

BAM

2004
September - October
Issue



Dave Edwards demonstrating his pedal hammer at the September 25th meeting.

Order Blank for BAM Shirts is on Page 25

Corrections to Last BAM Newsletter

1. Lunch will be provided at the November 20th meeting at Flicker Forge.
2. The March 2005 meeting at Maurice and Bess Ellis's shop is March 19th, not the 27th as published. Lunch will be provided.

Editorial Comments

Letters to the Editor are Welcome. Got a bone to pick with BAM, send a letter to the editor.

BAM Disaster or Welfare Fund - Does BAM Need One?

BAM has a big heart for its members, always willing to assist with learning the craft or when a member is in need. A suggestion has been made of the need for a disaster or welfare fund, created outside the official BAM general fund to assist members with emergencies. With medical costs now reaching all time highs, any effort in this direction must stand careful scrutiny. In addition to the necessity of establishing a legal framework for any such fund, care must be given to the methods for funding and disbursements. Standards and procedures should be established to proposals for disbursements through board members or an appointed committee to provide review oversight. Finding members in need of assistance will not be difficult, accidents and misfortunes occur as part of our routine lives. The task facing BAM leadership will be to establish a system to deal with this issue in the future. A precedent has been set, albeit a worthy cause, nevertheless, it is a precedent. The future will present similar causes unless a system is established for proper review prior to such proposals being presented to the membership for a vote with momentary exposure.

Membership

What best describes membership in BAM? Does one membership fee cover everyone residing in a household or does it cover only husband and wife and minor children? Some blacksmith organizations, ie: ABANA affiliates like BAM, have membership rules which specifically state at what age a household members must become a member in their own right even though they continue to live in with membership parents. A clarification of what is inclusive with a BAM membership should provide answers to the above. This is an item that the board should give attention to and publish their guidance in the newsletter.

BAM Treasurer Volunteer Needed

Bruce Herzog has announced that he will not continue as BAM Treasurer after the BAM annual conference in May. Bruce has served at Treasurer and Membership Coordinator for the past four years and previously he served as the BAM Librarian. As Treasurer, Bruce is custodian of the BAM funds and financial records. As Membership Coordinator, Bruce mails BAM information to new members and supplies the newsletter printer with a current roster for each issue. Anyone desiring to assume these duties should have computer skills, preferably in Excel or a similar program.

BAM Newsletter on www.bamsite.org

Both President Don Nichols and Bruce Herzog (Treas) have expressed objections to the BAM Newsletter being published in full length on the internet bamsite. The webmaster is Ed Harper, 2nd Vice President of BAM. The newsletter editor sends a pdf copy of the newsletter to the webmaster for information he needs to maintain the website. Some blacksmith organizations publish their newsletter in total on the internet, some publish part, ie: meeting schedules, and many do not publish any part of the newsletter. The webmaster has the capability to publish the BAM newsletter and the BAM roster, if desired, with the requirement for a password to view the information on the website. A resolution of the newsletter question is currently being considered by President Don Nichols and the board members. Please direct your opinions and desires to the president or other officers.



An Interview with Dave Edwards *by Ruth Hull*

Our editor got in touch with me shortly before the September meeting to ask if I would substitute for Esther in interviewing Dave Edwards, our demonstrator, since Esther was on Grandma Duty elsewhere. Walt and I were not able to attend, due to another commitment, but I told Ned that I would very much like to interview Dave and, if he and Dave were agreeable, I would get in touch with Dave after the meeting and see if we could put something together. Here's what we came up with.

BAM: I want to thank you for taking the time to sit down and answer some questions about your work and about your pedal hammer. Ned tells me it made quite an impression at the meeting and that you and it made the front page of the local newspaper afterward. We'll get to that shortly, but first I'd like to get a little better understanding of how you got into blacksmithing in the first place.

DAVE: Wood carving and woodworking served as my hobby for many years. I began to take off in the direction of early and primitive woodworking and other traditional skills about 15 years ago. I saw one of Roy Underhill's PBS television programs that featured blacksmithing and decided to try making some rustic box hardware.

BAM: What was your first encounter with the actual craft of blacksmithing?

DAVE: Once I'd decided I wanted to try making the hardware, I built a small forge from an old Weber grill and a vacuum cleaner motor, using charcoal as fuel and a piece of railroad rail as an anvil. It surprised me that I could make it work and I was hooked.

I began to collect tools and read books and gradually found links to the important resources like ABANA. I was fortunate to subscribe to The Anvil's Ring just in time to learn about the Rocky Mountain Smiths' Carbondale conference that was the last for Francis Whitaker, so I got to meet and visit with him and get some advice from him. I made a commitment to build a studio and do artist blacksmithing as a retirement business.

BAM: What areas of the craft are of most interest?

DAVE: When I started learning blacksmithing skills I stuck with my interest in colonial America trades and worked on trying to reproduce those artifacts - fat lamps, hearth tools and simple hardware. Then I got more interested in joinery and learned how to do grille work and some furniture.

I got my first commission project for a set of glass fireplace doors for an older home with a rock fireplace that no standard frame could fit. I have had a life long interest in botany, especially trees, so plant themes appeal to me. After completing the doors we added grape leaf and grapevine and grape clusters across the top panel and it looked pretty good even though my forging skills left a lot to be desired.

My second commission came for a set of fireplace tools from clients who had some very definite ideas in terms of functionality but wanted me to be inventive about the artwork. After I worked out the mechanics of their tools I decided to group them so they would stand as a hearth sculpture that would be appropriate year round. I continued with the botanical element theme and made their piece a stand of cattails with oak leaves and acorns on the ground. I think it came out well and they liked it. I'm now working on the fourth piece for their Ozark home.

I've gradually moved even more toward organic elements and in the past year, I've worked more with chasing /repousee techniques and forging floral elements on the anvil and vise stakes.

BAM: What courses, demonstrations, etc. have had significant influence on your work?

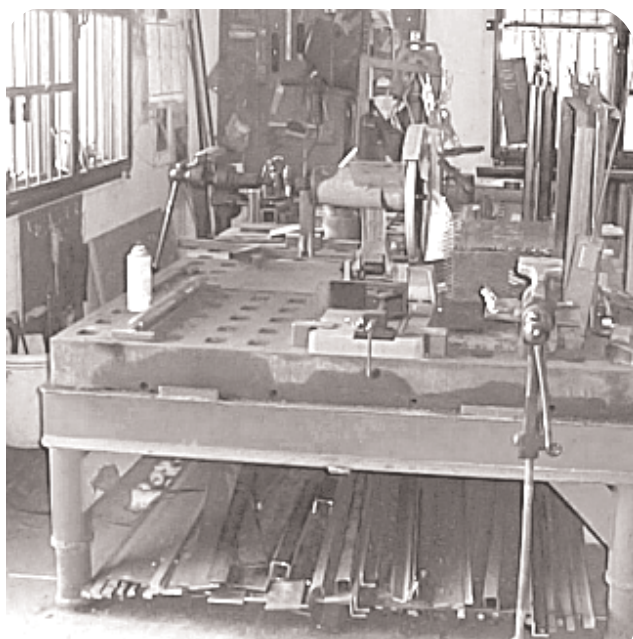
DAVE: While I was working full time as an orthopedic surgeon, I couldn't seem to find time for the formal week long courses offered by the craft schools, although I still long to do so. Bob Patrick came to Wichita and did a one-day forge welding course for the Great Plains Blacksmith's Association. I was able to go to that and it helped me a lot.

I have been to three ABANA conferences and to a number of BAM conferences and monthly meetings. I took Sid Suedmeiers's Little Giant course, and usually go to the Saltfork conferences and the Rocky Mountain Smiths conferences. As a result, I have seen a lot of fine artists work.

I also try to stop by artist shops as we travel and pick up tips from what they are doing. The first time I sought an invitation to a shop was when I called Walt Hull and, even though he was neck deep in a big architectural project, he made time for me to come up and see his setup. Universally, I have found blacksmiths to be gracious and generous with beginners and I'm proud to be associated with such people.

BAM: Who among the smiths you've met, watched demonstrate, read about, whose books/articles you've read influenced you? In what ways?

DAVE: In addition to those already mentioned, my current interest in chasing/repousee techniques is a result of seeing Wendell Broussard do this work at a Grapevine Ironfest. Later I was able to watch George Dixon, Dan Naumann, Mindy Gardner and Kirk Sullens do such work and I try to emulate them.



At left:
Dave's
super size
Acorn Table
in his studio

At right:
Ken
Johnson,
shop
assistant
(Ken is a
retired
chemistry
professor)



BAM: So how's the retirement business working out?

DAVE: I retired last December and, after getting through some struggles with the deaths of parents, got Persimmon Forge started as a full-time business in April. Betty does the business management and I also have a part-time assistant, Ken Johnson. We are still trying to get our web page published and have some more shop remodeling to do. I feel our first year has come along pretty well.

I took my first art class at Emporia State University and we are trying to work out some adjunct relation to their art department.

I did some 1870s period demonstrations which take a lot of time and work. The National Tallgrass Prairie Preserve scheduled us for demonstrations on the three summer holiday weekends. We did the Folklife Festival at Cottonwood Falls and the Living History Day at the Howe House here in Emporia October 3.

One of our goals was to learn something about forging metals other than iron so we have done a little work with copper, bronze and aluminum and hope this may eventually add another dimension to our repertoire.

BAM: So how did you come up with the pedal hammer?

DAVE: You might say an unintended consequence my orthopedic surgery background colliding with the interest in chasing/repousee was responsible for the development of a pedal hammer. It allows comfortable sit-down chasing/repousee work with fine control. I think this will be useful to anyone who likes this type work and especially helpful to those who have back or knee problems, which make standing to use the larger treadle hammers uncomfortable.

This machine is being developed by an engineering firm here in Emporia and will be available soon. I hope it extends the force spectrum of blacksmith tooling. I think of it as the most energy conserving and delicate tool. Moving up the force line, work on stakes in the vise or anvil is next, then work done with hammer on anvil, then treadle hammer work and lastly power hammer work. A pedal hammer can give us plenty to do on those really hot days when we don't want to fire up the forges.

BAM: How did you get so good so fast?

DAVE: That's a very kind way to put that. I will admit to thinking that I am making good progress and that could be attributed to some carry over from orthopedic surgery. Both involve the use of tools, problem solving, putting things together, thinking on your feet, and improvising on the spur of the moment. Putting in long hours helps. I was also exposed to art growing up thanks to my mother's interests in drawing and painting.

BAM: Do you do anything else in life besides pound iron?

DAVE: Pounding iron does take most of my time these days but we do try to fit in an occasional play at Emporia State University, attendance at Emporia Arts Council presentations, our book discussion group, working in the yard and garden, and traveling. It is a joy not having a call schedule to deal with and to be able to sleep through every night without the phone ringing.

BAM: Finally, tell us a little bit about you and your family.

DAVE: I was born in Jefferson City, Missouri, and moved around the country a lot in my youngest days. My father was a flight surgeon with the Army Air Corps until WWII ended. I grew up in Sedalia, attended Westminster College in Fulton and the University of Missouri School of Medicine at Columbia. I did my orthopedic surgery residency at William Beaumont Army Medical Center in El Paso, Texas, and served ten years in the army during the Vietnam era. I settled in Emporia, Kansas, in April 1977 and practiced orthopedic surgery here until December 2003.

You know Betty. We were childhood neighbors, and high school sweethearts, and married after college just before medical school. We have two grown boys, still dating. Keith is a senior software engineer for Motorola in the Chicago area. Kevin is a teacher by training now working in the housing construction business in Lawrence and surrounding area.

You can contact Dave Edwards at: djedwards@cableone.net

From President Don Nichols

Well, we had another good meeting on Sept. 25th. It seems like they all are good and that reminds me of a blessing at the dinner table. "Good folks to visit with, good food on the table, so good gosh let's eat." Doesn't that sum it up?

We met at Ned & Esther's shop. Ned cleaned up his shop with a little help. So guys good things can come out of having a meeting at your place. Joe Wilkinson and Ed Harper gave good demos. After that, Dave Edwards demoed and showed a few of his gadgets to save time in blacksmithing. It sounded like his shop is full of all kinds of devices to make his wife's job easier. He talked about his help or helpers. Is there more than one of her?

The trade items were good. It's nice to see all the different ideas people come up with. I got Peggys. At the State Fair, I think it started out as a back scratcher then it was twisted to something else. It was twisted again and again and finally it's a plant hanger. Is that right Peggy?

So guys and gals keep them hammers bright making trade items. Don't forget for the next conference to make something for the auction, the gallery or both. So remember, only you can do something for BAM that no one else can. Do it! Now read this with a grain of borax.

See you at the next meeting at Alice James & Japheth Howards and don't forget little Cyrus Howard.

Minutes of the September 25th Meeting

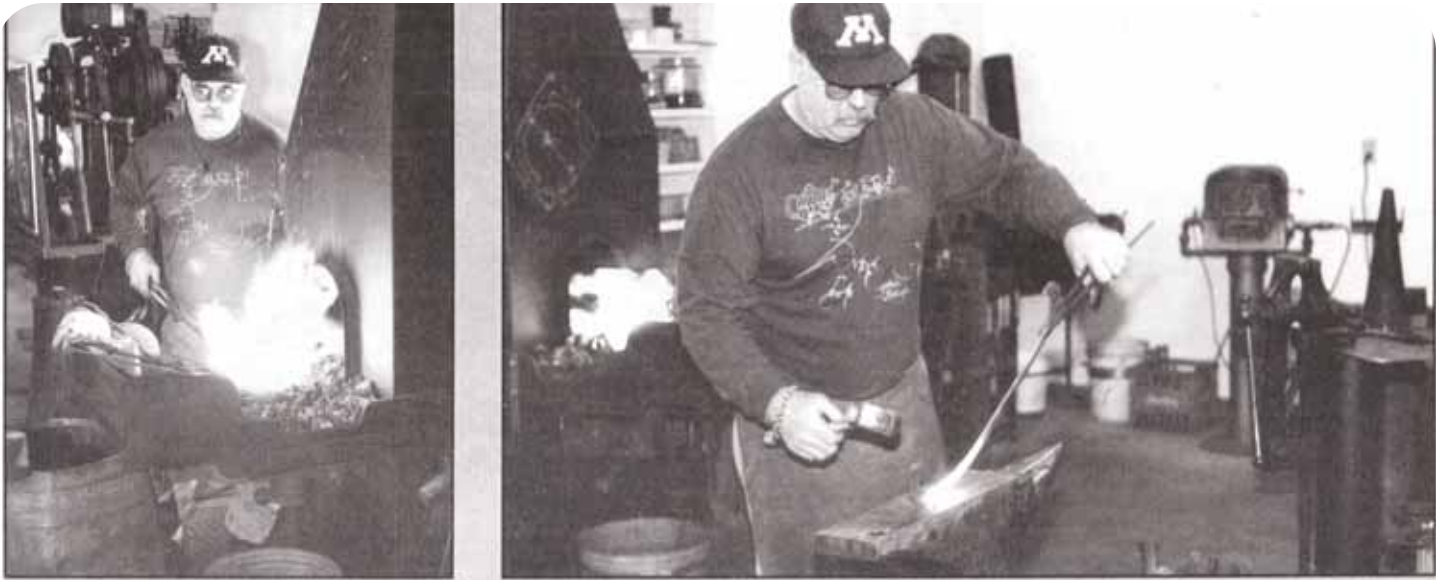
BAM met at Ned & Esther Dighs. We had beautiful weather for the meeting. Bruce gave the financial report and Peggy gave a State Fair report. There was a good group of demonstrators and some are already lined up for next year.

Don Birdsall gave a report on the Mobile Training Station. It's going good and he needs some feedback on what to do next year. So if you have ideas on what they need to do different contact Don.

Old Business-Don Nichols wanted to clarify on Lifetime Membership. We will be giving one a year except this coming year. He wants to have two given this year because he thinks two members deserve them and it's long over due. Also, the gift to Bob Patrick was a one time thing because of what Bob has done for BAM.

New Business-There was a motion to raise the coal price 50 cents a bag. So now coal will be \$8.00 a bag. This will help our distributors to pay for gas. It was second, voted on, and passed.

Memories: Doug Hedrickson at the January 1998 BAM meeting at Bob Alexander's shop



How to forge a ring by Doug "Lord of the Rings" Hendrickson: Step one (above left), Get it hot. Step 2 (above right) beat on the edge, Step 3 (below left) forge weld and make it round again and Step 4 (below right) admire it and try to figure out what goes inside.



BAM Workshops

Tong Making Workshop

Charlie Comstock is planning to hold one or more tong making workshops. Each workshop will be limited to 4 students. Participants will learn tong making methods and leave the class with several tongs they have made. Call Charlie for workshop dates and cost. 417-927-3499



Blacksmith and Farrier Supplies

Charles and Patrice Comstock
Rt. 1 Box 20, Deerfield, MO 64741
417-927-3499

MTS at Fulton & Mexico

Ned Digh will host the MTS classes at Mexico Voc-Tec School on 6 & 13 Nov. Classes at Fulton tentative for December. Call Ned for details at 642-8332 (leave message if no answer)

Treadle Hammer Tools Workshop

BAM will have a treadle hammer tools workshop on 8 & 9 January, 2005 at Lou Mueller's shop in Sunset Hills, MO with Clay Spencer. Bob Alexander will be the coordinator.

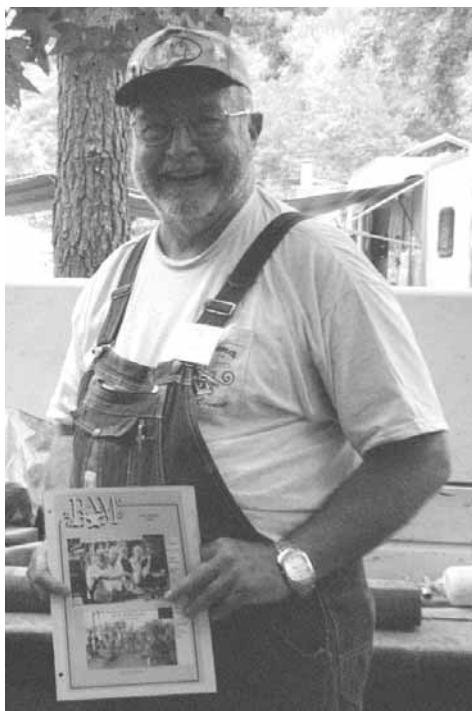
In Clay's 3 day workshop, 30 tools are produced. This will be a 2 day workshop and is planned to produce 20 tools for each participant. The cost data is not definite yet, but a rough estimate is \$100 - \$125 per person. Bob Alexander will figure the cost and those figures will be announced at the November meeting in Salisbury.

To sign up for this workshop, send \$50 to Bruce Herzog before December 1st. An additional \$50 is to be paid when you arrive at the workshop. Any balance remaining will be dealt with later.


A list of the 30 tools, normally made in a 3 day workshop is shown on page 21 of the Jul-Aug BAM Newsletter. Clay will decide what 20 tools are appropriate for the 2 day workshop. Bob Alexander may ask for some volunteers for a pre workshop day in December. It is anticipated that approximately 30 members will participate in this workshop and that means that 600 handles must be made, so Bob may desire to get a head start.

Recruiting Results *by Ned Digh*

You may remember the photo at left. It appeared in the , 2003 Sep-Oct issue of the BAM Newsletter. The original photo explained that Esther Digh was giving Gary Meredith a recruiting pitch for BAM, while attending the Alabama Forge Council Conference. Recently Gary and his wife visited Fulton and toured my shop. Result: Gary is now a member of BAM. P.S. Gary is an native born Missourian, helicopter & balloon pilot, see card below!



**BALLOON FEDERATION
OF AMERICA**



Gary Meredith
Pilot Member

306 ELM STREET
ENTERPRISE, AL 36330
(334) 347-5704

From Walt Hull Ironworks in Lawrence, KS

Walt Hull had two of his sculptures accepted for the Lawrence Own-Your-Own Art Exhibition and Sale, September 24 through October 3. His sculpture, Volleyball at the Convent, received a merit award from the show patrons and sold at the private showing before the public grand opening.

Kate Dinneen designed and made drawer pulls for a chest that her brother-in-law entered in the show, which received second place overall. He does really fine woodwork, mostly furniture. In awarding the prize for the chest, the judge specifically mentioned the drawer pulls.



Some additional interesting information on Walt Hull and associates:

In April 1994, Walt Hull quit his daytime job and started working full time at the forge at Pleasant Grove.

Kate Dinneen joined the company in August of that year. Walt Hull Iron Work celebrated ten years in business with the 10th Annual Company Picnic for Customers, Family and Friends Appreciation Day September 26 at Clinton Lake west of Lawrence.

Walt recognized Kate with the "Employee of the Decade" award.

The weather was about as perfect as it gets. Walt always puts somebody in charge of arranging the weather for the day, usually an attractive female, and it seems to work. We've never been rained/snowed/frozen out. This year thanks go to Mary, one of Walt's customers, who was in charge.

Ed: Thanks to Ruth Hull for providing this info and congratulations to all at Walt Hull Ironworks. Kate is also super member of BAM. She always volunteers to assist the demonstrators at the annual BAM conference and also did so at the ABANA conference.

BAM Roster Changes

New email addresses: Bob Alexander - scruboakforge@jcn.net
Larry Hults - whiskers@yhti.net
Tom Clark - tclark@ozarkschool.com
Ozark School of Blacksmithing: www.ozarkschool.com

New email and/or phone: Clay Spencer - clay@brmemc.net 828-937-0708
Mike Williamson - 870-445-2779
Lou Mueller's (new) shop: 12951 Mauer Dr, Sunset Hills, MO 63127 314-842-0796

A Short Synopsis of the SOFA Conference. *by Bess Ellis*

Not having attended the SOFA Quadstate Blacksmith Round-Up in Troy, Ohio, for 8 years, we decided to attend this year. What a difference the 2004 conference was compared to the 1996 one!!!!!! The 1996 SOFA conference was not very memorable. This year's conference was scheduled for September 24-26, 2004. We had heard that lots of people attend. Therefore, we figured that the tailgate area would fill up fast, so we decided to get there on Thursday, September 23. It was a good thing we did as the tailgate area was almost full when we got there. Many people had been there for a day or two already. The variety of blacksmithing related supplies and equipment was as good as any we had ever seen at any blacksmith conference anywhere. Also a number of commercial vendors were set up inside. We talked to many people who came just to look for items to buy. It appears to be a great place to go to sell or to buy items.

One thing that was really neat was a gallery with several categories, including youth, spouse crafts, antique display, and general exhibit categories. SOFA members were lucky enough to have a space for the gallery that was about as large as the whole building that we use for the BAM conference.

The conference hosted 8 demonstrators so everyone had someone to watch if they wanted to do so. Two free family programs were available for those who did not want to watch blacksmiths. Since we were selling spun items, brooms and handmade soaps, we had little time to watch the demonstrators except for a slide demonstration presented by Peter Ross, Colonial Williamsburg Master Blacksmith. The registrants at SOFA were as personable and friendly as BAM members. We had a great time at SOFA even though we had to miss the BAM meeting at Ned Digh's.

BAM Members in Demo Action

Left: Lou Degginger, center: Bob Bailey both at Williamsburg Fall festival. At right: Pat McCarty at Deutsch Days (Marthasville) and Silver Dollar City, both of which Pat does annually.



A Shop Visit with BAM Member Larry Crow in Eldon, IA *by Ned Digh*

Recently my wife Esther and I had the opportunity to visit with Larry and Esther Crow (yep, another Esther and a quilter too). Larry is not only an active BAM member, but his activities are legion. He does custom blacksmith work, teaches blacksmith classes at his shop for a community college, has an active auctioneer practice, and drives a school bus. Even with all this, his shop is loaded with projects in progress or waiting to happen. While the two Esthers were visiting, Larry and I were having a good time in the shop. He was sharing some of his blacksmith techniques, when he suddenly looked at his watch and said “oops, got to go, it is school bus time”.



Tumbler from old concrete mixer



At Left: Larry's "big ol treadle hammer"

At right: OSHA's response to his seeking approval was something like "you can't be serious?".



At right: teaching stations in Larry's shop.

A community college sends students to his shop for classes.



A Letter From Kate Dinneen, dated October 14, 2004

It's been awhile since the conference and it is way past time that I thanked everyone who helped with the Terry Clark/ Peter Parkinson demo site. There were quite a few of you who lent a hand. The challenge of this particular job was that Terry and Peter wanted a little more than the traditional demo with an anvil or two, one big hammer etc. They wanted to have enough equipment that several people could be working at the same time. On top of that the location of the conference was such that there was no local affiliate to help out. So the first really big thank you goes to Walt Hull for letting a large part of his shop be moved to Kentucky for a week. The second big thank you goes to Tracy McCarty for also providing equipment and helping to load and then driving the trailer down and back. Kirk Sullens also chipped in some requested items and generally provided support. Andrew McDonald and Dr Iron gave me some good ideas on where to beg for a fly press and Andrew gave me a good basic course on them so I would have an idea what to ask for. Keene and Sons had a press there for us soon after we arrived.

Once we arrived Pat McCarty and Ralph Sproul and the site crew were wonderful. Anything the lads asked for we were able to provide with the crews help. Tom Clark was a prince -really- providing an air hammer and specific dies that Terry had requested as well as the odd tong and hammer that was needed at the last minute. He also provided an anvil. Our president Don Nichols came by to check on us and see if we needed a break from our duties as demo crew and a former ABANA president Lou Mueller provided medicinal support at crucial moments. And then there were the two BAM members who showed up at the end of the day Saturday as Terry and Peter were finishing up the grille. These two mysterious BAMmers helped us to tear down the site and kept an eye on things when we went to the auction. My memory of that evening is a bit vague and I never did find out who you are but we were very grateful for your help. Anyone else who helped thank you, thank you. It was a lot of work but definitely worth it to spend time with 2 wonderful smiths.

til later, Kate Dinneen kld310@earthlink.net

The 14th Annual BAM Conference will be held on April 29, 30, & May 1, 2005.

Demonstrators will be - blacksmiths Bill Epps & Alice James; knifemaker Joe Szilaski; scrimshaw (family program) with Ron Newton; gourd art (family program) by Kathy Nichols.

Six (6) volunteers are needed for the whole weekend (Fri, Sat, & Sun), to help setup, cleanup and to help the demonstrators. The volunteers will get free registration and Saturday evening meal.

Conference Committee:

David Smith - 573-659-5601; dlssmith@fidnet.com
Bob Stormer - 636-441-6807; bobstormer@sbcglobal.net
Pat McCarty - 636-239-3814; budden51@netscape.net
Larry Hults - 636-629-7411; whiskers@yhti.net

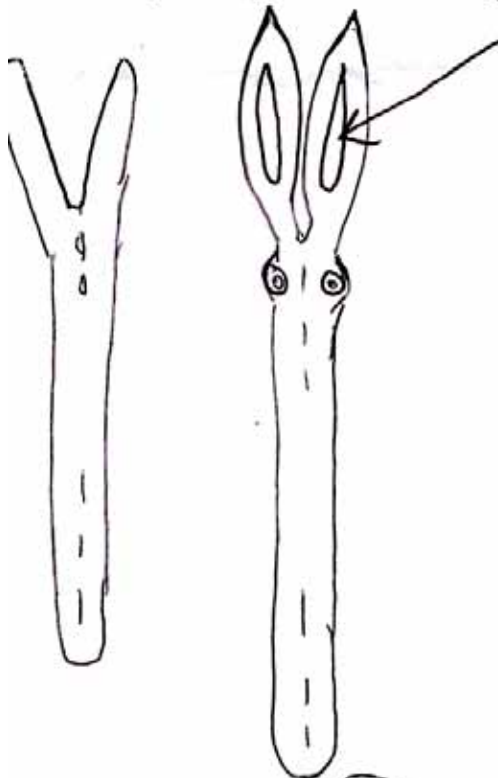
Start planning for items that you will put in the gallery and the auction. BAM depends on these activities for the educational financial support, ie: BAM Scholarships

A Holiday Gift That You Can Make *by Don Nichols*

I met a man at "Barnyards Days" at Joplin, MO. He was from Oklahoma and his name was Ron Lehenbauer. His forge was called Rusty Anvil. So we went together like toast and jam. Rusty Hammer and Rusty Anvil go together pretty well. He was making what he called the Ugly Old MO Red Mule out of horseshoes.

First, straighten out and cut down to the 1st hole of the horseshoe.

Heat it up and open a little then spread out to look like mule's ears. Use cross peen

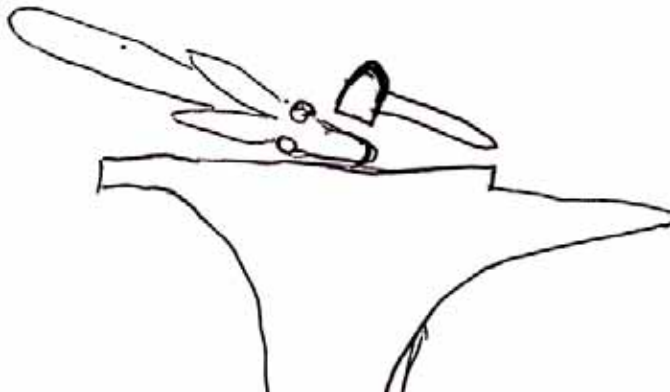


or make a tool to mark the ears. Heat up again and punch the eyes with eye punch tool. Use a fairly large one and go deep then center punch eyes.

Now heat up and go to the vice with ears down and put eyes about 3/4 inch in vice and bend back. Now to anvil and hammer together.



Heat up and taper nose a little and don't worry if you hit the eyes a little.



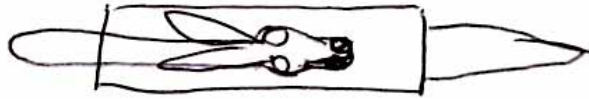
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Needed! Plans for Holiday Items That You Can Make!

Needed For The Next Issue, Surely You Have a Plan to Share!

A Holiday Gift That You Can Make Continued *by Don Nichols*

Heat up again and punch nostrils deep using a punch something like this.



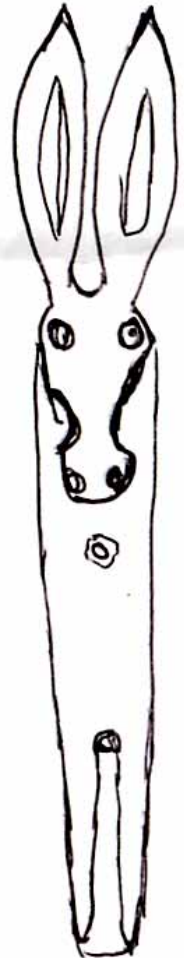
Heat up again and fuller between eyes and nose to look like this.



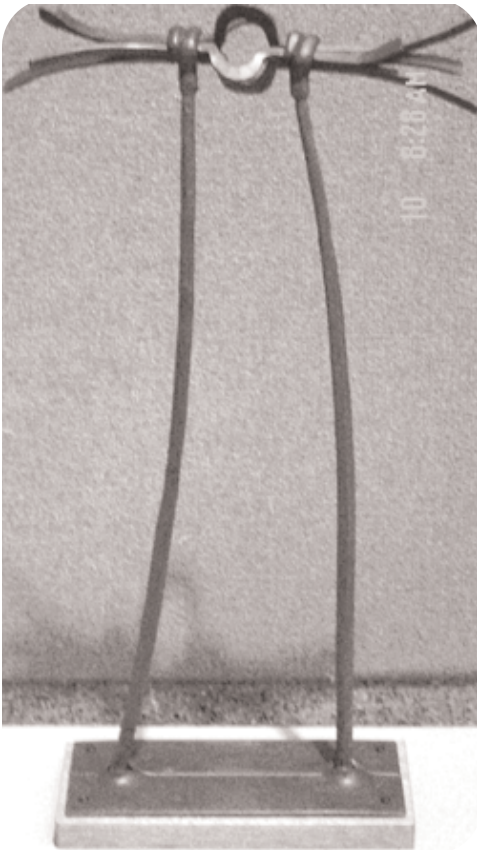
Now heat backside so you can bend head over toward the front like this.



Draw out the other end for a coat hook and then punch or drill for a screw. Bend the ears one forward and one back or however you want it to look.



Don't worry if he's not perfect. Have you ever seen a perfect MO mule?
Thanks to Ron Lehenbaur , Rusty Anvil Forge, Saltfork Craftsman Association of Oklahoma.



ABANA Gallery Entries by BAM Members

Left: Doug Hendrickson Center: Walt Hull Right: Steve Yusko

Last issue of the BAM Newsletter did not give the names of the artists for these entries.

COAL FOR YOUR FORGE



1. Bob Alexander, DeSoto, MO (636)586-6938
14009 Hardin Road, 63020-5586
2. Ken Jansen, Moscow Mills, MO (636) 366-4353
2257 Carter Road, 63362
3. Doug Clemons, Malta Bend, MO (660) 595-2257
RR 1, Box 124, 65339-9801
4. Jerry Rehagen, Rich Fountain, MO (573) 744-5454
Rt. 1 Box 97, Freeburg, MO 65035-9714
5. Doug Hendrickson, Lesterville, MO (573) 637-2576
Rt. 1, Box 16D, 6365
6. Jeff Willard, Willard, MO (417) 742-4569
P.O. Box 416, 65781
7. James Rumbo, Oak Grove, MO (816) 625-8675
P.O. Box 215, 64075-0215
7223 Hardsaw

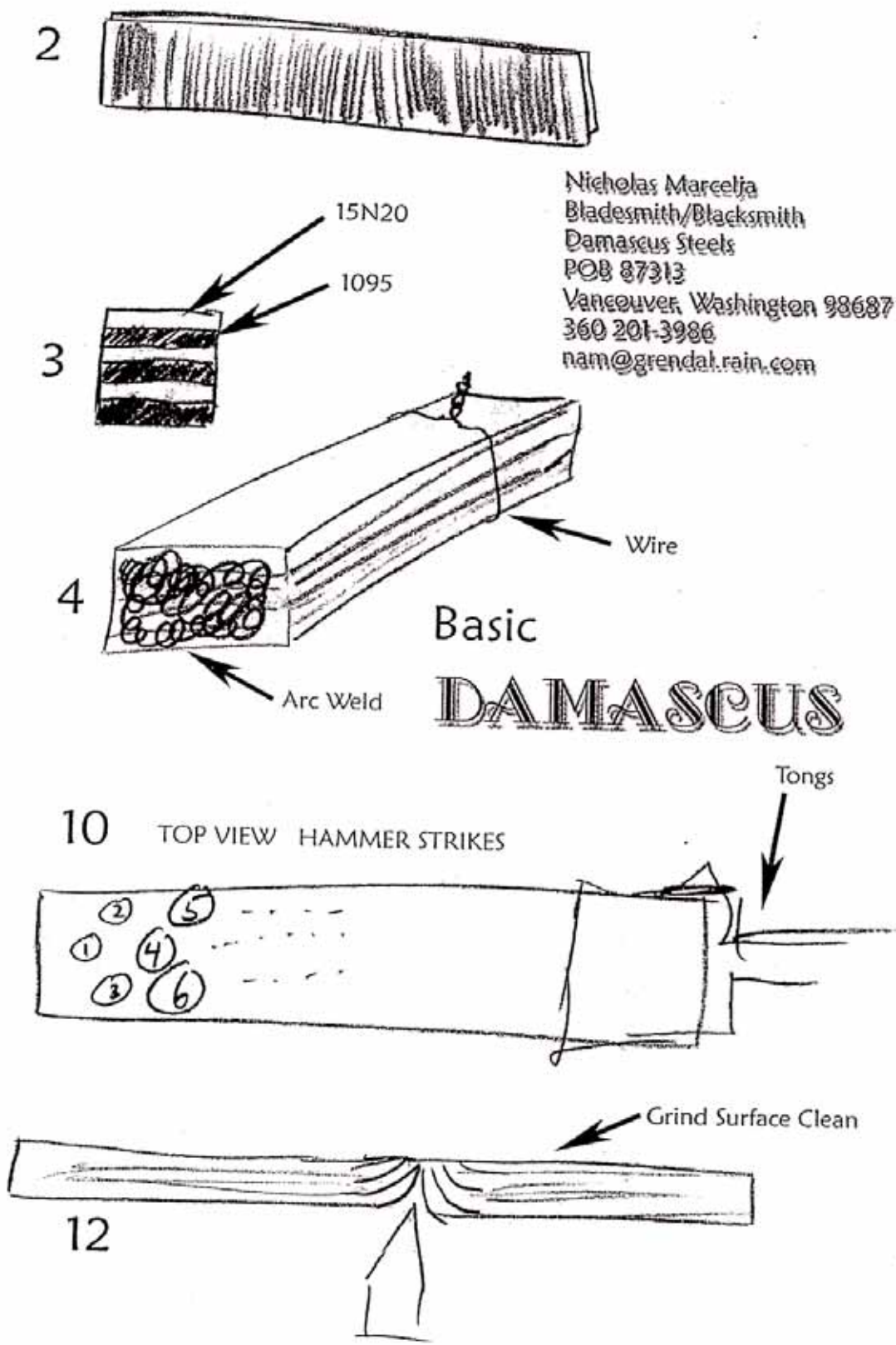
Ed Note: Pages 16 & 17 have been reproduced from "The Hot Iron Sparkle", Vol 21 No. 3, May/Jun, 2004 and credit therein was given to The Northwest Blacksmith Association & Nicholas Marcelja; and noted as reproduced from "The Iron Trillium", Sep-Oct issue, 2003.



1. Use L6 or 15N20 for the lighter colored layers, 1095 for the black layers.
2. Grind ALL of the mill scale off of the materials. Grind line should go across the bar stock, not lengthwise.
3. Stack the two types of steel in alternating layers. Clamp this stack together.
4. Use a welder to weld one end of the billet solidly together.
5. Wire the other end of the billet securely. This allows the layers to shift while heating.
6. Place the billet in the forge.
7. When the billet has gotten to a low red color, flux the billet. Put an even coat of flux over the entire billet.
8. You want to coat even the parts of the billet that have not come to full temperature. This ensures that oxides will not form in-between the layers.
9. Continue to heat until the billet comes to about the same color as the forge. Use a thin steel/iron rod to test the billet to determine if it is at welding temperature. When the rod begins to stick to the billet it is ready for welding. Test the billet in several places to ensure even temp.
10. Remove the billet from the forge and strike solidly. Start at one end of the billet in the center. Then strike towards the edges. Move along the bar until the entire billet is sealed. Brush the edges to look for any delaminating. The layers will cool at different rates if delaminated. So look for dark areas. If found then flux and weld.
11. Draw out the billet to about ½ inch thick and about 1 inch wide. Make sure it is even thickness and width throughout.
12. Prepare to fold by notching the billet in the center with a hot cut. Cut about ¾ of the way thru the billet. Flatten the enter billet
13. Allow the billet to cool. Grind the surfaces that will be joined clean of all scale.
14. Heat billet in forge. Make sure that the center thin hinge area is in the hot part of the forge. As soon as the billet shows red color flux. This will help prevent oxides from forming.
15. When the center hinge is yellow hot, fold the billet onto itself. Flux some more.
16. Use the touch rod to determine when the billet is at welding temperature.
17. Go thru steps 10-16 until the desired number of layers is achieved. Remember each fold doubles the number of layers.
18. Forge out to desired size for making whatever.

Continued on next page

Ed Note: Pages 16 & 17 have been reproduced from "The Hot Iron Sparkle", Vol 21 No. 3, May/Jun, 2004 and credit therein was given to The Northwest Blacksmith Association & Nicholas Marcelja; and noted as reproduced from "The Iron Trillium", Sep/Oct issue, 2003.



Nicholas Marcelja
Bladesmith/Blacksmith
Damascus Steels
POB 87313
Vancouver, Washington 98687
360 201-3986
nam@grendal.rain.com

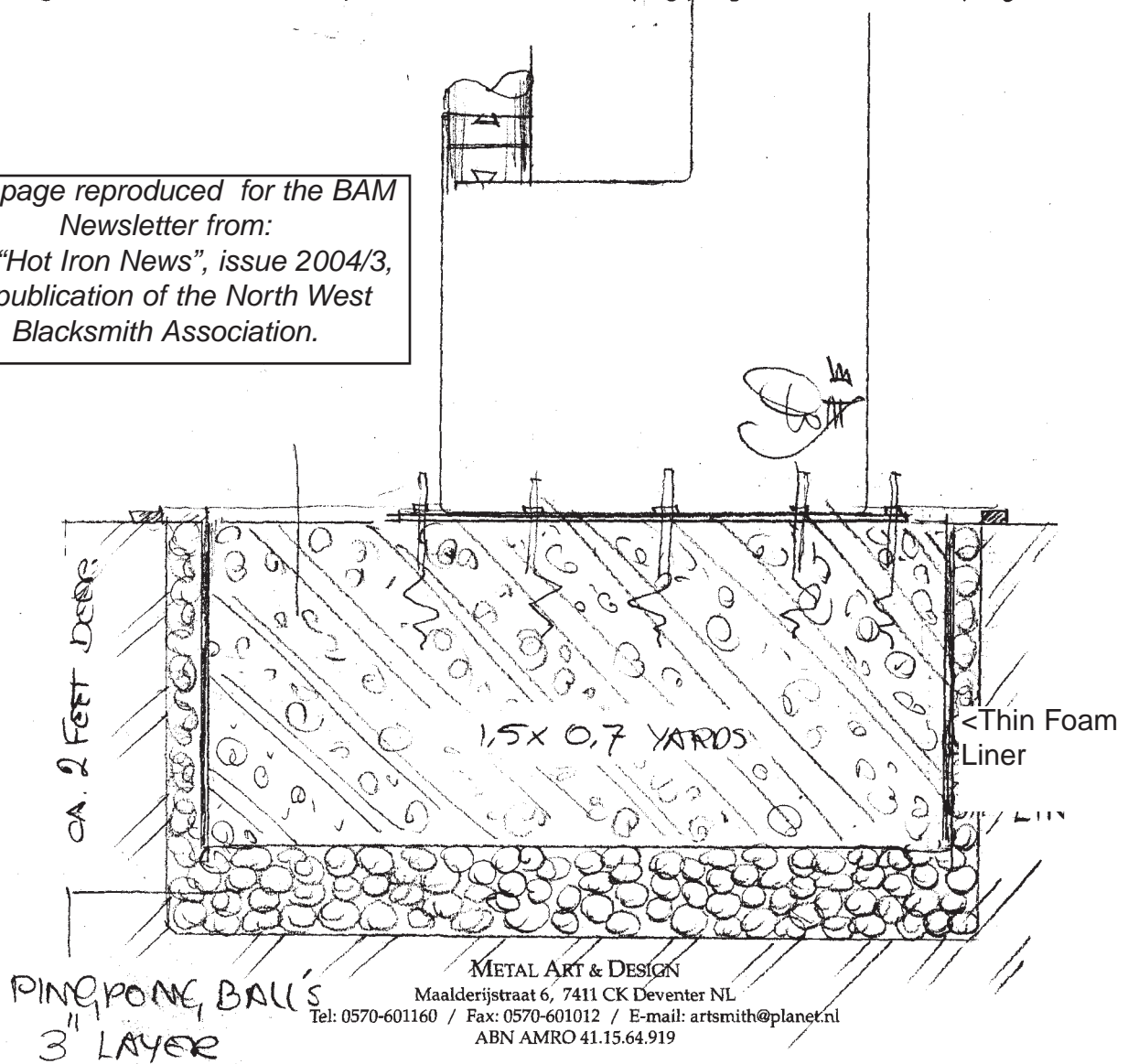
Pounding on Ping Pong Balls!!!

WILLEM JONKERS III

Vormgeving in metaal

Just when you think you've heard it all, comes now the blacksmith for the Dutch Royal Family, and probably one of the top five smiths in the world, and claims that ping pong balls are the perfect base for air hammers up to 100 pounds! Willem believes that the concrete pad should be poured on a three inch bottom layer of ping pong balls and side walls also containing ping pong balls, held in place by thin foam. The bottom layer of balls is simply covered with a plastic sheet. The resulting air pocket will reduce ground vibration. Now, a quick internet check shows ping pong balls are about \$60 per gross:

This page reproduced for the BAM Newsletter from: the "Hot Iron News", issue 2004/3, a publication of the North West Blacksmith Association.



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The Big BLU Hammer Manufacturing Facility

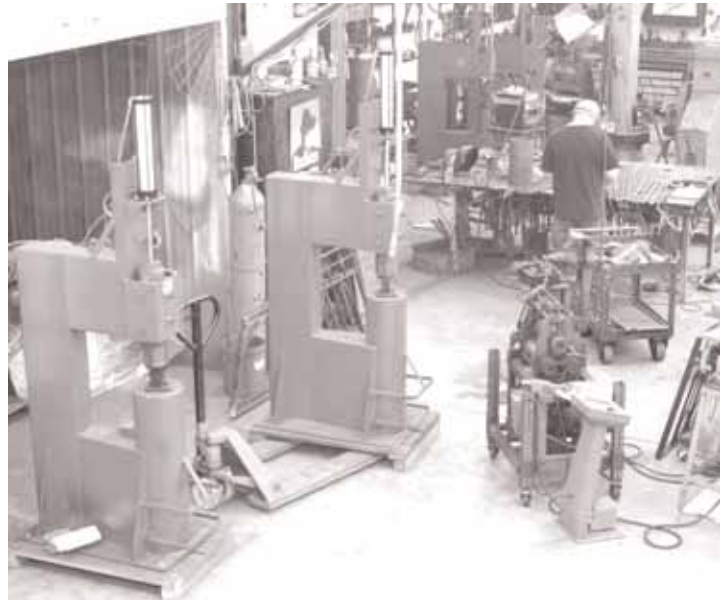
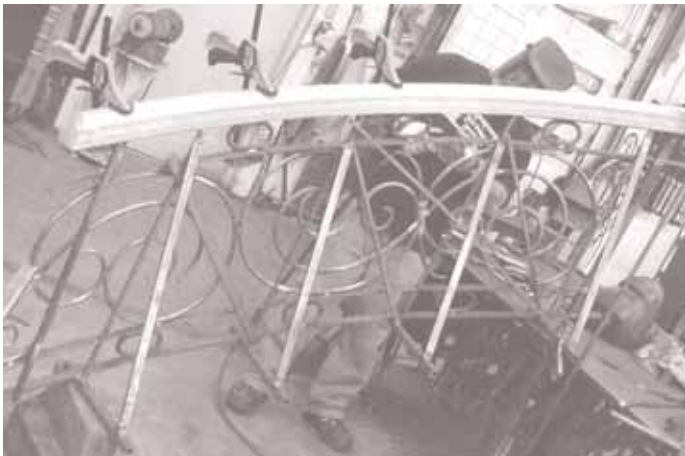
Test Station



In the last issue, I wrote about while attending the ABANA conference, I was able to wrangle an invitation to visit the Big BLU manufacturing facility. located in Morganton, NC. This is a busy place, but two things sort of greased the tracks for the visit and red carpet treatment. Being the editor of the newsletter offers some credibility and second, I grew up not far from this facility and still have relatives nearby. Dean Curfman, his Son-in Law, Josh, and Zevik Gottieb were superb hosts for the visit. *Ned Digh*

Assembly Line

Custom Work



A Shop Tip

I keep my Borax for forge welding in a small shampoo bottle. That way it doesn't draw moisture and when I'm prepping a weld I just pop the top up aim and squeeze. If the borax is good and dry it flows like water right where I want it. It's quicker and easier than messing with a flux spoon and can of borax. I've been using the same bottle for 4 years and haven't melted the end yet, so if your even a little bit careful the plastic bottle is no problem.

Robert Ehrenberger

John Huff - A Sawed Cross



Holiday Item

Reproduced from: Nov-Dec2004 issue of "The Upsetter", a publication of the Michigan Artist Blacksmith's Association

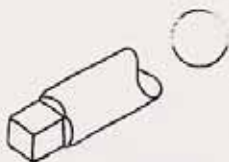
As the holiday season approaches, here are a couple of items you might find fun to make at the forge. Both would be good beginner projects.

Iron Candy Canes

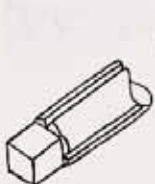
Created by: Steve Anderson



- 1) Start with 1/2" diameter round stock. I use a piece about 2 feet long to avoid using tongs.



- 2) Heat the end and square up about 1/2" of the stock for holding in vice.



- 3) At a yellow heat, groove 3 lines for 11 inches, using a chisel while placing the stock in a half round hardy or swage block. Repeated heats will be needed. You will only get a few inches at a time. (You can also use a spring groover on a power hammer by making two passes.)

- 4) Place the square end in a vice and use channel locks or vice grips to make a slow twist in grooved portion. Quench if necessary to keep the twist even.



- 5) At a yellow heat cut twisted portion off on hardy while rolling piece to center. This keeps the stock round and looks more like an actual candy cane. Dress and round over ends to remove any sharp edges.

- 6) At a yellow heat use a wooden mallet to bend shape over horn.



- 7) Clean up the candy cane with a wire brush or on a wire wheel. Apply a wax or other finish.

*If you want to get creative, add a ribbon made from flattened 1/4" x 1/4" angle iron.

(editor's note: When I tried the candy cane for the article I flattened both ends and grooved the entire length. Because the stock was hot I used a 1/2" bolt tongs to position stock in vise. I twisted both halves and made two 11" candy canes from the 24" piece of stock. The grooving took me a little time, this first pair of candy canes were finished in an hour and a half. Steve Anderson said he can make one in about 15 minutes. They were fun to make!)

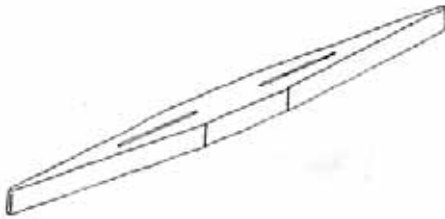
Holiday Item

Reproduced from: Nov-Dec 2004 issue of "The Upsetter", a publication of the Michigan Artist Blacksmith's Association

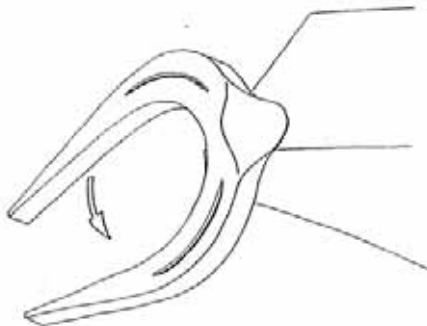
Reindeer Shoe tree ornament

Created by: Steve Anderson

- 1) Start with 1/4" x 1/2" flat bar stock 4-1/2" long.
- 2) Taper from both ends to center to obtain a total length of 7". Be sure to maintain the 1/4" thickness.



- 3) Chisel a 1-1/4" nail groove 1/2" off both sides of center as shown.
- 4) Bend to a pleasing horse (reindeer) shoe shape.



- 5) Forge a toe clip on corner of anvil heel.

- 6) Use small scroll tongs to shape heel ends as creative as you like.



- 7) Use fish line and a paper clip to make a hanger.
*Use a brass brush for Rudolph's shoes (they were always made of gold).



(editor's note: for me, these 3 shoes took 2 hours to finish. While Steve Anderson has them down to 15 minutes each.)

Emil Badovinac's Wood Stove Lid No -Welding-Needed Forge



Written up by: Steven Sporre

This article started as a conversation with Emil at Black Iron Days, Emil then sent me several sketches to work with. This forge can be easily broken down for transportation and was put together with scrap iron and a few tools. The following materials were at hand. Use these plans as a general guide.

Start with a 10" dia., cast iron, wood stove lid. Remove a 9" dia. area of the bottom ribs by grinding them off. The object is to create a flat area for the 2" flange to attach to and seat tight over the hole in the forge plate.

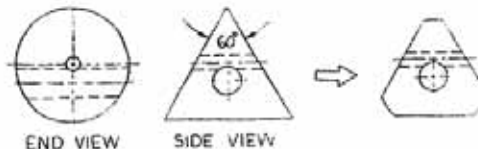
Next put a 1 3/4" dia. hole through the center of the lid using a drill and small grinder. Center the 2" flange over the hole, mark the mounting hole locations, then drill the mounting holes through the lid.

Cut a 9" dia. hole in the center of a 2'x 4' plate (1/8" thick in this instance) with a chisel. Use a round file to smooth and finish the edge. Save the cut-out to use later.

Notch the pipe legs so they sit flush with the angle iron, top and side, edges. (See figure 1) Drill and file a square hole to accept a carriage bolt. Another option is to bolt or rivet a cleat at each corner. Drill and tap a hole in the center of the cleat's face for a set screw. Using channel steel for the legs, the forge

will easily break down, be adjustable to any height and be stable on uneven ground. (See figure 2) Lower leg supports can be made from two, 5' long pieces of threaded rod attached diagonally between the legs.

To make the clinker breaker, cut a 60 degree wedge from a 2" dia. rod. Drill a slightly over-sized

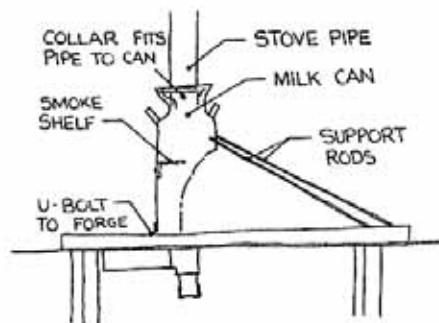


hole through the center to accept the handle rod. Then grind the corners down so it will spin freely inside the 2" pipe nipple. With the clinker breaker and rod assembled, drill a hole through them both so they can be keyed together later with a hollow or roll pin.

Tightly screw the 2"x2" nipple into the flange and drill a hole into the flange collar as close to the flange base as possible. Make the hole large enough to let the clinker breaker rod spin easily. Assemble the clinker breaker into the flange assembly and pin together. Put the rest of the pipe fittings together per the exploded view.

The clean-out gate can be made out of the 9" cut-out left over from the 2'x 4' plate. Cut out a rectangle wide enough to loosely fit between the angle brackets, mounted onto the 2"x3" nipple. Make it long enough for the open and closed positions, a turned up edge and the mounting of the handle rod.

Bolt the tuyère assembly to the stove lid, through the 9" hole in the forge plate. Attach the rods to the forge with "U" or "J" bolts and make a hanger to support the blower pipe.



Bolt on a hood option from Emil.

Continued from the previous page

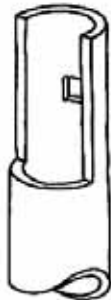


FIGURE 1

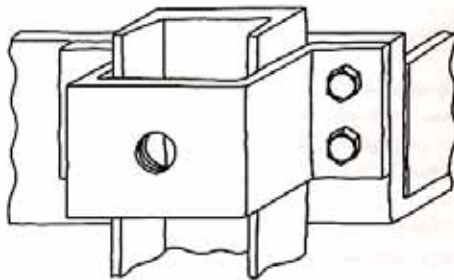
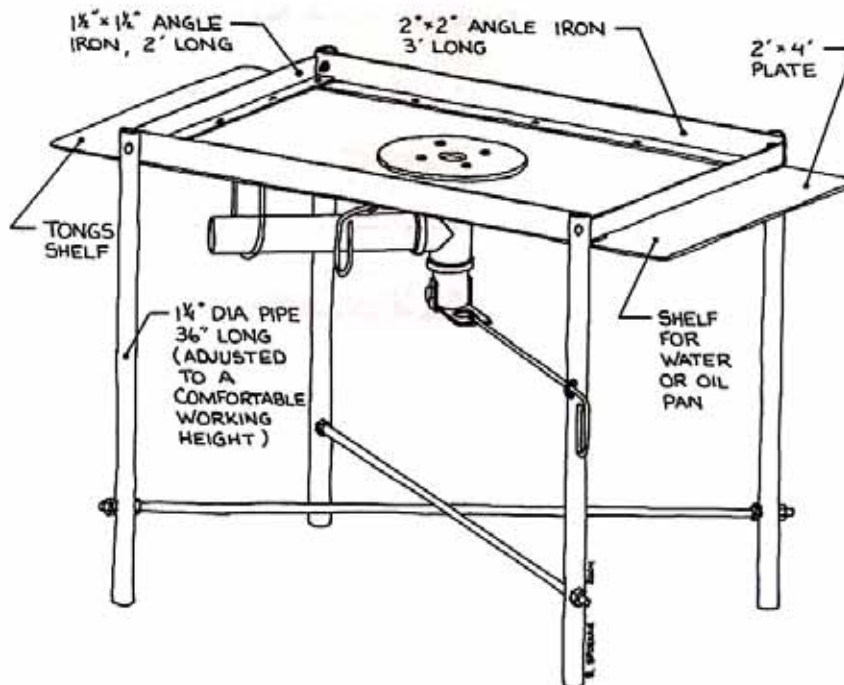
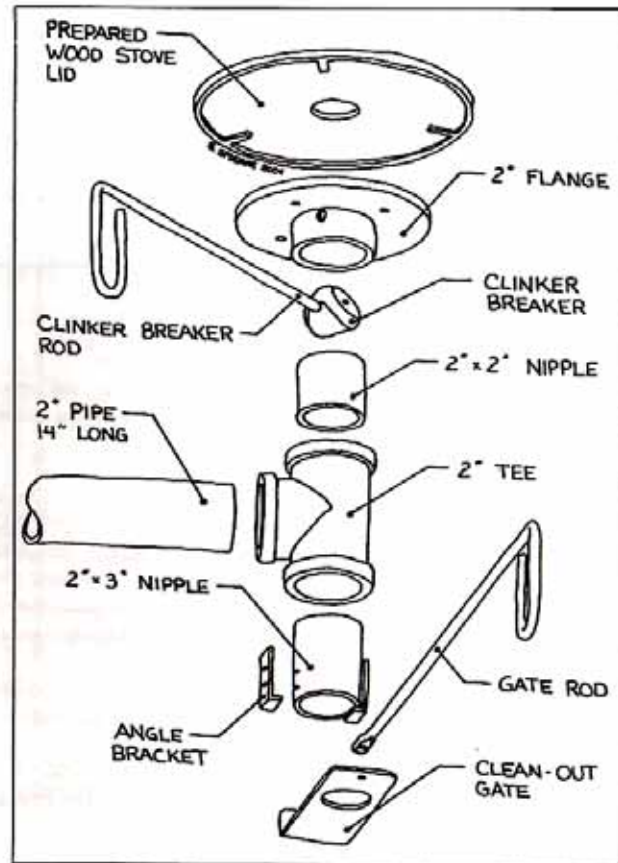


FIGURE 2



Shop Tip *from Don Gramond*



Freshly relined forge by Don. This forge has a 1 / 4 inch stainless steel fire pot with a sliding grate. This allows you to check the fire from the bottom.

COALFORGE LINER

If your forge is the free standing type its life can be greatly increased by placing a lining in it. This will protect it against repeated heat-cool cycles which can crack cast iron and the corrosive effects of damp coal that will rust away sheet metal.

Clay mud as taken from the earth does not hold up long and castable refractory is a bit of overkill.

What works well is "FAST SET FENCE POST CEMENT." It is brown in color and is a clay cement mix. (Not to be confused with gray mortar or concrete mix that may explode when heated.)

The stuff I used is made by Build Crete. It cost \$6.00 for a 60 pound sack at the farm store. It's made for setting fence post and mail boxes, by dumping the contents of 1 bag around the post dry, then adding water to it.

Clean loose rust and scale from the forge pan and tape up the twerye or grate. Mix contents of bag with enough water to make a thick mud. Dump this into the forge pan and rapidly shape, about 1 inch thick in the bottom and taper up the sides. If the forge has a fire pot do not coat it.

If you have a flat bottom forge the clay can be used to form a "ducks nest" around the grate.

Don't get carried away with creative sculpture work here because the clay will start to set within 10 to 15 minutes.

Let air dry a day or two before building a fire in it.

One 60 pound bag will do one 24" x 36" forge with a fire pot or two of the 20" round rivet type forges.

THE RUSTY RECLUSE

BAM Shirts

B.A.M. is taking orders to buy blue denim work shirts. They are long sleeved, two pocket, 100% cotton and will have the B.A.M. logo monogrammed over the left pocket in red.

Sizes are medium to 6-X Large and X-Large Tall to 6-X Large Tall.

All sizes are \$25 each.

We will take orders until the November 20th meeting. Shirts will have to be picked up at later meetings, they will not be shipped.

Order at the next meeting or use the form below and mail checks to:

**Bruce Herzog
2212 Aileswick Dr.
St. Louis, MO 63129-3604**

Call Fred Weisenborn evenings with any questions @ (417) 589-2497.

Name (Print):		
Sizes:	/	/
Amount Enclosed (\$25/Shirt): \$		

Shop Tip *from Dave Edwards*

Because I color code tools for quick identification and so they can be returned to their proper places, I keep many different colors of spray paint cans available, but usually lose their identifying colored caps. Without those caps they all look alike. I found I could save time looking for the right color if I painted the cans the same color as the contents. I buy the cans two or more at a time so I can use one can to spray the other and vice versa.



We can do repairs on any or all components of your Little Giant front assembly. Call for details. Call or write for new parts list

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Demonstrator List Forming

Fred Wisenborn has started a list of members available for demonstrations: fairs, historic events, and festivals, etc. Contact Fred to get on the list: 417-589-2497 email jweisenb@llion.org

For Sale: Custom-built air hammers. 6# table-top model #1400; 25# table-top model (redesigned 20# air hammer) \$2000; 20# floor model \$2300; 40# floor model \$2800. Some modifications to the basic hammers can be made to your specifications. Contact: Maurice L. Ellis 12486 Sutton Road, Belgrade, MO 63622-9197 Phone: 573-766-5346 E-Mail bellis@misn.com

Wanted by the Editor of the BAM Newsletter

The next issue will feature holiday items that you can make. Our response last year from a few members was good, but we need more for this year. Send plans or photographs. **Several members have promises to fulfill from last year!**

Treadle Hammer - Complete or Plans, and Beverly Shear Sharpening

Inline (rollerblade) treadle hammer for sale. \$1200, loaded at my shop in Murphy. Treadle hammer plans: \$9.00, includes postage. Beverly shear blades sharpened, \$35 plus shipping, bring the shear to the Folk School or ship the blades to me. Clay Spencer, 934 Partridge Ln, Murphy, NC 28906

New email/website for Tom Clark and the Blacksmith School

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Floral Study by Chad Gunter

You can view samples of my work here:
<http://www.metalsmiths.org/news/page4.htm>

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See photos from the manufacturing facility of the Big BLU hammers on page 20.

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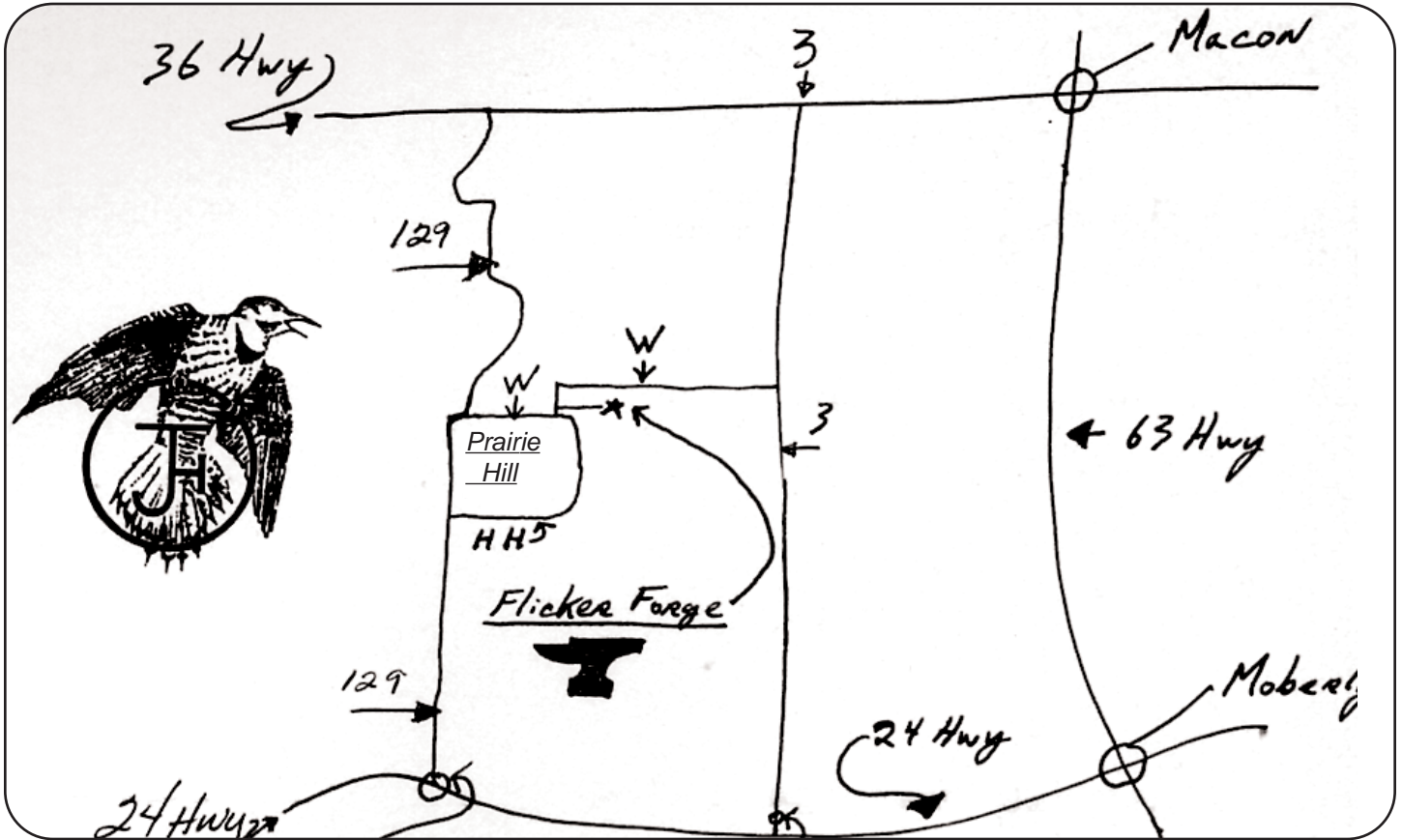
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Next Meeting: November 20th at Salisbury, MO (Prairie Hill)



**14TH ANNUAL OZARK BAM CONFERENCE
AT WARRENTON, MISSOURI
APRIL 29, 30, AND MAY 1ST, 2005**

Demonstrators
Blacksmiths: Bill Epps and Alice James
Knifemaker: Joe Szilaski
Family Programs
Scrimshaw: Ron Newton & Gourd Art: Kathy Nichols
 Volunteers Needed to Assist with Setup/Teardown
 (free registration and Sat evening meal)

David Smith 573-659-5601 dissmith@fidnet.com
 Bob Stormer 636-441-6807 bobstormer@sbcglobal.net
 Pat McCarty 636-239-3814 budden51@netscape.net
 Larry Hults 636-629-7411 whiskers@yhti.net

2005 Meetings
 June 5th Booneville, MO
 Host: Dale Gilman
 July Bass Pro (Maybe)
 September Shelbyville, MO
 Hosts: Bob & Jan Ehrenberger
 November Open - (Contact Kirk Sullens if interested)

**NOTE - Below
DATE CORRECTION
ON MEETING AT MAURICE
& BESS'S SHOP**

November 20th Meeting
**Host: Japheth Howard
and Alice James**
**Salisbury, MO
(Prairie Hill)**
Trade Item: Candle Holder
 Lunch: Brown-Bag
Lunch Provided !

January 22nd, 2005
**Hosts: Don Nichols
and Ken Harbit**
**State Fair A community
college College**
Sedalia, MO
Trade Item: Ice Cream Scoop
Lunch Details: TBA

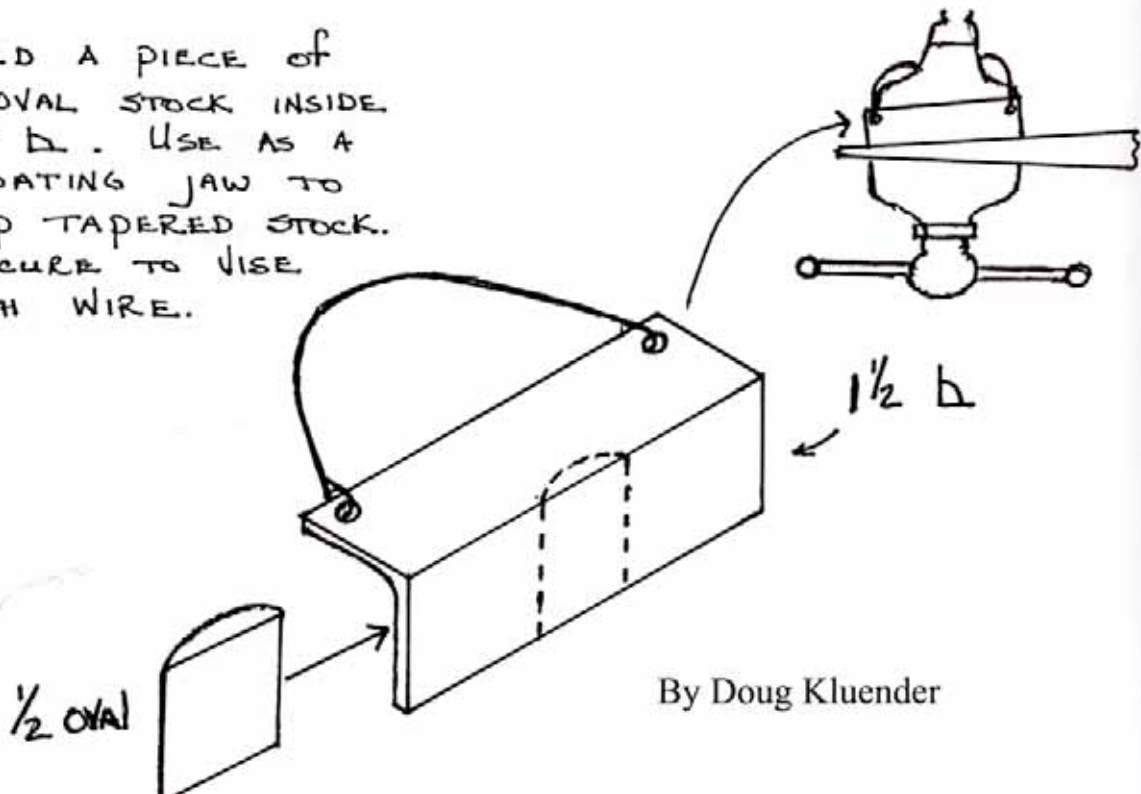
March 19th, 2005
**Hosts: Maurice
and Bess Ellis**
Belgrade, MO
**Trade Item: Any Kitchen
Utensil**
Lunch Provided!

Shop Tip

Reproduced from "The Anvil's Horn", Issue 107, May 2004, a publication of the Arizona Blacksmith Association

Vise Tool for Tapered Stock

WELD A PIECE OF
 $\frac{1}{2}$ OVAL STOCK INSIDE
 $1\frac{1}{2}$ " D. USE AS A
FLOATING JAW TO
GRIP TAPERED STOCK.
SECURE TO VISE
WITH WIRE.



BAM

2212 Aileswick Drive
St. Louis, MO 63129

Send address changes to Bruce Herzog, 2212 Aileswick Dr. St. Louis, MO 63129 or bjherzog@msn.com