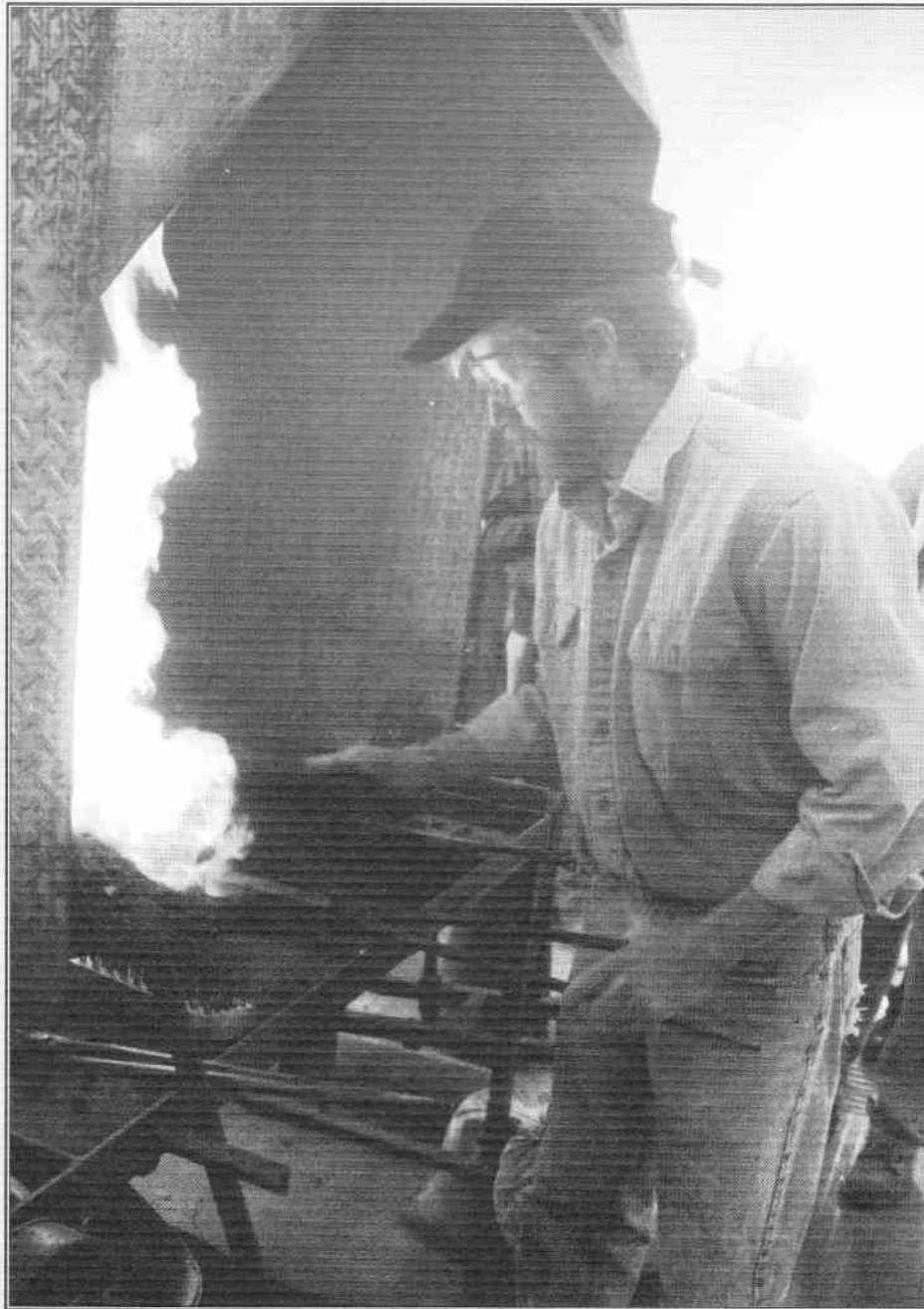


RAM

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NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

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16 No issue would be complete without something to make. This one's from Williamsburg.

Nail header

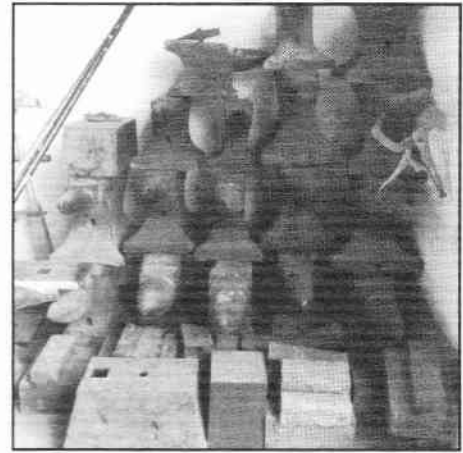
19 Here's a neat little nail header from the collection of Jim Sorber.

Shop tips

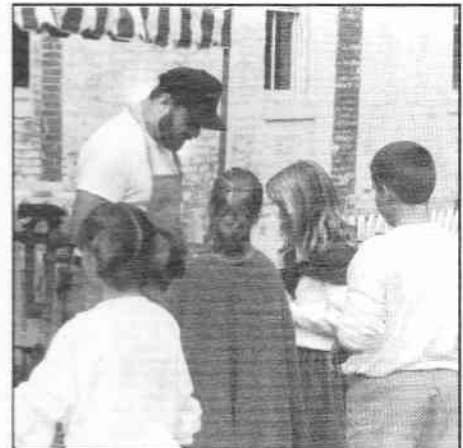
20 Clamp pads, propane, heat treating and a measuring device from Bob Alexander.

Next meeting

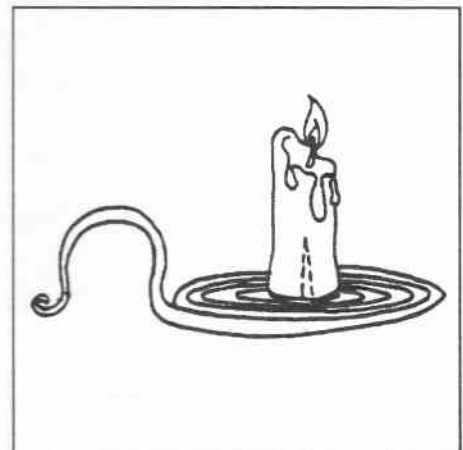
23 We head to Mt. Vernon Illinois for our next meeting on January 8.



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**Newsletter of the
Blacksmiths
Association
of Missouri**

*November — December
1999*

Volume 16 No. 6

Our cover: Rick Smith heats his stock during the maiden run of Andy MacDonald's forge. Rick showed us how to make a hammer head during BAM's November meeting held at Andy's new shop. Photo by Jim McCarty.

Editor

Jim McCarty

Contributing Editors

Bob Alexander
Fred Wiesenborn

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 or e-mail to jimmac@socket.net. BAM membership in-quiries should be addressed to: Maurice Ellis, Rt.1 Box 1442, Belgrade, MO 63622, (573) 766-5346 or e-mail to mbellis@therural.net. 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

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

- Regular Member\$45 yr.
- Senior Citizen (Age 65+).....\$40 yr.
- Fulltime student\$35 yr.
- Overseas airmail\$80 yr.
- Overseas surface mai\$60 yr.
- Contributory\$100 yr.
- Full time student\$35 yr.
- Public library.....\$35 yr.

See reverse

Editor's Anvil

Welcome to the new millennium! I am assuming it's January as you read this and that you got lots of coal for Christmas. I always appreciate that myself. Somehow it just dawned on me that we are talking the beginning of a new 1,000 years instead of just a new century. No time to do much in the way of celebrating for me. Guess I'll gear up for the next one. . .

It's amazing that blacksmithing is about as strong right now as it has been in the history of the craft, trade or whatever it is. One sure sign of this is the fact that lots of new tools, books and publications devoted to blacksmithing are coming along almost daily. You can even find shows featuring blacksmiths on the Home and Garden Channel if you can stay up late enough.

Let's do our part to keep it that way. One thing you can do is shell out \$45 and join ABANA. BAM is a chapter of ABANA, which stands for the Artist Blacksmith's Association of North America. ABANA was chartered to preserve blacksmithing at a time when it had just about died. That it's around now is a testament to the people who formed ABANA and to those like its president Lou Mueller who are determined to take it forward. If you aren't a member consider joining. There's an application in the front of this newsletter or you can join on-line using the secure site at www.abana.org.

A lot of good things could happen if ABANA doubled its membership. As it is, you will receive two magazines, *The Anvil's Ring* and *The Hammers' Blow*, have access to scholarships and can use the ABANA library of slides and video tapes. Coming soon, there will be a members' only area on the web with more good stuff. What are you waiting for? Join today.

Speaking of the publications, I did my last *Hammers' Blow* in December. I filled in for a year while the board selected a new editor. That person is Brian Gilbert from Chattanooga, Tennessee. Brian can use a lot of support to get him off the ground and running. Send him some stuff.

The Fall *Anvil's Ring* has a nice piece on our own Walt Hull, who is the "Focus" section this month. Walt is a real deep thinker and a pretty fair smith too.

What's going on with everyone? I haven't heard from anyone lately, hope everyone hasn't laid aside their hammers and given it up.

I did check in on Don Asbee recently. He says business is good and he had a number of projects going on to prove it. One was a set of gates. Don has many good ideas and one is the wheeled stands he made to move these big pieces around.

Also got to visit Joe Wilkinson briefly. Joe is hosting our May meeting. The last time we were at Joe's we did tailgating in the field in front of his shop. Now that area is taken up by a giant pole barn. Unless he loads it up we could do all the tailgating inside this time!

One of Joe's neighbors gave him an Emmert vise. Some guys just live right. This will tell you how powerful the Internet is getting to be. Joe called to tell me about his vise and while we talked I did a web search using Apple's Sherlock search utility. In 2 minutes I found the owners manual for this gem and instructions for mounting it.

At the November meeting we discussed the possibility of BAM setting up a permanent shop somewhere. A couple of ideas have come our way – one is to build something at the new site of the Missouri Valley Steam Thresher's Association in Boonville. They would like for us to do that.

Another possibility is Luxenhaus Farm which is a collection of historic structures from the 1800s. A long shot (or maybe not) is to talk the state into letting us set up shop in one of the buildings at the Lead Mines State Historic Site.

The consensus at the November meeting was that doing anything right now was out of the question as we just don't have the funds for what would most likely be a costly proposal. However I think it's something we should look way down the road toward. Many other chapters have done something like this. It would give those folks who don't have a



Emily McCarty, age 3

shop of their own a place to work. It could serve as a meeting place of last resort should we be unable to get a host for our winter meetings. And it would give us a place to hold workshops and store the stuff we have.

What else should we do? If you have a suggestion for a BAM class or workshop give our president Bob Alexander a holler. Some suggestions I have been hearing is to do another coal forge workshop and a gas forge workshop too.

Coming up, Lou Mueller is going to host a hammer-in featuring Steve Yusko Jan. 22. Steve was the resident smith at the Metals Museum. He is known for his surface texture treatment and for using common objects to create interesting pieces. Lou tells me Steve is setting up shop in the old Lemp Brewery in St. Louis.

Lou had a similar workshop in December featuring Doug Hendrickson. Wish I could have made that one – we had a huge turnout with 69 or so people counted.

Next meeting is January 8 in Mt. Vernon, Ill. After that we go to Tom Clark's Ozark School of Blacksmithing.

To all you people who gave me a hard time about Andy's upside down map, I think I got it right this time. See you January 8.

— Jim McCarty

Buying the Kerrihard

by Fred W. Weisenborn

Here's the picture of the Kerrihard I got a while back. There is a little story that I have to pass along with it though... An auction bill listed a "power punch" in the list of tools along with anvils and forges. The auction was the same day as Ray's meeting so I went down the afternoon before to check things out so I wouldn't miss the meeting for nothing.

As it turned out the power punch was a Kerrihard power hammer. It was under a shed and turned free. That night I called Jim McCarty to get an idea of the value. I counted my stash money and a jar of change, got an advance on my allowance, and borrowed a little from my son. I had enough to make a good try at it.

The day of the auction there were five other smiths casting greedy eyes on the anvils, forges, and blowers but none seemed too interested in the hammer — poker faces !? I fretted.

One of the most active bidders throughout the day was a crusty old-timer everyone knew as Double X. Even the auctioneer would just say "sold to Double X" — no bidding number was used in his many purchases.

One of the locals explained that a while back Double X was in the hospital in bad shape, not expected to live. Two of his daughters were in his room and he overheard them talking about what they each were going to do with their share of the inheritance. Well he got better and took excep-



tion to what he heard. Ever since he has been spending everything he could at auctions, usually getting what he bids on and filling a new 40x60 shed with truckloads of junk. Revenge!

Well, the blacksmithing equipment brought good prices, picked up by all the other smiths. Finally the auctioneer led everyone over to "power punch" and started it out very low. Shocked, I jumped in bidding against an unanticipated opponent but he only ran it up out of the practically "give-a-way" range.

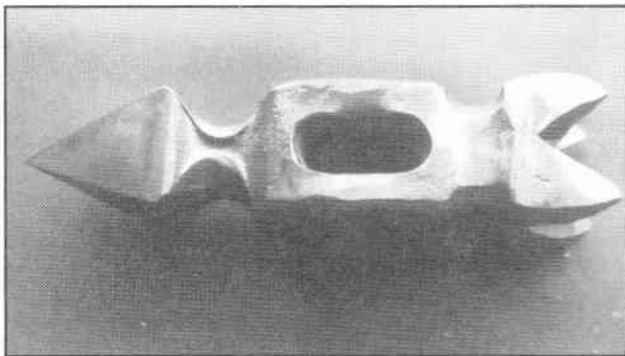
Next, one of the smiths ran me through the "super-bargain" range. Long pause, starting to think I was getting the greatest deal I could have hoped for and then Double X jumped in and off we went! I was sweating bullets all through the "bargain", "what-a-deal", and "good deal" ranges when XX suddenly dropped out right at the threshold of "lower fair price" range!

I got it!

Later when the auction was over and I was waiting for a tractor to help load my prize, Double X came over to ask what I was going to do with an old power punch. I told him it was really a power hammer, the kind blacksmiths used years ago. A scowl came over his face and he turned quickly to look at the machine.

After a moment of study he turned back to me and said, "If I'd a known what that was, I would've bought it", and off he went to finish loading his truck.

I stood there and marveled at my luck.



This is John Murray's Y2K hammer. He said it is based on one unearthed from a Medieval battle site in France where the experts were puzzled as to why so many of the dead had square holes in their armor. Better leave John's groceries alone . . .



ABANA

New ABANA Logo: Jack Andrews has been working on a new image for ABANA. Here's what he came up with.

Bob's Business

As not only another year, but another century has ended, it causes one to reflect on the past. Studying the past can give one the knowledge to move on into the future. This learning process can be applied to many aspects of your lives, including blacksmithing.

By studying the works and ideas of our predecessors and not only using them, but using them as building blocks, then we can contribute to the growth and development of blacksmithing.

At a recent workshop at Lou Mueller's, Doug Hendrickson showed us a variety of useful ideas. I think these ideas were meant to be used as a seed to provoke the thinking process and take these ideas to a greater height. One must not be satisfied with why something happens but ask what if I do something different, will this perhaps be an improvement?

For example, watching Uri Hofi demonstrate and knowing that he has studied with some of the world's greatest smiths, one can see that he has taken their ideas and by asking "what if" has built upon their knowledge to improve the art of blacksmithing.

So the challenge for the next century is not just to learn as much as is already discovered but to try and ask "The what if" question and see if we can contribute to the advancement of blacksmithing.

Hope everyone had great holidays and hope to see you at the January meeting.

Keep on hammering,

Bob Alexander



2000 BAM Meetings

March 25, Tom Clark, Potosi

May 20, Joe Wilkinson, Hope

July 29, Kirk Sullens, Bass Pro Shops

Fabrication Shop, Springfield

September 23, Ed Harper, Browning

November 11, Pat McCarty, Washington

BAM

November MEETING

by Jim McCarty

In November about 50 BAM members got a first look at Andy MacDonald's shop. It was a new shop for Andy too as he just moved in a week or so before the meeting. We didn't see any wet paint but it was obvious the place was new – no clinkers on the floor and the forge had never had a fire in it.

Andy's shop was an old garage in the Illinois town of DeSoto. (Wonder how many BAM'ers went to DeSoto, Missouri?) Seeing it made me realize there are probably a lot of similar places in small towns that could be had pretty cheap.

We all know Andy as a world-class tool scrounger and of course we figured he keeps the best of the rusty iron for himself. This proved to be the case as we quickly discovered. Outside his shop, standing like the silent sentinels on Easter Island, were power hammers in various stages of disrepair. These aren't no wimpy hammers either but big mamas.

Inside he has a beauty of a Chambersburg self-contained unit that is just a few nuts and bolts from being operational. He also had the typical Little Giants and even a treadle hammer to round things out.

True to form, we were pretty slow

getting the demos cranked up. Everyone had to look at Andy's goodies, shoot the breeze and check out the limited supply of tailgate items for sale.

When we did get a fire going it was Rick Smith who stepped up to the anvil. Rick is the new professor of blacksmithing at Southern Illinois University. He started by spreading his hammers out on the floor and showing the function of each. Then he set out to forge a double-ended raising hammer from a jackhammer bit.

Rick may be small in stature but we soon realized this guy can wail with a hammer. At one point he was swinging a small sledgehammer one-handed with apparent ease – and not just one or two hits but a full heat's worth. Andy gave him a little help drifting the eye. It was a fine piece, would like to give it a try when it's handled.

After a short business meeting and a good barbecue feed Pat McCarty took over. Pat has been saving some new tricks and he put on a good show. His first was a clevis made from pipe. Pat had explained this to me but I didn't get it until he showed it.

His second demo was how to make a cow bell. Pat had many of the steps completed before hand on both of his demos so we didn't feel like we were watching paint dry. This is a good idea for others who demonstrate.

As usual John Murray had something interesting to show us. This time it was his Y2K hammer. John read an account of a battle that took place in France that had historians baffled. Seems they dug up a lot of armor from dead soldiers that had square holes pierced in them. John's hammer was what made those holes. Should things get a little crazy when the calendar changes don't go looking for groceries to steal at John's house.

This was one of BAM's better gatherings, great day, better site and even better demonstrators. Thanks to Andy for all the effort he made to get the place ready for us.

Minutes

- Thanks to Andy for hosting us (great shop).
- Minutes of last meeting approved as

published.

New Business:

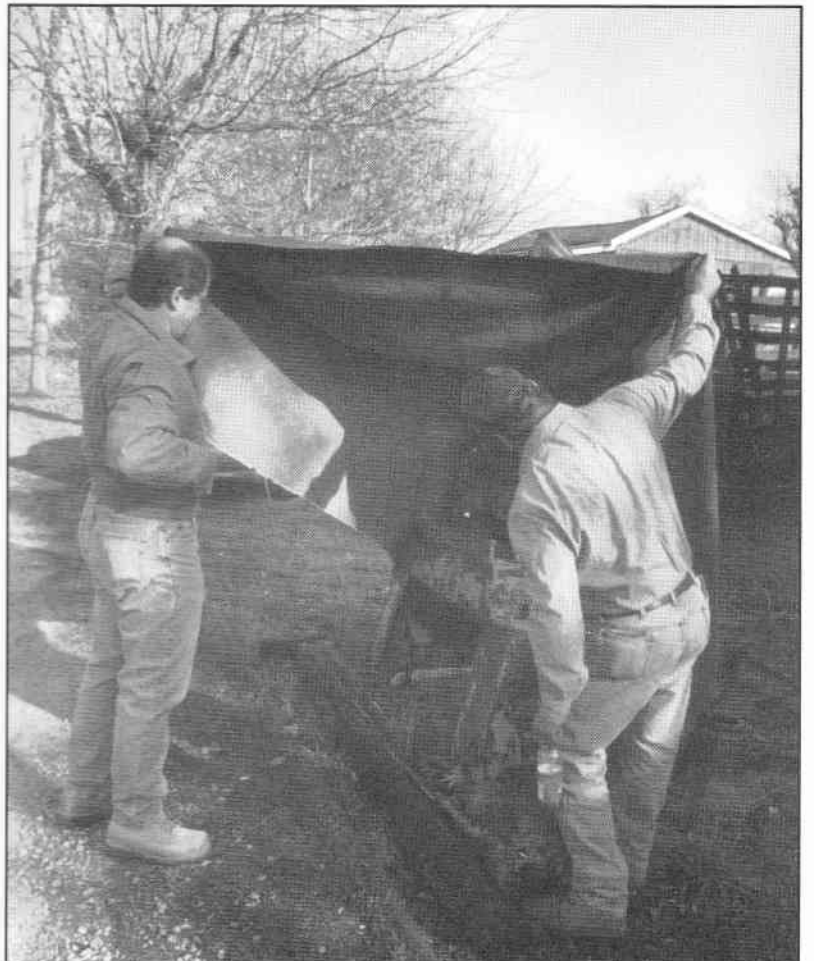
St. Louis Renaissance Fair in Spring 2000 – more to come. May be a good chance to demo.

- Michigan Blacksmiths Association proposed a membership and T-shirt trade. This idea approved.
- Maurice Ellis spoke on the Missouri Valley Steam Engine Association proposal. They are developing a site, possibly a living history museum and would like to include a blacksmith shop. This whole idea is in the planning stage, more info and discussion to come. This is a complex subject with aspects of finance, responsibility, ownership, upkeep etc.etc. More to come.
- Bob Alexander spoke on the ABANA 2000 Conference projects; that is, the buffalo skull, chain and balusters.
- Tom Clark and Maurice Ellis also spoke on this. More on this to come and more detail at the January meeting.
- Doug Hendrickson spoke on BAM's 2000 Conference, 5-6-7 May 1999 to be held at the Warren County Fairgrounds in Warrenton, Mo. Doug handed out an info sheet (to be published) with details. Doug spoke on the various demonstrators and emphasized the opportunity afforded by the photography lecture and studio shoot by Jeff Bruce. This can add a new dimension to your ironworking.
- Doug encouraged the members to make and donate items for the BAM Boutique. Volunteers also needed for teaching, manning forges, etc. Check with Doug if you can help.
- Lou Mueller will have a workshop at his shop in Fenton, Mo. On Dec. 11 featuring Doug Hendrickson at the forge. Doug will address two subjects: cheap tricks at the anvil (Wham, BAM, thanks Ma'am) and applying these techniques to sculptural work.
- Our next BAM meeting will be 8 January 2000 at Mt. Vernon, Ill.
- Lou Mueller has been elected president of ABANA. Congratulations Lou.
- Thanks to demonstrator Rick Smith
- Motion to adjourn approved.

*Respectfully submitted,
John Murray, secretary*

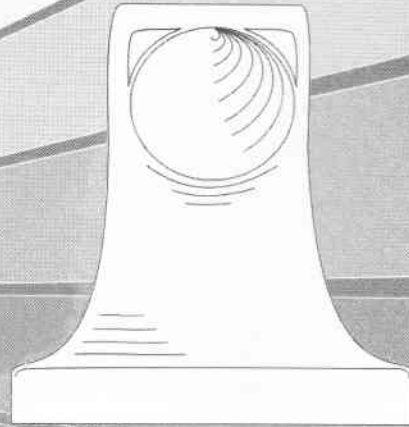


Above: Rick Smith and Andy MacDonald team up to complete Rick's hammer. Right: We always figured Andy kept the best stuff for himself, and we discovered a lot of treasures parked inside and out of his shop. Andy has at least five power hammers in various stages of repair. Below: If you ever wondered where all those old anvils went now you know. When Bill Clinton has his redistribution of the wealth Andy is in trouble!

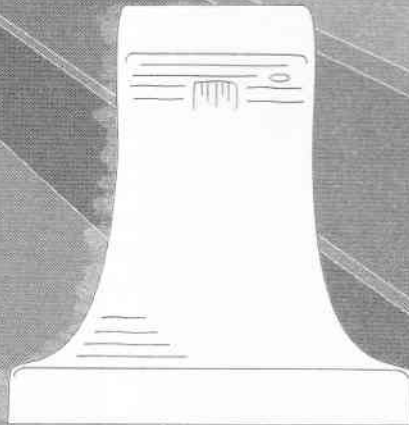


Make plans now for ABANA's big Year 2000 Event

ABANA CONFERENCE 2000



**A DIFFERENT
PERSPECTIVE**



**JULY 12-16, 2000
NORTHERN ARIZONA UNIVERSITY
FLAGSTAFF, ARIZONA**



CHAPTER LIAISON NEWSLETTER

November 1999

Dear ABANA members and prospective members,

First, thanks to ABANA members Curtis Evans, Carl Grainger, Buddy Leonard and Al Stephens, who showed their willingness to contribute to the future of ABANA by running for positions on the Board. Second, I look forward to hearing from our members and prospective members for ideas on how to improve ABANA and move the organization forward into the 21st century. And my thanks to Doug Merkel for the great job he did in this position. I appreciate the assistance, information and encouragement he has provided as I move into the spot and continue the stewardship that he and the other liaisons have provided ABANA's membership and the chapters over the years.

The ABANA Board members had a very positive and productive November meeting at the National Ornamental Metal Museum. Out of that meeting, several changes will come. One of the earliest will be in the ABANA web site, which is slated for a major overhaul in the very near future. Also, we have a new editor for *The Hammers' Blow*, Brian Gilbert of Hixon, Tennessee. You will see Brian's impact on this, the "how-to" journal of ABANA, in his first issue. Please support Brian by sending him material to share with all the membership. Planning for the 2000 Conference in Flagstaff is proceeding well. Bill Callaway and his team are doing an excellent job in preparing an excellent educational and entertaining conference. We all hope to see you there.

From my end, I am still settling into the position, but will address these issues first: 1. By May 2000 the updated demonstrator list will be sent to all Chapter newsletter editors and posted on the ABANA web site. If prospective demonstrators wish to be included in this list, please send your information, including availability, demonstration topics, any restrictions and fee

schedule to LeeAnn at the Central Office. Demonstrators who were on the previous list will be contacted to allow them to comment on their retention on the list, and/or change their posting information. 2. By February 2000 the safety guidelines will be sent to all Chapter newsletter editors and posted on the ABANA web site. 3. By February 2000 the ABANA statement on copyright for articles in ABANA publications will be sent to all Chapter newsletter editors and posted on the ABANA web site.

Please feel free to contact me with your positive comments and suggestions and constructive criticism on how to make ABANA even better. We, the Board of ABANA, can only respond to our members if we hear from you. I look forward to meeting you at regional meetings and conferences. In between meetings, my evening telephone number is (215) 489-1742, and my e-mail address is: cjfdlearn@mindspring.com

Finally, when you stand at the anvil next, pause and remember Francis Whitaker, who passed from this life in October. For more on Francis, please go to the ABANA web page www.abana.org. The banner on the bottom will link you to two other sites. Also, go to links, then publications, then Anvil Magazine to read Dorothy Steigler's tribute to Francis.

Thanks for your support in serving ABANA.

dbl

Editor's note: Congratulations to BAM's friend Doug Learn who was elected to the ABANA Board last Fall. He replaces Doug Merkel who chose not to run again. BAM members will remember Doug Learn from when he lived in Memphis and helped organize the River Bluff chapter. Doug now lives in Pennsylvania where he keeps Al Stephens in line.

BAM

Bulletin Board

Heavy duty frying pan blanks: Steel, approximately 9 inch in diameter with 2 inch sides. 12 gauge thickness. Available with or without two 3/16 inch holes for handles. Now tumbled clean. 1-4 \$9 each; 5-9 \$8 each; 10 or more \$7 each. Shipping \$2.50 plus \$.50 for each pan. Contact: Bob Tuftee, 3855 Aspen Hills Dr., Bettendorf, IA 52722.

300-pound Arm & Hammer logo anvil with some hardie tooling, \$450. Need someone to weld a crack in a cast iron forge. Charlie Trevena, Wentzville, (636) 332-6260.

Verticle milling machine, \$750; Tiny horizontal mill \$250; Libert metal shear \$350; metal planer \$550; 2 punch presses, \$450/\$600; nibler \$350; Tiny shaper \$350; 2 rivet machines, \$350 for the pair; electric heat treating oven \$250; huge drill press \$350; huge gas air compressor \$350; Shopsmith \$260; treadle leather sewing machine \$350; roofing tar kettle \$200; '49 Chrysler limosine \$1,600; motorcycles, tractors and more. Contact Steve Combs (636) 797-9093.

New 3-phase rotary converter, 5 h.p. Has panel box with three breakers, \$550. 10 h.p. \$650. Also new style 25-pound Little Giant, \$1,800 and 50-pound high speed hammer good for sheet metal, \$2,500. Also woodwork- ing tools including large jointers and a bandsaw. Contact Bob Bergman,

Bob Bergman, (608) 527-2494.

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. Contact John Murray at (636) 398-4640.

The editor has a huge machinest vise mounted to a 4 foot square heavy steel table, \$300 for both. Also a 7-1/2" post vise, \$250. Call Jim McCarty, (573) 395-3304 or e-mail to jim-mac@socket.net for details.

For sale: 3/8" diamond tread plate about 33" x 89". will trade for a vise, pony or what ever. Pat McCarty, (636) 239-3814 or e-mail to bud- den@usmo.com

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, Wash- ington, 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.

Kayne and Son Custom Hardware, 100 Daniel Ridge Road, Candler, NC 28715. (828) 667-8868 fax (828) 665-8303, email: kaynehdwe@ioa.com, website:

www.kayneandson.com. Offering Big Blue 100 ram air hammers, Pedding- haus 2 horn anvils, Offcenter tongs and swages, etc, hammers, tongs and more. 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: kaynehd- we@ioa.com. Check out the web site at www.kayneandson.com.

Tom Clark has expanded his line of Hofi style hammers to include a nice rounding hammer and punches, drifts, tongs etc. He's also importing a new line of air hammer, the Sayha from Turkey. For more info on the tools and his Ozark School of Black- smithing contact him at (573) 438- 4725. He also has coke for sale at \$6 per 50-pound bag..

Power hammer history! *Pounding out the Profits — A Century of American Invention* by Douglas Freund (hard- bound, 317 pages, profusely illustrat- ed) is available for \$32.50 plus \$4.50 shipping and handling through Min- gus 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.

George Dixon is offering a new line of tools called "The Old Philadelphia Tool Co." These tools are patterned off of old European designs and will include directions for using them effectively. He offers a brochure if you send him a stamped, self- addressed envelope to: The Old Philadelphia Tool Co., 1229 Bee Tree Lake Road, Swannanoa, NC 28778. He is also starting a new black- smithing publication called "The Tra- ditional Metalsmith" set to debut in January. For \$28 you will get four issues of How to information. George is the past editor of *The Hammers' Blow*.



Ozark Conference 2000

Featuring:

New Location!

Tom Latané
Traditional Ironwork

Bill Fiorini
Damascus knifemaking

Kirsten Skiles
Repoussé

Plus:

- The ABANA Teaching Station beginner's workshop
- BAM's greatest hits
(New tricks from BAM's best)
- Auction of high-quality ironwork with the esteemed Col. David Cornett presiding

Contest of Forging Skill

**Metallurgy lecture with
Ruben Funk**

**Photography lecture with Jeff
Bruce**

**Family program
(Stained glass & hot beads
with Leigh Funk)**

***Warren County Fairgrounds,
Warrenton, Missouri
May 6, 7 & 8***



Above: Tim Underwood made a big impression on some future blacksmiths with his nail-making demo. Right: BAM President Bob Alexander shows his wares to a group of youngsters. Business was brisk for Bob and others who had forged iron for sale — at least until the rain started.



Oktoberfaust 1999

George Dixon was the featured Oktoberfaust demonstrator. He did well despite a broken leg.



Lou Mueller is determined to let the general public know that blacksmithing is back. With that in mind he organized the second Oktoberfaust event at St. Louis' Faust Park. This year the event was entirely a BAM affair, with George Dixon coming in from North Carolina to give us a Gothic iron demo.

We had a huge crowd going early on. There was plenty for them to see. Pat and I had a primitive hand crank forge set up under one tent. Next to us was Bob Alexander with a gas forge and a good supply of his candlestands, fire tools, spike knives and the like. Tim Underwood took the BAM sidedraft forge and pounded out nails. He didn't quit until every kid had at least oen.

Meanwhile Maurice Ellis was spinning metal, Mike Schmidt had the park forge going. That left George Dixon under the big top, working a treadle hammer and Lou's Little Giant with a broken leg. Later Tom Clark showed with his Hofi hammers and we found a tent for him too. I almost forgot the knife makers. Roy Warden and V.J. McCracken had a number of fine knives and a bar of Damascus with them to show how it starts. They had the biggest draw at the event, I think.

Just when it looked like the crowd would make us forget all about last year's event the leaden skies, which had been threatening all morning, broke loose. Undaunted, I think all the smiths kept pounding

The crowd made a pretty good effort at staying with us, breaking out the umbrellas. But before long we discovered we were forging for ourselves, which isn't such a bad deal until the roofs would dump a load of water into your fire.

I know Pat and Bob sold quite a bit of iron and took orders for some more. A lot of business cards changed hands and if nothing else we let people know there is an alternative to the cheap imported stuff.

I wish I could have caught more of George's demonstration but I was having too much fun. Lou, let's give it another try next year.

Williamsburg candle holder

Recently Dennis Sutton came to visit from Kentucky. While working in my shop, Dennis showed me how to make a reproduction of a candle holder that was dug up at Williamsburg. He thinks! Well, if it wasn't, it should have been. Here's how he did it:

Reprinted from the Ocmulgee Blacksmith Guild Newsletter
by Buster Grubbs

1. With about a 3-1/2 foot length of 3/16" round stock, heat one end to bright red and taper to a point.



2. Heat pointed end again and bend 90 degrees for about 1/2"



3. Heat at bend and bend again 90 degrees opposite other bend.



4. Heat about 8 to 10 inches at end and catch point in vise jaws. Let vise jaws cool point just enough so it won't twist off. Start making a coil by going around and around keeping coil tight.

5. Keep heating and coiling tight and flat until you have about a 3 to 3-1/2" flat circle made from coil with point protruding from the middle.

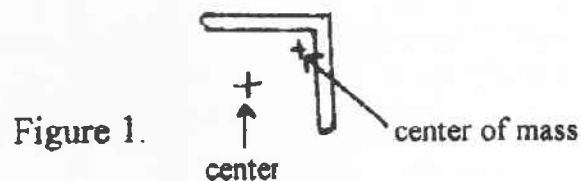


6. This should leave about 4 or 4-1/2" to form a handle. Heat handle end and bend to form handle.

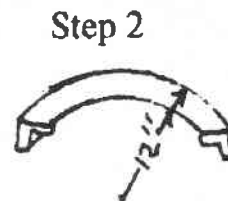
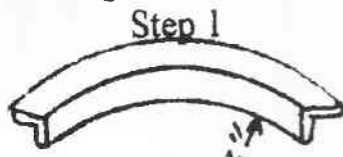
Note: I have watched our president, Jeff Mohr, demonstrate so much that I have taken up his habits. Notice that all measurements are *about*. This will give you a little room for self expression and me a little room for error. Thanks, Jeff!

Bending angle iron

Reprinted from the Bituminous Bits, Alabama Forge Council

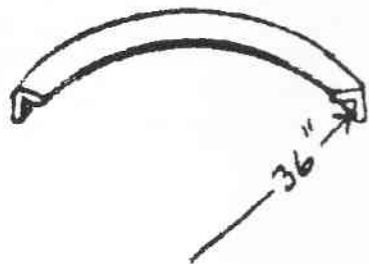


To bend with angle turned in: Shown with 12" radius



To bend with angle turned out:

Step 1



Step 2



by Robert Holden

This is a method of curving angle iron I saw demonstrated by Clay Spencer at John C. Campbell Folk School. It is described in "The Blacksmith Cookbook" by Francis Whitaker.

When hand bending angle iron one must understand that the center of mass is not the true center; rather it will try to bend around a point close to where the two flanges meet. See Figure 1. to allow for this, this

method stretches the opposite flange so when you bend the final diameter you will come out with an angle that has little or no distortion. To do this you must bend the first flange to a radius three times the final radius. As you do this you will notice that the opposite flange to the one you are bending will also bend. That is what you want to happen. Do not straighten this as it will straighten itself when you do the final bend. You can bend angle up to 2 inch cold using a bending fork.

Get a gig

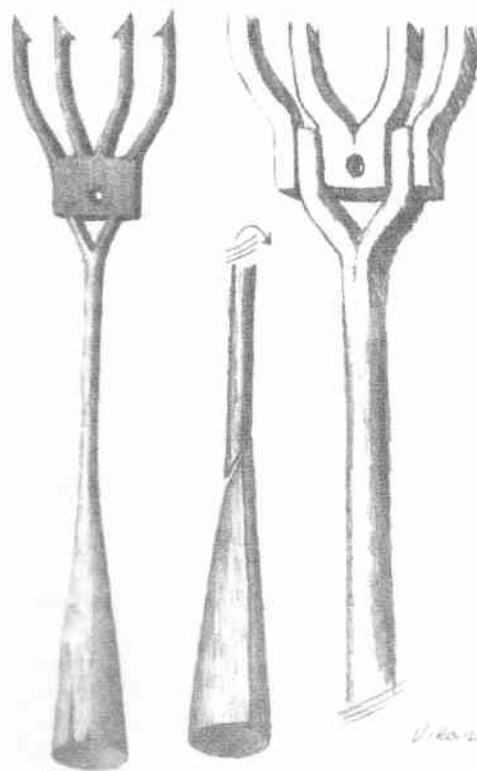
Here's an interesting new way to make a gig, probably not new but it was at least new to the editor. It would save a lot of trouble splitting out the tines from a piece of leaf spring which is how I have always seen it done. This method would involve a few forge welds or, dare we say it, arc welds, but should result in a strong gig.

By the way, this really isn't a gig but a tool used on whaling ships to remove blubber as it was cut off. Whales being in short supply in Missouri, it would make a suitable gig for fish and frogs.

This drawing came from the North Texas Blacksmiths Association newsletter. The original was brought to Virgil Vines at the Heritage Farmstead Museum and he made the drawing from that.

The original was made from five pieces Virgil guesses. The drawing shows welding on the socket which is formed from sheet metal. A better method might be to forge this from one piece of solid stock, flaring it out with your pein and working it thin.

To get the shape forge a mandrel from some long round stock, work it close in the step of your anvil. Then heat the socket, drop it on your mandrel and bounce the mandrel on your anvil or a piece of heavy steel set in the floor. As you bounce it the socket will form itself. This is how Paul Martin of Bunker makes his gigs. You need



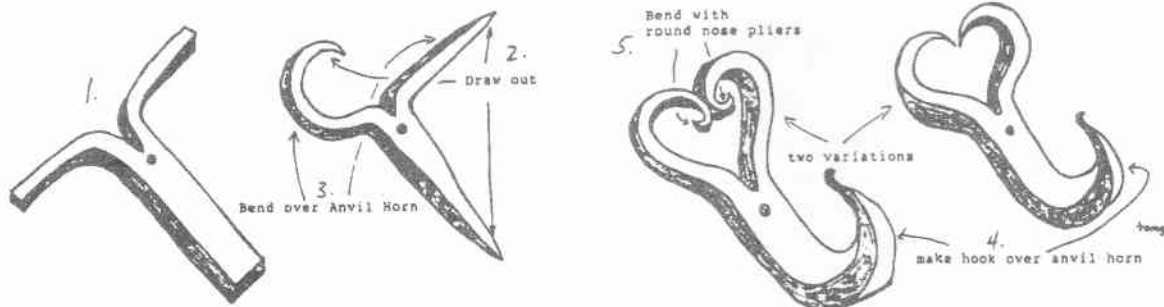
one other thing and that's a hole in the socket to pin it to the gig handle. Paul used a file to cut through the socket rather than drilling it.

Make this from tool steel and temper it to withstand the rocky bottoms of Ozark streams. Hand made gigs are much in demand. A good one sells for no less than \$50.

Anyone making something like this should first read "Moby Dick". Good luck finding a volunteer for the tempering step!

Rainbo's heart hook

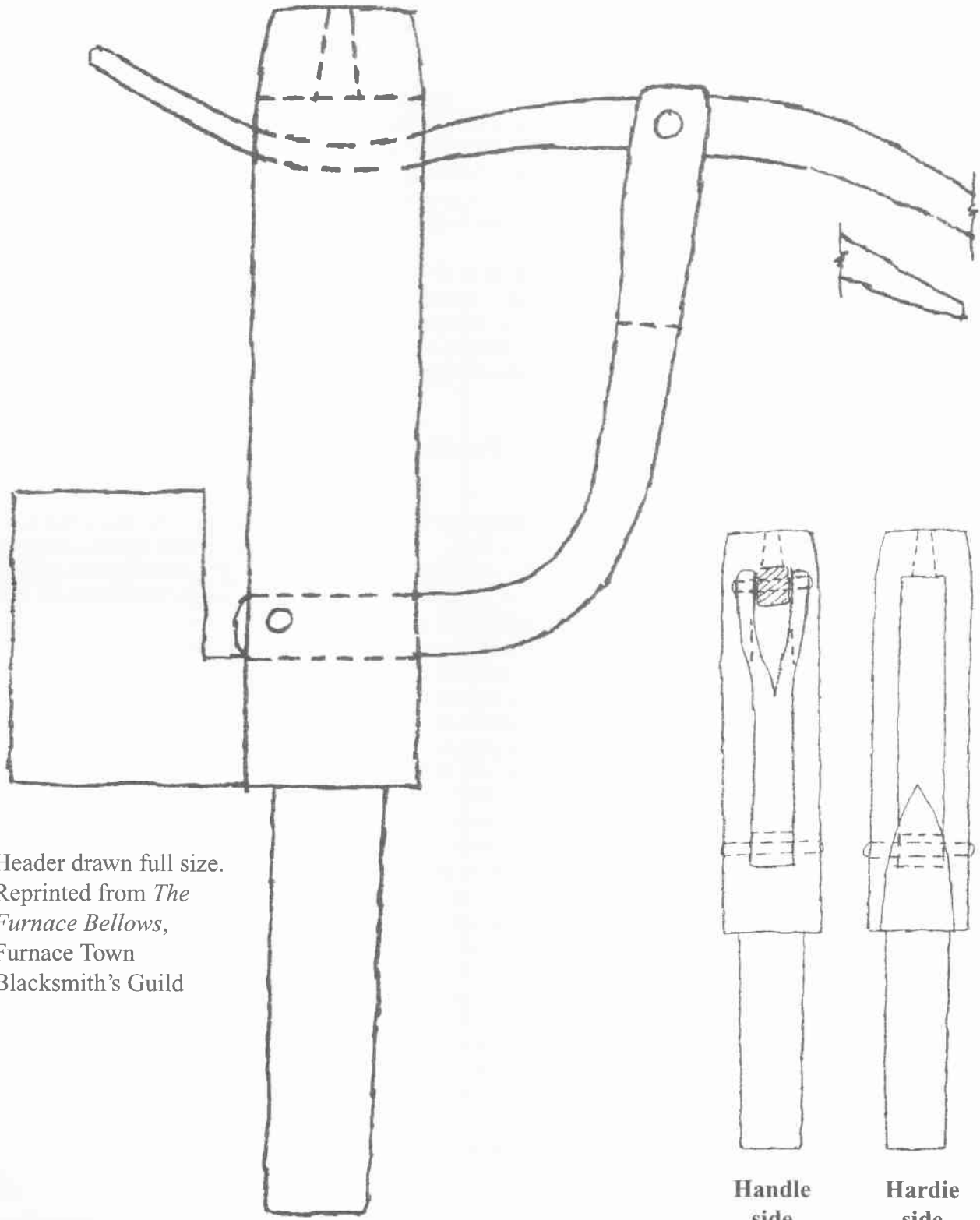
This heart hook is one of the many projects Rainbo Clary has contributed to the Illinois Valley newsletter. If you make it I would suggest one change: Use a small spring fuller to put a fuller mark on each side of the hook just below the hole for the mounting nail.



Colonial nail header

Of all the tools in Jim Sorber's collection, this one is my favorite. It lets you do all the work of nailmaking except for drawing out. Note the cutoff hardie on the left side. The handle pops the headed nail out of the top.

from the Sorber Collection



Header drawn full size.
Reprinted from *The
Furnace Bellows*,
Furnace Town
Blacksmith's Guild

Handle
side

Hardie
side

BAM SHOP TIPS

Clamp pads

Q: Do you happen to know a good way to replace the floating tip on the end of a c-clamp screw. I buy a lot of them at the junkyard without them and need to repair them.

A: Drill the pad slightly larger than the ball and about 1/2 again as deep. Peen over.

— Roy Wilson

Heat treat 13

Q: I gotta chunk of H-13 for my air hammer dies. When I look at the hardening data that I have, it says something like "heat to 1400 degrees and hold that temperature for one hour for every cubic inch of stock". Well, I have a coal forge, not a heat treating furnace. Anyone have any GREAT ideas for hardening this stuff with the tools on hand? I would imagine you don't want power hammer dies too hard.

A: H-13 Makes good air hammer dies if tempered after heat treating at 1000 F. Here is how I heat treat H-13 with a coal forge. (Don't quench H-13 in anything but STILL AIR — NOT OIL and above all NOT WATER.)

Start by heating your piece slowly, there is no hurry. Industrial heat treat includes a stress relief step — that is why we heat slowly. Start on the out-

side of your fire and bring it into the center a little at a time up to about 1000 F — Dark Red, in low light. Now go on heating up to above the critical temperature which for H-13 means to take it to 1850 F. This is a good Bright Orange heat, (not yet a Bright Lemon which is 2000 — 2050 and too hot). Again I assume in low light — not outdoors in sunlight. Don't hurry here either — let the temperature soak in, but don't get it too hot, keep turning your item over.

Now comes the easy part. Set the item on a fire brick and let it air cool. This is a STILL AIR QUENCH — a lot of smiths have trouble believing this is a quench but it is. Let it cool to 140 — 150 F. (You can just hold your hand on it.)

Now temper by heating to 1000 F, the Dark Red, some call it Blood Red. Let air cool again, repeat. (temper twice). You are done. Clean up and put to work. It should be about Rockwell C 54.

— Dave Smucker

Prepared for propane?

You mentioned the torches thread and that reminded me of something that I've been meaning to post to the list. One of the side conversations regarded regulators and differences between propane and acetylene regulators. There were two sides in this issue with regards to using acetylene regulators for propane. There was sufficient argument on the part of the "you can't use acetylene regulators because of the material used in the interior gaskets, diaphragm, etc..." group to make me want to confirm what my dealer had told me. That was, essentially, that the only difference between the two regulators was the gauge face and that the acetylene regulator was safe to use with propane. (Hoses, on the other hand, are a totally different matter.)

Well, anyway, I contacted the Customer Service rep at Smith Equipment and asked about my torch setup (a SMITH acetylene set, using propane tips and propane for fuel). In particular I asked if there was any difference in their fuel regulators in their propane

sets vs their acetylene sets. The SMITH EQUIPMENT Customer Service Rep that answered replied on 12/07/99. I didn't post the reply back then, as I thought the thread had gotten heated enough and needed time to simmer down a tad. Anyway, the reply (direct unedited quotes) is as follows:

"The acetylene regulator will work fine for you. The basic difference between a propane and an acetylene is the gauge face. An acetylene regulator has a red line beginning at 15 psi to warn against over-pressurization. That same issue is not present when using propane."

With regard to hoses, he went on to say:

"As for hoses, technically, you should be using T grade hose for alternate fuel. Over time, non T rated hose can degrade."

In the case of my SMITH torch set, it came with T grade hose although it was an acetylene set that I purchased.

I called back for a clarification regarding the materials used for gaskets, o-rings, diaphragm, etc... in their fuel regulators. His verbal reply was that at one time, there were differences in these materials. However, that was changed a long time ago (no specific time frame given) and that the same material is used in both acetylene and alternate fuel (i.e. propane) regulators. The only difference, he reiterated, being the gauge face. When asked about other brands of regulators, he did state that the same applies to most if not all oxy/fuel gas set manufacturers, but he didn't know for sure if it applied to all of them. He said that if in doubt one should contact the specific manufacturer directly and not rely on "common wisdom" (his words, not mine).

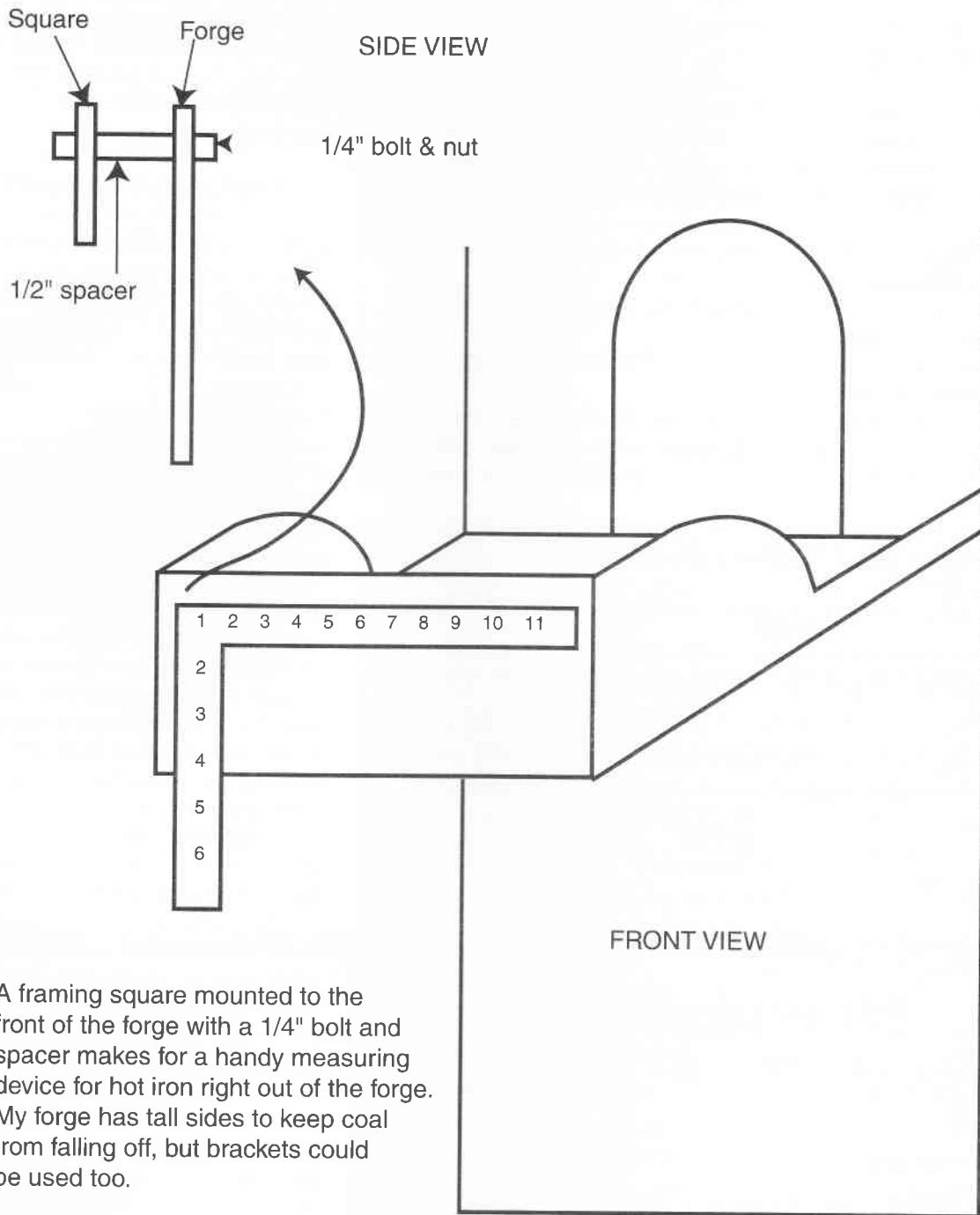
So, the answer to this question comes down to: If you have a newer oxy/fuel gas set it is probably safe to use with either propane or acetylene, but first check with your dealer or the manufacturer. If you have an older acetylene rig, it is probably not safe to use it long term with propane, or get it rebuilt with new multi-fuel compatible components.

Or, such is how I concluded.

— Dave Brown

Bob Alexander's

Hot Iron Measure



A framing square mounted to the front of the forge with a 1/4" bolt and spacer makes for a handy measuring device for hot iron right out of the forge. My forge has tall sides to keep coal from falling off, but brackets could be used too.

BAM NEWS

Hammer-in at Lou's

Lou Mueller is hosting another in a three part series of hammer-ins at his new shop in Fenton, Missouri. This one will feature Steve Yusko and will be held Jan. 22.

Steve is an excellent blacksmith who some of you saw demonstrating at the 1998 ABANA Conference. His specialty is taking common objects like diamond plate and forging interesting objects from them. He has a great imagination and does some amazing surface treatments.

This demo is free to all BAM mem-

bers. Lou will also be holding a beginner's workshop soon. We'll get you more details on that down the road.

Roster update

Plans are underway to publish a BAM membership roster in the first newsletter of Y2K (if not eaten by the millennium bug). If you know that you have had changes in your address, phone number, or phone area code (I think I have corrected all of those in Missouri), please let me know. If you have not given me your e-mail address, you may wish to do so. Now that e-mail is getting to be common, we hope to have an e-mail listing in an issue of the newsletter next year also (maybe along with the roster). Send changes to: Maurice Ellis, Rt. 1 Box 1442, Belgrade, MO 63622. (573) 766-5346.

e-mail: mbellis@therural.net.

Host a meeting

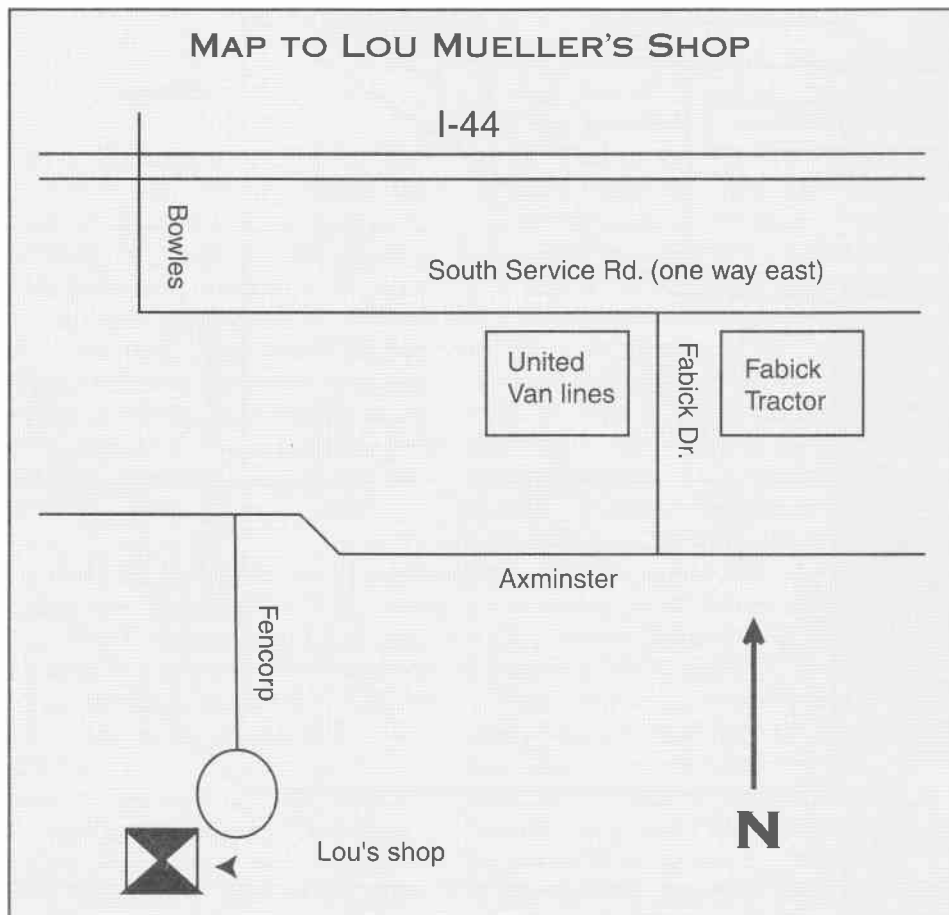
The BAM meetings have been scheduled for the year 2000. They have been published in the newsletter.

It is not too early to start scheduling meeting places for the year 2001. If you would be willing to have a meeting in 2001, please let me know. It is advantageous to have meetings held throughout the area so some members do not always have to drive great distances to get to them. The only way meetings can be scheduled throughout the membership area is to have people volunteer who live in various regions. If a meeting has not been held in the area where you would like, volunteer to have a meeting if possible or see if someone in that area would like to have one. Contact Maurice Ellis, (573) 766-5346, or send e-mail to: mbellis@therural.net .

What's a trade item?

Some newer members have inquired as to what "Iron-in-the-Hat" and "Trade Items" mean. These are two activities that take place at each scheduled BAM meeting. "Iron-in-the-Hat" is a means for BAM to obtain additional operating money and an opportunity for those attending the meeting to acquire tools, metal, sculptures, etc. BAM members bring and donate various blacksmith-related items. Two-part tickets are sold for \$1 each or 6 for \$5. The ticket purchaser then places half of each ticket in the container(s) for any item(s) he/she hopes to win. Usually just before the business meeting begins, a ticket is drawn from all the tickets that were placed in the container for each donated item. The person holding the other half of the drawn ticket wins that item.

"Trade Item" means that the person who hosts the BAM meeting decides before the meeting what the trade item will be (published in a newsletter prior to the meeting.) Those attending the meeting, who choose to do so, bring an item of the named trade item that they are willing to trade for another item of the same type. Typically, members make the trade items. At the meeting each "Trade Item" is assigned a number and a corresponding number goes into a container. Each person who brought a "Trade Item" draws a number from the container and gets the item with the corresponding number.



Next meeting January 8, Jefferson County Historic Village, Mt. Vernon, Ill.

John Lovin is the host for BAM's next gathering which will be held at the Jefferson County Historic Village in Mt. Vernon, Illinois. This group has been active for years improving the blacksmith shop and it has been the site of numerous activities, so many of you will already know the way.

John has some demos lined up already:

- Joe Littrell will give a talk on thermite welding.
- Roy Plumlee will give a forging demo.
- Gary Sporre will also demo.

John says there are three forging stations so there will be plenty of room for anyone wanting to do some work.

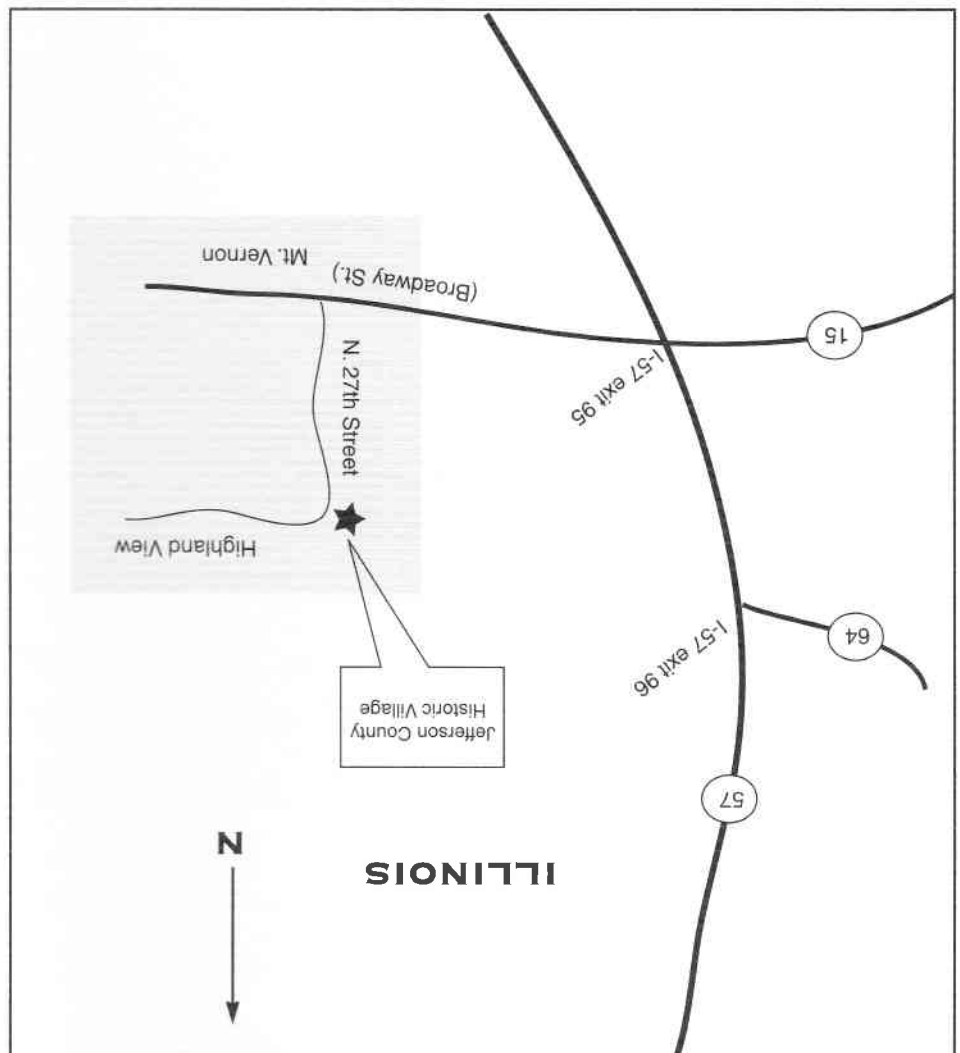
If you get lost or want more info call John at (618) 756-2331, Wilbur Haley at (618) 242-1365 or Ed Karcher at (618) 244-2171,

The trade item is a hot cut.


There will be soup and sandwiches for lunch or you can find a restaurant in Mt. Vernon.

As usual bring something for the iron in the hat (money for tickets if nothing else) and don't forget those trade items. For the new guys, if you make a trade item you get to take someone else's trade item (hopefully better than yours) home with you.

See everyone in Mt. Vernon, Illinois on January 8.



Note: Many people let me know that the map to the last meeting at Andy MacDonald's looked a bit odd. The editor just put's 'em in like they send 'em most times but this time I made a few changes just for those of you who complained. If you guys see a Chicago city limits sign turn around and go the other way for awhile ;--)

 <h2 style="text-align: center;">2000 Schedule</h2>		
January Meeting	March Meeting	May Meeting
John Lovin Mt. Vernon, Il Jan. 8, 2000 Trade item: Hot cut	Tom Clark Potosi, MO March 25, 2000 Trade item: Fire tool	Joe Wilkinson Hope, MO May 20, 2000 Trade item: Bell



Roy Warden talks knives to a bunch of interested youngsters at the 1999 Oktoberfaust event.

BAM
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