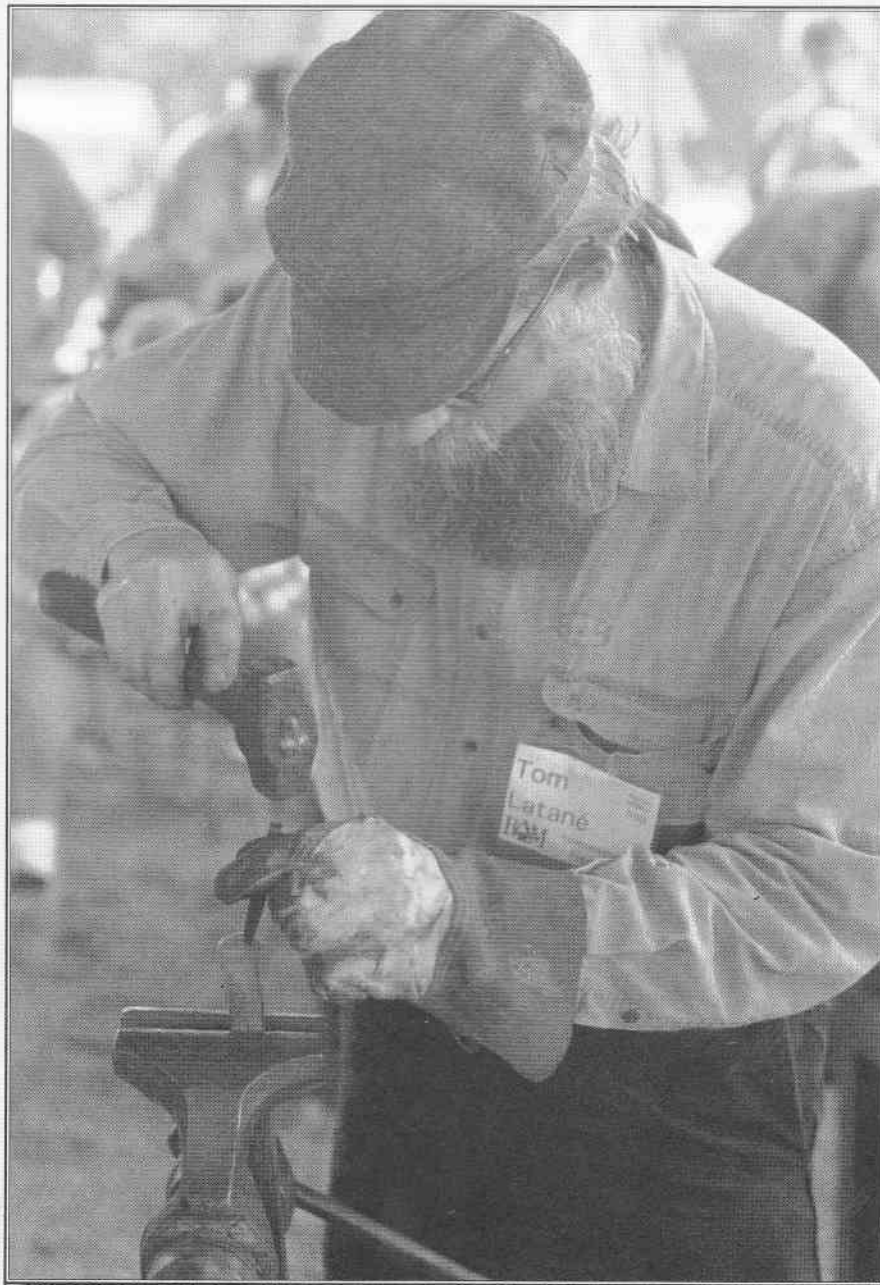


RAM

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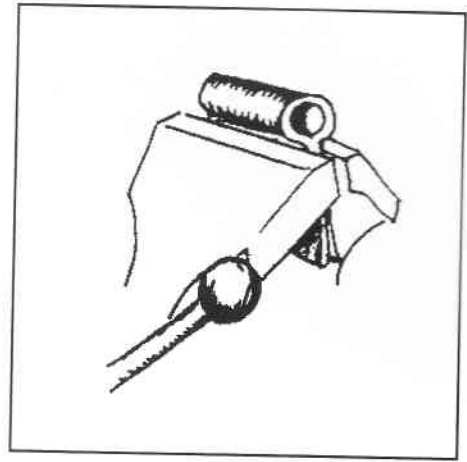
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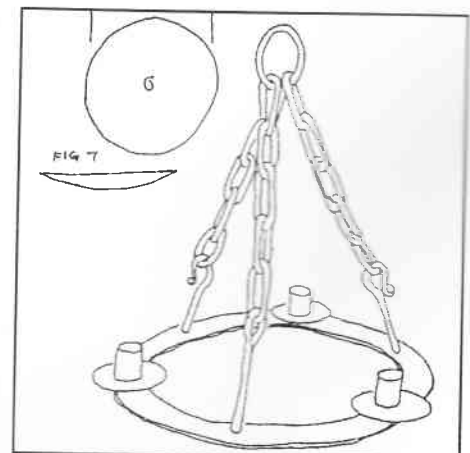
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**Newsletter of the
Blacksmiths
Association
of Missouri**

*May — June
2000*

Volume 17 No. 3

Our cover: Tom Latané puts the details on a figure he forged as part of his demo at BAM's 2000 conference. Tom was one of three featured attractions at the conference. Photo by Jim McCarty

Editor
Jim McCarty

Contributing Editors
Bob Alexander
Maurice Ellis

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 you can send e-mail to jimmac@socket.net. BAM membership inquiries should be addressed to: Maurice Ellis, Rt.1 Box 1442, Belgrade, MO 63622, (573) 766-5346 or send 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: _____
E-mail: _____

New Member Renewal

How did you learn about BAM? _____

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

ABANA Membership Application

Primary ABANA Chapter Affiliation: _____
Name: _____
Address: _____
City: _____ State: _____
Phone: () _____ Zip: _____

New Member Renewing Member

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

- Regular Member\$45 yr.
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- 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

Send this form in an envelope with your payment to:

BAM,
c/o Maurice Ellis
Rt.1 Box 1442
Belgrade, MO 63622

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

MasterCard VISA Check/Money Order

Card Number

Exp. Date (Required)

Checks must be in U.S. currency

SEND RENEWAL TO:

ABANA

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.

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ABANA

Editor's Anvil

Hello again...I finally got caught up enough to try to get this newsletter back on track. Believe it or not, this is the May-June news, which means if you get this in September I am only one issue behind. If one of my legs was bigger than the other you guys would start calling me Clay Spencer!

I think you all know I enjoy doing this newsletter but sometimes it really eats my brain. I like to play around with it way too much and make it look nice and when I get my copy in the mail it is a real uplifting experience. But I have been sitting in this chair in front of this computer all week and every once in awhile it would be nice to go forge some iron instead of writing about it!

So keep those submissions coming. When I don't have to scrounge around for something or write it myself it goes a lot faster which means I get to the forge faster.

Last month I stopped off at Bob Alexander's Scrub Oak Forge to pick up coal for the state fair. Bob has really done some neat things at his shop since I last visited. He has all kinds of new toys. My favorite was a complete set of forging tools all painted blue and never used that he talked some unsuspecting individual out of. For some reason he wouldn't let me break them in.

Bob has been getting lots of big commissions including some balcony railings for a home in Ladue or Clayton, one of them ritzy towns where you got to wipe your feet before you are admitted.

Bob has a sure-enough gallery attached to his shop and I got lots of ideas looking through his wares. Bob and I started forging about the same time but he has left me in the dust.

I finally finished my mailbox and will run some pictures of it in the next issue. There's an article on it in The Anvil's Ring and if I can get the author and the publications

committee and the editor to give me their blessing maybe I can reprint it in the next BAM newsletter.

Did any of you make it to Flagstaff for the ABANA Conference? If so, I am in need of some articles to publish in the Fall Ring. BAM was well represented out there with Jerry Hoffmann's gate demo, Don Asbee, Bob Patrick and I know I am forgetting some others demonstrating plus Kirk Sullens buffalo skull getting the seat of honor at the top of the bridge project. If anyone did ballusters and remembered to take a picture of their work before or after it was installed how about sending me a shot or two? Ditto on the chain links.

For some strange reason I didn't get either one done.

There are several conferences coming up this fall, plus a number of workshops including two sponsored by our friends across the river. Check this newsletter for more details.

Maurice has all of the meetings for 2001 scheduled. I really appreciate him doing this as I can publish the info and then you guys can't say I didn't know the meeting date. Put these dates on your calendar and if the news doesn't arrive in time at least you know when and where. Anyone who has a meeting set for their place needs to get me a map and a trade item. I hope to get all of this info on the BAM web site, which by the way is at www.bamsite.advertisnet.com.

There is some talk floating around about maybe doing a few more meetings this year. If that happens I'll try to let you know.

I haven't been able to make many of the meetings this year. If that happens it would be nice if someone would appoint themselves to write what went on and send it my way. E-mail works best for me because then I don't have to type it again. The address is

jimmac@socket.net.

This summer I had Al Stephens' "not-so-little" girl Julie working for me. She is a real hard worker, guess Al did something right there. Big Al bought out Doug Hendrikson's business and is going to make a go of it full time I understand. Al doesn't know it but he also bought the privilege of providing me with unique tips and techniques like Doug always did. Read it Al, it's in the contract...

I can't let this issue go to bed without pointing out that one of our founders turned 50 Aug. 23. Can you guess which one? If you can't, ask Patti Tappel, I bet she knows.

I think Bernie was about 32 when we last saw him.

Don't forget to put in an appearance at the third annual Oktoberfaust event. The lead demonstrator is Roger Boekstaele (or however you spell it) and he is something to see. Lou says his work will be on display at the gallery. If you went to the Asheville conference you saw his work and I know you were impressed.

Gotta beat it, write if you get work.

— Jim McCarty

THE JEFFERSON COUNTY HISTORICAL SOCIETY
WILL HOST THE 8th ANNUAL

BLACKSMITHING WORKSHOP

9:00 AM - 4:00 PM

OCTOBER 28 AND 29, 2000

AT THE HISTORIC VILLAGE ON NORTH 27th STREET
MT. VERNON, IL

COST - \$25 BOTH DAYS; \$15 ONE DAY

PROCEEDS TO BENEFIT THE BLACKSMITH SHOP AND VILLAGE

Roger Carlsen, Frankfort, Ill., will be our guest demonstrator this year. Roger is the Sec/Treasurer of the IVBA and operates Ephraim Forge. He will cover topics including beginner projects for the occasional blacksmith, blacksmithing as a business, restoration of old work, replication of old work, philosophy, tooling, techniques, and the meaning of life. Also some power hammer techniques, and working with a striker. Don't miss the opportunity to attend a unique and informative weekend at the forge.

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, 2000 although walk-ins welcome.

.....

NAME _____

ADDRESS: _____

CITY: _____ STATE: _____ ZIP: _____

PHONE: _____ AMOUNT ENCLOSED: _____

MAIL TO: Wilbur Haley, 19 Rushton Dr., Mt. Vernon, IL 62864

ANY QUESTIONS: Call Wilbur at (618) 242-1365 or John Lovin at (618)756-2331

Bob's Bidness

It seems the weather from our Potosi conferences found us at Warren-ton this year, but that's life. For those of you who weren't able to attend I'm sorry that you missed a great weekend of activities. I'm sure that our editor, Jim will have extensive coverage in this issue, so I won't repeat all that happened.

If anyone has any suggestions or comments to help make next year's conference a success please drop me a line. Also if there is anyone who has a particular type of demo, let me know. Next year I think we should expand a couple of different crafts for the spouses to choose from. Many thanks too all who participated in making this conference the success that it was.

As I write this column it is but a few days before our May meeting at Joe Wilkinsons' in Hope, Mo. Joe has a nice spacious shop along with his own

little piece of heaven on earth at the end of a long driveway far from the hustle and bustle of our noisy everyday world. There is always a good turn out and lots of rusty iron to trade.

The trade item was a bell and the demonstrator used this item to demo. This seems to be a good idea if anyone hasn't the skills to do a particular trade item, then by watching one being made may plant a seed for the future.

Next meeting is in July at Bass Pro Shops hosted by Kirk Sullens. July is typically election time for our club officers, and this July will be our last time that it will be held in July.

It has been decided that elections will now be held at the conference to allow more members a chance to participate. I think that just because a member may not be able to attend the election meeting, they shouldn't lose their

chance to vote. I would like to see the opportunity for an absentee ballot system to be used.

There is still some talk about a permanent BAM Forge site, and some have asked about smaller meeting groups that could meet and forge together more often than our bi-monthly club meeting as some of the other clubs do. If you have any thoughts on these issues or anything else please drop me a line or e-mail.

If you would like some coal brought to the next meeting please call or write to let me know. See ya at the next meeting.

*Keep on Hammering,
Bob Alexander
BAM President
scruboakforge@juno.com*

Interesting bits of useless Trivia

1. Rubber bands last longer when refrigerated.
2. Peanuts are one of the ingredients of dynamite.
3. There are 293 ways to make change for a dollar.
4. The average person's left hand does 56% of the typing.
5. A shark is the only fish that can blink with both eyes.
6. There are more chickens than people in the world.
7. Two-thirds of the world's eggplant is grown in New Jersey.
8. The longest one-syllable word in the English language is "screeched."
9. On a Canadian two dollar bill, the flag flying over the Parliament building is an American flag.
10. All of the clocks in the movie "Pulp Fiction" are stuck on 4:20.
11. No word in the English language rhymes with month, orange, silver, or purple.
12. "Dreamt" is the only English word that ends in the letters "mt".
13. All 50 states are listed across the top of the Lincoln Memorial on the back of the \$5 bill.
14. Almonds are a member of the peach family.
15. Winston Churchill was born in a ladies' room during a dance.
16. Maine is the only state whose name is just one syllable.
17. There are only four words in the English language which end in "dous":
tremendous, horrendous, stupendous, and hazardous.
18. Los Angeles' full name is "El Pueblo de Nuestra Senora la Reina de Los Angeles de Porciuncula"
19. A cat has 32 muscles in each ear.
20. An ostrich's eye is bigger than its brain.
21. Tigers have striped skin, not just striped fur.
22. In most advertisements, the time displayed on a watch is 10:10.
23. Al Capone's business card said he was a used furniture dealer.
24. The characters Bert and Ernie on Sesame Street were named after Bert the cop and Ernie the taxi driver in Frank Capra's "It's a Wonderful Life."
25. A dragonfly has a life span of 24 hours.
26. A goldfish has a memory span of three seconds.
27. A dime has 118 ridges around the edge.
28. It's impossible to sneeze with your eyes open.
29. The giant squid has the largest eyes in the world.
30. In England, the Speaker of the House is not allowed to speak.
31. The microwave was invented after a researcher walked by a radar tube and a chocolate bar melted in his pocket.
32. Mr. Rogers is an ordained Presbyterian minister.
33. The average person falls asleep in seven minutes.
34. There are 336 dimples on a regulation golf ball.
35. "Stewardesses" is the longest word that is typed with only the left hand.

BAM

MAY & JULY MEETINGS

by Bess Ellis

On May 20, Joe Wilkinson hosted this meeting near Hope, MO. Joe lives in one of the most beautiful settings in Missouri and he has one of the most organized shops in the state.

Several interesting and informative demonstrations were presented. John Murray demonstrated how to make a hot cut hardy tool. Bob Alexander showed how to make a garden hose plant protector as well as other garden related items. Pat McCarty demonstrated bell making. You missed a lot of neat techniques if you were not there.

On July 29, Kirk Sullens hosted this meeting which was held at the Bass Pro Fabrication Shop in Nixa, MO, where Kirk works.

Approximately 125 people enjoyed all of the activity and demonstrations associated with this meeting. Todd Kinnikin and John Murray (with various helpers) demonstrated the 700# air hammer in the shop. Stephen McGehee from Elkins, AR, showed and discussed a small furnace he had made to use to melt brass.

Kirk Sullens showed how he makes his pine cones with pine needles and his "quick and easy" frog. (Kirk claims that it is easy to make all the neat stuff he makes. He says that each project is just a collection

of small, simple techniques that are then put all together.)

Frank Renn, a friend of Kirk's, demonstrated armor making — which he does for a living. (If you missed this meeting, Kirk is hosting the January 20, 2001, BAM meeting. Frank Renn is scheduled to forge a one-piece helmet top at that meeting. Don't miss it.)

For lunch, hamburgers and hot dogs cooked on a huge charcoal grill

were enjoyed by all. The lunch even included a delicious decorated "BAM" full sheet cake. After the business meeting, Bass Pro provided vans to transport those at the meeting to their Big Cedar Lodge — A Resort for All Seasons (south of Branson). Those who took the tour were able to view and marvel at the tremendous amount of iron work in and around the buildings.

A good time was had by all.

Blacksmithing workshops

*Sponsored by the Sun Foundation and the Illinois Valley
Blacksmith Association*

Sept. 9-10 Beginning blacksmithing with John Simmons and Gary Jameson. This class provides all the info you need to comfortably enter the world of blacksmithing. No previous experience needed.

Sept. 16-17 Swinging Betty and Mr. Jamb Hook with John Simmons. This workshop will cover the basics of creating 2 unusual lighting devices, the Betty lamp and miner's candle holder. Previous experience required.

Sept. 16-17 Drawknife and carving chisel with Gary Jameson. This workshop involves forging a straight wood arving chisel and a 2-handled draw knife. Previous experience necessary.

Sept. 30-Oct. 1 Flora & design with Gary Jameson. This class is for the person who wants to tap into greater creativity by creating a floral wall piece. Advanced forging skills required.

Sept. 30-Oct. 1 Forging copper with John Simmons. This workshop will give experience to the blacksmith who wants to become more comfortable forging copper by forging a ladle and spatula. No previous copper forging required but knowledge of general forging techniques recommended.

These workshops are held in rural Edwards Illinois. The cost is \$85 or \$80 for IVBA members. For more information call Gary Jameson at (309) 691-2410.

Carbondale Metals Conference 2000

Hosted by the Southern Illinois Metalsmiths Society
at
Southern Illinois University at Carbondale

Featured Metalsmith—**Jeffrey Funk**

Saturday, October 14

Please bring eye and ear protection

Schedule

Cost:

\$20 General registration

\$10 Student Registration

8-9 am Registration at Pulliam Hall

9-12am Jeffrey Funk
Demo and lecture

12-1:30 pm Lunch on your own

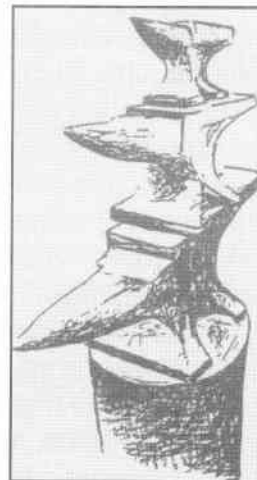
1:30-4:30 Jeffrey Funk
Demo and lecture

4:30-5:30 pm Benefit auction
*Please bring donation items for auction. All
proceeds benefit SIMS*

5:30-7 pm Dinner

7-8 pm Jeffrey Funk
Slide presentation

For more information please contact
Jen Townsend: (618) 687-5076
Eric Cuper: (618) 351-1391
School of Art & Design: (618) 453-4315



**2000 T-Shirt
Design on
sale at the
Conference**

Drawing by Kelly Jacobson, based on a
photo by Eric Cuper



ABANA

May 2000 Liaison Letter

The time is getting close for the Flagstaff Conference. June 1 is the deadline for mail submission of balusters for the bridge project, buffalo skulls, and chain links. You can still bring the skulls and balusters with you to Flagstaff, but an early submission is preferred. The address for submission of the chains, balusters and skulls is in the registration packet information and on the ABANA web site, www.abana.org. The Whitaker memorial wall will also be a feature at Flagstaff. Give some thought to what Francis meant to you, how he influenced you or any other stories and jot down those thoughts to share with the attendees.

I will host a meeting of the chapter presidents on the Wednesday afternoon of the Conference. Exact time and place is not settled, but the information will be in the registration packet, along with an agenda. Other Board members will be present at this meeting, as well as roaming around the conference, so please talk to us! While we all try to attend as many local chapter meetings and regional conferences as possible, this is your biennial chance to meet as many of us in one place at one time as possible. We look forward to talking to as many ABANA members as we can.

The ABANA Board elections are rapidly approaching. ABANA needs dedicated and hard-working volunteers to make our organization bigger and stronger. If you have any questions on what being a Board member is like, give any of us a call, either a newcomer like me, someone who has been on the Board for a while, like Jack Andrews or Joe Harris, or someone who was on once and has come back, like Dorothy Stiegler or Bill Fionini. Any of the current Board members will be more than happy to discuss their experiences with you. Discuss this at your chapter meetings, identify those members who are proven leaders with drive and a desire to help guide ABANA in the coming years, and nominate them. We need a statement from the nominee, a picture of the candidate, and at least 10 ABANA members' signatures in support of the nomination. Deadlines to have this information to the Central Office is July 15. LeeAnn Mitchell will also accept hand delivered packets at the ABANA booth during the conference. Election ballots will be mailed to ABANA members on or before August 15, with completed ballots returned to the ABANA Central Office and postmarked no later than September 15, 2000. Winners will be posted on the web site as soon as all nominees have been notified of the election results.

BAM

Bulletin Board

25-pound Little Giant, electric motor, runs good. Would like to trade for a sheet metal break, preferably 10 feet long, 10 or 12 gauge. Del O'Rear, PO Box 16, Cenerview, MO 64019. (660) 656-3389.

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.

Bob Bergman always has hammers, ironworkers, shears and the like for sale. Call him at (608) 527-2494 and tell him what you are looking for. Ask for his video on the Kickass air hammer.

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.

New Zeller firepots. These are the

ones used by SOFA. Fire boxes are 3/4 inch thick cast iron. The sizes are small 8" x 11" x 4" weight 60 pounds and the large 8" x 14" x 4", weight 67 pounds. Also round pots 3" deep by 8" diameter. Contact Gerald Hawkins, 127 Weinland Dr., New Carlisle, OH 45344 or phone (937) 849-6964 for brochure.

Custom built air hammers -- 70-pound air hammer, \$2,800; 40-pound, \$2,500; 20-pound, \$1,800. Also custom metal spinning in brass, copper, steel, pewter and aluminum. Contact Maurice Ellis in Belgrade, MO, (573) 766-5346; FAX (573) 766-5451 or e-mail to mbellis@therural.net.

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, Peddinghaus 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: kaynehdwe@ioa.com. Check out the web site at www.kayneandson.com.

Tom Clark has expanded his line of hand forged 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 and just got a shipment of punches, shears and gas forges. For more info on the tools and his Ozark School of Blacksmithing contact him at (573) 438-4725. His 2000 schedule includes classes taught by Uri Hofi, Bill Bastos, Bob Patrick

and Jerry Darnell.

Power hammer history! *Pounding out the Profits — A Century of American Invention* by Douglas Freund (hard-bound, 317 pages, profusely illustrated) 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.

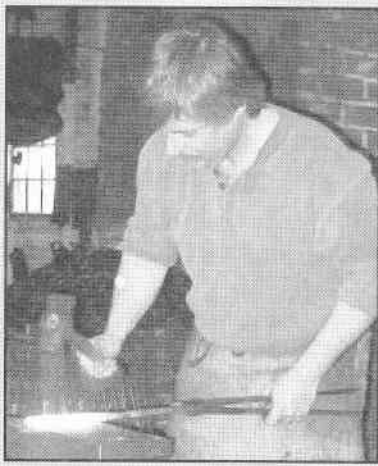
George Dixon is offering a new line of tools called "The Old Philadelphia Tool Co." These tools are patterned off of old European designs and will include directions for using them effectively. He offers a brochure if you send him a stamped, self-addressed envelope to: The Old Philadelphia Tool Co.,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

Need something or got something for sale? Send it to the editor and he will get it in the newsletter. BAM classifieds are free to members and anyone with something to sell to a member.

Lorelei Sims has a unique line of T-shirts called FEwear that you just gotta have. You can check her wares out on the web site at www.fewear.com.

As made by Ken Schwarz, Colonial Williamsburg

Offset T Shutter Hinge



by Don Plummer

The Anderson Blacksmith Shop in Colonial Williamsburg is a delight to the senses of sight, sound and smell. The clanging iron, whooshing bellows, scent of burning coal and the blazing fires in darkened walls create a phantasmagoric effect. If you have never visited with them you should put it on your "must do" list.

Ken makes an interesting comment regarding the use of the term "forge," particularly as it relates to blacksmith shops. He notes that in period documents, of which Ken has reviewed many, the term forge refers to finishing mills for iron. Smith's shops were always (as far as current research is concerned) referred to as a blacksmith shop, smith shop or simply "shop."

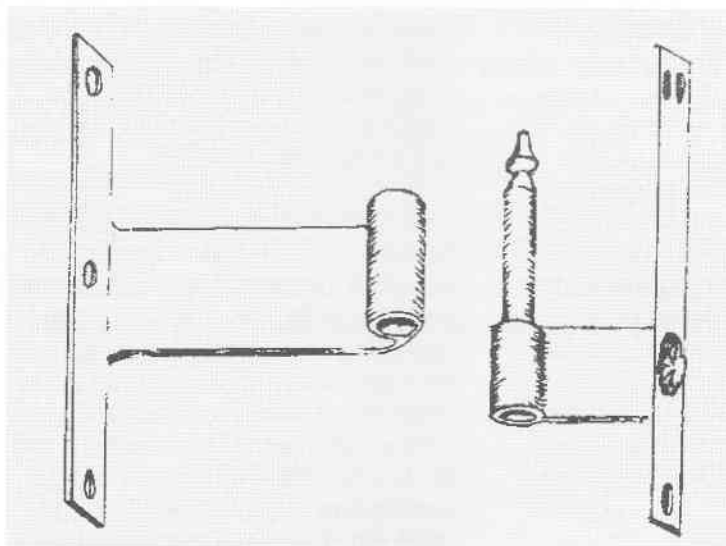
This current forge sits on the same site and is named after the James Anderson forge of the late 18th century. Although not a great deal is known of James Anderson's personal life beyond the fact he was born in 1740 and died in 1798, there are many documents and references relating to his blacksmithing business. This, in fact, is the best documented business in Williamsburg. Ken is currently in the process of review-

ing some of their day books and ledgers to derive a better understanding of the smiths and their respective roles and responsibilities in the 18th century Chesapeake area.

The Williamsburg smiths are often called on to make hardware for restorative projects . . . both within the Williamsburg community and for other important sites. This particular hinge is one of 64 made for a restoration project at Monticello. This hinge is copied from an original hinge still existing at the home. Although the original shutters were missing their hardware the ghost images confirmed that this style and size of hinge was used.

In the attached demonstration Ken worked with wrought iron in various stock sizes. Today we have a great selection of steel sizes available to us in flats, rounds, squares, plates, etc. But this was certainly not true during the late 18th century which is the representational period of the Anderson Blacksmith Shop in Williamsburg. Williamsburg, generally speaking, reflects a period of about 1760-1790. On other occasions I have seen Ken spend considerable time and effort working large stock down to size before beginning a project, a common blacksmithing task in the Colonial period.

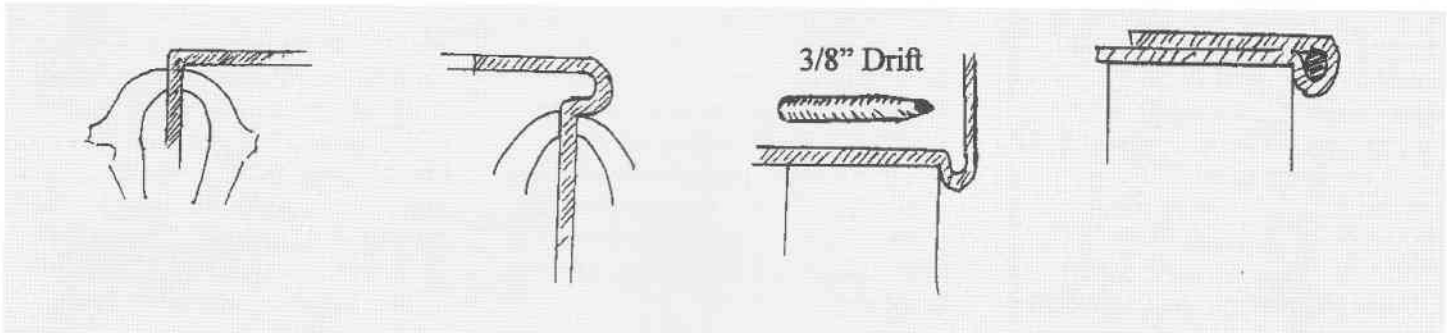
1. The two finished pieces are shown below. Begin the hinge with 1-3/4 x 1/8" stock and start the eye about 4-1/4" from the end of the stock. Using a pair of dividers set to 4-1/4" provides a quick technique to scribe the mark. Wrap and form for a 3/8" pin.



2. Begin with stock looking about like this.



6. Trim the hinge to a square cut and to the appropriate size. In this case about 3-1/4". Ken also narrowed the



3. In a single heat bend and rebend the stock in the vise as shown above.

4. Use the next heat to work on the anvil and wrap it around a 3/8" drift and close it up snugly.

5. Prepare for welding by heating the piece, opening the fold slightly, applying Borax liberally and tapping shut gently. Ken closes the eye just ever so slightly because he will be drifting it to size later on.

ever 'cause it needs to be thick for later welding to the "T".

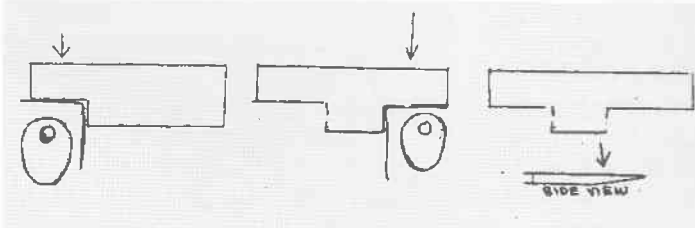
7. At another heat drift the eye to the correct 3/8" diameter. Use a proper drift that is dimensioned correctly in the center but slightly smaller at both ends so it may be driven through from either side. When drifting make sure the base is well supported. Ken catches an open corner of the hardy hole and drives the drift through. At this same time make sure everything is square and parallel. Sight along the eye and hinge for alignment. Check it from several perspectives.

end width of the hinge because this will tend to expand during welding. Make the cut from the eye side creating a very blunt scarf edge. Bring both pieces to a welding heat and weld neatly and accurately. (Easier said than done). A pair of hinge tongs will give you a great advantage. If you do much hinge work you will need to have pairs for several different barrel diameters.

6. At a good welding heat (which can be almost white hot with a few sparks flying for wrought iron) weld the eye shut and thin the stock somewhat just

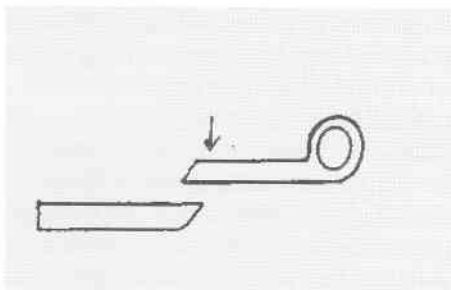
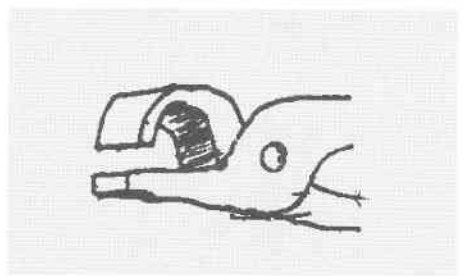
Note that at the Anderson forge they strive to remain consistent with tools and techniques in use during this late 18th century period. And they do an excellent job of it, too. You will be hard pressed to find them using or

7. Weld the two pieces positioned as shown here. That is, with the flat side up. This keeps the thin stock off the anvil face and better retains the welding heat. It is also easier to weld up thicker stock and thin it later. In this case Ken thinned and drew the hinge leg out to a length appropriate for these shutters and windows.



doing something that is out of period. A good example of this is that wire brushes were not available at this time. They keep their iron scale free by an occasional scraping at a high heat with an old file ground to a chisel edge.

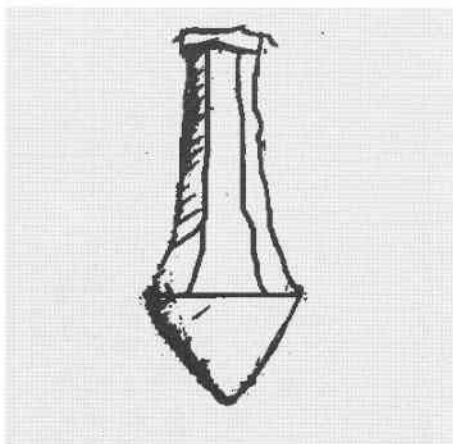
behind the eye. This, again, is consistent with the original hinges. But don't thin the end of the hinge how-



5. Now make the T that will be welded on to the hinge just produced. This is made with wrought stock that is 1/4 x 1 x 5-1/4. Form two indents about 3/16" on each end and then

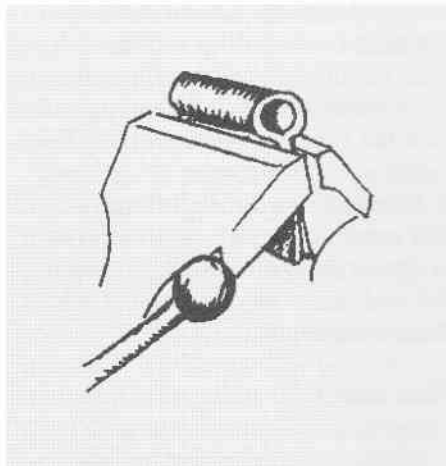
8. This particular hinge had three mounting holes punched in each half. Ken did all three of them in one heat. It's funny how it sometimes takes a long time to see and learn what is obvious to everyone else. I have always punched holes in two steps. Punch to the anvil surface, turn over and punch out over the pritchel hole. But Ken does it as a three step process. Punch to the anvil surface, turn over and punch the cold, shiny spot to the anvil surface again, then turn over and punch over the pritchel or hardy hole. It definitely works better. The Williamsburg smiths all use short punches, maybe 3" long and held with pincher type tongs. These shorter punches can be more accurately positioned. Punches are usually made with 1075, W1 or W2. All of these are relatively consistent with tool steel available during this American Colonial period.

9. Each of the holes is countersunk. These hinges were mounted with screws which were generally available during this period of Monticello's history about 1815. Their countersinks look about like this. This, like the punches, is held with pincher tongs. It appears that very little file work was done on these hinges. Perhaps just a slight profiling and a very light chamfer. They were usually finished at the forge. The pintles, however, had considerable filing performed on them to make the somewhat fancy finial ends.



10. Now for the pintle. Round stock was not generally available during this time and had to be shaped from whatever was on hand. Ken beat this 3/8" pintle out of about a 1/2" x 1" piece that was lying around. Using a bottom fuller helped maintain the round shape. This is forged until it fits the hinge eye and is then cut to length. As mentioned earlier the finial end of the pintle is shaped with a file. The "flame" finial is filed to shape after it is matched to the hinge. The "Flame" starts at the top of the hinge eye.

11. The wrap for the pintle is made from 1/4" x 1" stock. Heat and wrap around the pintle. Ken tucked this up in the vise as shown.



12. Flux with Borax at a red heat and then bring the piece up to a good welding heat. Focus on welding in the pin solidly first rather than trying to do the pin and straps at the same time. On the second welding heat finish welding the strap and neaten everything up. Using an appropriately sized bolster block (right) will help get a nice flat surface for the hinge to swing on.

13. Cut a tenon on the end of this pintle strap so it can be inserted through a mounting plate. The mounting plate is more of the 1/4" x 1". Punch and countersink three round mounting holes and a rectangular hole for the pintle. The distance between the pintle post and backplate

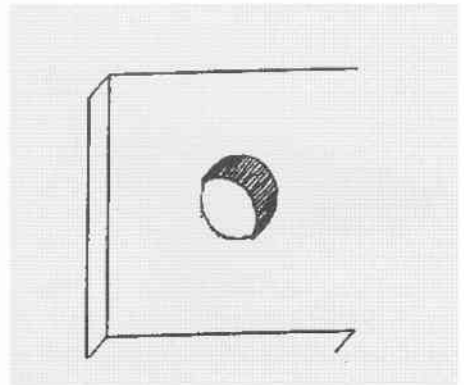
is critical so the tenon is cut with a saw for accuracy.

14. Head over the tenon inserted through the plate.

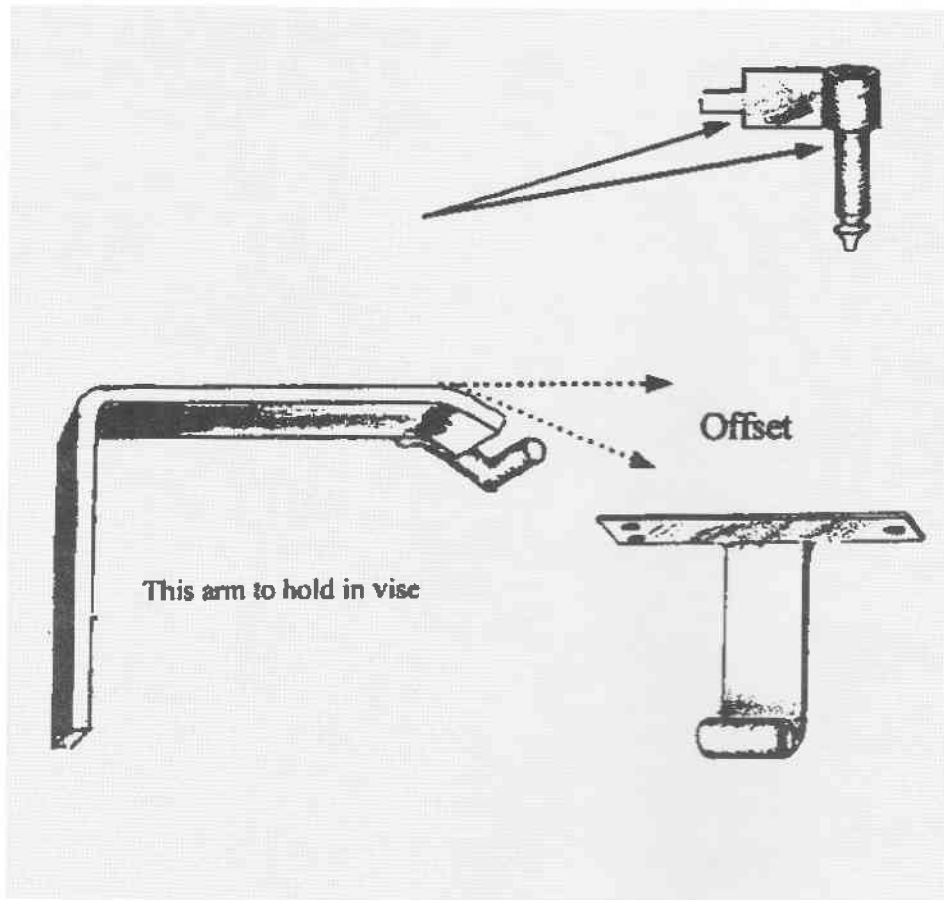
15. Only thing left to do now is to bend in the offset in the strap hinge. If you are going to do 64 of these or even four you will want to take the time to make an offset bending jig as shown to the right. Now just heat up the strap, slide the pintle over the stud on the jig and bend it down tightly, squeezing it in place with tongs. Bend the "T" to a right angle.

Once in the swing of things the Williamsburg smiths can make one of these hinges in about 1/2 hour. Recognize, of course, that a job like this would be treated as a production run and a series of the same operations would be performed on many pieces before moving on to the next operation for these same pieces.

As mentioned earlier, when Ken is able to squeeze out any free time he is doing some research on the Anderson Blacksmith Shop and the smiths who worked there. Some of the information he is obtaining will be most interesting to many of us who have



an interest in Colonial blacksmithing. He is, for example, transcribing some of the day books and ledgers to computer. Much of this is pre-Revolutionary information. If any of you have ever tried to read any of these documents you know how very difficult and time-consuming a task this is. It is often very hard to decipher



and understand these 200-year-old writings.

Ken has so far identified the names of 48 smiths who worked at the forge during the American Revolutionary War. Apparently there were more than just this one building that was a part of the Anderson Shop. There were many varieties of smiths in attendance. They were not all black-smiths. There were file smiths, tin smiths, white smiths, gun stockers, gun smiths, lock smiths, etc. The forge did a lot of work for the state of Virginia during this war. It will be most interesting to see what Ken finally unearths for all his research.

In case you do get to Williamsburg make sure you say hello to whoever of the eight smiths currently work there that might be in attendance. They are: Peter Ross, Ken Schwarz, Steve Mankowski, Mark Sperry, Nick Nuhlicek, Chris Furr, Shell Browder, and Tres Loeffler. Good fellows, all!

Many thanks to Don Plummer who not only took careful notes on this demo but also took the time to submit them to his chapter newsletter editor and to take the time to add extra information from Ken and then mail it at his own expense to all of the other chapter editors. Way to go Don — may your forge welds all stick on the first try!

As made by Ken Schwarz, Colonial Williamsburg

*Offset T Plumb Line
Hinge*

Conference 2000



*John Murray
does his part
as one of
BAM's Best
Beaters.*

Damascus, Repoussé and Latané featured at BAM's Big Event

BAM's 2000 Conference held the first weekend in May featured something for everyone: Damascus blades by Bill Fiorini, repoussé and high-relief chasing by Kirsten Skiles and the hard-to-categorize detail work of Tom Latané. As if that wasn't enough, several of BAM's regulars were pressed into service in a display of "BAM's Best Beaters:" John Murray, Kirk Sullens, Tim Underwood and Jim McCarty.

BAM's Conference is well known for attracting bad weather. Tornadoes, spring snow storms, thunderstorms, cold weather and mud are par for the course. This year it looked like the god's were finally going to smile on us — day one dawned with blue skies. By Saturday evening though much-needed rain was falling. It turned into a record-setting 18-inch deluge that put nearby Union and Washington on the map for all the wrong reasons. Meanwhile, at the new Warrenton, Mo. site the rain just settled the dust on the rows of tailgate items for sale.

Kirsten started the demonstration on Saturday, while Bill, her husband, watched their new baby. She was well-prepared for the demo, illustrating each step so that those watching could take notes before she worked. She brought with her dozens of little tools and seemed to use each one.

Bill as usual was a flurry of activity. He seemed to be everywhere, forge welding, heating new stock, working at the anvil or under a Bull power hammer trailered to the conference. His



demo covered pattern welding, forge building and turning the result into a knife.

The BAM demonstrators held court under a wind-swept pavilion. Most conference-goers made a three-legged trip between the main demonstration area, the BAM site and the tailgaters. Sadly absent for the first time was the Centaur Forge team. More than one person remembered that this was the first time Bill Pieh, who died just prior to the event, was absent. Bill always loaned us an air hammer for the conference. He will be missed.

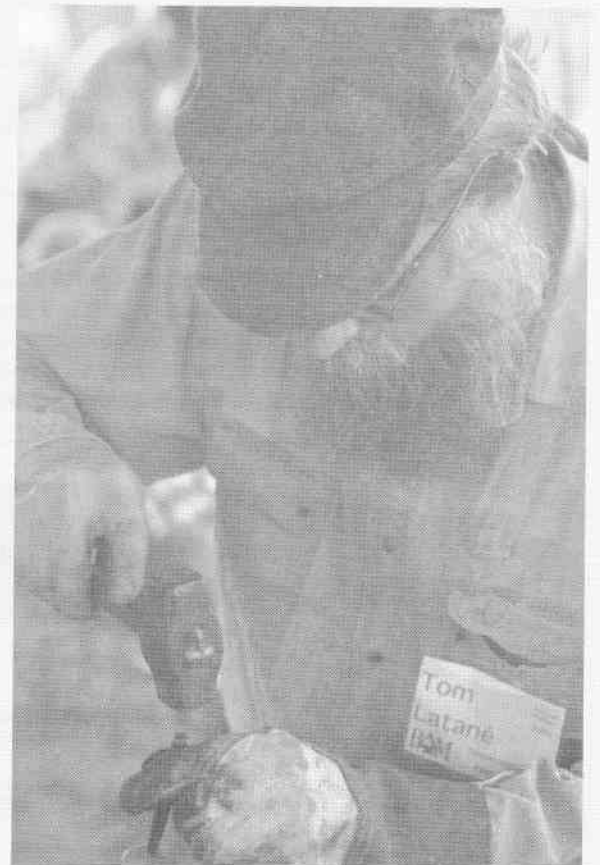
David Cornett was pressed into service to lead our auction and he came through for BAM. David turned some beautiful hand-forged iron into nearly \$7,000 for BAM's

treasury.

Sunday morning belonged to Tom, who had a host of techniques to show us. He demonstrated faces, latches, and the tooling needed to make them all. Tom is no stranger to a file, unlike most blacksmiths. We all spent a lot of time looking at the samples he brought with him.

This year's event featured a nice turnout, an excellent site and actual modern toilets, perhaps a first for the Missouri bunch. Mark your calendars for the first week in May, 2001 and join us next year.

Above: Bill watches baby as his wife, Kirsten, does her repoussé" demo. Below: Tom Latané does what Tom does best, shape faces on hot iron.



LETTER OPENER

1. Start with a piece of $3/16 \times 3/4 \times 7-1/2$ " long material, taper the one end down to $1/4$ ".



2. Place about $3/4$ " of the tapered end over the edge of the anvil and strike with half face blows reducing the material to a $1/8$ " square section and then taper it to a point. Then hammer round.



3. Next, form the rat tail by first tapping the end around to form a small loop. Then, form the hook over the horn of the anvil.



4. Use a spring fuller to neck down the material at the blade end of the handle. This creates a nice transition between the blade and the handle.



5. Next, draw out the taper on the blade end and shape to your liking.



6. For something different, try a brass inlay on your blade or handle. Select the area for your design, file and sand it smooth. Next, punch and chisel your design into the steel. Using an oxy/acetylene torch and brass-brazing rod, braze over this area to fill in your design. After cooling, sand off the excess brazing material and clean the letter opener. With the torch, apply a low heat to the backside of the opener to give the steel a deep black color. Be careful not to overheat and soften or discolor the brass.



By: David Fisher

Reprinted from the Pennsylvania Striker

Jerry Darnell's Chandelier

By C. Marlin Arnold

Reprinted from the Appalachian Area Chapter News

Being the winner of the AAC scholarship for a week of my choice at a blacksmith school, I was fortunate enough to spend a week at the John C. Campbell School the week of July 11-16, 1999. Our instructor was Jerry Darnell. We tried to make and complete a project each day. One of these projects was a three candle chandelier. I will try to explain how this is made to the best of my ability.

For the base of the light, you need a ring made from $3/16''$ by $1''$ flat bar. Since you want a ring about $12''$ in diameter, you'll need a piece approximately $36''$ long. Imagine laying the piece flat on a table and bending it into a circle. (See figures 1 and 2.) After bending, scarf and forge weld. After welding, true the piece on a mandrel to a true circle. You can chamfer the outside of one side of the ring if desired . . . this will be the top side of the light. Drill six $1/4''$ holes that are equally spaced around the ring. (See figure 3.)

Using $1/4''$ round, make hooks and rivet to the ring. (See figure 4.)

Now make the three candle holders. Using 16 gauge sheet steel, cut three holders and form as shown. (see figures 5 & 6.) Use $3/4''$ rod to form the holders and drill a $1/4''$ hole in the ear for mounting to the ring. Drill the hole after the holder is formed.

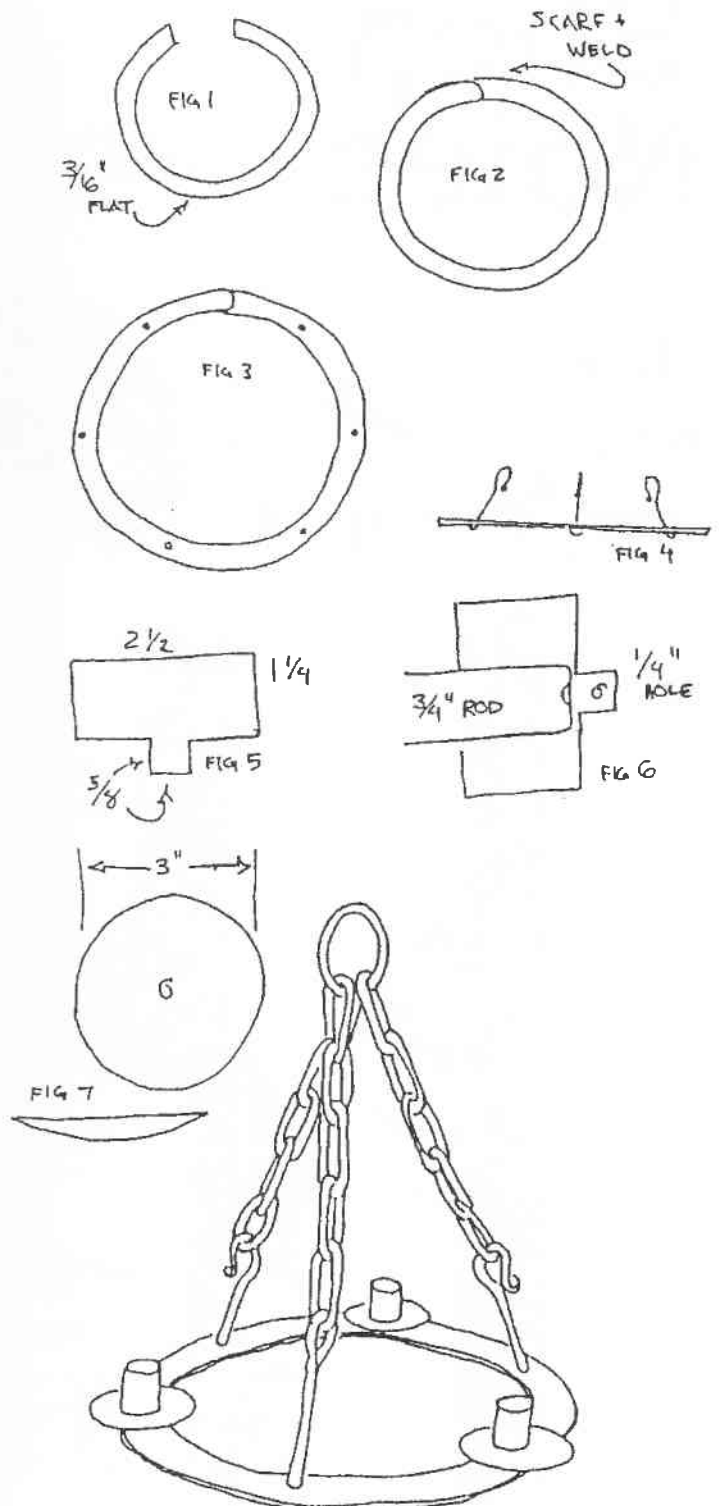
You will also need three candle cups. They can be made from 16 gauge material also. $3''$ diameter with about $1/4''$ dish will work. (See figure 7.)

Rivet the cups and holders to the ring, using $1/4''$ rivets through alternating holes.

Next are the support chains. You'll make three chains with about five links per chain. Use $1/4''$ round about $6''$ long for each link. Make a $2''$ ring for one end of the chains . . . the other ends of the chains are attached to hooks in the ring. You may want another hook to attach the light to its hanger if needed.

Finish as desired. We used the beeswax/turpentine mix in class and it worked well.

This is a one day project and you can see we were very busy. We slept good every night. I hope you can make heads or tails of this . . . I never said I was a writer or artist.



BAM

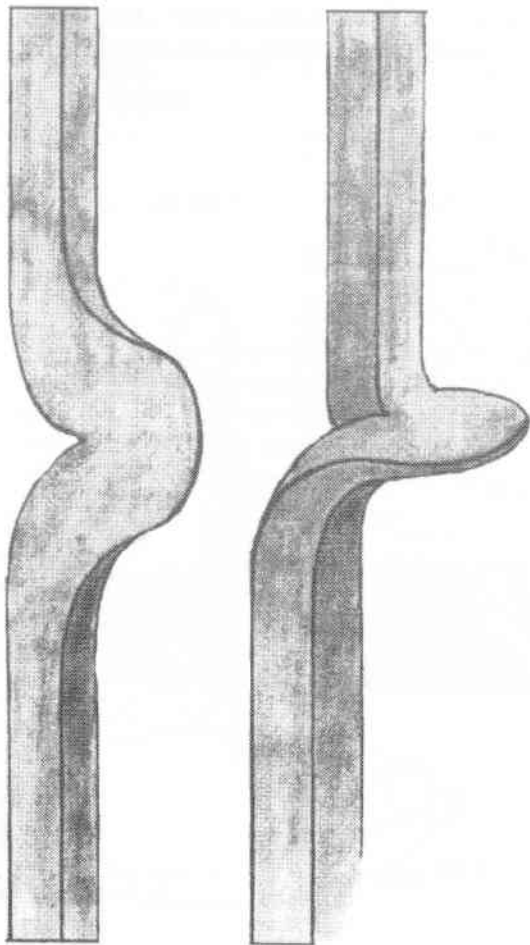
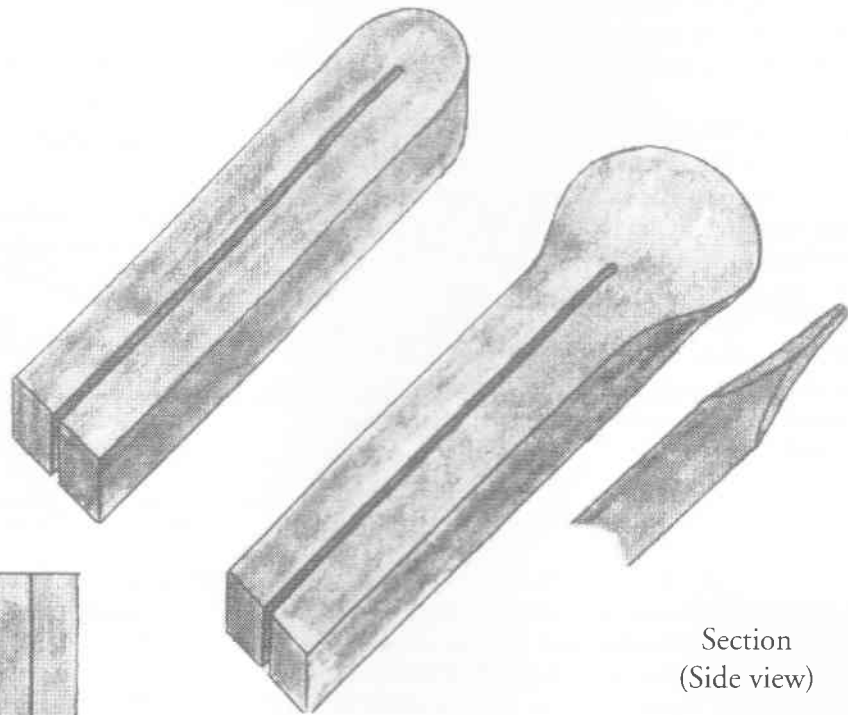
Shop Notes

Contemporary Picket Decoration

by George Dixon, metalsmith

From The Cole Dusst News, Ocmulgee Blacksmith Association

Heat,
fold,
forge, then open!



The two variants of this motif are shown at left. They both come from the same preparatory form, which is illustrated above. The bar stock is heated and folded over tightly. Another heat is taken and the folded end is drawn out. As the section above shows, the piece is drawn out evenly. Use the anvil horn for the last adjustments.

Once the center is drawn out, and the forged area is blended back into the picket bar, take a localized heat (yellow) and open the effect. If it is opened along the axis of the bar, you get the effect at far left. Open the forged area across the axis of the bar and you get the near left effect.

Try putting several of these effects on a single bar, switching sides as you go.

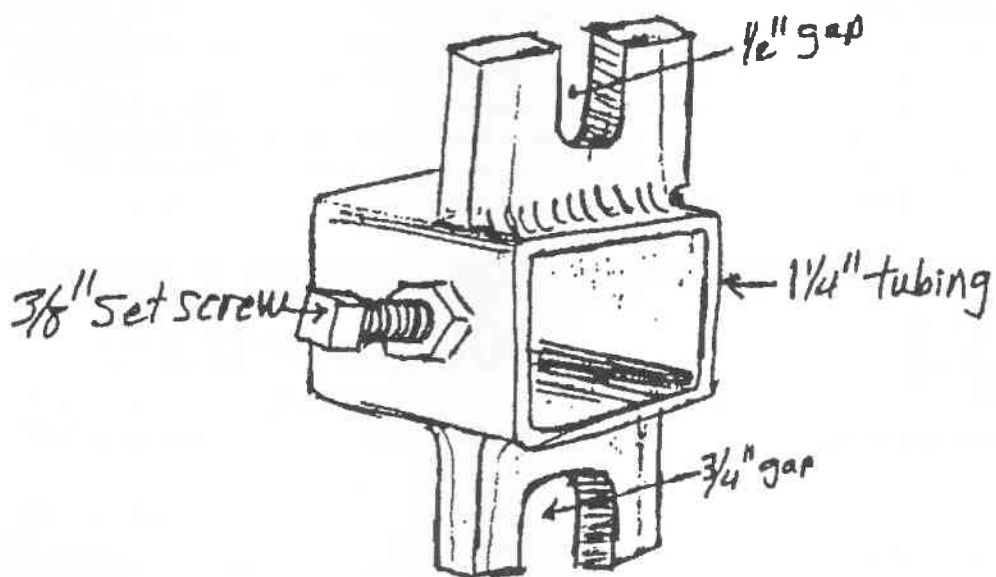
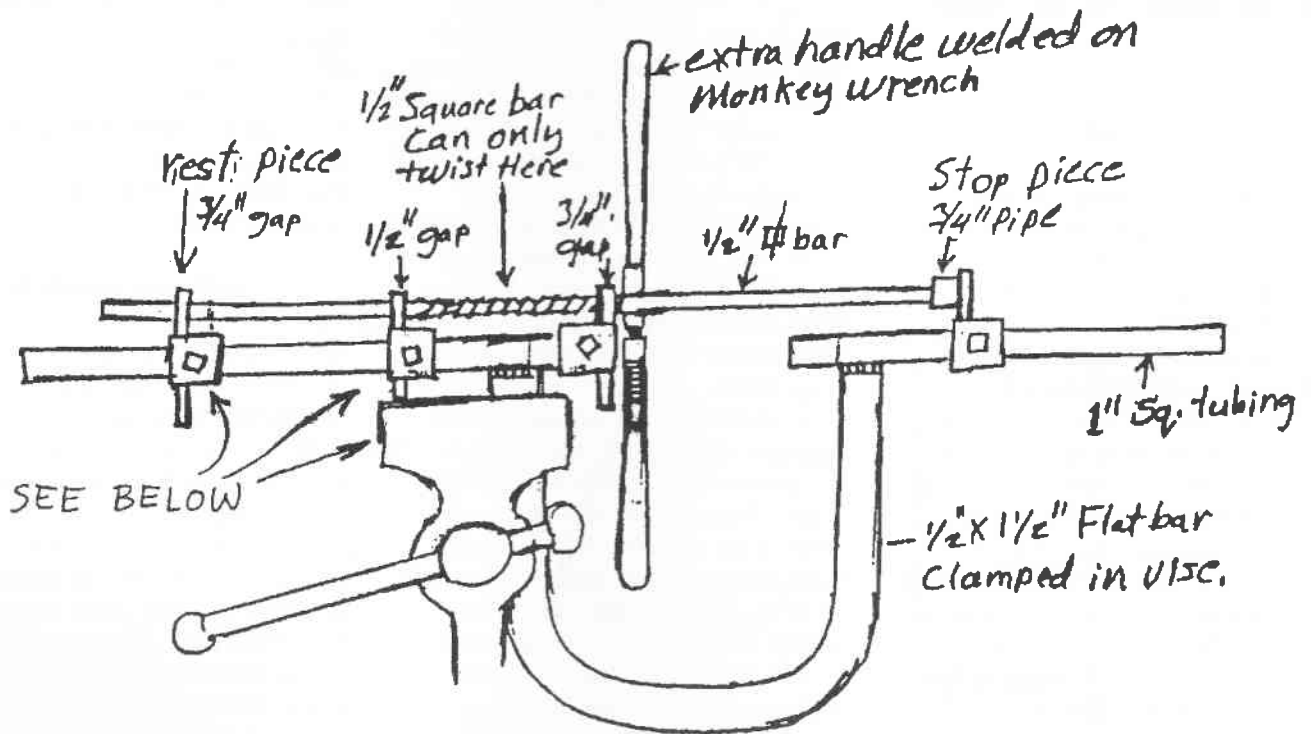
And . . .

wear safety glasses!

Hot twisting jig

by Berkley Tack

Reprinted from the Hot Iron News



BAM NEWS

Next meeting

Ed Harper is hosting the next BAM meeting to be held September 23 in Browning, Mo. Now before you dig out your road atlas check the map on the next page. I think this meeting might be the first one we've had in north Missouri since Bob Patrick left Bethel years ago. Browning is just south of Milan, which is a good place to spend the night if you need to come up a day early. I am going to recommend the Stanley Hotel, one of those oldy moldy hotels that you just don't find around anymore. But bring your own alarm because the last time I stayed at the Stanley they didn't have any clocks in the rooms! Ed says to remind everyone that lunch is on their own — bring one or plan to head into town for it. Trade item is a toilet paper holder, use your imagination and bring some with you as people in this part of Missouri don't use the stuff or so Ed tells me. Also don't forget something for iron in the hat...hope to see some north Missouri

folks we don't usually see at this meeting and I was just kidding about the TP -- they use corn cobs, a red one and then a white one to see if you need another red one.

Get ready for Oktoberfaust

After two successful years, Oktoberfaust, ABANA's first attempt to educate the public to the benefits of forged ironwork, is back with a foreign flair. This time Roger Bockstaele from Belgium will be the main demonstrator for the event, to be held in St. Louis' Faust Park October 7 and 8. He will be joined by other BAM demonstrators.

Bockstaele was a surprise addition to the 1998 ABANA Conference in Asheville, N.C. He brought a gallery of incredibly detailed animal sculptures and an entire room was devoted to his work.

In addition to the demonstrations, 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 and 1999 Oktoberfaust events succeeded in that regard -- some 8,000 people watched the demonstrations, which included a tent devoted to architectural ironwork.

Lou needs lots of BAM members to man forges at the event. For more information contact him at (636)

343-4223.

BAM's 2001 schedule

The BAM meetings are scheduled for the year 2001. Please mark your calendars as follows:

January 20, 2001-Kirk Sullens, Bass Pro Fabrication Shop, Nixa, MO

March 24, 2001-Maurice Ellis, Belgrade, MO

May 19, 2001-Don Nichols, Sedalia, MO

July 21, 2001-Doug Hendrickson, Lesterville, MO

September 8, 2001-Bob Ehrenberger, Shelbyville, MO

November 10, 2001-John Murray, New Melle, MO

Hermann needs U

The Hermann Chamber of Commerce is putting on a special Octoberfest weekend October 14-15. Looks like we will have several gas engines, apple butter and/or pear butter cooking, kettle corn, and other old-time demos and we would like to include a blacksmithing demo. The activities will take place down at the Riverfront Park. There would be grassy areas next to the parking lot, where stakes could be driven for shelter. It is a nice location and you can drive right to the area where you would unload.

Let me know if there is any interest.. Show & sell. (And of course, recruit) !!!!!!!!!!!!!!!

John Wilding
523 West 9th St.
Hermann, MO
65041



2000 Schedule

September Meeting

Ed Harper
Browning, MO
Sept. 23

Trade item: Toilet paper holder

November Meeting

Pat McCarty
Washington, MO
November 11

Trade item: Medieval weapon

January 2001 Meeting

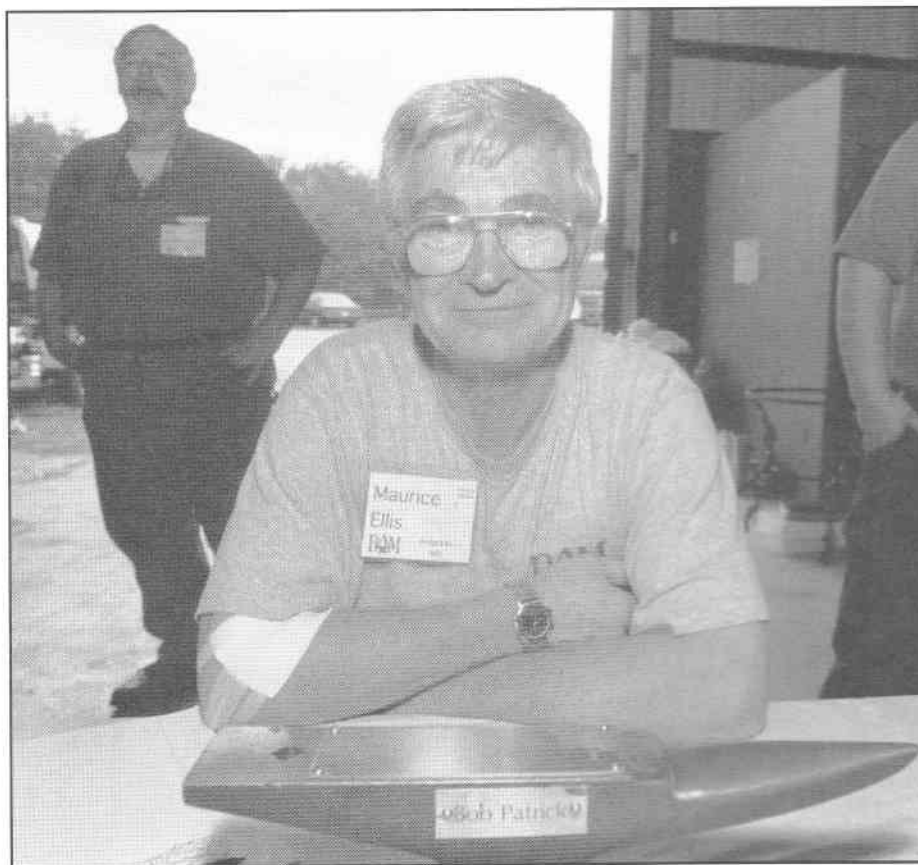
BASS Pro Shop
Nixa, MO
January 20

Trade item: Drawer pull

Next Meeting: September 23, Ed Harper's, Browning (way up north), Missouri



Congratulations to Maurice Ellis



BAM'S 2000 Bob Patrick Founder's Award Winner

BAM
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Belgrade, MO 63622

First Class
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Address Service Requested

Please send changes to Maurice Ellis, Rt. 1, Box 1442, Belgrade, MO 63622; mbellis@therural.net