

RAM

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www.bamsite.org

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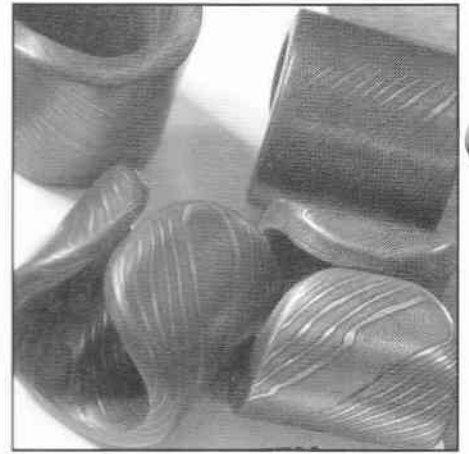
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Newsletter of the Blacksmiths Association of Missouri

Volume 20 No. 1
January-February
2003

Our cover: Maurice and Bess Ellis team up on a project under their new bigger air hammer as a warmup to the next BAM meeting.

Editor

Jim McCarty

Contributing Editors

Maurice Ellis
Bruce Herzog
Bob Patrick
Bob Stormer
Joe Wilkinson
Doug Hendrickson

Mailing Labels

Bruce Herzog

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 65110; (573) 395-3304 or you can send e-mail to jimmac@socket.net. BAM membership inquiries should be addressed to: Bruce Herzog, 2212 Aileswick Dr., St. Louis, MO 63129; (314) 892-4690 or send e-mail to bjherzog@msn.com. 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 ABANA member?

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.

Senior Citizen (Age 65+)\$40 yr.

Fulltime student\$35 yr.

Overseas airmail\$80 yr.

Overseas surface mail\$60 yr.

Contributory\$100 yr.

Full time student\$35 yr.

Public library\$35 yr.

See reverse

Editor's anvil

Greetings again. I hope this late newsletter didn't keep any of you from attending the last BAM meeting held at Maurice and Bess Ellis shop. I have really been struggling this winter, not just with the BAM news but with everything it seems.

I have been toying with the idea of running a marathon for some time and decided this winter was as good a time as any to get started. So in January I started training real hard, adding 2 miles a week to my long run until I hit 20 miles.

Between that and fighting with my sons to get their homework done I was just too exhausted to get much done on the news. Well, I completed the St. Louis Marathon April 4 so all that is behind me — well, the running part, I am still fighting with the boys on the homework.

Speaking of boys, my son James put the blacksmith shop to work on his science project. This time he took four pieces of mild steel and experimented with hardening it.

I helped him forge the stock into four chisels. One was heated and let to air cool. One was quenched in oil, one in water and one in Robb Gunter's Superquench.

After quenching the boys took turns holding and striking with a sledge hammer to see if the tools would cut through a piece of the parent stock. The air cooled one failed right away and hardly left a mark. The water cooled one made a slight dent and then failed. Surprisingly, the oil quench went halfway through the stock before it folded over on itself. As we expected, the Superquenched piece cut through the stock with no damage to the tool, proving it did get hard.

James got first place in the science fair for his efforts. This was his second blacksmith-related science project. The other one involved proving the law of conservation of mass. In other words, matter can neither be created nor destroyed, only its form is changed.

He did a lot of form changing for that one, punching, twisting, upsetting, drawing out etc. First he weighed each sample, then did his thing on it and collected any scale that fell off. When it had cooled he weighed the sample again along with the scale. All weighed the same as expected. This project also won first place.

That's about the only time this winter my forge has been lit. Sounds like I'm not the only one that let their forge fire go out. I've heard from others who said it was just too darn cold this winter.

I had a nice chat with our President Joe Wilkinson this week. I have been editing the BAM news for 10 plus years now. I have really enjoyed it but it has taken its toll on me. I've got to admit my heart is just not in it anymore. I could really use a sabbatical and Joe agreed to help me find a replacement.

So if anyone out there would like to take a stab at it I would appreciate hearing from you. BAM will pay you

\$300 if you get it out on time, \$150 if you are late. I have all the software, (Mac) lots of art and would be glad to do some training. I think BAM should buy a computer for the project plus a scanner and pinter. But if you have your own that would be a plus.

I really do need to simplify my life some. I sure do hope someone steps forward with an interest in being editor.

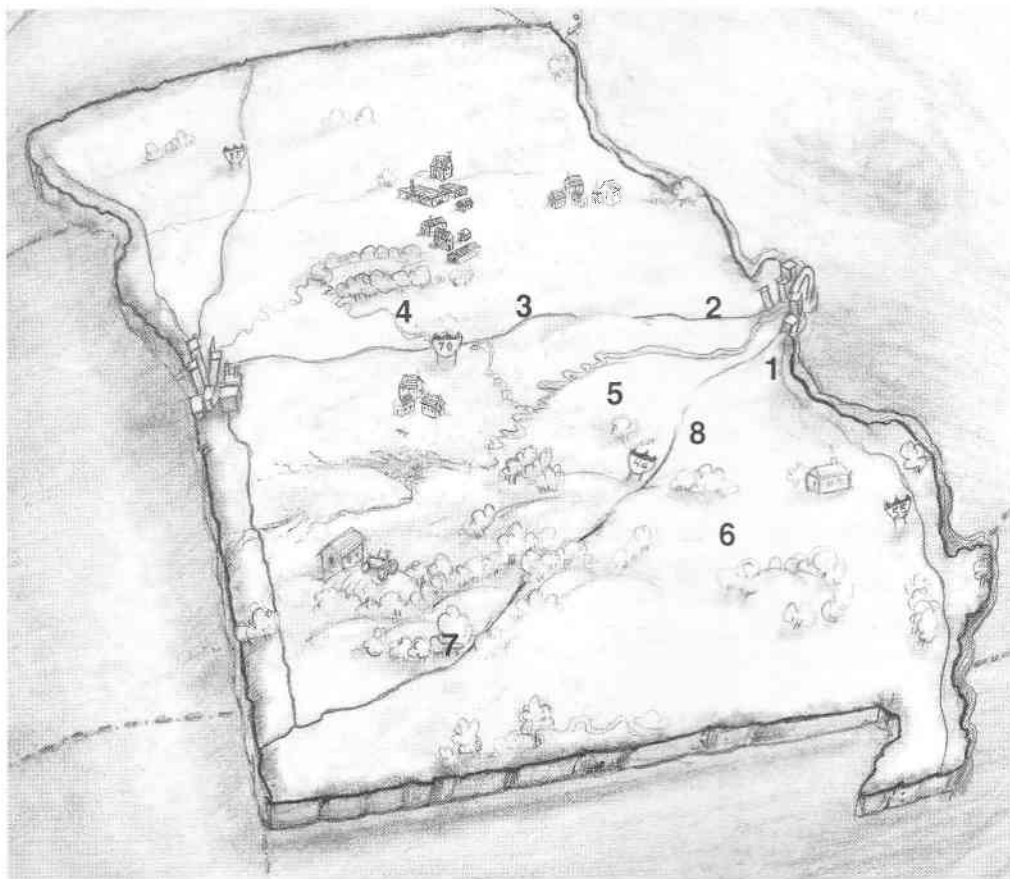
— Jim McCarty



You know you're a blacksmith when you burn a huge hole in you shirt. Bob Patrick must be a blacksmith judging by this one.

Coal Stash

Coal Captain: Bob Maes



1. Bob Alexander, DeSoto, MO
(636) 586-6938 Lotsa bags

2. Ken Jansen, Moscow Mill (636) 366-4353

3. Ruben Funk, Columbia (573) 445-8340

4. Doug Clemons, Malta Bend (660) 595-2257

5. Jerry Rehagen, Rich Fountain
(573) 744-5454

6. Doug Hendrickson, Lesterville
(573) 637-2576

7. Jeff Willard, Willard (417) 742-4569

8. Keith Barrick, Cuba (573) 885-3799
(Note corrected phone number!)

Price \$7.50 per bag

Coal keepers earn 50 cents a bag

Bob's bunker has just been restocked so we
have plenty of coal.

Joe's jive

Thanks to John Lovin and all his helpers for hosting our January meeting at Mount Vernon, IL.

Saw some new things and met some new people. Meetings always seem like they take a lot of effort to attend, but after they are over I'm always glad I went.

Bob Haverstock worked his magic with the English Wheel. I had never seen one used before. In a short time he cranked out a motorcycle fender as good as a factory could make. He says he gets a lot of orders for motorcycles that no longer have replacement parts available. He also makes many other things that require compound bending and stretching. I was impressed with his entire demonstration.

I had a visit from Stan Stevens and John Wilding from Hermann, MO, recently. Stan is a scoutmaster and will be participating in the Lewis and Clark Celebration in Jefferson City, MO, next year. He is asking for some

blacksmiths to demonstrate at their event. I understand they will try to have many of the primitive crafts demonstrated that were in use during the Lewis and Clark Era. I told him he could count on us to do our part. More details will be available later. I'll keep you posted.

John Wilding, (a BAM member) told me he will be looking for demonstrators for the Maifest (3rd. weekend in May) and the Octoberfest (1st thru 4th weekends in Oct.) in Hermann, MO. Anyone interested should call John @ 573 486-5544.

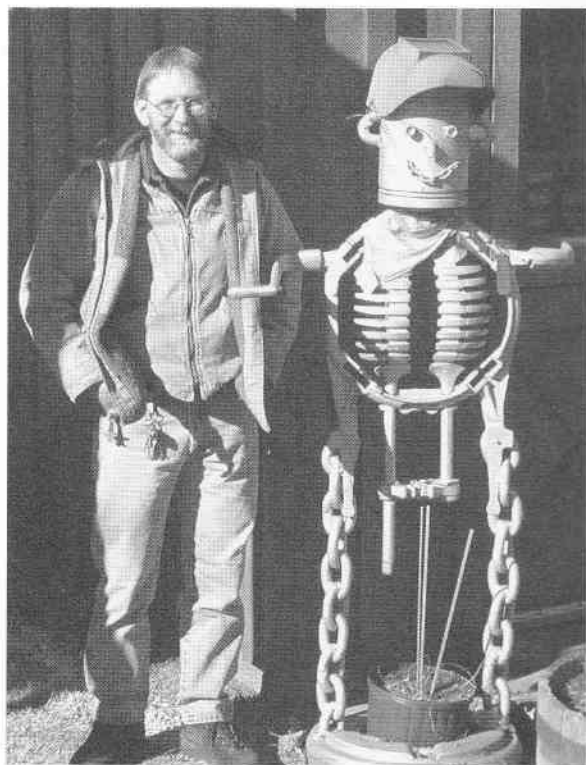
Don't forget Feb. 22nd when Don Asbee of Hartsburg, MO will be giving a demonstration at his studio on body safety and his big new air hammer he's building. Don is a plankowner of BAM and he has much knowledge about the blacksmithing craft. I've always felt BAM is a repository of a vast amount of blacksmithing knowledge. It boggles my mind when I think of all the things the

membership as a whole knows about blacksmithing. Demonstrations like this is one way we can spread it around.

We plan to have a demo about every other month (between meetings) if we can. So far we have Clay Spencer in June of this year scheduled at Lou Mueller's shop. I'm still working on others.

We had our maiden voyage of our mobile teaching station at Lou Mueller's last Sat. the 25th. All went well. We had a good supply of volunteer teachers and a good supply of bubbling enthusiasm from the students. I believe the student headcount was 19. It was a long and intensive day but well worth it. We still have a lot of work to do before the station is truly mobile but progress continues. Lou Mueller and his committee has put a lot of effort into this project and we owe them our thanks.

*Happy Hammering,
Joe Wilkinson*



It's rare when both McCarty brothers show up for a BAM meeting.

Dear BAM

This is a letter of appreciation to the members of BAM. I joined BAM after going to the Oktoberfaust Event at Faust Park in St. Louis. Soon after joining I read about the Beginner's Workshop held at Lou Mueller's shop.

I signed up for the class and was not disappointed! There was lots of enthusiasm from the 20 or so students, and the volunteers who worked with the class were very forthcoming with sharing their skills and knowledge with the students.

I was pleased that I took the class and recommend it to anyone starting out.

I would like to say thank you to all the volunteers and to BAM for setting up the workshop.

Thank you,

*John Burcks
St. Ann, Mo.*

BAM

January Meeting

Minutes

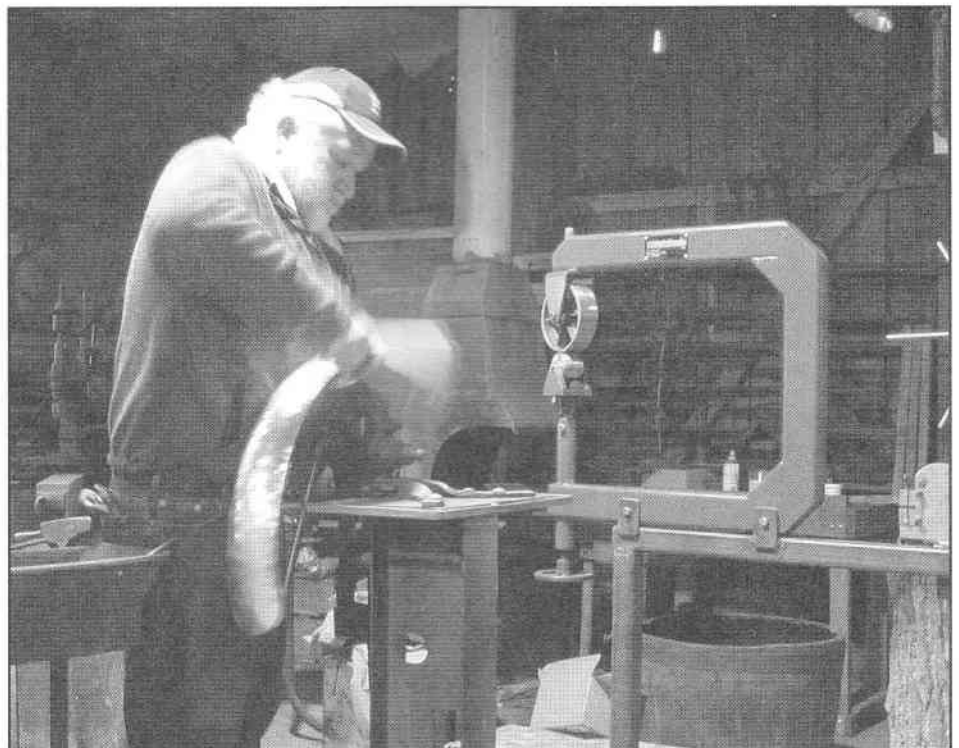
- Thanks to John Lovin and IVBA for hosting and feeding us.
- Bruce Herzog gave a treasurer's report, 542 members.
- Joe showed a letter of thanks from the Metals Museum for our recent donation.
- Joe and Bruce spoke on the Beginner's Class at Lou Mueller's shop on 25 Jan.
- Joe spoke on the 2003 BAM Conference. Make lots of auction items.
- Col. Tim Ryan will call the auction this year.
- Doug Hendrickson spoke on a workshop with Clay Spencer on June 21 & 22 at Lou's shop. This will be a great opportunity. The object will be to make a table. This will also be Bonnie Hendrickson's birthday.
- Joe mentioned a safety workshop at Don Asbee's shop 22 Feb.
- Joe also mentioned a memo from Caniron concerning their conference in July.
- Joe, Bruce and Don Nichols spoke on the logistics involved with the teaching workshops (trailers, propane, tools, etc.)
- Andy MacDonald spoke on demonstrator selection for our conferences. A lively (near brawl) discussion ensued.
- Meeting adjourned.

Trade items were made by John O'Connor, Ken Markley, Maurice Ellis, Wilbur Hayley, Joe Wilkinson, Doug & Bonnie Hendrickson, Bob Stormer, Pat McCarty, Don Nichols-Dave Shepard, Don Birdsall, John Huff, and Bruce Herzog. Iron in the hat was donated by: John



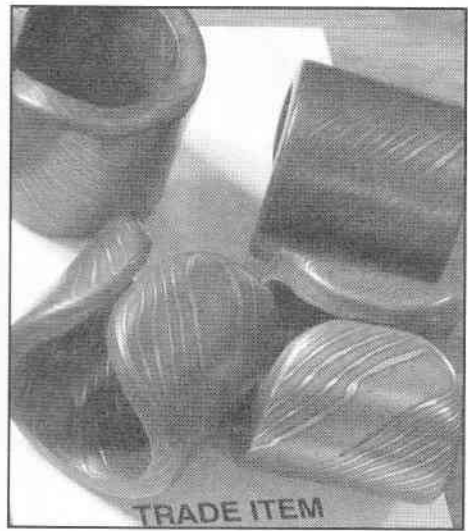
Lovin, John Murray, Pat McCarty, Mike Maculers, Don Nichols, Peggy Williamson, Don Birdsall, Dean Coonrod, Bruce Herzog, John Huff, Joe Shilling, Bess Ellis, and Ed Karcher

Above: Wood stove art was attributed to Doug Hendrickson but no one knew what this depicted. He was actually diagramming the winning play that would have put the Rams in the Superbowl. Below: Most had never seen the English wheel demonstrated.





A big crowd filled the Jefferson County Historical Society shop.



Above: Ken Markley's Damascus trade item. Left: Demos were up close and personal.

Photos by Bob Stormer

BAM 12th Ozark Conference Schedule
Friday Evening, May 2, 2003

- 9 am -7 pm Beginners Workshops (details p.4)
9:00a-12 noon Beginners Blacksmithing-Lou Mueller, Inst.
1:00-5:00 pm Beginners Blacksmithing, continued
5:30-7:00 pm Beginners Bladesmithing-Ken Markley, Inst.
5:00 pm- BBQ pork steak dinner available on site
6:30 pm Lectures by Demonstrators
8:00 pm Forging Contest (details on p. 3)

Saturday, May 3, 2003

- 7:00 -8 am Casserole Breakfast available on site
8 -12 noon **George Dixon**-Traditional Forging
Don Fogg-Bladesmithing
Power Hammer Demonstrations
and/or Flypress Demonstrations
(Featuring **Tom Clark, Sid Suedmeier, John Murray, Phil Cox, and Japheth Howard**)
8 -11:30 am Family Workshops (details on p.5)
8:00-9:30 am Friendship Bracelet-Leigh Funk, Instructor
10-11:30 am Jewelry Making-Leigh Funk, Instructor
12:00-1 pm Lunch break (Sandwiches, chips, soda,
candy, desserts, etc. available on site)
1 -4:30 pm **George Dixon**-Traditional Forging
Don Fogg-Bladesmithing
Power Hammer Demonstrations
and/or Flypress Demonstrations
12:45-4:30 pm Family Workshop (details on p. 5)
Basket Making (pie carrier)-Mary Jo McCarty, Instructor
5:00-6:30 pm Dinner Banquet on the grounds
(Banquet tickets must be purchased during pre-registration)
6:30-? BAM Award Presentations and
Auction with **Colonel Tim Ryan**

BAM 12th Ozark Conference Schedule
(Continued)

Sunday, May 4, 2003

- 8:00-12 noon **George Dixon**-Traditional Forging
Don Fogg-Bladesmithing
Power Hammer Demonstrations
and/or Flypress Demonstration
(Featuring **Tom Clark, Sid Suedmeier, John Murray, Phil Cox, and Japheth Howard**)
8:00-12 noon Family Workshops (details on p. 5)
8:00-12 noon Spouses Beginning Blacksmithing
9:00-12 noon Landscaping-**Tim Ryan**, Instructor
12:00 noon-? **BAM Members**-Tear Down and
Clean-up Conference site

Additional Conference Activities:

- **Large tailgate site free to Registered Participants
- **Free camping site with lots of modern toilets
- **Sales of various items of interest to blacksmiths
- **Food will be available on site Fri. p.m. & Saturday a.m. & noon

Questions???

Contact one of the Conference Chairmen -----

Fred Weisenborn	Dave Shepard	Rubin Funk
417-589-2497	314-966-2330	573-445-8340
jweisenb@llion.org	dcshep38@aol.com	(relocating this spring)

➔ **THE REGISTRATION FORM FOR THE** ←
CONFERENCE IS ON THE INSIDE BACK COVER

Demonstrator Bios

George Dixon

George Dixon has over fifteen years experience in traditional metalwork. As the former Head Blacksmith at the historic firm of Samuel Yellin, Metalworkers, he has an established reputation in the art of traditional forge work. Designs from personal interpretations of historic motifs to the Grilles on the Curtis School of Music's entrance in Philadelphia all involve an intense attention to detail and quality. He believes blacksmithing is not defined by time period of decorative motif; but that blacksmithing is defined by process alone.

In addition to forge work, he teaches this ancient art at craft schools and colleges around the United States. It is more than a living for him, it is a life. George Dixon is also owner/publisher of The Traditional Metalsmith, a quarterly journal about art blacksmith tools and techniques.

Additional information about him can be found at his website, <http://users.aol.com/metalsmith/index.htm>

Don Fogg

Don Fogg has been forging knives fulltime since 1978. In the early years, the trend in knifemaking was toward exotic steels and space age materials. He has tested many blades and compared them to his own hand forged, carbon steel knives. He has yet to find a knife that will out perform a well forged, properly heat treated, carbon steel blade. They are tougher, sharper, and hold an edge longer than any knife made any other way.

For several years, Don was partners with Murad Sayen and together they crafted Kemal knives. He has since chosen to center on functional knives in his work

and only occasionally makes creative pieces.

Don Fogg feels that his work is more than making a product, it is a way of life. He takes pride in what he does and guarantees to give it his best or it doesn't leave his shop. Anyone interested at all in bladesmithing is sure to enjoy watching Don Fogg's demonstrations.

Additional information about him can be found at his website, <http://www.dfoggknives.com/>

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## FORGING CONTEST

2003 OZARK CONFERENCE



**BAM**



Friday, May 2, 8:00 p.m.

Forging to Length

The challenge of this contest is to take a piece of steel and draw it out to a specified length, without going over, in one heat and in one minute or less.

All contestants will use the same hammer, tongs, and steel cut to identical lengths.

The length to be drawn to will be kept secret and revealed to each contestant as he/she starts their round of forging. They should keep this length secret after their forging in order not to give later contestants unfair advantage.

No rulers, tapes, calipers, gauges, travelers, body parts, or other items of known length can be utilized during the contestant's participation.

Each forging will be measured by the judge or his lackey and recorded. The winner will be the forger that comes closest to the specified length without going over. In the event of a tie, the piece with the most unused parent stock will be favored.

First prize is \$50, second prize \$40, and third prize \$30.

**Doug Hendrickson is in charge of the Forging Contest.**

Sign up at the registration table.



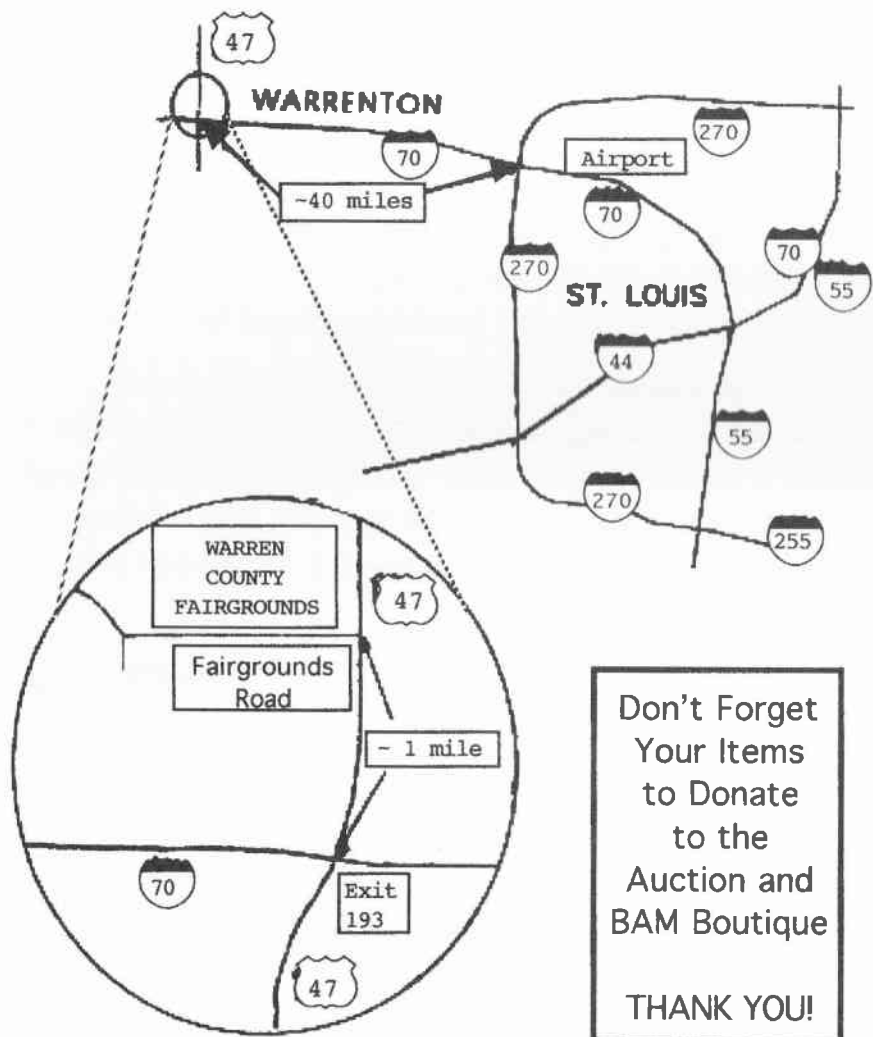
# MAP TO

## BAM 12th Annual Ozark Conference

### May 2, 3, & 4, 2003

### Warren County Fairgrounds, Warrenton, MO

Registration table and information in first building on right as you enter fairgrounds.



Don't Forget Your Items to Donate to the Auction and BAM Boutique  
**THANK YOU!**

# LODGING

**Camping** Free camping is available on site with lots of modern toilets. Showers should be available.

## Motels

- AmeriHost Inn, Warrenton 636-456-6000  
AmeriHost has offered BAM a special rate of \$58 plus tax per room which is at least \$10 off their regular price. If you choose to reserve a room at the Amerihost, tell them that you are with the *Blacksmith Association of Missouri* and ask for the special rate of \$58/night. It is quite new and has an indoor pool, sauna, and spa.
- Super 8, Warrenton 636-456-5157 or 1-800-800-8000  
(This is a new motel but doesn't have a pool or spa for ~\$52-\$54 plus tax per room.)
- Budget Host Inn, Warrenton 636-456-2522
- Budget Inn (4 mi w of Warrenton) 636-456-7272
- Days Inn, Warrenton 636-456-4301

# DINING

Warrenton has a number of fast food and regular restaurants within a few miles of the conference site. Coffee and donuts will be made available on site for Saturday and Sunday mornings. In addition, food will be available on site for purchase from The Benevolent Society of Brothers & Sisters, St. Louis, MO--Christine Mueller, Director. BBQ pork dinner will be available for Friday dinner, casserole breakfast for Saturday morning, sandwiches, chips, soda, candy, desserts, etc. for Saturday noon. (She promises to try to have enough food available for all who desire it this year.)

Don't forget you must pre-register by April 19 for the Saturday evening buffet banquet which will consist of roast pork and baked turkey with all the trimmings including dessert for only \$8.50 per person.

# WANTED

BAM's Boutique needs small forged or craft items for the Conference. All proceeds from the BAM Boutique goes into the BAM treasury. Therefore, please support the BAM Boutique by donating items valued at less than \$20 each.

\*\*\*\*\*

*For the Conference Auction, your forgings, tools, books, and other blacksmith-related items are necessary. Remember, the Conference Auction is BAM's major fund-raiser.*

*Items valued at between \$20 and \$50 are usually limited at the BAM Auctions. Many more items in this category could go a long way to make a more successful auction. Of course, the normal more expensive items are always needed also.*

*Therefore, please support the BAM Conference Auction by donating items (large or small) and/or bidding on items at the Auction Saturday, May 3, 2003, at 6:30 p.m.*

*Items for the BAM Boutique and/or the Conference Auction may be brought to the BAM March meeting or to the Conference Registration Table for disposition.*

**DON'T FORGET THE ITEMS YOU WOULD LIKE TO "SHOW" AT THE CONFERENCE DISPLAY GALLERY**

## PRE-REGISTRATION FORM (DUE APRIL 19) BAM OZARK CONFERENCE May 2, 3, & 4, 2003

Send Pre-registration form to: Bruce Herzog, Treasurer  
2212 Aileswick Dr., St. Louis, MO 63129-3604  
Phone: 314-892-4690; e-mail: bjherzog@msn.com

Pre-Registration FRI/SAT/SUN:\* # \_\_\_\_\_ @ \$35 \$ \_\_\_\_\_

SATURDAY only:\* # \_\_\_\_\_ @ \$25 \$ \_\_\_\_\_

SUNDAY only:\* # \_\_\_\_\_ @ \$10 \$ \_\_\_\_\_

Family members (spouse and/or children) are Free

Sat. Banquet w/dessert: # \_\_\_\_\_ @ \$8.50 \$ \_\_\_\_\_

### WORKSHOPS:\*\*\*

Fri.- Begin. Blacksmithing (9-5 p) # \_\_\_\_\_ @ \$20 \$ \_\_\_\_\_

Begin. Bladesmithing (5:30-7 p) # \_\_\_\_\_ @ \$10 \$ \_\_\_\_\_

Sat.- Friendship Bracelet (8-9:30 a) # \_\_\_\_\_ @ \$5 \$ \_\_\_\_\_

Jewelry Making (10-11:30 a) # \_\_\_\_\_ @ \$10+ \$ \_\_\_\_\_

Basket Making (12:45-4:30 p) # \_\_\_\_\_ @ \$21 \$ \_\_\_\_\_

Sun.-Spouses Blacksmith. (8-12 n) # \_\_\_\_\_ @ \$10 \$ \_\_\_\_\_

Landscaping-T. Ryan (9-12 n) # \_\_\_\_\_ @ \$10 \$ \_\_\_\_\_

Total Enclosed \$ \_\_\_\_\_

Name \_\_\_\_\_

Attending Family Members \_\_\_\_\_

Address \_\_\_\_\_

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

Phone \_\_\_\_\_ e-mail \_\_\_\_\_

\*On Site Weekend Registration \$40, Sat. \$30, Sun. \$15

\*\*\*INFORMATION ON WORKSHOPS IS ON PAGES 4 AND 5

Pre-registration deadline Saturday, April 19  
to reserve Saturday Banquet tickets and most workshops

cut along dotted line

# BAM

## Bulletin Board

Wanted: A small Metal Shaper. 7-10" size. Ammco, Atlas, Delta, Logan, South Bend or something similar. Contact Bruce Herzog. Call (314) 892-4690 or e-mail bherzog@msn.com

Looking for an anvil. Call Tim at (573) 546-6321.

For sale: A-366 deep drawn ultra low carbon steel sheet for repoussé work. Only .005% carbon. 14 gauge cold rolled. Call John Murray, (636) 398-4640.

Coke for sale, \$10 per hundred pounds loose or \$9 per bag sacked. Bags hold 60-70 pounds. Call Japheth Howard for more info, (660) 777-3508.

For sale: 3-1/2" bench vise, opens to 8 inches, small anvil on rear, 40 lbs., \$50; Canedy-Otto post drill, hand crank, automatic, has original chuck and Craftsman 1/2" chuck, mounted on steel post with feet, 5'5", \$130. Emil Bubash, 3151 Lin-Tel Rd., St. Louis, MO 63125; (314) 892-4086.

Wanted: B-2 or B-3 Beverly throatless shear. Please call with price and condition. Bob Woodard (618) 692-6508.

Ray Chaffin has a new computer operated plasma cutting system that can cut anything out of metal. Mail, call or e-mail your design for a price quote. Also hardwood blocks 2-2 1/2" x 12-14" are \$5 each in curly maple, straight maple, English walnut, birch laminated in brown and white and blue and white. Ray Chaffin, (660) 438-6720 or Ray's Welding, RR 3,

Box 279, Warsaw, MO 65355.

Heavy duty frying pan blanks: Steel, approximately 9 inch in diameter with 2 inch sides. 12 gauge (2.5 lb.) or 14 gauge (1.75 lb.) 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 \$4 plus \$.50 for each pan. Contact: Bob Tuftee, 3855 Aspen Hills Dr., Bettendorf, IA 52722; bobforge@hotmail.com; (563) 332-4800.

Custom-built air hammers. 6-pound table top model \$1,300; 20-pound table top model \$1,900; 20-pound floor model \$2,200; 40-pound floor model \$2,600. Some modifications to the basic hammers can be made to your specifications. Also custom metal spinning in copper, brass, pewter, and steel. Contact Maurice L. Ellis, Route 1, Box 1442, Belgrade, MO 63622-9709. Phone: (573) 766-5346. E-mail: mbellis@misn.com.

BAM members, 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. From art to parts I do it all. Now offering: 12" x 18" BAM logo signs plasma cut from 1/8" A36 steel plate, \$25 BAM members, \$35 non-members. Call (573) 474-8749 and ask for William Irvin.

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, the Blu Crusher rolling mill and Forgemaster gas forges. We ship and accept Visa and Mastercard.

Subscribe to Jerry Hoffmann's Blacksmith's Journal, a monthly publication for blacksmiths. Call 1-800-944-6134 for more information.

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 punch-

es, shears, belt grinders and gas forges. For more info on the tools contact him at (573) 438-4725.

Power hammer history! *Pounding out the Profits — A Century of American Invention* by Douglas Freund (hardbound, 317 pages, profusely illustrated) is available for \$32.50 plus \$4.50 shipping and handling through Mingus Mountain Machine Works, PO Box 532, Jerome, AZ 86331. For blacksmithing books contact Norm Larson, 5426 E. Hwy. 246, Lompoc, CA 93436 or call (805) 735-2095. Ask for his catalog.

George Dixon edits a blacksmithing publication called "The Traditional Metal-smith". For \$28 you will get four issues of how-to information. Contact him at 1229 Bee Tree Lake Road, Swannanoa, NC 28778.

Irony is a new publication by BAM member Stephen McGehee. It's full of metalworking projects as well as his own brand of wit. Subscriptions are \$35 a year or \$65 for 2 years. Send checks to P.O. Box 925, Corydon, IN 47112.

L Brand Forge coke now packaged in 50 pound bags, 1,000 pound bulk sacks on pallets and 2,000 pound bulk sacks on pallets. Send your zip code for a quote on price including delivery. 1-800-441-0616 or LBrandForgeCoke@aol.com.

Bells Novelty Casting is a foundry in Anniston, Alabama manufacturing blacksmiths' tools. We are currently looking for dealers to market our products. We have anvils of all sizes, swage blocks, hardies and drift pins. Call 1-877-FARM-BEL. Web site www.bellsandmoe.com.

# Scholarship Payback

by Maurice Ellis

**D**uring the week of June 17-22, 2002, I took a class at John C. Campbell Folk School to learn to make open and closed dies (swages) for making decorative pieces. The class was taught by Allan Kress. Allan makes different dies for making everything from mice to horse heads, acorns, round balls and other decorative pieces.

Although we mostly made dies, we also made other tools such as cutters, snappers, flatters and fullers.

A power hammer with flat dies is very helpful in

making the dies; although it is not absolutely necessary. If you make the dies with an anvil and hammer you will need a helper to swing the sledge hammer. A treadle hammer will work also.

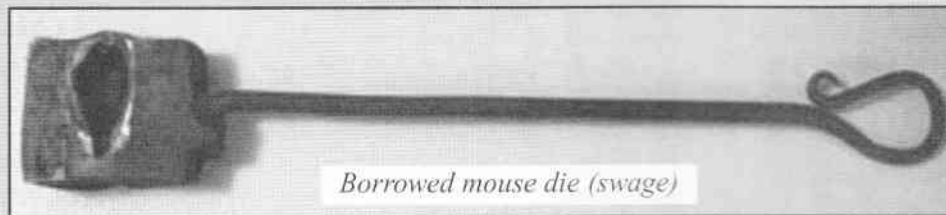
In order to make the desired die, a master is needed. In the class we could use one of the dies that Allan brought with him to make a master or forge one of our own. Everyone in the class made dies both ways. Of course it is much more time consuming to forge the master than it is to use an existing die to make one. So if at all possible borrow a die from a friend to use to make a master to use for making your own die.

## MAKING AN OPEN DIE (SWAGE)

To make an open die, first decide what decorative piece you want to make. Let us say that a mouse is what we want. If possible get an existing mouse die (See Figure 1) and forge a master in it. In this case a piece of 5/8 inch round, mild steel is sufficient to make a mouse. If a lot of dies are going to be made from this master, then better grade steel should be used for the master. Coil spring is good if

the correct size can be found.

To make the mouse master using an existing mouse die, heat the end of the 5/8" round stock and slightly taper to fit the die cavity as much as possible. Heat the tapered end to near welding temperature (almost white). Take the existing mouse die and the heated metal to the power hammer. Place the taper horizontally into the die cavity under the power hammer and forge it



*Borrowed mouse die (swage)*

into the cavity. Be careful not to let the heated piece move around in the die cavity. After the master is forged, it must be cleaned up and all the flashing ground and filed away so that a full clean die can be made. (See Figure 2)

When the mouse master is finished, choose a piece of 3/4 X 2 inch flat, mild steel stock for the die for the mouse. Next weld a handle of some kind on the die material. Heat the piece of 3/4 X 2 inch metal in the forge until it is close to welding temperature. When the piece is hot enough, take it and the mouse master to the power hammer. Place the mouse master on the die block with the bottom of the mouse up. Center it on the die block and gently drive the mouse master into the hot die block. If a second heat is needed that is okay. When the mouse is driven in far enough to make the mouse cavity, set the die aside to cool. When the die is cool, take a die grinder and a carbide burr or a grinding stone and grind the sharp edges off the die. It is now ready to use to make decorative mice. Now return the original mouse die you borrowed to its owner. You now have your own.

## MAKING A CLOSED DIE (SWAGE)

For the closed dies first cut a piece of 1/4 X 1 inch flat stock about 30 inches long. This will be the handle for the die. Heat this piece in the forge and bend it in the middle. In class we made a tool to bend the handle, which consisted of a piece of angle iron with a piece of 1 1/2 pipe welded on top of it and a piece of 1/2 inch rod for a stop (See Figure 3).

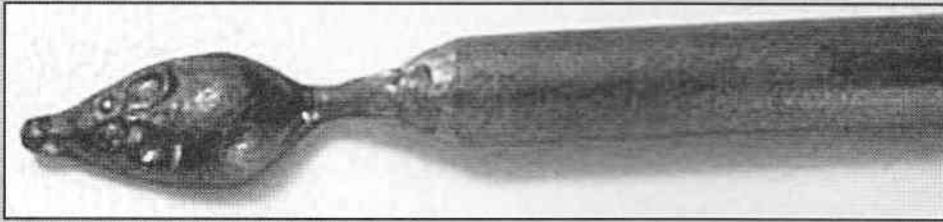
When the handle is hot enough to bend, bend it in the middle and then bend it around the angle iron fixture described above.

This makes a spring handle for the closed die.

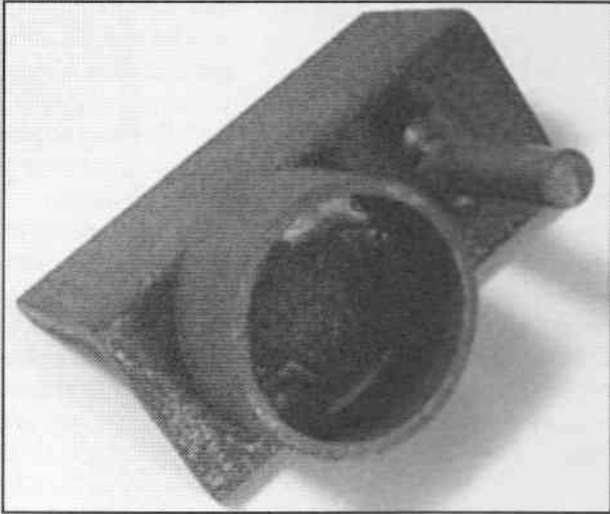
As we did for the open die, forge a master or use an existing die to make the master. For this die a 1/2 inch acorn will be used as the master. (See Figure 4) To make the die cut two pieces of 3/4 X 2 inch flat, mild steel stock. Weld the handle to the 3/4 X 2 inch pieces so that they are on top of each other. Put the die blank end in the forge and heat it close to welding temperature. When it is hot enough, take the die and the acorn master to the power hammer and place the master between the two pieces of the die blank. Hold the master acorn with one hand and the die handle with the other and center the master acorn in the die. When everything is lined up, gently drive the die down onto the master. When the master begins to seat in the hot die, rotate the acorn master as you hammer it down into the die so that the die cavity will be symmetrical. A second heat may be used if needed to complete the die. Clean up the die after it is cool. (See Figure 5)

I will demonstrate making both types of dies at the March 29 BAM meeting at my shop. I want to thank BAM for the scholarship that enabled me to take this class.

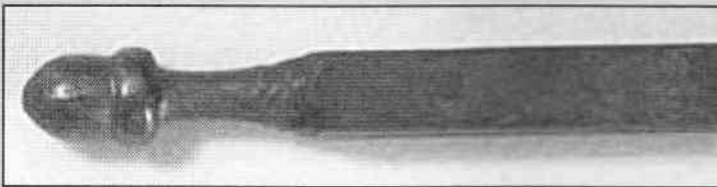




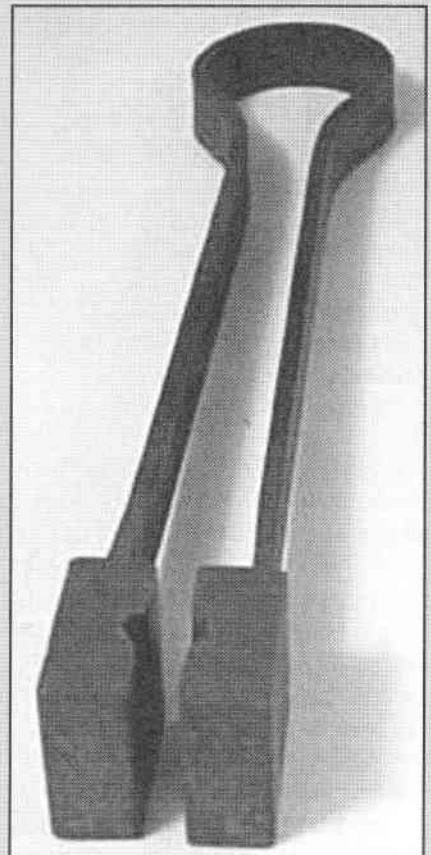
*Mouse master*



*Closed Die*



*Acorn master*



*Closed acorn die (swage)*

# BAM NEWS

## Scholarship time

Scholarship time is here again. SBAM has lots of money and would like to give some of it to you to further your development as a blacksmith. Please contact committee Chairman Walt Hull if you are interested: (785) 865-5771. The program is being reorganized. If you have suggestions contact Walt or members Kirk Sullens or Don Birdsall.

## Future meetings

Our meeting coordinator Kirk (Raoul) Sullens has been hard at work setting up a meeting schedule. Here's what he's got so far:

### May 31:

Don Asbee, Hartsburg Trade item:  
Door knocker

### July 29:

Ag Hall of Fame, Bonner Springs,  
Kansas.

### September:

Bob Ehrenberger, Shelbyville, Mo.

### November:

John Murray, New Melle, Mo.

## Conference '03 update

The 2003 BAM Conference Committee has been hard at work lining up demonstrators and other details of the next big event. Here's some of what they have planned so far:

- Knife workshop is full, other classes filling fast, so egiste now.
- Main demonstrators will be George Dixon and Don Fogg. George specializes in traditional blacksmithing and he is a master at the treadle hammer. Don is a world-class bladesmith.

We'll also have a basic blade forging workshop.

- All-around blacksmith contest.
- Sid Seudmeir will offer a Little Giant tune-up seminar and his power hammer collection.
- There will be a power hammer tent featuring Tom Clark, Phil Cox, Sid and others. The BAM teaching station trailer will be complete and set up so that beginners can learn some skills in an all-day Friday workshop.
- There will also be a fly press demonstration.
- The auction needs your items! It's a little-known fact that the auction brings in most of our spending money for the rest of the year. Also make something for the BAM Boutique.
- BAM gallery will be set up so bring your good work.
- The committee needs ideas for the family program.
- We'll get you more information in coming issues.
- Dates are May 2, 3, 4.

## BAM's Teaching Station

BAM's Teaching Station was an idea started by Lou Mueller. The Teaching Station is equipment and a program designed to go to different locations within the BAM area to teach Blacksmithing. Lou has donated gas forges, tooling and developed a written program for the course. Additional people have put in time and work to help develop this class. 10 anvils were purchased by BAM. In addition, the following people donated their anvil refund to help fund additional equipment:

Jeff Bardol, Rick Crawford, Joe Davis, Don Grammond, Charles Gruel, Andrew Herzog, Bruce Herzog, Mike Hogan, Wayne Holder, Ken Jansen, Craig Kaviar, Tom Kennedy, Noah Kirby, Gary McCullough, Earl Million, Michael Morton, Mike Nave, Don Neuenschwander, Dan Nibbelink, Don Nichols, Dick Nietfeld, Richard Obermark, Albert Rudd, Jeff Sainz, Charles Schumann, Dave Shepard, Michael Smith, Robert Stormer, William Tanneberg, Roger Treece, Ken Valdejo, Fred Weisenborn, Jim Wilson, Bob Woodward

Their donations came to \$1,748. This money will be put to use to help buy a trailer and additional tooling. The first class was held January 25, 2003. The class filled quickly and was a great success. Lou is doing a little fine tuning to make it even better the next time.

To complete the idea, we also need to teach the Trainers. Trainers and their assistants will be people who will be capable of running the program at different locations. Come if you are interested. The success of BAM's new program is dependent on having both trainers and locations to have our classes.

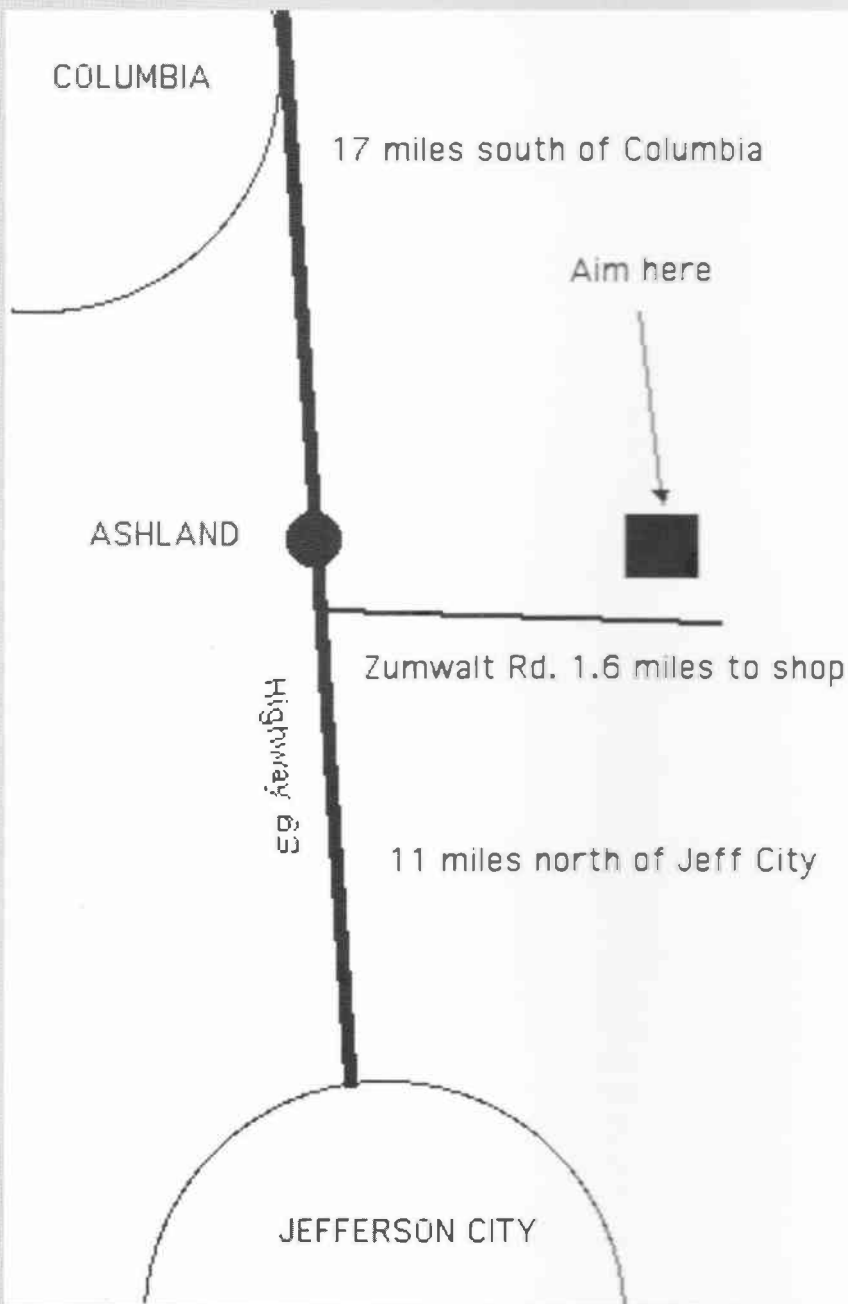
In addition to people taking the Beginner's Blacksmith Class, we also need to teach the trainers. Trainers and their assistants will be people who will be capable of running the program at different locations. Come if you are interested. There will be no charge and the success of BAM's new program is dependent on having both trainers and locations to have our classes. In the future we hope to add additional types of classes.

## Clay Spencer workshop

On June 21-22 Clay Spencer will lead a hands on workshop at Lou Mueller's shop in Fenton, just west of St. Louis. The workshop is free to all BAM members. Here is how Clay sees the workshop happening: "We will build a small table using techniques taught by Francis Whitaker. It has rings with slit, upset and drifted holes and forge welds. Several teams will lay out the parts, make three rings, two cross pieces with welded scrolls and four legs on the first day. On the second day we will assemble the table using collars, rivets and tenons. To top it off we will make a small steel decorative element for the center and enamel it with a torch. Bring you safety glasses and work clothes. We will learn something and have some fun making this table.

Watch for more info in the next newsletter.

## Next meeting: May 31, Hartsburg, Mo.



Don Asbee is the host of the next BAM meeting to be held May 31 at his shop east of Highway 63 near Ashland.

Don's not too hard to find. Just head north from Jeff City 11 miles or go south from Columbia 17 miles to Zumwalt Road. Take Zumwalt east (it's a gravel road) 1.6 miles and watch for the signs.

You can't see Don's shop from the road. His drive is on the left hand side of the road.

Don has one of the best equipped shops in the state. If he needs it he builds it. His stock cutting rack, welding set up, heat exchanger and his new air hammer are must sees.

Not sure at this writing what Don has planned for us but it will no doubt be good. Don just did a nice workshop for us in February.

See you in May for the next BAM meeting.

**BAM**

## 2003 Meeting schedule

### May Meeting

Don Asbee  
Hartsburg, MO  
May 31

Trade item: Door knocker

### July Meeting

Agriculture Hall of Fame  
Bonner Springs, Kansas  
July 29

Trade item: TBA

### September Meeting

Bob Ehrenberger  
Shelbyville, MO



*This photo was taken in the 1930s by a Farm Security Administration photographer. The smith worked on a cooperative farm in southeast Missouri.*

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