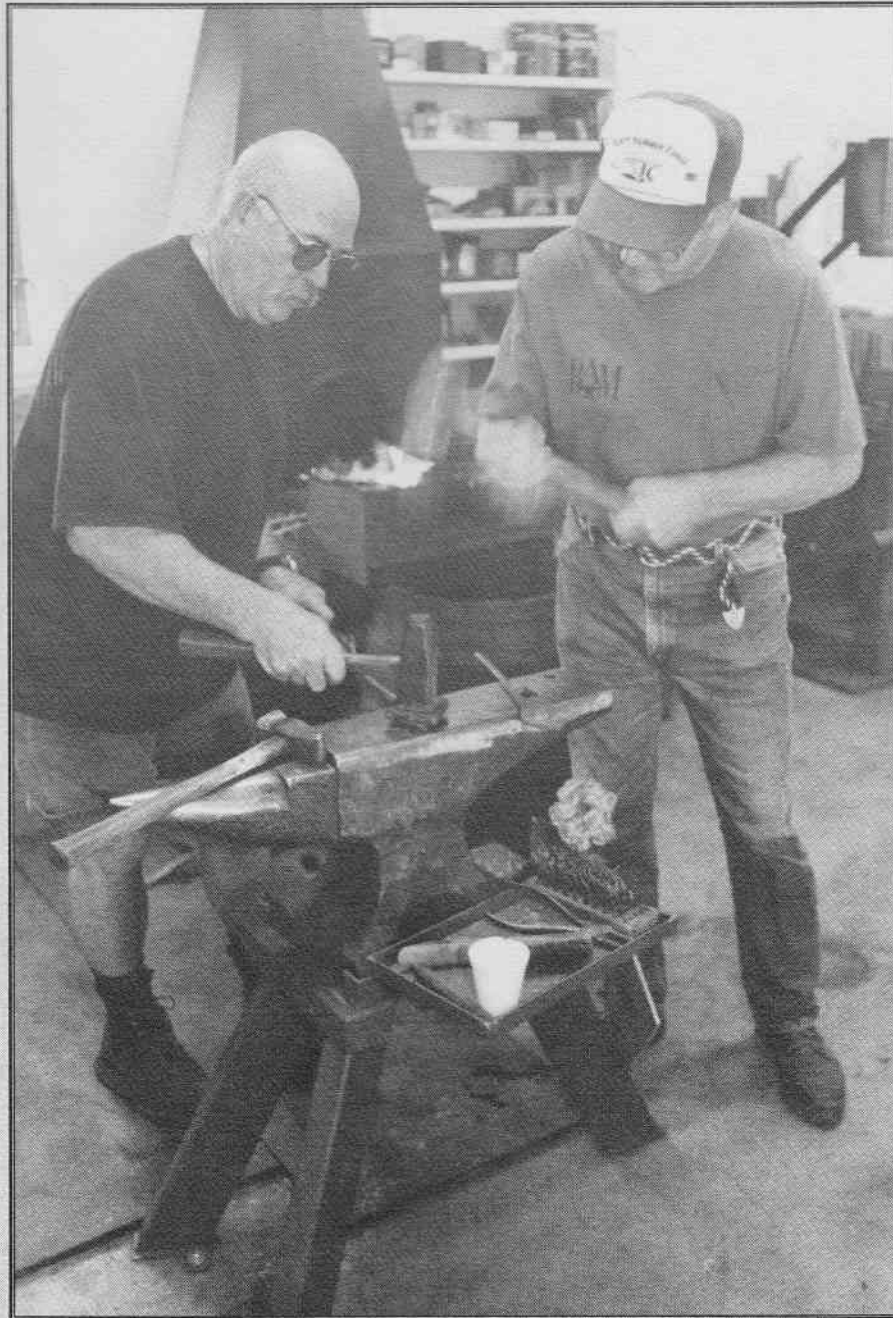


# RAM

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NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

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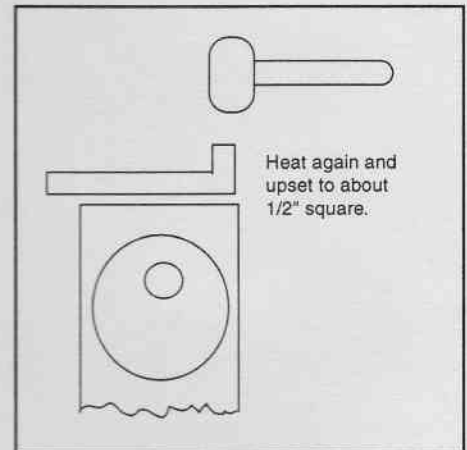
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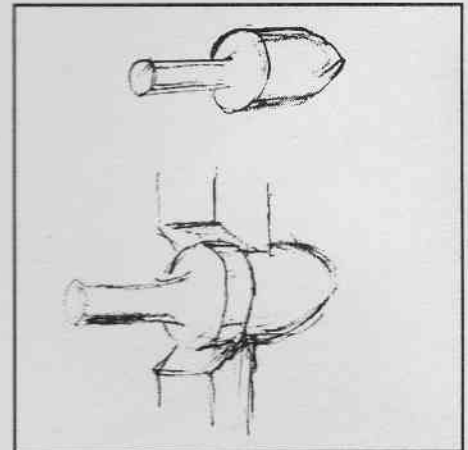
**23** Ray Chaffin is the host as BAM heads to Warsaw for another September meeting.



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# Newsletter of the Blacksmiths Association of Missouri

July — August 1999  
Volume 16 No. 4

**Our cover:** Doug Hendrickson holds the flatter while Don Nichols gives it a hit during the July BAM meeting held at Bob Alexander's DeSoto shop. Doug made tongs and a cross during the meeting.

### Editor

Jim McCarty

### Contributing Editors

Bob Alexander  
Bob Ehrenberger  
Walt Hull  
Pat McCarty  
Roy Warden  
Mark Williams

### Mailing Labels

Maurice Ellis

The Newsletter of the Blacksmiths Association of Missouri is published six times a year and is mailed to members of BAM. The annual fee for regular membership is \$20/year; a portion of this amount is for a subscription to this newsletter for one year. Editorial inquiries should be addressed to: Jim McCarty, 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: \_\_\_\_\_

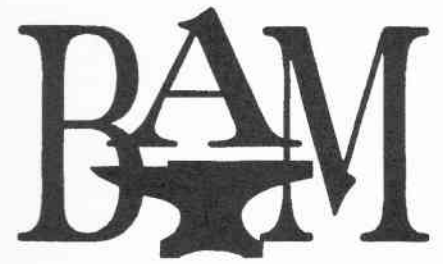
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New Member     Renewing Member

*Includes a Subscription to the Anvil's Ring and The Hammers' Blow magazines*

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- Contributory .....\$100 yr.
- Full time student .....\$35 yr.
- Public library.....\$35 yr.

*See reverse*



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Belgrade, MO 63622

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I \_\_\_\_\_ hereby apply for membership  
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P.O. Box 816 Farmington, Georgia 30638

Dues Distribution:  
1 year subscription Anvil's Ring: 68.5 % \$24  
Adm. offices & other ABANA projects (Conferences, etc.): 31.5% \$11

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

The Newsletter of the Blacksmiths' Association of Missouri and its members do not manufacture, distribute, sell, test, warrant, guarantee, or endorse any of the tools, materials, instructions or products contained in articles or features in the Newsletter of the Blacksmiths' Association of Missouri. The Newsletter of the Blacksmiths' Association of Missouri disclaims any responsibility or liability for damages or injuries as a result of any construction, design, use, manufacture or other activity undertaken as a result of the use or application of information contained in any articles or features in the Newsletter of the Blacksmiths' Association of Missouri. The Newsletter of the Blacksmiths' Association of Missouri assumes no responsibility or liability for the accuracy, fitness, proper design, safety or safe use of any information contained in the Newsletter of the Blacksmiths' Association of Missouri.

## Editor's Anvil

Well the highlight of my summer so far has been the July 4 trip to Calgary in Canada for the 2nd annual Caniron conference. You know how it goes when you anticipate something it seem like it takes forever to arrive and then it's over in a flash. That's how this trip up north went.

I almost missed the trip altogether. For some time I have been keeping my ear tuned to changes in the whine coming out of the transmission on my Dodge truck. The first warning it gave as I headed for Kansas City International was a slight vibration I first mistook for two Power Rangers fighting it out on the dash. When the tranny dropped three gears it shouldn't have been any big surprise. Somehow I managed to limp into a motel in fourth gear, parked the truck and called a cab for a \$60 ride to the airport.

Since I'm always too early I made it in plenty of time for a trip that was otherwise uneventful. Rob Sadowski, the conference organizer, was in the Calgary airport to pick me up and the first thing I saw after clearing customs was Tim Ryan, who had Susan Hutchison, a demonstrator from North Carolina in tow. Tim was on his best behavior throughout the event and I don't think he caused an International incidents.

Rob dropped us at the Alberta College of Art where the Caniron gallery was set up. Here we found other old friends — Charles Lewton-Brain, the fold-forming fool who who wowed us at the Alfred Conference; Uri Hofi, with a new striker, Amit; Francis Whitaker; Bill Fiorini and his wife, Kirstin Skiles; Rich and Bev Cross; and of course Don Neuenschwander, who makes every conference on Earth.

The display was small but real nice. Often the ABANA galleries contain pieces I have seen before, either in the Anvil's Ring or on display at previous conferences. This one was all new and most of the artists were new to me too. The most striking piece was Rob Valentine's suit of armor. Bill Fiorini and Kirstin

Skiles had some nice work on display, as did some of the other demonstrators. I really liked the style of Doug Newel, who was supposed to demonstrate but had to back out due to an injury.

The conference started under leaden skies that would belch rain for three straight days. I think we may have had one hour of sunlight during the entire event. But no matter — Rob had some of the fanciest tents you'll ever see at a blacksmith event and they kept us dry if a little chilly. There was no loitering outside, suffice it to say.

While the demos featured some ABANA Conference regulars: Frank Turley, Bill and Kirstin, Uri Hofi, and Susan Hutchison — there was a good number of local talent that I had never seen before. My favorite was Mark Pearce, who made such effortless forge welds a bunch of people no doubt sold their arc welders. The only demo I sat all the way through was Charles Lewton-Brain's. He kept us captive with his fold forms in copper, brass and later steel.

For sheer ingenuity though the hands down winner was Bill Plant, a Saskatchewan native who can make anything out of anything. Bill made most of the tools he worked with,

including the anvil. He also had a post vise on display that he made himself.

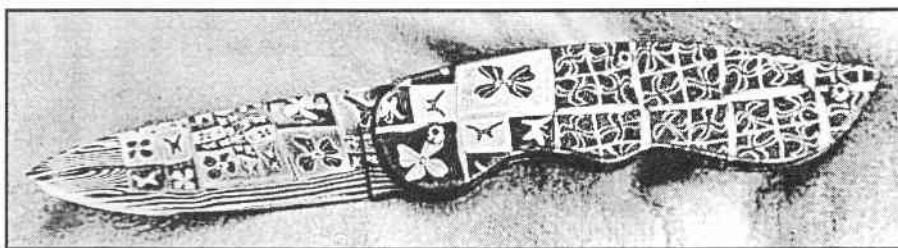
The next Caniron I understand will be in Vancouver Island. If you get a chance to go don't pass it up.

Looking forward, I see my weekends dedicated to blacksmithing demos. Next week I will be at the State Fair, then I have a short break until the Boonville Steam Engine Show. Tim Underwood usually works this one but is having back surgery and has asked me to lend a hand. If anyone wants to come along you would be most welcome — give me a call. I will be set up at the Moniteau County Turkey Festival on Sept. 18 and again at the Hartsburg Pumpkin Festival October 10. I almost forgot Octoberfaust which is the first weekend in October, the 1st and 2nd.

This event is being organized by Lou Mueller. He is asking all BAM members who are interested to take a spot and demonstrate to the public that blacksmithing is back.

Check this issue for the BAM meeting dates for 2000. Mark your calendars just in case the newsletter is late. I will see you all at Ray Chaffin's in September.

— Jim McCarty



Who else but Roy Warden would forge a dogwood folder like this one?



# Experiencing Jeff Mohr and the Campbell Folk School

by Mark E. Williams

I want to thank BAM for the opportunity to attend the class taught by Jeff Mohr in early February 1999. Without the need to use the scholarship, I would not have gone and then I would have missed a very good class. You may wonder how I used a 1998 scholarship in 1999. Well, owing to the patience of the J.C. Campbell staff, I was able to request a short extension of the calendar year. My request was helped by the fact that I did not learn about the award of the scholarship until June 1998.

I left Snow Hill, Maryland on Saturday, February 5, 1999 and drove for about 10 hours to arrive in Asheville, NC. Sunday required about two hours to get to the school. I stopped to visit with Steve Kayne and Clay Spencer along the way. My residence was the Keith House, a long walk to the blacksmith shop but quite close to the dining hall. An initial meeting with Jeff occurred after supper. Most of the group then went to the shop for a look around. While we were there, it seemed reasonable to light a fire and pound on some metal. This helps get the kinks out and lets you sleep better at night.

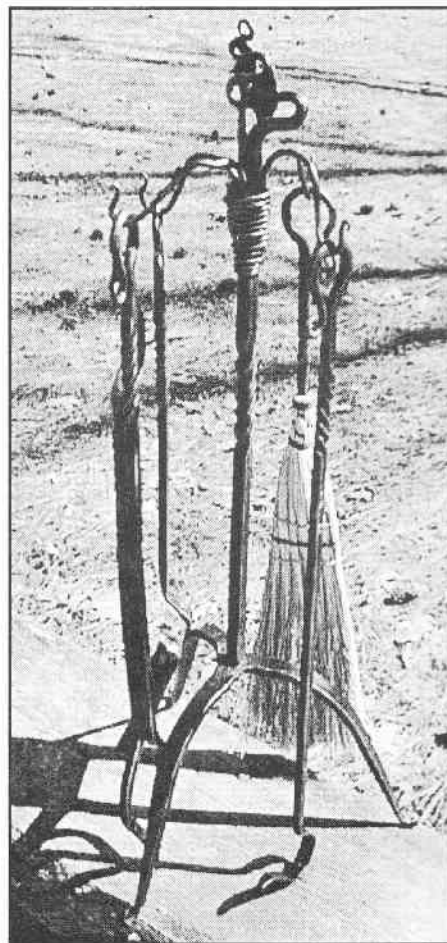
Those of you who watched Jeff demonstrate at the Ozark Conference in early May know most of his jokes and sayings but I'll go over a few. The project for the week was to build a fireplace set — poker, shovel, broom, tongs and stand. Jeff would demonstrate in the morning and the class would struggle through the rest of the day making that part of the project. In addition, we were encouraged and helped by Jeff to make other hearth-related items or to make tools to help us with our project. In addition to making a very nice fireplace set, I also made a shovel mold, an acorn spring swage and got a start on a pair of heart-shaped andirons. You can see a picture of the stand with its tools in this issue.

We worked steadily through the week ending on Friday with a collec-

tive show at Keith House of all the projects and crafts completed that week. Since one of the classes was in hammered dulcimer performance, we were serenaded by the class. Saturday morning, after breakfast, saw us packed and on the road. A little mechanical difficulty with my timing chain allowed me to spend more time in Durham, NC than I had planned. I arrived home late Tuesday night. My wife is very pleased with the fireplace set that now resides in our living room and is urging me to finish the andirons. I enjoyed the class, gained knowledge and experience with ironwork, and made several new friends including Jeff Mohr.

## Construction details.

Jeff says that given a choice between delicate and sturdy, to go with sturdy.



*Mark's finished fireplace set looks a lot like the one Jeff forged at the Ozark Conference.*

The tools were made of 1/2" square stock and the stand from 5/8" square with 1" x 3/8" for the legs. The first tool was the poker. Start with about as much length as you want the finished poker to have. Let experience be your guide as you make more of them. I started with 34" of 1/2" square stock and ended with a poker approximately 29" long. Generally one wants the poker length to be a little less than the height of the fireplace opening, about 1 or 2 inches.

Begin by drawing one end into a long, smooth taper. You will need to have a tapered length of 7 or 8 inches so plan accordingly. I started with about 4" of stock. When the taper is done to your satisfaction, make the square an octagon and the octagon round. Scroll the end until you think it looks pleasant. Knock the corners of the square stock down before finishing the end of the handle. It may be awkward afterward or you may inadvertently damage something. Make a 90 degree bend where the taper meets the square stock. Do not straighten the end having the scroll. Bend the tapered stock around the horn of the anvil to form a nice handle. Jeff likes for the scroll to touch the parent stock thus closing the handle. About 2" to 4" below the handle, take an even heat and twist the straight stock 1 & 1/2 to 2 full twists. Use water to ensure a nice, even twist.

On the other end of the piece, put a short, blunt taper. About 4" back from the tip, fuller the bar to 1/4" to 3/8". Make the transition abrupt. Taper the length from the fullered point back toward the handle. Flatten the area from the tip to the fullered mark. Bend the end in a pleasing shape.

Adjust the poker so all is straight and it looks good to you. Wire brush either by hand or use Mr. Makita. To finish, put a thin coat of Watco medium walnut Danish oil using a rag. Let stand for a time. Then spray with clear laquer.

I'll leave the making of the other tools and the stand for a future article. Once more thanks to you for this opportunity.

## Bob's Business

As I sit this morning in the office and write this article the temperature outside is a cool 68 degrees and this is the middle of August. Temperatures the past week around here were more like October. It sort of made up for the extreme heat we experienced in July.

The weather cooperated for us in July for the BAM meeting. Thanks to Doug Hendrickson and Tom Clark for the demo's and to everyone else who helped make this a success. A special thanks to my wife for her help in cleaning, lunch and cleaning again after the meeting. July meetings are club officer election time. This year seems that all positions remain the same, except that the void from our loss of Phil Williamson was filled by Joe Wilkinson. Good luck Joe on your new position as second vice president.

July brought about two new opportunities for me to attend JC Campbell Folk School. The first was a week assisting Doug Hendrickson in his class called "Bang Some Iron: Make Some Stuff." The second was a week assisting Jerry Darnell in his class, Colonial Lighting. I really couldn't afford missing out of more than two weeks of work in the shop at this time, but great opportunities like this should not be passed by. Teaching is always a learning experience for me which brings me to another story on the same topic.

Teaching and educating the public was the main focus of the latest president's message to the chapters from ABANA. Lou Mueller explains one approach to solving the problems of the public not knowing the difference and availability between good hand-forged quality ironwork and mass produced machine manufactured products. The North Texas Blacksmith Association has begun distributing flyers showing the differences between the two. Maybe we should build on this and think of more ideals for educating the public. Letting

them know that blacksmithing is not A LOST ART.

August is State Fair Days and many thanks to those who helped with BAM's demo site. Hopefully all went well and we will receive a report from our editor Jjim McCarty who is one of the ramrods of this endeavor.

Down in the hills of Potosi, the Ozark Blacksmithing School had a class in August with Bill Bastas being the instructor. The class was scrolls and joinery and involved making a 12 inch square grill utilizing different joints at each corner and using four different scrolls together to form a decorative center. For more information on the school's schedule look in this issue of the newsletter.

Spring and Fall is a very busy time of the year for blacksmithing. Besides all of our own little demos to try and schedule around there are some really important events such as Tannehill, Quad State, etc. We should perhaps become more aware of these schedules and plan our meetings to avoid some conflict. With a little forethought this may not be too impossible. Thanks again to all who throughout the years have volun-

teered for hosting our meetings and to Maurice for his continuing efforts in obtaining volunteers.

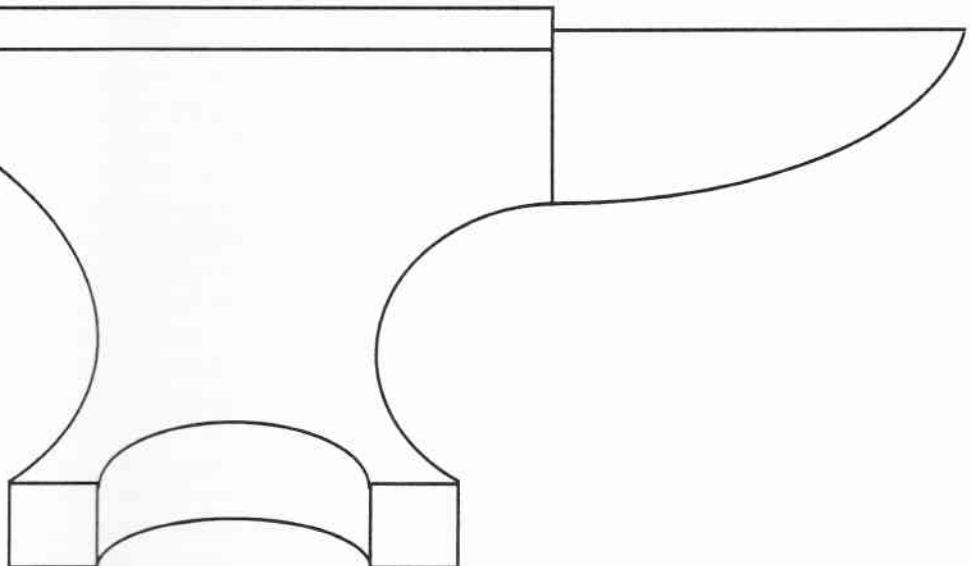
Next meeting is Sept. 11 at Ray Chaffin's in Warsaw, Mo. Trade item is a doorknocker. I have heard that a person could spend days looking at all of Ray's stuff! Hope all goes well for the meeting.

Our newsletter is one of the finest thanks to Jim McCarty and all who contribute, but let's make his job easier by sending him some fuel for the fire. Shop tips, recent work pictures, project plans or even a picture of the family would be appreciated.

Don't forget to contact Lou Mueller for info about the festival at Faust Park in Oct 2-3. For those who didn't attend last year this involves working stations to demo and sell your work, stations to display your work and a gallery to display your best work. The gallery will be set up weeks prior to the festival. For all the particulars contact Lou and I hope to see you there.

Keep hammering,

— Bob Alexander



# BAM

## JULY MEETING

by Jim McCarty

Bob Alexander was the host for our July meeting and it turned out to be a great event. Bob has one of the newest and most efficient designs of all the BAM member shops we've been in. He is turning out some



Above: Gary Koehler turned in this nice example of a wizard for his trade item. Gary has been bitten real bad by the blacksmithing bug and has turned into one fine smith.

fine work and a lot of it was on display in the adjoining gallery.

The day started with Dr. Iron, Doug Hendrickson, demonstrating to pay back his scholarship from BAM. Doug made a pair of Poz tongs. Bob had seating arranged around his forge to make it easier on our knees. About half of the crowd of 50 or so watched the demos while the rest checked out the stuff for sale, swapped lies or just took in the scenery.

Doug got some help from Don Nichols on the sledge hammer and soon had his tongs roughed out. I can't remember if he finished them up or not. He has a commission to forge a cross for a church and showed us what he had in mind for the project.

The design is easier to show than to describe but if you picture two circles joining a bar of square stock at 90 degree angles you might get the picture. I don't know what magic Bob has in his shop but at one point Doug left the forge area, hid behind a canvas screen and appeared to be consumed with white light. He emerged unscathed, however, and the two pieces of iron were stuck together! Maybe sometime he will show how he did this.

When Doug wrapped up the anvil had scarcely cooled before Tom Clark took over with some help from Pat McCarty's big hammer. Tom started with (what else) nails. I think he just about has the technique down. After going through a good size chunk of stock he brought out a beautiful door bolt made by Uri Hofi. The design was both traditional and contemporary in style.

While forging a replica of Hofi's piece Tom explained how the Hofi hammering style works and told some of what is done in his classes. Before he would say he was done, Tom worked the bolt until it moved fluidly in

the keeper. This was a nice demo.

We had a huge feed served from a table in the gallery area and I don't think anyone went away hungry. The business meeting was short but informative and there was a huge turnout for the trade item, which was a corkscrew.

Elections were held and Bob Alexander again emerged as the president. All of the other officers were reelected and Joe Wilkinson was picked to replace Phil Williamson, who died last winter. Once again we learned there's than one way to skin a cat, and more than one way to forge a corkscrew for that matter.

Several of us tried to stay long enough so that Bob would have to leave for his class at the Folk School. We wanted to clean him out, I mean up, while he was gone. Unfortunately he was able to wait us out so we will have to wait for next time.

Thanks to the Alexanders for hosting us — no one got stuck this time.

### Minutes

- Thanks to Bob and Bryanna for hosting us.
- Good show on corkscrew trade item. Many bottles of cheap wine guaranteed to be opened.

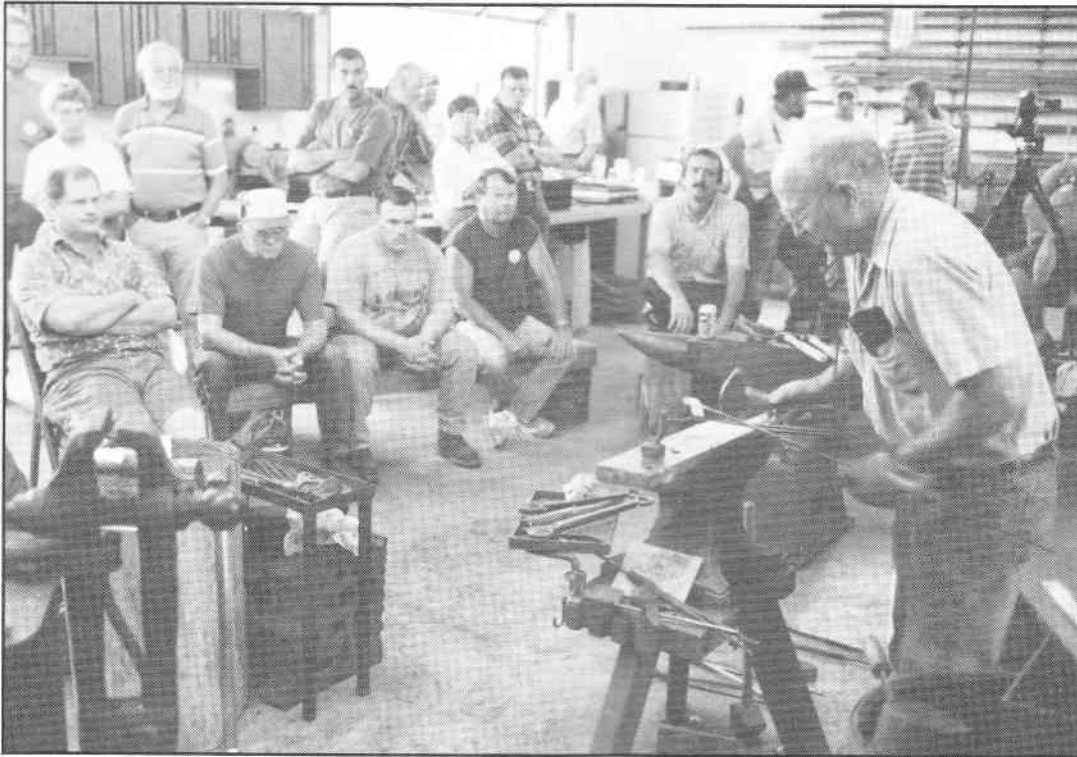
### Business meeting

- Minutes approved as published.
- No old business.

### New business

- ABANA has scholarships
- ABANA will have board member elections soon. Deadline for entry is July 31, 1999.
- Bob showed drawings form ABANA concerning the 2000 conference in Flagstaff. ABANA is promoting a project for a buffalo skull, also a bridge for which individuals can donate pickets. This info will all be published in the Anvil's Ring and our newsletter.
- Bob spoke on a letter from Califor-





*Left: Tom Clark did a fine demonstration on making a door bolt in the style he learned from Uri Hofi. Below: Doug Hendrickson contemplates his cross after mysteriously welding it together.*

nia smith Clark Rozas who was seeking funds to take blacksmith courses. General consensus was he should approach ABANA for funds.

- Maurice Ellis spoke on "Oktoberfaust 1999" to be held in Faust Park in St. Louis County the first weekend in October. More info to come.
- Tom spoke on the ABANA 2000 conference chain project. He will make his shop and school available to work on this. Specs for the links are in the last Anvil's Ring.
- Jim McCarty spoke on BAM's demo at the Missouri State Fair (Aug. 16-22). Jim would like to sign up more volunteers to man the forge. He promises cool weather and a good time for all.
- Bob spoke on BAM's 2000 Ozark Conference. Bruce Herzog and Maurice Ellis also spoke on this. Doug Hendrickson is conference chairman. It will be May 5-6-7, 2000. Doug has instructed the committee members to be smart and think hard. Bruce has compiled a list of suggestions concerning this year's event.

BAM Elections

JULY — AUGUST 1999

By acclamation all officers shall continue their posts. Joe Wilkinson was nominated to fill the post held by the late Phil Williamson. Many thanks.

Tom spoke on the Iron in the Hat for ABANA 2000. Tickets are now available for 1. A Hofi anvil, 2. A Ron Kinyon air hammer and 3. A Pat McCarty BAM Box.

• Tom spoke on weekend classes at his Ozark School of Blacksmithing. See Tom for details.

• Bruce spoke on the BAM library. Bruce sez get the books back when you're done with them!

Meeting adjourned

Respectfully submitted,  
John Murray, secretary



Trade items were made by Joe Wilkinson, Gary Koehler, Phil Koontz, Peggy Williamson, Bob Alexander, Maurice Ellis, Fred Weisenborn, Pat McCarty, Ed Harper, Don Nichols, Fabian Schilly, Tom Clark.

Iron in the hat donations were made by John Murray, Fred Weisenborn, Maurice Ellis, Tom Moroni, Jim McCarty, Doug Hendrickson, Anvil Magazine, and Jeff Mohr.

THE JEFFERSON COUNTY HISTORICAL SOCIETY  
WILL HOST THE 7<sup>th</sup> ANNUAL

# BLACKSMITHING WORKSHOP

9:00 AM – 4:00 PM  
OCTOBER 23 AND 24, 1999  
AT THE HISTORIC VILLAGE ON NORTH 27<sup>th</sup> STREET  
MT. VERNON, IL.

**COST - \$25 BOTH DAYS; \$15 ONE DAY  
PROCEEDS TO BENEFIT THE BLACKSMITH SHOP AND VILLAGE**

Lou Mueller of Fenton, Mo., current president of ABANA, will be our guest demonstrator. Lou will be using Professional Smithing by Donald Streeter as a reference, demonstrating tooling, techniques, and projects from this classic book. Lou has been a featured demonstrator at the national conferences, as well as many regional and state workshops. Don't miss this opportunity to learn from a master craftsman, and a gentleman in the world of forged metalwork.

There will be an auction Saturday evening of donated ironware, tools, and supplies. The money raised will be used to fund the monthly open forge workshops held the second Saturday of each month year around.

Coffee and donuts and a wiener roast Saturday evening free to registrants.

Lunch will be available at a small additional fee.

Tailgate sales welcome and encouraged

Please pre-register by October 1, 1999 although walk-ins welcome.

.....  
NAME: \_\_\_\_\_

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# CHAPTER LIAISON NEWSLETTER

AUGUST 1999

## ABANA BOARD MEMBER ELECTION

By the time you read this the ballots for electing five new members to the ABANA Board of Directors should be in the mail to you. All current members of ABANA (dues up to date) will receive a ballot. Please take the time to read what each candidate wrote and how they will represent you for the next three years.

## ABANA 2000 CONFERENCE IRON IN THE HAT

If you haven't done so yet, get out your calendar and mark out 12 - 16 July 2000 for the ABANA conference in Flagstaff, AZ. There are a number of projects ongoing in which you can take an active part, metal buffalo skull, chapter chain links, and balusters for the bridge project are just a few. Review the article in the Anvil's Ring for details. The conference committee is charging forward to what looks like another "bang-up" (pun intended) conference, don't miss it. During each conference an IRON IN THE HAT is conducted to raise funds for the ABANA Scholarship fund with some of these funds going to the host chapter for their scholarship uses. Once again, Len Ledet and Tom Clark are out ahead of the power curve in working hard to raise a record amount. To this end they have sent IRON IN THE HAT tickets to each chapter. They did forget to include one small item: the cost of the tickets! Each ticket for the drawing is to be sold for \$1.00 (one dollar). Consider supporting this worthwhile cause.

## ABANA SCHOLARSHIPS

There are still scholarship funds available to members of ABANA which can be used for:

- Attending blacksmithing classes or schools
  - Matching chapter scholarship funds for training/schooling
  - Conducting demonstrations in your local community
  - Continued educational studies
- Contact your chapter scholarship officer for an application. It is not hard to be approved for a scholarship. Most who apply receive some if not all the assistance they request.

## ABANA SCHOLARSHIPS AWARDED!

Congratulations to George Pare of Berlin, NH on receiving

an ABANA scholarship. He plans to use it to attend classes at John C. Campbell Folk School this year. There are scholarship funds still available from ABANA. Talk to your chapter scholarship officer for an application. Most chapters have their own funds available so you can receive more than one scholarship and pay for all your education expenses.

## SUMMER FORGING SAFETY

Summer should be in full swing by the time you read this letter. For many of us that means all the doors and windows are open when the forge is operating. This helps the venting of fumes but usually means that the shop starts out warm and gets hotter as the day progresses. Probably the best safety tip for this hot time of year is to keep yourself hydrated. Cut down on the sodas and coffee and increase your intake of plain water. You might try some of the "sport" drinks; however, there are good and bad reports on the value of these types of fluids. It's hard to beat water in replacing lost body fluids. Today's recommendations from doctors are to stay away from salt tablets. You take in enough at meals to replace that which is lost in sweat.

## NEWSLETTER EDITORS

Just a note of interest and a request for assistance from other editors. Please provide as much advance notice of an address change to your fellow editors. Many of the chapters use bulk mailing, and under present post office regulations they are required to include "Return Service Requested" on the newsletters. That means that the newsletter is returned to sender (with return postage due) when there is a change of address. It costs the chapter about a dollar for each newsletter returned. An unnecessary expense.

## ABANA SAFETY GUIDELINES

ABANA is currently reviewing safety guidelines for use by its members. Once this initial review is completed the guidelines will be sent to the chapters for their review prior to publication. Our ABANA charter speaks of education and safety education is a very important part of learning to move metal. A special thanks goes to Dr. Mark E. Williams for getting this ball rolling.

Get it hot, hit it hard, quit when it's done!

— Doug Merkel, ABANA Chapter Liaison

# BAM

## Bulletin Board

Surplus copper sheet for sale — new stock, leftovers from a sculptural job. 110 alloy, dead soft, .125 thick, forges easily hot or cold, welds good. \$1 a pound. Pieces range from hand size to 100 pounds or so. Also 305 pound Arm and Hammer anvil (Dick Postman's favorite). Edges rebuilt by an expert, ready for use. \$500. contact John Murray at (636) 398-4640.

For sale: 75-pound Mayers Brothers power hammer converted to an air hammer. Located in west-central Tennessee. Can load, \$2,000. Ken Scharabok, (931)296-3793.

Wanted to buy: 8-inch leg vise. Contact Rick Scarlet at (660) 263-8982 or Rt.1 Box 220C, Moberly, MO 65270 or e-mail to rscarlet@missvalley.com

Video tapes of the 1998 ABANA Conference, and others, are now available. Full length videotapes from \$24 give you the opportunity to learn from the best artist/blacksmiths in America. Free catalog. Phone orders welcome. Rocky Comfort Forge & Video Production, Rt.3 Box 3678, Quincy, FL 32351; (850) 627-7949.

If you don't already subscribe to Jerry Hoffmann's Blacksmith's Journal consider doing so. The Journal is published monthly and a one-year subscription totals about 190 pages. There are over 1,200 pages already published and back issues are also available. If you haven't seen it, call

or write for a free sample. Cost is \$32 per year. Call 1-800-944-6134 for credit card orders or write to: Blacksmith's Journal, PO Box 193, Washington, MO 63090.

For sale: 70-pound air hammer. 40-pound air hammer, call for prices. Also custom spinning in copper, brass, aluminum, steel and pewter. Maurice Ellis, (573) 766-5346.

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.

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. Check out the web site at [www.kayne-andson.com](http://www.kayne-andson.com).

Tom Clark has expanded his line of hand forged Hofi style hammers to include a nice rounding hammer and punches, drifts, tongs etc. For more info contact him at (573) 438-4725.

Power hammer history! *Pounding out the Profits — A Century of American Invention* by Douglas Freund

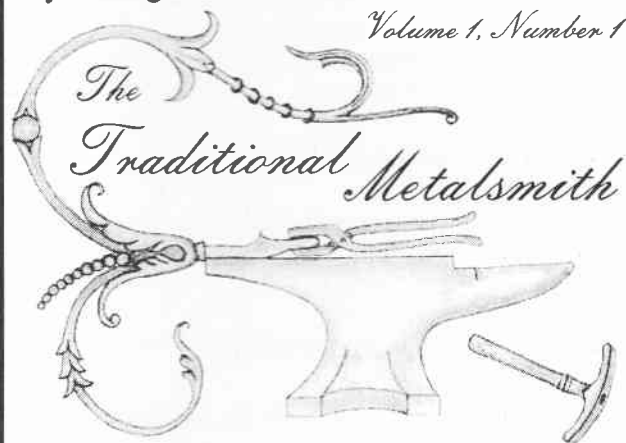
(hardbound, 317 pages, profusely illustrated) is available for \$32.50 plus \$4.50 shipping and handling through Mingus Mountain Machine Works, PO Box 532, Jerome, AZ 86331.

For blacksmithing books contact Norm Larson, 5426 E. Hwy. 246, Lompoc, CA 93436 or call (805) 735-2095. Ask for his catalog — he offers hundreds of books on blacksmithing and related topics and is a real nice guy too.

Colonial Wrought Iron is a photographic record (506 pictures) and descriptive text of the wrought iron items that have been forged by blacksmiths during the colonial period in America. The book was inspired by the collection of James Sorber and was written by Don Plummer. To get your autographed copy, send check or money order for \$44 plus \$4 shipping for each book to: James C. Sorber, 1105 Wilson St., Pottstown, PA 19464.

### A New Quarterly Technical Journal by George Dixon

*Volume 1, Number 1*



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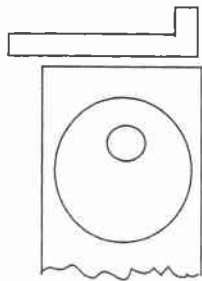
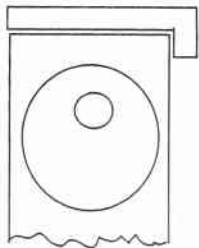
"Blacksmithing is not defined by time period or motif;  
Blacksmithing is defined by process alone."

# The making of a Welded Eye Strap Hinge

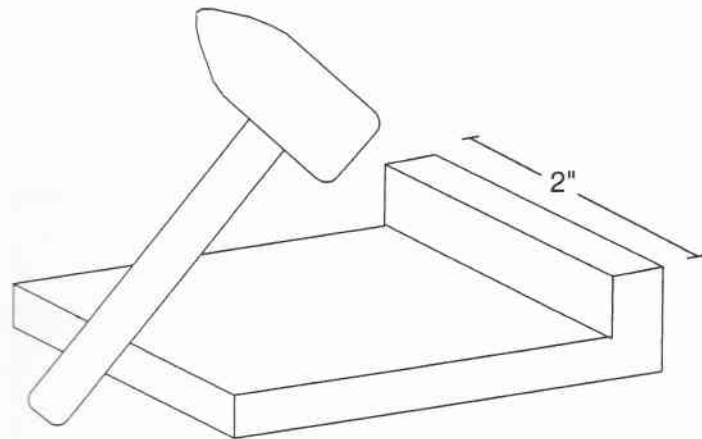
by Bob Alexander

On my last visit to the John C. Campbell Folk I spent another leisurely week with Jerry Darnell. Monday's project was a pair of bean strap hinges with a welded pintle, Tuesday a five-piece Suffolk latch, Wednesday a bean swivel latch, Thursday was a large pair of cathedral hinges and on Friday, for us finished with every thing else, we made H-hinges.

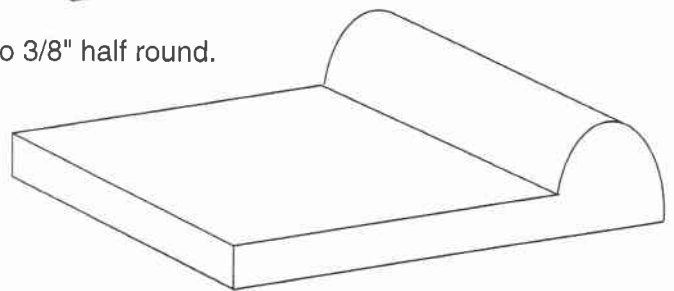
## TOOLING



Heat again and upset to about 1/2" square.



Then hammer into 3/8" half round.



For this article I will begin with the steps for a bean strap hinge. The strap hinge could have many different ends such as the bean, weeping heart, penny foot, etc.

To make a welded strap hinge, one needs a couple of easily made tools. The first tool is an eyeforming jig. Use 3/8" x 2" x 6". Heat and bend 1 inch over the anvil. Heat again and upset to about 1/2 inch square. Then hammer it into 3/8 inch half round.

The second tool is a tapered-end pin. Use 3/8 inch round x 3 inches. Heat and hammer tapers on each end.



Second tool is a tapered-end pin. Use 3/8" round x 3" long.



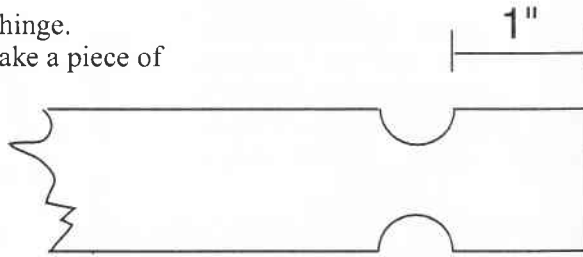
Now to begin the strap hinge.

To begin the hinge, take a piece of 3/16 x 1-1/2 x 24" and fuller it down to 1/2 inch wide 1 inch from the end. Hammer end into a semi-circle. Keep it the same thickness. Now draw a taper from the fullered part back to the other end leaving about 1-1/2 inch untouched. Chamfer top and bottom front edges.

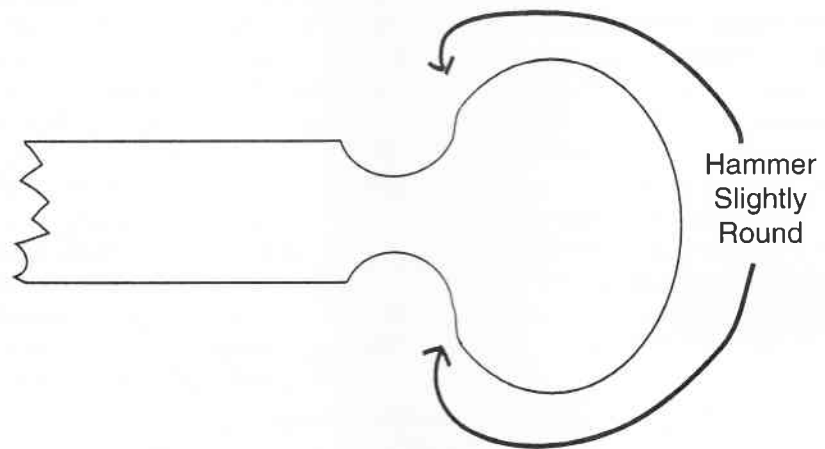
Now to open the bean we start hammering the width first. Hammer from the center out to both ends until it is about 2-1/2 inches wide using the hammer's cross pein. Now is the time to set the cusp by placing the bean over the horn and hammering at an angle to the back forming a shape like a kidney bean.

Then hammering both flat on the anvil and on the edge on the horn, peen the front to make a bulge and work the voids out of the edge. After the beans and tapers are finished, check both for length and cut to make them the same length.

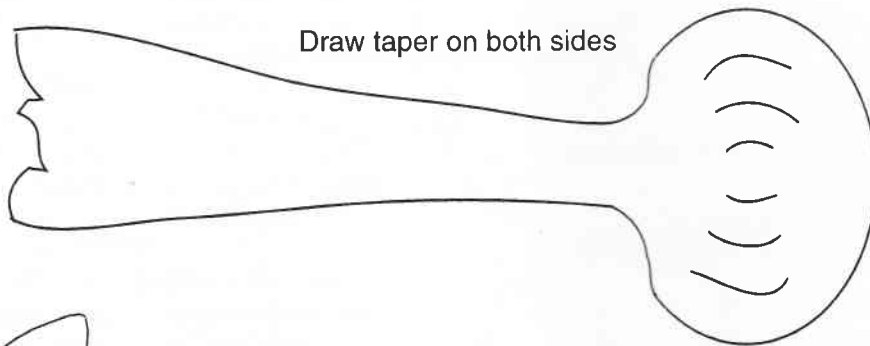
## BEANS



Anvil horn



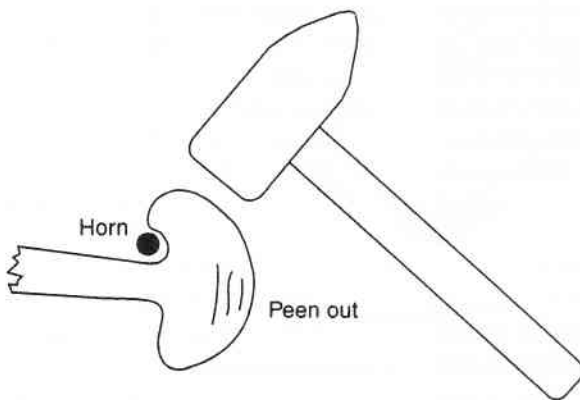
Hammer Slightly Round



Draw taper on both sides

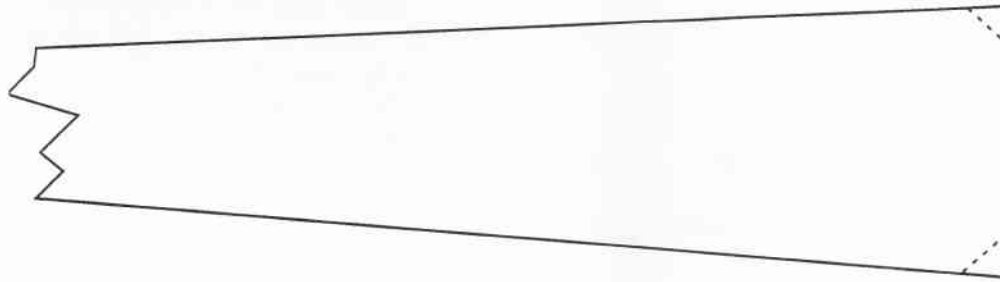
- 4
- 3
- 2 Hammer
- 1 in this
- 5 order
- 6
- 7

Cross pein to spread

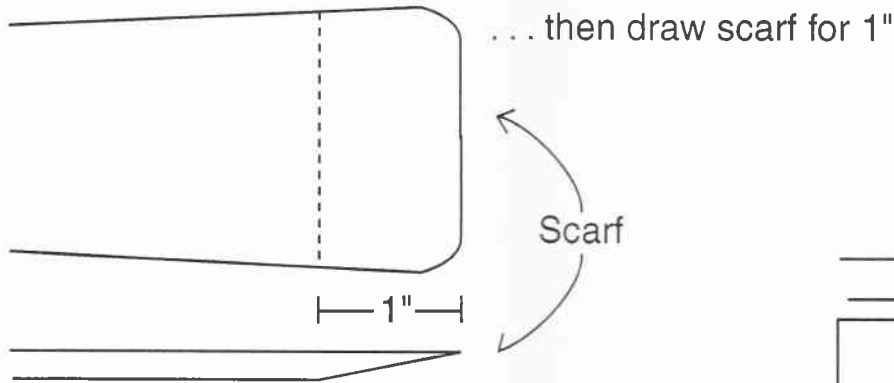


Horn

Peen out



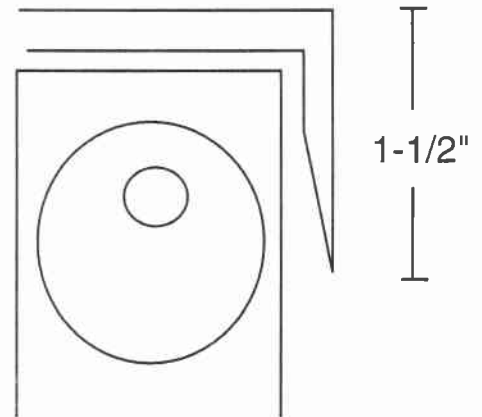
Hammer on corners ...



... then draw scarf for 1"

Scarf

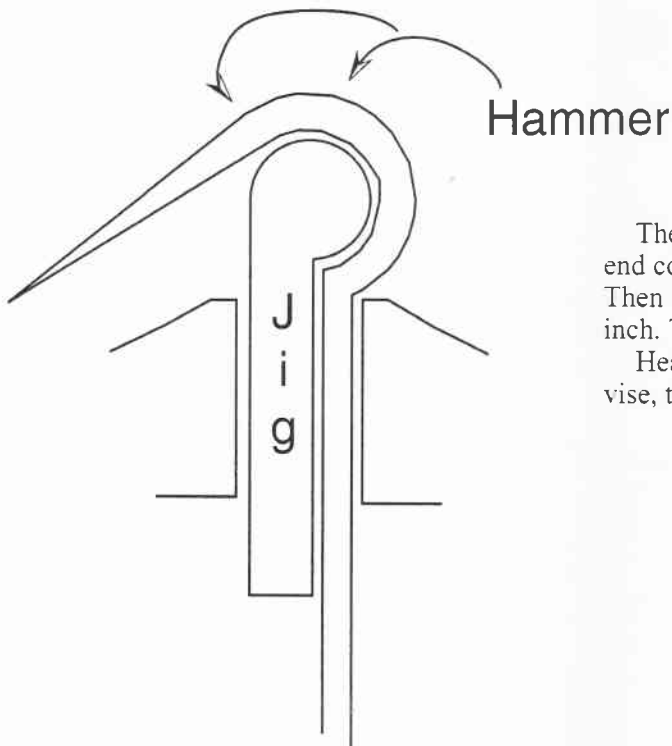
1"



1-1/2"

This prepares the hinge for the jig

Now bend over the anvil edge about 1-1/2"



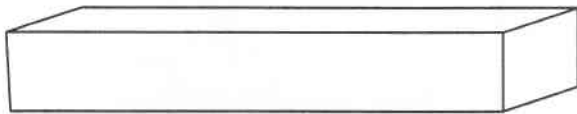
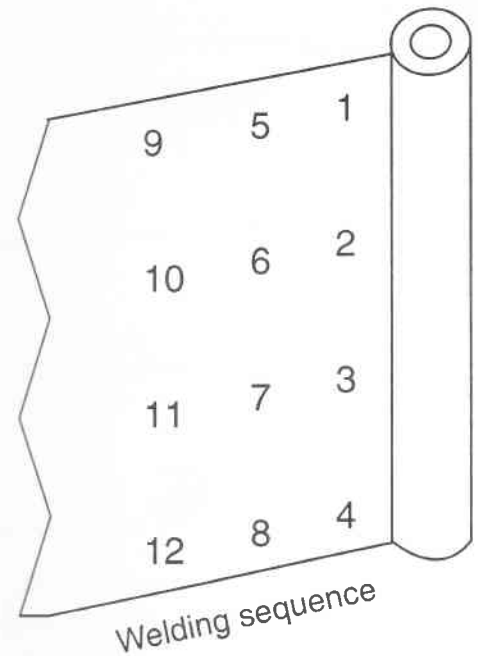
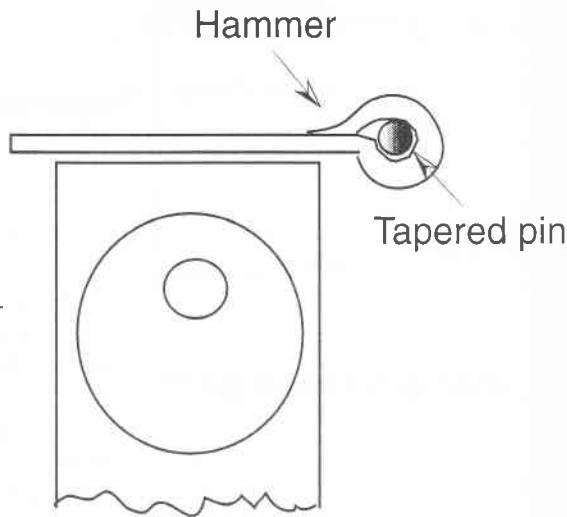
Hammer

The welded eye begins by making a scarf. By first chamfering the end corners, you avoid working to keep the width from spreading. Then draw scarf for 1 inch. Now bend over the anvil edge about 1-1/2 inch. This prepares the hinge for the jig.

Heat the hinge and quickly place the hinge and jig together in the vise, then begin the bend around the jig.

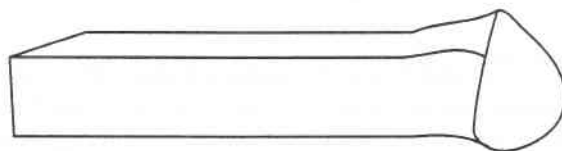
Remove the jig and insert the tapered end pin, then hammer together over the anvil until the hinge is flat. Next remove pin, flux, heat to welding temperature, and weld using this hammer blow sequence:

After welding, heat, insert tapered end pin so as to align and shape up hole.



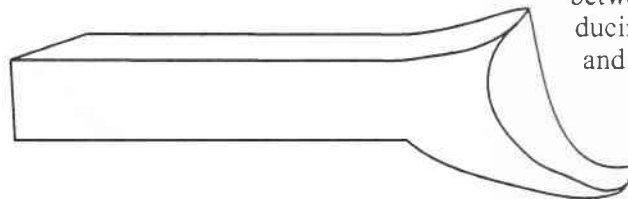
## PINTLE

### Upset



For the welded pintle take a piece of 1/2-inch square longer than needed using the extra stock for the handle. First heat and upset the end to make 5/8 to 3/4 inch. Make a scarf to look like this:

Next by hammering over a sharp edge on the anvil make two deep notches as per the drawing. These are fullering marks. Now heat and hammer between these notches over the horn producing a round fullered place. Next heat and bend around.

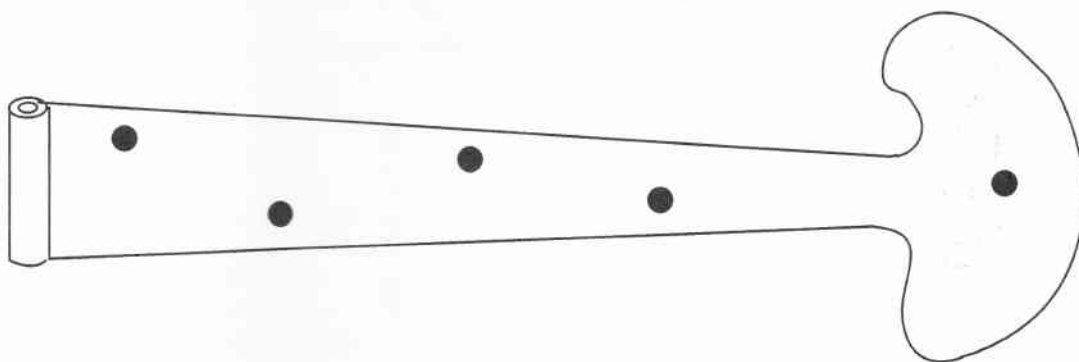
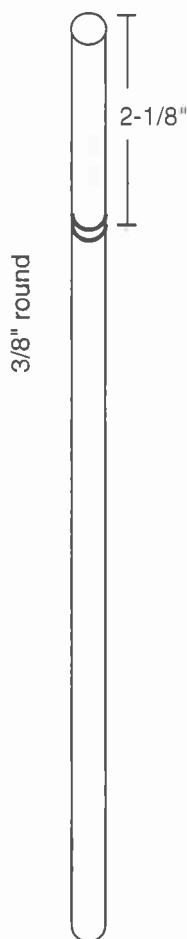
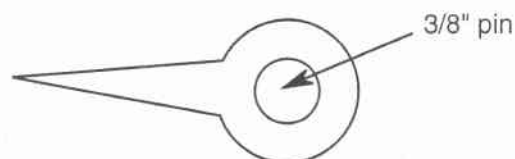
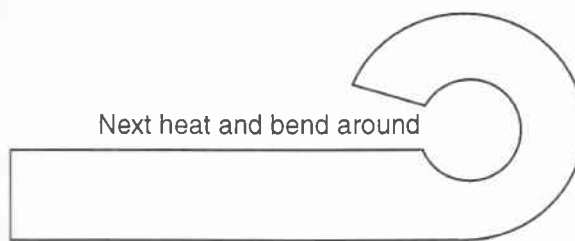
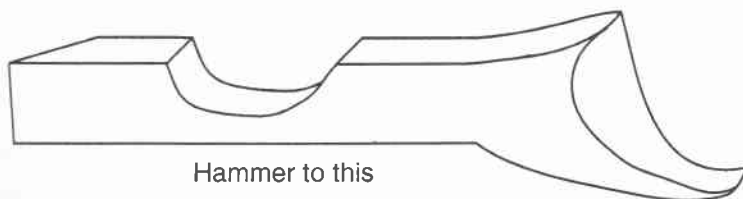
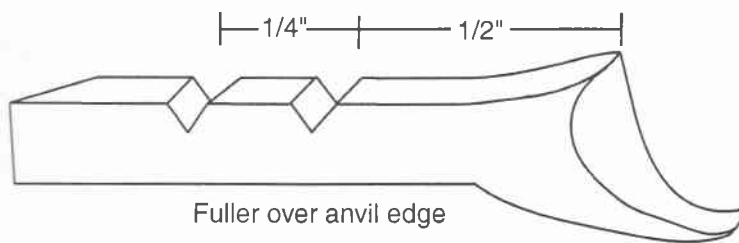


Take a piece of 3/8 inch round long enough to hold and notch with a hardie almost through using the extra stock for a handle. Heat the pintle piece, insert the 3/8 inch pin and hammer closed. Then just twist off the handle of the pin at the place where you cut it.

Now we are ready to heat and weld. Begin hammering to close first, then flip and center the eye. Now flux, reheat to welding, and weld in vise hammering to weld pin and pintle. To finish weld the top using a bolster or the pritchel hole in the anvil.

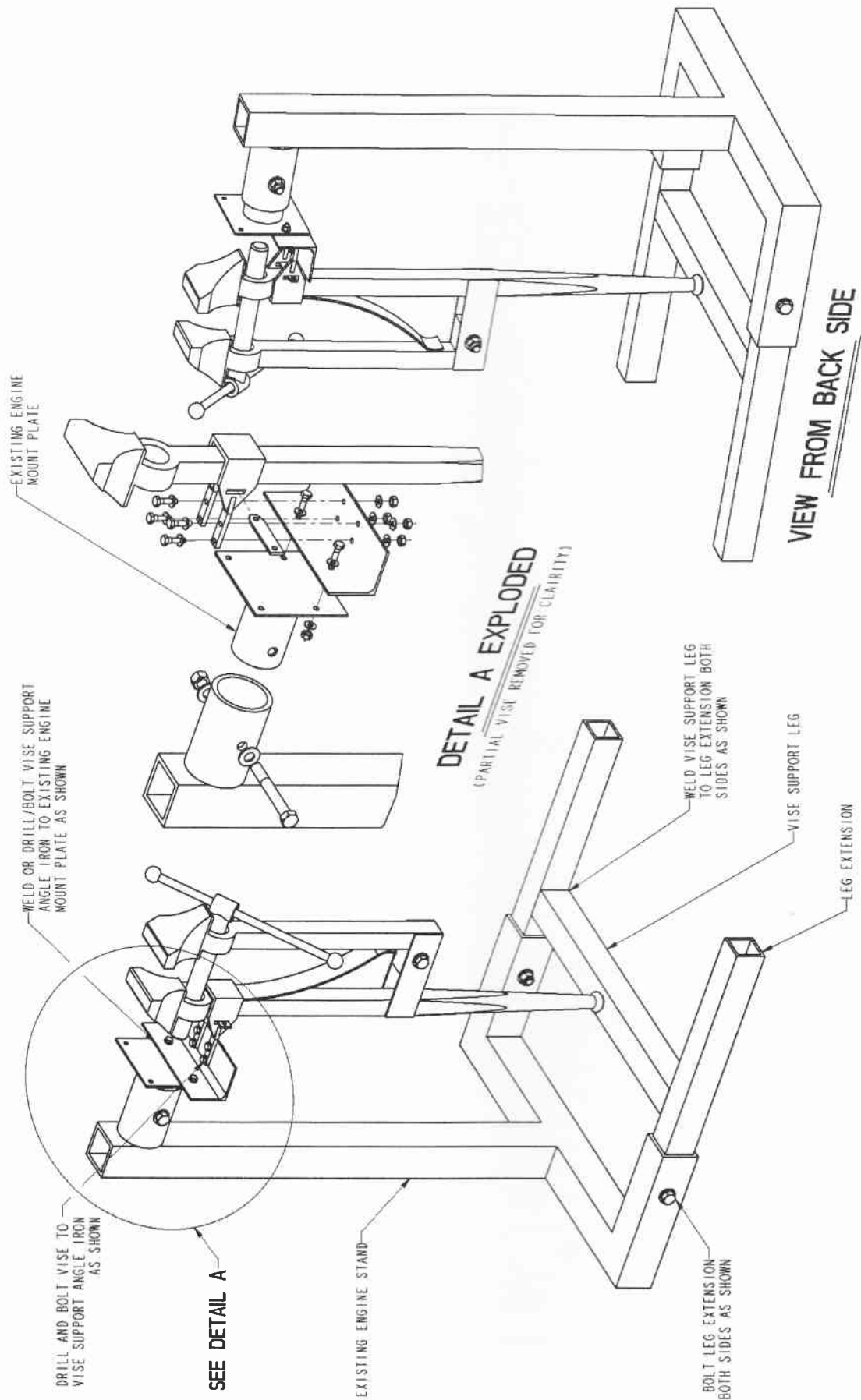
Last cut off handle, and draw a tapered shank. While hot use chisel to cut barbs in shank. Punch or drill hinge for attachment to door.

The finish I use on Colonial pieces is to blacken them on a green coal fire, then while still warm apply a bee's wax-linseed finish.



# Vise stand

by Bob Ehrenberger  
Illustration by Rich Haumesser





# BAM SHOP TIPS

## Building a Free Standing Post Vice

by Bob Ehrenberger

I recently had a need for a portable free standing post vice. Not wanting to start from scratch, I went to my resource center, the scrap pile. I quickly came up with just what I needed, an old engine repair stand. I inherited it when it had been left behind at my previous home. I had never used it because I don't rebuild engines like my predecessor. I recognized that it had a lot of good steel in it and I knew that I would need it or the steel some day. Well this was the day.

The stand has a simple design of 2 1/2" square tubing for the main body, with 2" square tubing for the extended leg braces. The engine mount itself is constructed of two pipes that fit closely one inside the other with one welded to the stand and the other to a face plate that the engine bolts to. The two pipes are drilled so that the engine can be rotated to several positions and pinned there.

Converting this to a vice stand is a simple matter of devising a method of connecting the top of the vice to the engine mount and supporting the bottom of the post.

To make the top brace I used a piece of 3" x 5" angle iron 12" long. I drilled the 5" side of the angle iron to match the mounting bracket on the vice. Then bolted the vice and the top brace (angle iron) together.

The post support was made by cutting two pieces of 1-1/2" angle to fit between the legs of the stand and then welding them into a box making a 1-1/2" square tubing. A 9/16" hole was drilled through one side of the brace so the post would set firmly in the hole.

The assembly was simple. With the post brace sitting loosely between the legs of the stand the post of the vice was inserted into the hole. The vice was brought up to the stand so the 3" side of the top brace was against the engine mounting plate. A C clamp was used to hold the angle brace in place. The post brace was moved in and out until the post on the vice was plumb. The post brace was welded to the legs of the stand. Finally I welded the top brace to the engine mounting plate. (If you actually use your engine stand for occasional engine work you would want to drill

and bolt it to the stand.)

When I want to transport the vice all I have to do is pull the pin on the engine mount and the pins in the leg extensions and it comes apart into three easy to manage pieces: the frame, the legs with brace and the vice with angle iron and engine mount. It comes apart in about 15 seconds and can be put back together in under a minute.

The angle iron that I used was a little longer than it needed to be which comes in handy as a table. I have plans on adding a plate to the top to give me a larger work area. I want this to be about 12" x 18".

There is a little more slop in the vice than I would like. This is caused by the pipes for the engine mount not being as tight of a fit as they should. I will probably shim this to take up the slop.

It took me about as long to write this article as it did to build the stand. Under two hours.

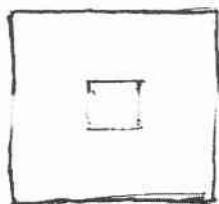
If you want to build this and don't have an engine stand to start with here are some dimensions to get you started:

Total height: 34 1/2"  
Total width: 25 1/2"  
Legs: total 26"  
Stub on frame 7"  
Leg extensions 24"  
Pipe welded to frame: 3" diameter 4 1/2" long  
Pipe welded to engine mounting plate: 2 1/2" diameter 4 1/2" long  
Engine mounting: 6" x 6" x 1/4" for small engines

# A Simple Ornament

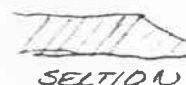
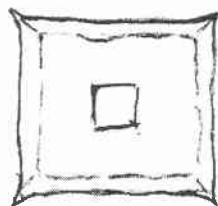
by Walt Hull

We made a bunch of these for a little garden fence. To start carefully cut 1/4" x 2" bar 2" long. Deburr and locate exact center. Punch a 1/2" square hole.



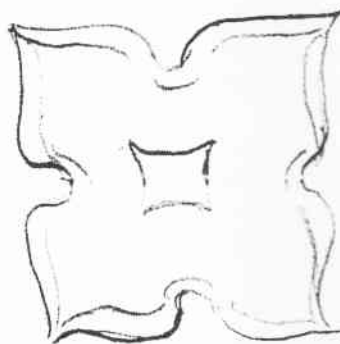
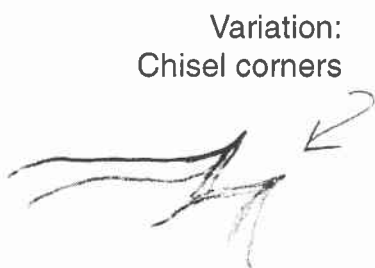
We cut ours on the bandsaw and punched with the ironworker.

Next hammer down the edges:



Notice how corners are automatically pulled out a little. Something for nothing! Cool!

Carefully locate the center of each edge and fuller in with a 1/4" round fuller:

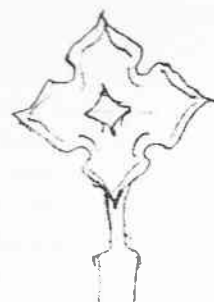


Notice how edges are pulled down next to fullering, giving flower-petal effect, and sides of square hole are pushed in. more something for nothing!

Forge a piece of 1/2" square down to 1/4" square for a little bit and scarf:



Scarf one corner of flower thingie



and weld to make a picket.

by Walt Hull

Here's another approach  
to the acorn:

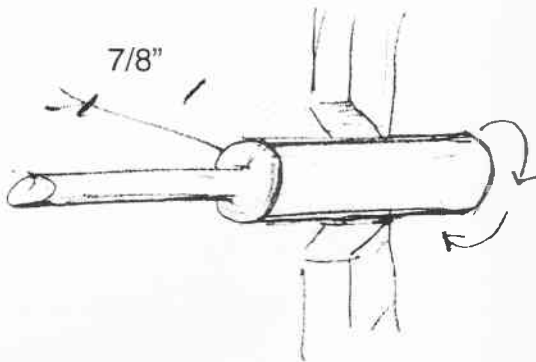
# Walt's Acorn

1.



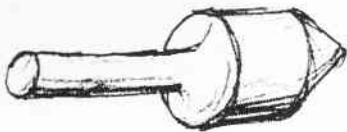
Forge 1/2" round tenon

2.



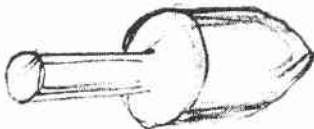
Use Smithin' Magician to cut like this. Rotate while cutting.

3.



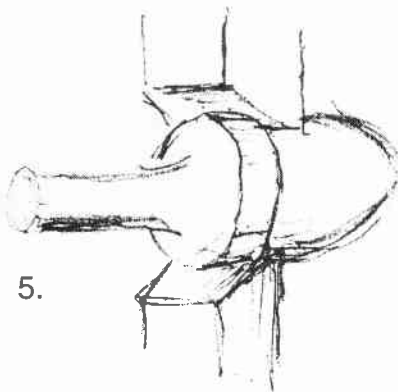
Refine with hand hammer, rasp, etc. . .

4.



. . . then butcher a shallow ring.

5.



Refine again, then use this to make a die for the power hammer. Use steps 1-3 to make blanks for finishing in die.

# BAM NEWS

## New dates for Ozark School

Tom Clark has a number of classes scheduled for his Ozark School of Blacksmithing. Besides Uri Hofi, he has Bob Patrick (forge welding), Jerry Darnell (traditional lighting) and more) and Bill Bastas (scrolls and joinery on a 12" grill) lined up for courses this Fall. He's also planning a Phil Cox power hammer course although the date for that one has not been set.

In addition to these classes, Tom invites anyone who is interested to do a 1, 2, or 3-day toolmaking class with him. He will take a maximum of three people per class and will schedule these anytime that works for the participants, weekday or weekend. For more information give him a call at (573) 438-4725.

### 1999 Classes

Oct. 18-22: Uri Hofi (Basic)  
Oct. 25-29 Uri Hofi (Advanced)  
Dec. 6-10: Bob Patrick  
Dec. 27-31: Bill Bastas

### Year 2000 Classes

March 20-24 Bob Patrick  
April 24-28 Uri Hofi (Basic)  
May 22-26: Bob Patrick  
June 12-16: Jerry Darnell  
Aug. 7-11: Bill Bastas  
Sept. 25-29: Bob Patrick  
Oct. 9-13: Uri Hofi (Basic)  
Oct. 16-20: Uri Hofi (Advanced)  
Dec. 4-8: Bob Patrick  
Dec. 26-30: Bill Bastas

## BAM events coming soon

Lou Mueller is working on four workshops for BAM members to be held at his new shop in Fenton. Lou

wants to do a couple with outside demonstrators, possibly George Dixon if his leg mends in time and two others for beginners, probably a women only class and one for other beginners.

No word yet on when they will be held but most likely time frame is November, January and February. We'll let you know the details.

## BAM'ers wanted for Oktoberfaust

Oktoberfaust, set for Oct. 4-5 at St. Louis' Faust Park, will be back featuring a new look for 1999. This time BAM is taking top billing and we need you to show the public that blacksmithing is back.

The plan is to set up as many demo sites as possible with two-three BAM members doing their thing at the forge and anvil. You can sell your wares or just show what is possible.

A gallery of ironwork from amateur and professional smiths will go up before the event and stay for another week or so. At least 10 forging stations showing many aspects of metalworking are planned to be placed around the parks' historic structures.

The goal of the event is to educate the buying public rather than to educate the blacksmiths as is our usual procedure. Most would agree the 1998 Oktoberfaust succeeded in that regard — some 5,000 people watched the demonstrations, which included a tent devoted to architectural ironwork.

For more information contact Oktoberfaust organizer Lou Mueller at (314) 343-4223.

## New officers elected by landside

At the July meeting BAM elections were held and the entire cast of characters won by a huge margin (there were no other candidates!). Joe Wilkinson was picked to replace the late Phil Williamson as second vice president.

In case you forgot who they are, Bob Alexander is president, Mike Williamson is first VP, Joe is second VP, John Murray is secretary and Maurice Ellis is treasurer.

Other volunteers include Doug

Hendrikson, Ozark Conference chairman, and Bruce Herzog, who is our librarian. Thanks to all for volunteering for BAM.

## 2000 Meeting dates set

Maurice Ellis has meeting dates for the entire year 2000 set. Please put these on your calendar just in case the newsletter is late.

### 1999

September 11, Ray Chaffin, Warsaw, MO  
November 20, Andrew MacDonald, Carbondale, IL

### 2000

January 8, John Lovin, Mt. Vernon, IL  
March 25, Tom Clark, Potosi, MO  
May 20, Joe Wilkinson, Hope, MO  
July 29, Kirk Sullens, Bass Pro Shops Fab shop, Springfield, MO  
September 23, Ed Harper, Browning, MO  
November 11, Pat McCarty, Washington, MO

## ABANA Honors Daryl Meier

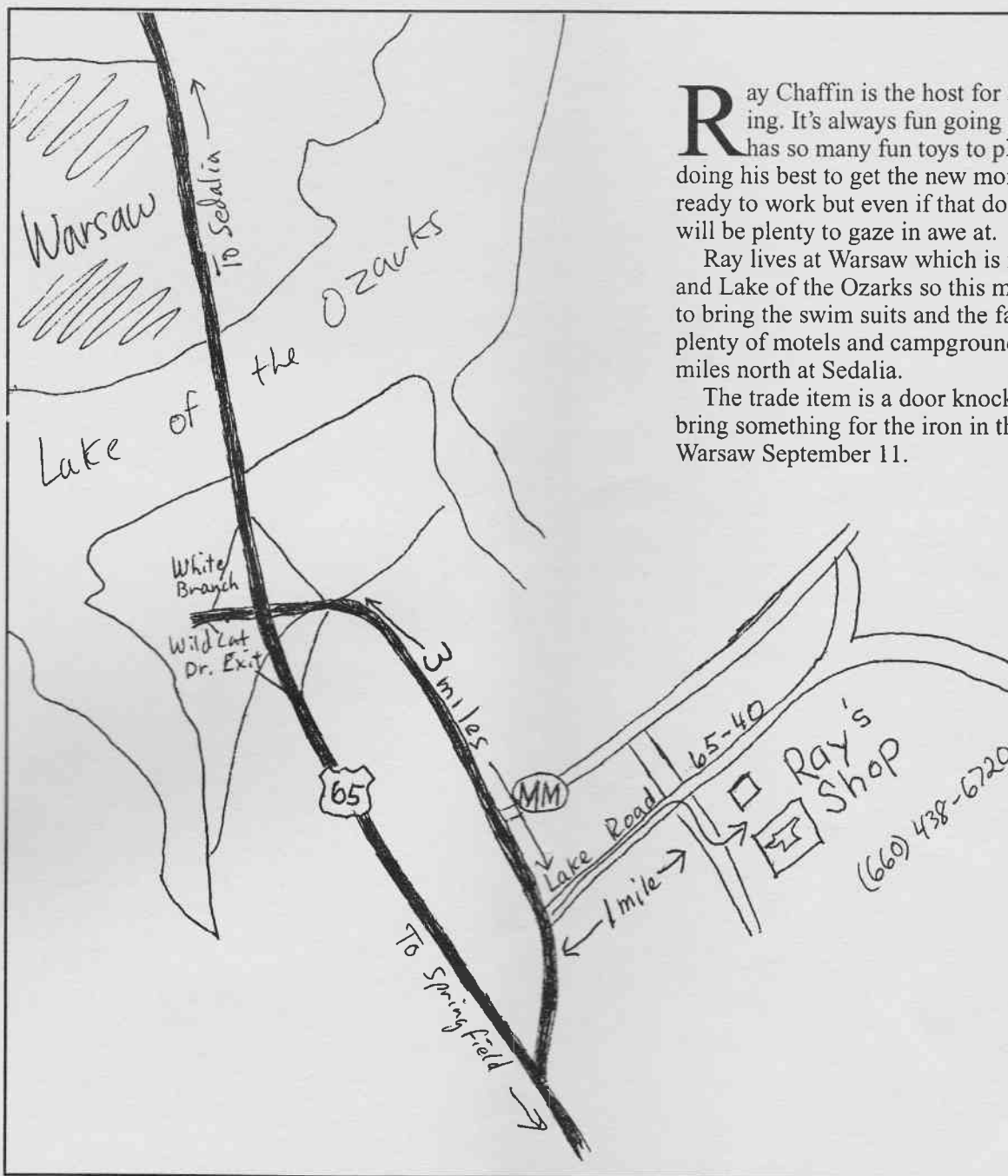
Congratulations to Daryl Meier, the latest winner of ABANA's coveted Alex Bealer Award.

Daryl has done more to advance the creation of Damascus steel in this country than perhaps any other person. He learned the basics of forging pattern welded steel from Ivan Bailey in 1973, then pioneered the initial investigation in the technique as a student at Carbondale, Illinois and has contributed greatly since. Of his many accomplishments one of the highlights had to be the knife he created for President George Bush. The knife featured 13 waving flags (each with 50 tiny stars) and a banner that said USA on the reverse side, all pattern welded into the blade. It was finished with a crossguard partially composed of a meteorite.

In the blademaking community the words "Meier Steel" are synonymous with quality. Congratulations to Daryl on a well-deserved honor.

For more information on Daryl Meier check out his web site at [www.Meier.steel.com](http://www.Meier.steel.com).

*Next Meeting September 11, Ray Chaffin's, Warsaw, Mo.*



**R**ay Chaffin is the host for BAM's next meeting. It's always fun going to Ray's because he has so many fun toys to play with. He is doing his best to get the new monster air hammer ready to work but even if that doesn't happen there will be plenty to gaze in awe at.

Ray lives at Warsaw which is right on Truman and Lake of the Ozarks so this might be a good time to bring the swim suits and the family. There are plenty of motels and campgrounds in the area or 30 miles north at Sedalia.

The trade item is a door knocker. Please also bring something for the iron in the hat. See you in Warsaw September 11.



## 1999 — 2000 Schedule

### September Meeting

Ray Chaffin  
Warsaw, MO  
Sept. 11  
Trade item: Doorknocker

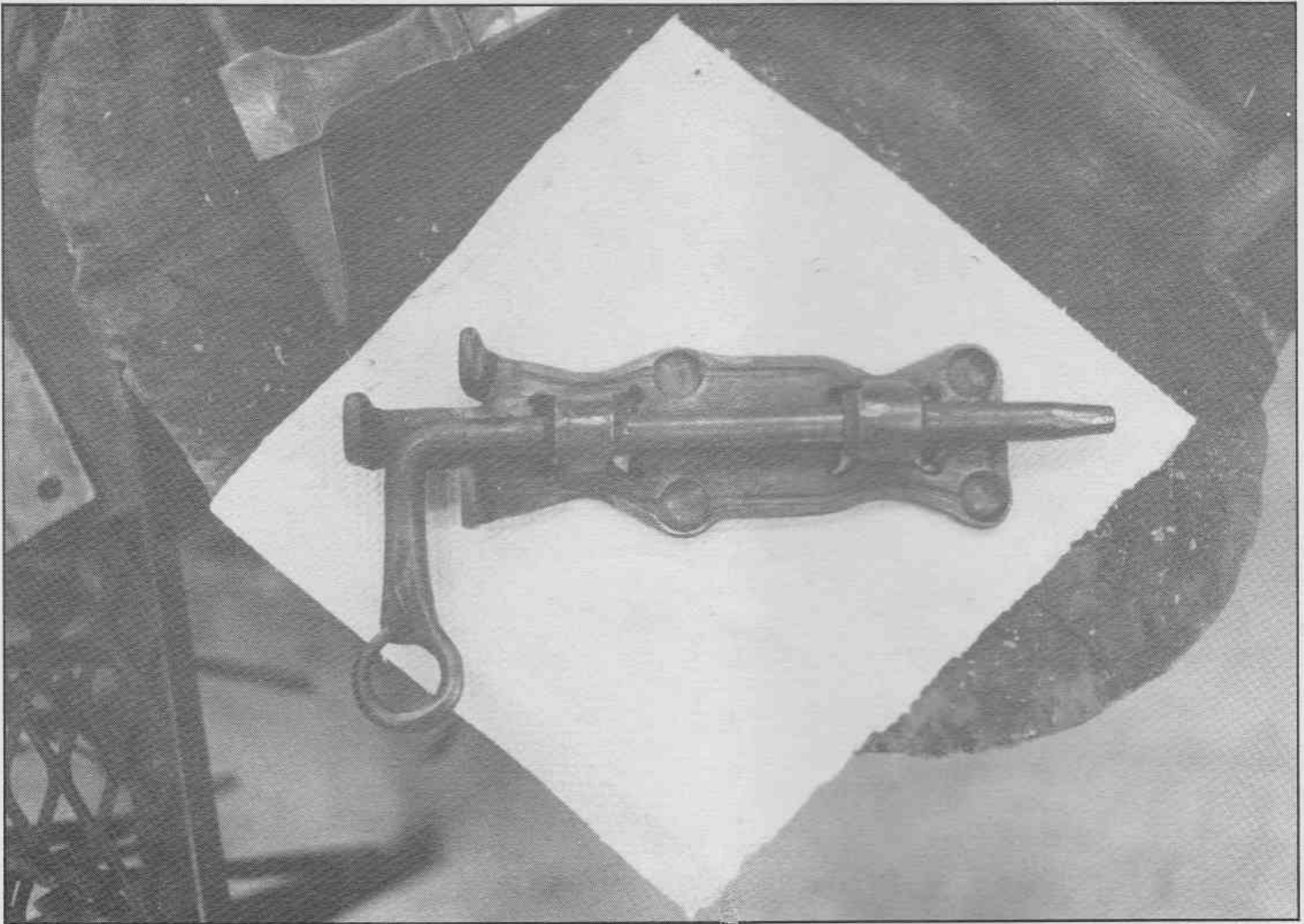
### November Meeting

Andrew MacDonald  
Carbondale, IL  
Nov. 20  
Trade item: TBA

### January 2000 Meeting

John Lovin  
Mt. Vernon, IL  
Jan. 8, 2000  
Trade item: Hot cut





Tom Clark forged this Hofi-style door bolt during BAM's July meeting held at Bob Alexander's shop.

**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