

BAM

May-June 2005



Joe Szilaski instructing Matt Bruton

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Contents

Editorial

5 From the Editor

Boonsborro

6 Minutes from 6/4/05 meeting

What's His Name

7 President Don Nichols

LIFERS

9 BAM lifetime members

Knife Demos

10 Joe Szilaski at conference

Heron Demo

14 Alice James at conference

Ladle Demo

16 Jr. Strasil aka irnsrgn

Knife Makers

18 Hammer-in at Corbin Newcomb's

ABANA

20 ABANA president Don Kemper

Reviews

21 Video, Book, Magazine

Ham's Prairie

22 Schedule of activities for July 30th get together

Classified Ads

24 Ads -Personal / Business

COAL

26 BAM coal storage locations

Scheduling

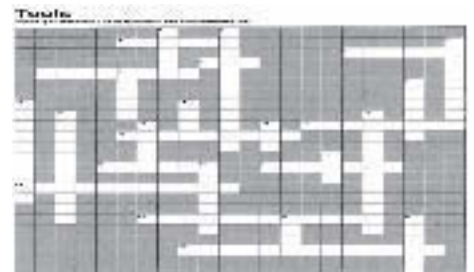
27 Upcoming Events



Joe Szilaski



Alice James' Heron



Puzzle on pg 23

**Newsletter of the
Blacksmiths
Association
of Missouri**

*Volume 22 No. 3
May-June
2005*

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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: Bob Ehrenberger 6192 Hwy 168 Shelbyville, Mo 63469 or email to bameditor@centurytel.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.

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How did you learn about BAM? _____

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The Blacksmiths' Association of Missouri is an affiliate 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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From the Editor

By Bob Ehrenberger

The conference is behind us and from all I could tell it was another good one. There was the usual cool weather but it wasn't as wet this year. Even with the tailgaters in a new location there was plenty of good stuff for sale. I even saw a tire shrinker in someone's truck, those are pretty rare.

The demonstrators were all excellent. I'll have a detailed report on the Alice James demo and Bob Stormer has provided a report on Joe Szilaski. No one has come forward with a report on Bill Epps, maybe we can look forward to that in a future issue.

The forging contest Friday night was great fun, and the master/striker category added a new twist. When all was said and done the difference between the winners and losers took a careful measurement. Here are the winners:

Individual

- 1st Tom Clark
- 2nd Mike Lanham
- 3rd Jon McCarty

2 Member Teams

- 1st Tom Clark & Pat McCarty
- 2nd Trace Price & Charles Comstock
- 3rd Mike Lanham & Daniel Ehrenberger

Now how many of you even knew there was a third McCarty brother? And he can swing a hammer too.

The annual business meeting was short and sweet since most were eager to get on to the auction. Of note all the previous officers were reelected except for John Murray who elected not to

run and was replaced as secretary by Peggy Williamson. John has been secretary for as long as I can remember, thanks for your many years of service. The other major event at the business meeting was the announcement of three new life members, Doug Hendrickson, Tom Clark, and Pat McCarty. All have served BAM well and richly deserve this honor. There is a short bio on each later in the news-



letter, and I plan on taking an in-depth look at each in future issues.

Tim Ryan did another excellent job with the auction. He really knows how to make it fun and get people to gladly part with their money. Thanks to all who donated to the auction and participated in the bidding, you made it a big success.

We also had a couple of pretty good beginners' classes. Don Birdsall and I taught a basic forging class. Ken Markley and Daniel Ehrenberger taught a bladesmithing class. Both classes were well attended, and I think

every one learned something and had a good time. Remember, when it loses it's color, put it back in the forge.

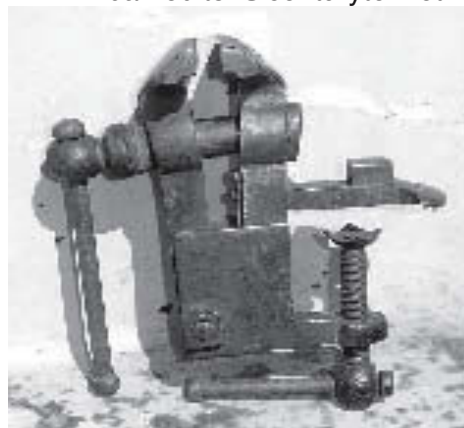
New Publishing Software

If you are reading this I must have successfully transitioned to the new publishing software since I am using it now. I was able to import the previous newsletter into InDesign and it did about a 90% automatic conversion. It is very similar to the old program so the learning curve isn't too bad. Thankfully the undo feature works so I can back out mistakes and try again.

June meeting.

I have started the main part of my year and had to attend a Civil War reenactment the weekend of the June meeting. From Don's report it sounds like it was a fine event. We have cut our show schedule back from 26 weekends to only 17 so I think that this is the only meeting I'll miss this year. If someone would like to submit a report on the demonstration, I'm sure that the members that missed it (myself included) would appreciate it.

My new E-Mail addresses:
eforge@centurytel.net
bameditor@centurytel.net



Minutes BAM meeting 6/4/05

By Peggy Williamson

Thanks to host Dale Gilman

A new member was introduced, Brian Lami.

Bruce Herzog gave a financial report.

Bruce gave a membership report, we currently have 596 members.

Dues will be raised to \$25 January of 2006.

Peggy Williamson gave a State Fair report. While we have someone signed up for every day there are several days where we need additional demonstrators. Contact Peggy if you want to help. The dates of the fair are August 11-21.

Don Nichols gave a MTS report. We will not have a class unless there are at least 6 students signed up.

Fred Weisenborn is putting together a list of demonstrators. Contact Fred if you want to be added to the list.

Don Nichols said that we need a number two man (first assistant) on the conference committee. Larry Hults was the assistant this year and has become the chairman for next year. If you are interested in being on the conference committee contact Larry.

Bruce Herzog announced that he intends on retiring as treasurer next June (2006). We still need to get a replacement for Bruce in time to train him for the job.

Bruce requested compensation be allocated for the job of treasurer. It was agreed to pay him \$100/month for his time and the use of his computer.

The last shipment of coal was \$1000 more than before. Also with the high price of gas the coal keepers are losing money making coal available around the state. It was agreed to raise the price of coal by \$2 to \$10/bag with one dollar going to BAM and one to the coal keepers. Making it \$2 that they get to keep for each bag that they transport and sell.

Don Nichols said that Fred Weisenborn has a source to purchase brass anvil hat pins. It is proposed that we purchase the pins and sell them to the membership, like the BAM hats and shirts.

There was some discussion on doing another BAM anvil purchase. There was a lot of interest but no one stepped up to organize it. Any volunteers??

The next meeting is at Ned and Esther Digh's, the trade item will be a bell.

Meeting adjourned.

A Word From Old What's His Name

By Don Nichols

We just got back from Dale Gilman's meeting. My wife and I went to the camp out on Friday night and enjoyed our evening with the Gilmans and a few other Bammers. We had fun making and eating tin foil dinners and enjoying the peacefulness of the country. We watched a VCR tape on Williamsburg as part of the evening's entertainment. The blacksmith was making a musket and it really was very interesting.

What made the evening interesting too was the name John. If anyone asked John to do something, most of the men answered. Out of the five men, three were named John. One was Dale and the other didn't know what his name was. But of the three named John two were John Dale. We had John Dale Bouchillon and wife Lana, John Dale Huff and his wife Connie, and third John Oilman middle name not given. His dad's name was Dale Oilman and his mother Pat.

Pat entertained the ladies with a dragon making session on Sat. that was fun. She used yellow pages and masking tape and helped them create playful dragons. Thanks again to Dale, Pat, and son John, from Oregon, for a wonderful BAM meeting.

On Saturday, we had a little rain early and then it cleared up and we had a nice day. Ken Jansen did a superb demo on flowers. We had some visitors who went away excited about blacksmithing after watching Ken.

I'm sure Peggy, our new secretary, will have information about the price of coal in her minutes. Our last load cost about \$1,000 more. With gas prices going up, we voted to give our coal keepers a little more to help pay for their expenses. Coal will now be \$10.00 a bag.

Also, we voted to give our treasurer \$100 a month for use of his computer and I believe he deserves it. Thanks Bruce for all you do!

Remember the July 30th meeting at Ned Digh's. The trade item will be a bell.

Also remember the Sept. meeting at Bob E's. We are going to have a chuck wagon meal. This man does a great meal over an open fire, so come and enjoy something different. The meal charge will be \$8.00.

It was mentioned in the last newsletter, to help our new members by inviting them over to our shops. If we could open our shops on the off months from our meetings, and help them learn some of the basic techniques of blacksmithing. Now August is our first month off, but we have the MO State Fair. The fair is a good place to come and learn. There is always someone there to help new members. The next issue would be the Sept. issue. Turn your date in when you might be able to have a Hammer In, at your shop, for beginners to come in Oct. I'll try and have my date in the Sept. issue, how about you? We could have several spread out over the state. We could help beginners work on the trade item for the next meeting. Of course new and old members would be welcome. How about it?

Well, I'd better go. Oh, are there any other John Dales out there?

So long, from Old What's His Name.
Don

From The Conference Committee

We would like to thank everyone that attended this year's conference. Everyone helped make this year's conference possible; the demonstrators, vendors, tailgaters, those that prepared the food, auctioneer & helpers, and the list goes on.... We had so much help, that there is no way to list everyone – so **THANK YOU! THANK YOU! THANK YOU!** for your help. We would have been hard pressed on our own.

You have our sincere thanks,
2005 BAM Conference Committee
David Smith (chairman)
Bob Stormer
Pat McCarty
Larry Hults

Mark your calendar!

May 5, 6, & 7, 2006 is the BAM Ozark Conference at the Warren County Fairgrounds.

I need three volunteers to help on the Conference Committee for next year. Hopefully one of those volunteers would like to be the Chairman for 2007.

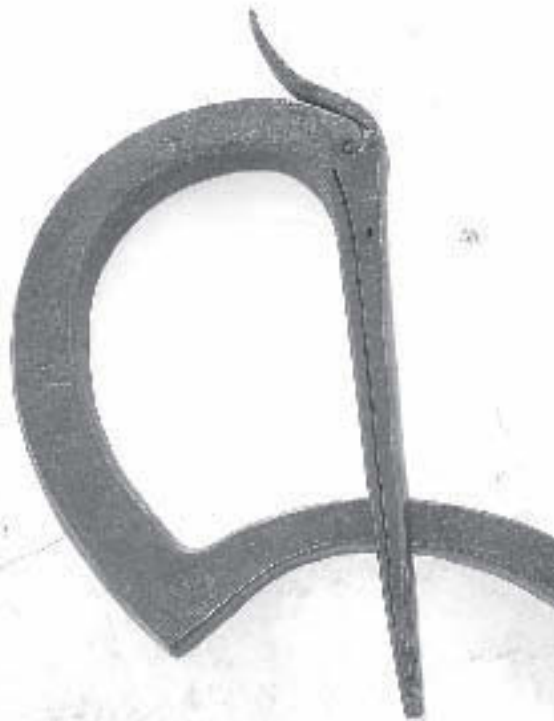
If you have any suggestions or want to volunteer please contact me at my NEW address:

Larry Hults
1515 Sycamore Lane
Saint Clair, MO 63077-2217
636-629-7411 home
314-322-8793 cell
whiskers@yhti.net

Thanks



Bill Epps



Close up of Alice James' Heron

LIFETIME MEMBERSHIPS

(Nomination speech By Don Nichols)

This year I want to nominate these men for Lifetime Memberships in BAM. You know these men and I hope you agree with me that they have played a huge part in the growth and success of BAM. Though they are not founding members, they all joined early in BAM's formation and through the years they have helped it to grow and prosper to where our association and conferences are highly respected by other blacksmith associations in the U.S. Please hold your applause until I have made all the recommendations.

The first man, we want to honor tonight, brought anvils, power hammers, tools and whatever was needed to have a good conference and I feel he hasn't been thanked enough for all he's done. So this is just a big thanks to the man, who as a matter of fact, had the first conference and financed it himself at Potosi in 1992. He believes so much in this craft of blacksmithing that he formed his own school so that others can learn blacksmithing. Tom Clark we want to grant you a Lifetime Membership. Thanks.

The second man has had several names. He was editor from 1986 to 1991. Also, he was a



medicine man and advertised "slag water" in a newsletter to cure poison ivy and was called Dr. Iron. He was also called Lord of the Rings in one of our newsletters and he tears doll heads off and hangs them in his truck. He's helped with our conferences every year since I joined and we especially like your great help with the contests. We will miss you there. Thanks Doug Hendrickson our second Lifetime Membership recipient.

In the beginning, I wanted to be permitted to give two Lifetime Memberships, but I hope you will allow me to do a third one tonight.

This third man, I'm sure, wouldn't want me to say much about all that he's done for BAM because he's not one to be in the limelight. He can always be found helping in the spot where help is needed. He joined in 1988, I believe. He has made beautiful and unique BAM boxes for all the conferences. Pat McCarty we want to honor you too and say a big thanks.

Now can we give a vote of approval to these men and show our appreciation for all that they have done for our conference by standing and giving them a round of applause? Thanks

Editor's Note:
I have since been informed that Doug Hendrickson is one of our founding members.



Joe Szilaski's BAM 2005 Conference Demonstration

By Bob Stormer

Joe Szilaski was invited to demonstrate at the BAM 2005 Conference because of his reputation for making first class tomahawks and because the author had attended a seminar given by Joe at the Atlanta Blade Show. That seminar, and Joe's tomahawk that was featured on the cover of the December 2000 issue of Blade magazine, and duplicated for the movie The Patriot, starring Mel Gibson impressed the author. If post-conference comments are any indication, a lot of others who watched Joe's demonstration confirmed his expertise.

Railroad Spike Hawk Demo

The first part demo was to make a tomahawk using a railroad spike. Joe's method uses the spike head for the tomahawk head. To begin, all edges are ground smooth to help prevent the possibility of stress risers and cold shuts. The first part of the forging is to flatten the spike head as shown in figure 1.

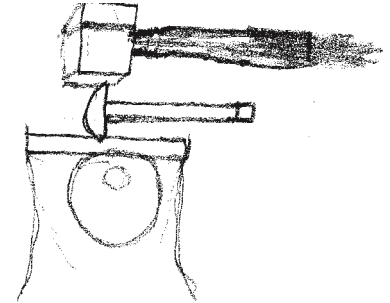


FIGURE 1

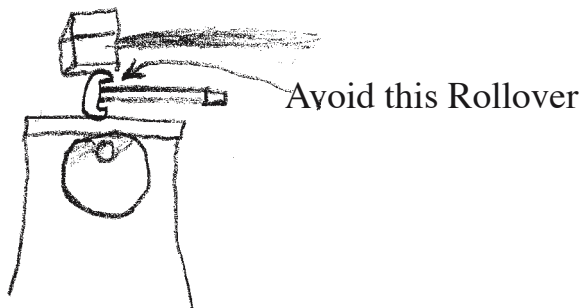


FIGURE 2

It is important to keep turning the spike from side to side to keep the steel centered on the spike shaft. A critical step in forging this part is to avoid rolling the edges over and causing cold shuts as identified in figure 2.

Completing this part of forging should result in the tomahawk as shown in figure 3. As Joe said repeatedly, the shape of the tomahawk head is up to the maker. There are NO RULES for how it should look.

BOTTOM VIEW



SIDE VIEW

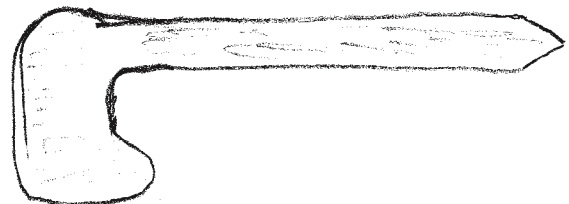


FIGURE 3

The next step was to slit the spike shaft for the eye. The center of the eye was approximately 2 1/2 inches from the head as shown in figure 4. Joe began the slit by punching 2 round holes (approximately 1/8" or 3/16") at the ends of the intended slit. He prepared the chisel by rounding the shoulders so the eye would be rectangular, but with no sharp corners. He then used a chisel to open the slit between the holes. The size and shape of the eye depends on the shape of the haft (handle) that will be used.



FIGURE 4

The last step was to draw/shape the spike end to whatever is desired, possibly as shown in figure 5.

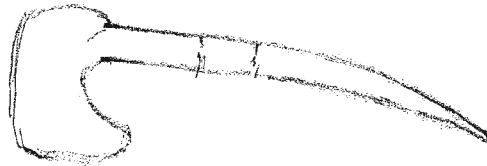


FIGURE 5

MOUSE Hawk Demo

In the second demonstration, Joe made a "mouse" hawk from a piece of 1/2" square stock. He began by reducing the center section of the stock to the shape shown in figure 6.

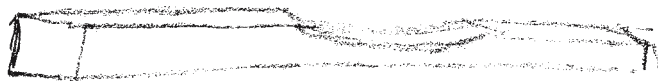


FIGURE 6

The piece was then folded over, as in figure 7, and forge welded.



FIGURE 7

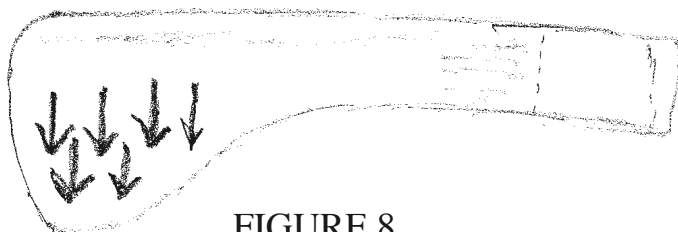


FIGURE 8

The head is then shaped by drawing the tapered end down as in figure 8.

PIPE Hawk Demo

Joe's third demonstration was to make a pipe hawk starting with a piece of hexagonal gun barrel from a defunct muzzleloader. A piece of stock about 5 – 6 inches long is required for a full size pipe hawk. The next step Joe did was to fuller the neck of the pipe bowl about 1" from the end of the stock over the horn of the anvil. See Fig 9.

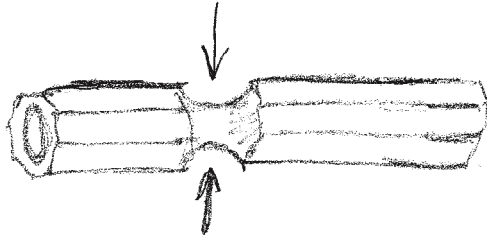


FIGURE 9

TOP VIEW



SIDE VIEW



FIGURE 10

Joe then flattened approximately a 2" section of the barrel to collapse the bore where the eye would be slit for the haft. See Fig 10.

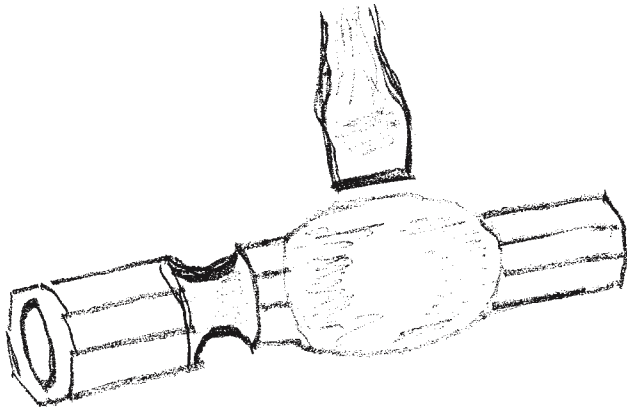


FIGURE 11

A chisel was used to slit the eye lengthwise through the long dimension of the flattened section. See Fig 11.

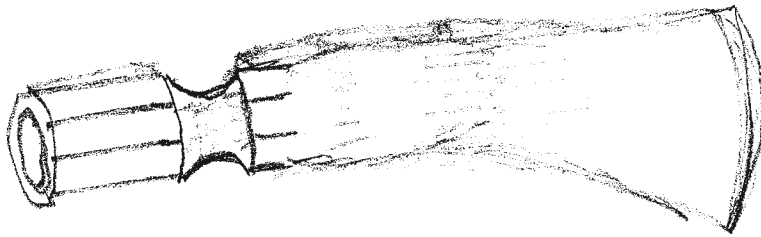


FIGURE 12

The next step would normally be slit the end of the barrel back a few inches and forge weld a piece of high carbon steel in to provide a good, hardenable cutting edge. Gun barrel stock is normally mild steel. Since we were running short on time, Joe collapsed the barrel and forge welded the bore closed. He then drew the head out to the shape shown in figure 12.

The Audience makes Railroad Spike Hawks

The last portion of Saturday's demonstration was to invite the audience to make a railroad spike tomahawk. A number of onlookers took up the challenge and went home with some very nice looking tomahawk heads. However, the hit of Saturday's demonstration was when Joe helped 8-year-old Matt Bruton make his first knife. 1095 flat stock (1 1/2" x 1/4") was used for this task. Joe was very impressed with Matt's enthusiasm and striking ability. The resulting knife was a small hunter with the tang drawn out to a rat-tail and bent around to shape the handle. Joe did some initial grinding, with the limited equipment that was available, and provided Matt's dad, Bob, with instructions for finish grinding and heat-treating. Don't be surprised if you see more knives by Matt Bruton.



After a short question and answer session and casual discussion, Sunday's demonstration got off to good start with Joe making a railroad spike knife with a twisted handle (expertly twisted by Bob Stormer). Before beginning, Joe repeated the importance of grinding off all sharp edges. Joe forges the shape of the knife before twisting.

The final forging demonstration was making a pole axe starting with a car axle of about 1" diameter. This was a very natural demonstration for Joe since he usually uses 2 1/2" round stock for most of his tomahawks. Joe started by putting flats on four sides in a section about 4 inches long, leaving the edges round. He then drew the end down in the shape of an axe as shown in figure 12. Again he used a chisel to make a slit for the eye approximately 3" back from the tapered section.

Lesson learned:

- There are NO RULES for how a tomahawk should look.
- Grind all sharp edges (except the intended cutting edges) on the stock and any tools used to work the stock.
- You don't need a shop full of equipment to make some very nice tomahawks and knives.
- Take advantage of youthful enthusiasm to keep our organization alive.

Alice James Conference Demonstration By Bob Ehrenberger

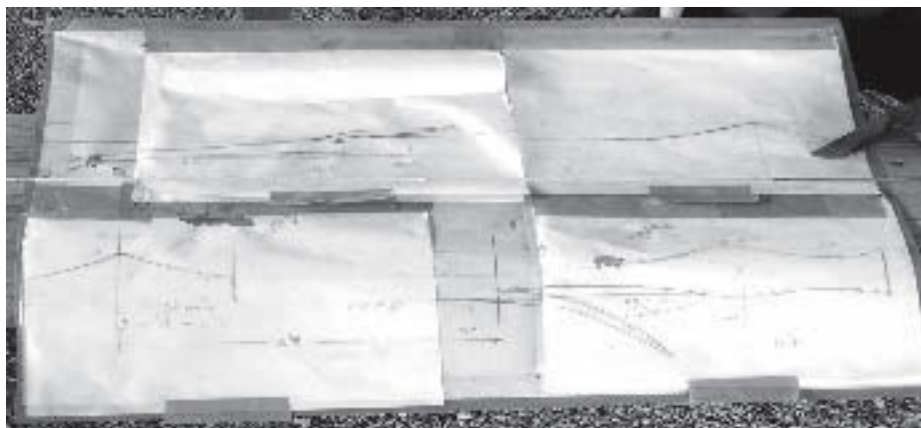
Alice brought to conference how she recently solved a challenging commission.. Her job was to create a pair of massive end irons with matching heron figurines as the prominent feature. She went for a stylized heron where a single arch that followed the heron's back would represent the whole body. As expected, your mind would fill in the rest.

Since most of us are unlikely to have a need to produce a heron sculpture, I don't see much point in following this demo step by step, start to finish. Instead I would like to focus on the things that I learned from her that can be applied to a large variety of work.

She started with a succession of sketches to see what features of a heron were necessary to transfer the image from your eye to your mind. This let her figure out how abstract she could get and still have it be a heron. So start with paper, you can draw it much faster than you can forge it.

She then made several small scale test pieces. In an hour she could make a test piece out of 3/8" stock that would take her all day with 2" stock.

Alice created a flip chart that showed the progression of the forging. It started with the original stock, the next picture was the rough blocking in, then the precision forging, and finally the chasing was added to finish the last picture. As the project progressed, she could flip from one picture to the next to make sure each step was completed correctly.



Alice said that when you need to have a matched set (in her case mirror images), you should work on both pieces and bring them up to the same point before proceeding to the next step. That way if you need to make adjustments you can do it early and make the same adjustment on both pieces. Another trick was to look at the pieces upside down. This way you can do comparison that will catch things you miss when right side up. (Your mind tends to fill in the blanks)

When blocking in the form, she initially set the hammer up with drawing dies top and bottom. Then as the form progressed, she changed the set up to have a drawing die on top and a flat die on the bottom. This allowed her to have a curve on top and a flat bottom on the piece. It also gave her more control over how aggressively the material was moved.

One design feature that was unique, she formed the tuft of feathers on top of the head, not by cutting it off the back of the head and raising it up as it appears. But by cutting it off of the beak and folding it back.

This exposed the cut line and made it much easier to clean up. It also gave a clearer transition line between the beak and the head.

Alice stressed that it was important to chamfer all the edges after forging. The chamfer not only softens up the piece making it more pleasant to look at, it also makes it harder to spot imperfections in the piece. If you have a long straight section with a sharp edge it is easy to spot any place where it isn't perfectly straight. But if the edges are chamfered you have harder time seeing where the edge is, therefore a harder time seeing where the edge varies.

The piece required a square corner where the neck joined the body. Instead of drawing the piece to a uniform thickness, making the bend and then upsetting the corner. Alice left extra material where the corner was going to be. So after bending she didn't have to upset the corner, she merely had to shape the material that was already there into a square corner.

It is important to protect the work that you have already done. Alice uses a lot of selective cooling before bending to make sure that only the part that she wants to bend is hot enough to bend.

Alice showed how if you overlap two bending forks you can simulate the bending action of a three point bender (like a hossfeld). This lets you create a very tight bend, with control.

Another tip on improving your work was to use a punch instead of a hot cut when you are going to slit and drift a hole. The punch, even a long skinny oval, will leave a rounded edge which will disappear as the hole is drifted. If you use a hot cut you will leave a crack which must be filed out later.



I would like to thank Steve White for managing the fire for the whole weekend. And to thank Walt Hull for magically appearing every time Alice needed a striker. What great timing

I may never make a heron, but I'm sure I'll be a better blacksmith for having watched this demonstration.



Steve,

Alice,

Walt

Forming a ladle for babbit or lead, etc

by irnsrgn AKA Jr. Strasil - pictures by baby-anvil

Editor's Note: Last time Jr. showed us how to make a sinking tool. Now he shows us how to use it.

ladle 001--5 inch diameter 1/4 inch plate circle laid out with a handle tang and pourspout extensions, I forgot the pourspout extensions on my first try.



ladle 002--The dishing hammer I have, spherical on one end, elliptical on the other. Made of 1- 3/16 PTO shaft material.



ladle 003--A close up of the spherical (ball) end.

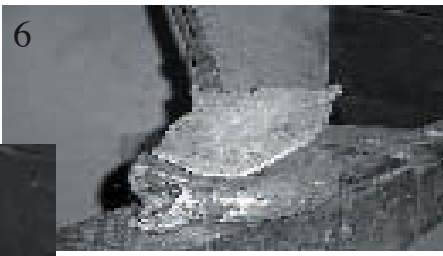


ladle 004-- A close up of the elliptical (slightly rounded) end.

ladle 005--The initial dishing of the blank, notice the depressions, I used the spherical end instead of the elliptical end. caught it before I ruined it tho.



ladle 006--Working the edges in stages.



ladle 007--Another view of working the edge.

ladle 008--Working the tang down.



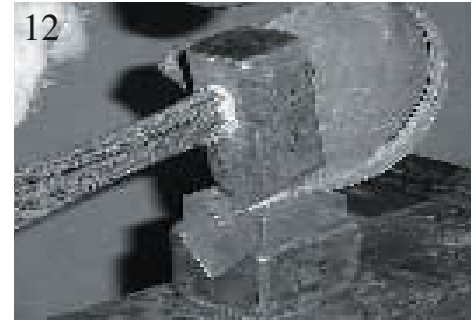
ladle 009--Working the pourspouts down.

ladle 010--My 90 degree straight set hammer. (I also have a 90 degree cross set hammer).





11 ladle 011--My bottom V swage in its base. There are 4 different sizes 1 to each side. The block lifts out so it can be rotated, there are also round swage blocks that fit in this base.



12 ladle 012--The bottom swage and 90 degree set hammer used to form the pourspouts.



13 ladle 013--What the pourspouts look like after the initial forming.



14 ladle 014--A short can a little larger than a tuna can almost full of water, setting on the cutting step.



15 ladle 015--Spot cooling the bottom of the ladle.



16 ladle 016--The ladle laid upside down on the anvil to flatten the pourspouts by tapping on the spot cooled bottom.



17 ladle 017--The ladle on my anvil leveling block, tapping on the spot cooled bottom to flatten the top edge.



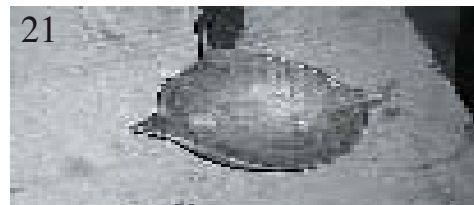
18 ladle 018--1/2 or 5/8 cast iron plate I came up with somehow. makes a nice leveling block as I do not have a metal work bench handy.



19 ladle 019--Bottom view with the 7/8 round shank that fits in the hardy hole.



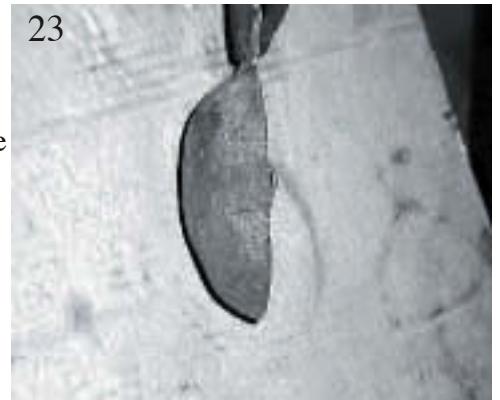
20 ladle 020--I needed to do a little work on the very outer ends of the pourspouts from the bottom, so I used my big V-block with the 2 inch square setting in it that has 4 different radii on the corners. There are 2 pendulums that swing on a rod that goes thru a hole bored in the center. These pendulums keep the block from sliding out of the bottom V-block during use.



21 ladle 021--Top View of the ladle, sans handle.



Ladle 022--Bottom view.



Ladle 023--Side View, notice the flat top.

This is my second babbit ladle, it took me a little less than a half hour from cutting the blank to the final picture and about 8 or 9 heats all told. All the forming was done with hand hammers.

Knife Maker's Hammer-In By Bob Ehrenberger

Every year for over 20 years Corbin Newcomb has had a hammer-in. He does this each spring before the weather gets hot. You see Corbin has a small shop and a very large gas forge. As a result his shop is like the seventh level of hell in the summer, so he makes all his damascus, and forges all his blades when it's cold out, and does his grinding and finish work in his home in the summer. The hammer-in marks the end of the forging season at Corbin's shop.



Ron Duncan's Press

Corbin's forge is set up on the farm of Ron Duncan. Corbin has taught Ron how to make knives, and Ron is doing a real fine job in his own right. (You may have seen the write up on him in the Missouri Conservationists a couple years ago) Ron kind of co-hosts the event, being that it's on his farm and all. As a side note, Ron likes old equipment, the big stuff. His place is a joy to wander around and admire things (at least for a blacksmith). If you need a 30hp electric motor Ron is the guy to call.

I've been involved in the event for about 5 years because my son Daniel is a knife maker. Daniel gets invited and I tag along. Several years ago Corbin gave Daniel a taste of making damascus using a hydraulic press. That planted the seed to get Daniel busy building his own press.

The weather was perfect and Ron set up a second forge and his press out in the yard. Ron's press has a unique feature in that he has both drawing and flattening dies mounted at the same time, no changing.

There was plenty of opportunity for everyone that had a desire to make something to do it. Someone brought a generous supply

of 5160 drops from a local spring shop so even if you didn't bring a billet ready to make damascus there was no excuse to just stand around. Unless that's what you wanted to do. I took one of these drops and made a nice twisted rat tail knife, and the twisted rat tail draw knife that I donated to the BAM auction. It is truly amazing how fast you can take a piece of steel that's 1/2 x 3" and convert it into blade stock using a hydraulic press.

They used to have a pot luck dinner, but since the event was 90% men that didn't work out too well. Half of the guys would bring a bag of chips or a bucket of KFC, so it wasn't a very balanced meal. This year, it was bring a snack to share and a brown bag for lunch, It worked out fine, someone made a food run a burger joint in Moberly for those that forgot.



Guys taking a break



Corbin making Damascus

I'd like to say a word about Corbin's press. It was made by the

late Jim May and is a monster. The frame is an "I" beam off of a bridge and must be close to 2 foot across the web. As if that wasn't heavy enough, it has a piece of 2" x 10" solid steel welded to the flange to act as a ram guide. There is no chance for this bad boy to flex under load. It has the same quick change die setup

that Daniel copied for our press, there is no reason to run with the wrong dies when it only takes 10 seconds to change them.

You don't realize how many knife makers there are in Missouri until you get most of them in one place. We certainly have a depth of talent, and a most of them are BAM members. The hammer-in goes the whole weekend but we could only stay for the Saturday session. There were several guys that could only attend on Sunday so both days were well attended and everyone had a good time.



Corbin's Forge, Three billets at once



President's Letter
May, 2005

Artist-Blacksmith's Association of North America, Inc.
PO Box 816
Farmington, GA 30638 USA
706-310-1030 tel , 706-769-7147 fax
abana@abana.org * www.abana.org

Many exciting events have kept your board members very busy recently----

As mentioned in The Anvil's Ring, the ABANA EDUCATIONAL ENDOWMENT TRUST has been completed. It is seeded with the funds from the old Scholarship and Trust funds, together with general funds for a total of \$150,000.00. The scholarships and grants made possible by the trust contribute to the artistic blacksmithing community in many ways:

- The individual receiving a scholarship grows in ability, while sharing gained knowledge in demonstrations and articles to trade to affiliate and ABANA publications.
- Grants to facilitate extraordinary events not otherwise possible are made available to the blacksmithing community, which similarly benefits us all. Just a single example, an ABANA grant of \$500.00 was given to make a Metal Working Merit Badge booth possible at the National Boy Scout Jamboree this year. Filling an interest, educational outreach, and potential future new members in our fold, what a deal!
- For details or an application, visit the ABANA website: <http://abana.org/resources/education/index.shtml#pdf>

An excellent way to foster the artistic community we belong to, would be to contribute to the TRUST. The trustees, Dorothy Stiegler, Bill Callaway, and Doug Learn can help with any questions that arise.

Speaking of grants, the Controlled Hand Forging Committee that produces the excellent teaching articles in Hammer's Blow is seeking grants. They would like to expand on published articles in the Hammer's Blow and complete a book to make the information even more widely available. Contact committee chair Dan Nauman with information to help the committee achieve their goal.

ABANA is always looking to increase communication worldwide with other artist metalworkers. Most recently we have increased our liaison with the British Artist Blacksmithing Association.

Going fast are The Anvil's Ring back issues, available for \$1.00 on purchases of twenty or more, hurry to fill out your back issue library. Also available is a CD, picturing the gallery items at the 2004 ABANA Conference, thanks to our own editor, Brian Gilbert. The ABANA website is rotating pictures from the CD when you access it, check it out!

Remember you can renew your dues for two years at the current \$45.00 per year fee when you receive your notice. Dues will increase to \$55.00 on January 1, 2006. Just think of it as a way to save a buck, and make the board work a little harder to fill all our organizations needs at budget time!

It is with GREAT sadness that I received Tim Ryan's resignation from the board! Tim has been a long time board member and positive supporter of ABANA. We all owe Tim a round of appreciation—HEAR! HEAR!

Elected to the board was Louie Raffloer of Black Dog Forge in Seattle, Washington. Louie is a full-time smith and runs a multi-staffed shop in Seattle. The shop is involved in all aspects of artistic metalwork and known for its many creative productions. Please join us in welcoming Louie as he begins the work ahead.

Having the newest board member at 'Ground Zero' of the 2006 ABANA Conference will be a Big Help! The 2006 ABANA Conference in Seattle will be the most diverse to date! Tours and demos will be held at the University of Washington Metals Department, which is probably the most high-tech in the United States! Three-dimensional and digital design techniques will give smiths a view of the cutting edge of what's to come in metal design and execution! There will be an array of new and exciting smiths from around the Pacific Rim. A new feature will be the 'Smithy Social Center' where smiths can relax from the demos, chat with old friends, and enjoy a soft drink, snack or microbrew right on the water! On-going smithing activities and entertainment will keep the conference exciting from early morning to late at night!!! With so much smithing, you may be 'Sleepless In Seattle'!!!

May your fire be hot and your clinkers few!

Don Kemper
20100 NW 61st Avenue
Ridgefield, WA 98642
(360) 887-3903

dkemper@abana.org

REVIEWS

Subject: Video: **History of Horseshoeing**

Hi Bob, I had a chance to visit with Lee Liles at the conference, we had a long and interesting conversation about the history of horseshoeing, I learned many things I didn't know before. He has made a video tape of his museum in Sulphur, Oklahoma and he donated a copy to the BAM library. Of course I went in right behind him and checked it out.

It takes about an hour to view the tape, and I am happy to say it was a very informative and pleasant hour. I have no plans to become a farrier but the farrier of this ancient craft intrigues me. Did you know that horse shoes date back to B.C.?

Bob, if you would like to print this e-mail in the newsletter to let the membership know about the tape, feel free to do so.

best regards, Joe Wilkinson

Subject: Book: **101 Metal Projects for the Novice Blacksmith**, by Al Cannella

Ken Scharabok has donated a copy of this book to the BAM library.

Al Cannella has put together a nice collection of projects, tools, and techniques in this book. He has a simple straight forward illustration style that gets the point across in a manner that most of us can understand and follow. I recognized several projects that I am already familiar with, some that I already make, and a couple that I think I'll give a try.

This book would be a good motivator, for anyone that has ever had an open afternoon to spend at the forge, but just couldn't come up with a project to tackle. Bob Ehrenberger

Editor Note:

You can get a copy directly from Ken Scharabok via mail for \$22.83 postpaid, Poor Boy Blacksmith Tools, 1645 West Blue Creek Road, Waverly, Tn 37185

Subject: Magazine: **The Artist-Blacksmith Quarterly**, by George Dixon

George has donated a one year subscription to his new publication "The Artist-Blacksmith Quarterly" for us to put in our library.

If you have ever seen George's work it is of the very highest level of the craft. This publication is of equally high quality, showing you how to produce the kind of work that he does. The illustrations are beautiful as are the pictures of his sample pieces.

If you watched George demonstrate at conference a few years ago, and didn't take good enough notes to go home and reproduce his work, George has taken the notes for you. Take your skill to the next level with this publication. Bob Ehrenberger

See his ad in the classified section.

July 30th BAM Meeting at Fulton (Ham's Prairie Area)

By Ned Digh

Lunch will be provided at no cost to all attending the meeting. Those eating are requested to bring two (2) cans of food, which will be given to the Callaway Food Kitchen (operated by SERVE, Inc). If you forget to bring a couple of cans, you can stop by the Ham's Prairie Store and buy something.

There is plenty of room at the farm for overnight camping, either tents or RV's. Several electric hookups are available and a restroom will be complete by meeting time, either in the shop office or the pump house. Ham's Prairie Store has a hot grill and serves breakfast, like sausage, ham, eggs, and good stuff. The campers can order supper pizza from the store or cook out at the farm. Lunch Chefs will be Esther Digh and Scott Stager, no catered stuff!

Last year the effort to have Blue Grass Music after the meeting failed, but it appears to be on track for this meeting. Both John Murray and Doug Clemons have promised to bring their instruments. Cory Clemons is also a



maybe, depending on his schedule that weekend. All others are welcome and maybe we will have some local pickers.

Here are the demos known at this time and we hope to have more. Tom Lee, a Callaway County native will demonstrate his English Wheel skills. Tom is active in local antique car activities and restorations. Esther Digh will do her scholarship demo, with enameling on copper. She is also working to learn the techniques to put enamel on steel and may also do that. Lou Degginger will assist me in making two bells. One is a three sided bell that I learned to make from Allen Kress in a course at John C. Campbell. The other is a four sided bell as a deviation of Allan's design. An additional demo may be to make a mobile, hanging from the shop porch. This is still in the infancy of design, but it is showing promise. For those desiring to work after the meeting, they can make small items to hang on the mobile. Maybe Ed Harper will demo his tong making techniques again.

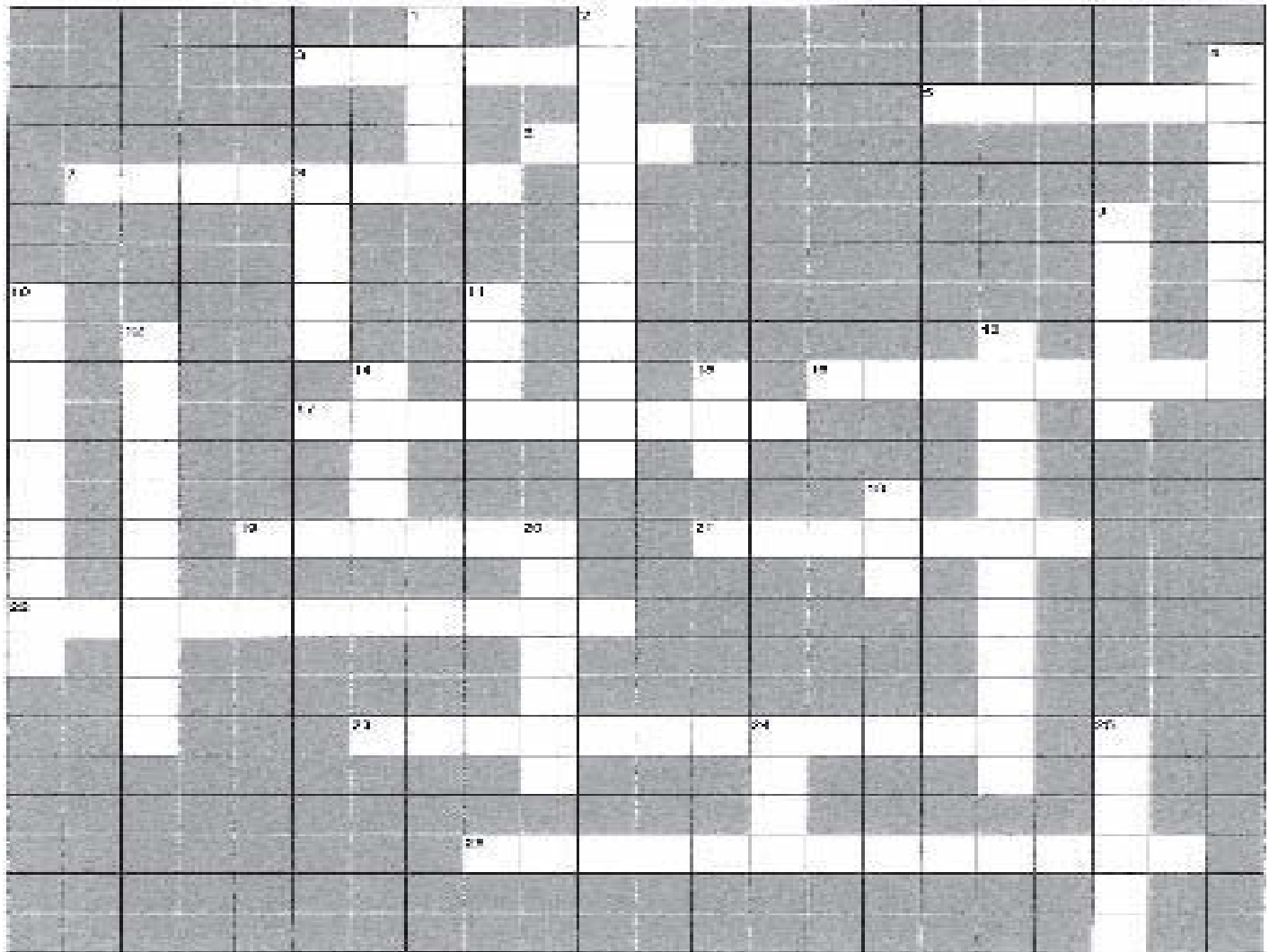
Post Meeting Hammer-In: We usually have members stay after the meeting and forge, but for this meeting we have a special opportunity

because we will have the MTS trailer at the meeting. This will permit the newer members, who do not have equipment, to work with the MTS equipment and be tutored by some of our experienced members. The hammer-in can be continued on Sunday afternoon, if desired. A donation will be requested for any steel used from the MTS trailer and for the propane.

Blacksmith Puzzle

Tools

Created by Ed Harner with Edipuzzle.com - www.edipuzzle.com



Across

3. A tool for measuring right angles
5. To beat
6. Used for making female threads
7. A hinged pair of points used for measuring distances
16. A hammer having one end of the head hemispherical
17. A thick walled tapered cone for trueing rings
19. A tool for turning a bolt
21. A sharply pointed tool used for marking lines
22. A tool for making a guide for drilling
23. A tool for drawing a straight line
26. Foot powered tool

Down

1. A straight instrument used for measuring
2. Process of shaping things out of metal
4. A hammer with a straight peen perpendicular to the handle
8. An implement with cutting edges for boring holes
9. A metal tool with a sharp beveled edge
10. A tapered steel pin used to open up or size a piece of metal
11. hand tool used for removing metal stock
12. process used as a decorative finish
13. A long handled heavy hammer
14. A furnace where metal is heated
15. A tool that is used to produce consistent parts
18. For making male threads
20. A tool for cutting metal
24. A device that provides a mechanical advantage in accomplishing a task
25. Hand tool primarily for gripping and cutting that uses leverage

Buy, Sell, Trade

Individual Classified ads

Treadle Hammer Old style Clay Spencer type Located in Washington, Mo. \$600 Pat McCarty 636-239-3814

Commercial / Resource ads

Services:

Custom spinning in copper, brass, pewter, and steel. Contact Ken & Kathy Markley, 7651 Cabin Creek Lane, Sparta, Ill. 62286. Phone: (618) 443-5284 Fax: (618) 443-5284

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.

Little Giant-- We can do repairs on any or all components of your Little Giant front assembly. Contact H."Sid" Suedemeier 420 4th corso, Nebraska City, NE. 68410 (402) 873-6603

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.

Treadle Hammer - Complete , and Beverly Shear Sharpening

I have donated my treadle hammer plans to ABANA and will not be selling plans in the future.

Beverly shear blades sharpened \$35 plus postage.

Roller Blade Treadle Hammer for sale, \$1400.

I will be leading workshops to build 50 lb. Tire Hammers, contact me for details.

Clay Spencer, 934 Partridge Lane, Murphy NC 28906-6149, 828-837-0708

or e-mail to clayms@brmemc.net

Information / Education

New email/web site for Tom Clark and the Blacksmith School

Tom: tclark@ozarkschool.com

Tong Making Class-Weekend Course

4 people per class - \$125 per person

Contact: Charles Comstock Rt.1 Box 20, Deerfield,MO. 64741 (417) 927-3499

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

George Dixon edits a blacksmithing publication called "**The Artist-Blacksmith Quarterly**". 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 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.

Products

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.

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, belt grinders and gas forges. For more info on the tools contact him at Phone (573) 438-4725. Fax (573) 438-8483.

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-FARMBEL. Web site www.bellsandmoe.com.

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

Buy, Sell, Trade, Continued

Persimmon Forge PEDAL HAMMER for sale for the more delicate work of chase and repousee, chisel and chase, leather stamping, some stone and wood carving applications, etc., done from a comfortable seated position with minimal effort, maximum safety, and faster strike.

Standard model sells for \$1,300.00 which includes a 1x5x6" mild steel anvil and circular 5" lead anvil with attachment carriage and seat mount.

The narrow footprint model sells for \$1,375.00.

Options include leather padded seat for \$75; 1.75x6x6" hardwood anvil for \$12.75; variable tilt anvil for angled chisel and chase work for \$33.20; 30-degree fixed tilt anvil also used for angled chisel and chase work for \$33.20; wheels with castor jacks for \$75.00 unmounted or \$125.00 mounted.

Contact Dave or Betty Edwards by e-mail at djedwards@cableone.net or write or call the manufacturer, Four Mile Carriage and Machine at 3220 West 6th Ave., Emporia, Ks. 66801, (620) 342-4440.

If you pick it up in Emporia you save shipping costs and Dave can provide some free instruction in its use.

SOFA fire pots are once again available. For information contact Bob Cruishank, 1495 W. Possum Rd., Springfield, OH. 45506 Phone: (937) 323-1300 or www.creativeironforge.com or www.sofablacksmiths.com

Wanted:

Articles for the BAM Newsletter. Email, or snail mail to Bob Ehrenberger.

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

BAM Demonstrator wanted:

My name is Matt Coley and I'm a board member of the Missouri River Valley Steam Engine Association, Boonville, MO. Would any of your members or club be interested in coming to our show every September and set up shop for a weekend and do working displays? We would like for someone to set up and build a permanent blacksmith shop on our grounds. We might be able to help with a building with some lumber we may have but not sure what you guys

prefer for something original looking. Please visit our website :www.mrvsea.com

Our annual show is always the weekend (Thurs, Fri, Sat, Sun)after Labor Day. We have an area we would like for a blacksmith shop to be built. This would be a permanent home for a shop. For more info, contact Dennis Ficken who is our president. 660-882-8473. I will email your website to some of our members. Hopefully we can work together.

Thanks, Matt Coley

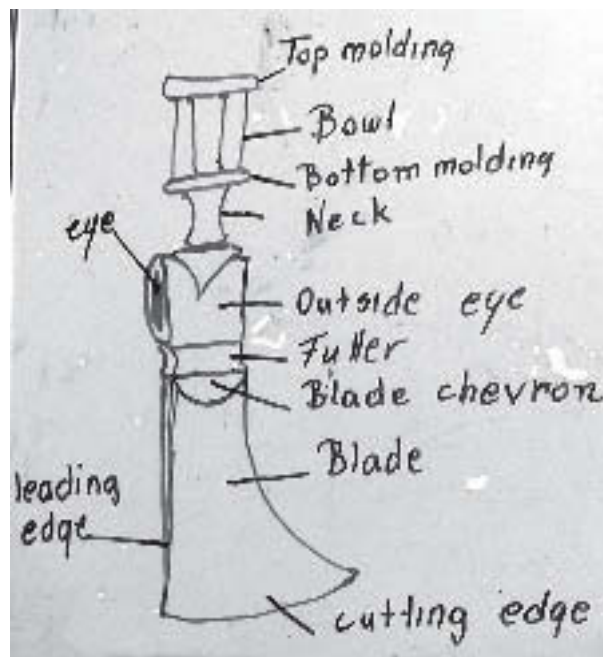
Help Wanted:

Artist-Blacksmith Position Available

Established artistic metalworking business specializing in high-end custom and production ironwork is seeking apprentice and journeyman blacksmiths.

Only serious, self-motivated, high-energy people need apply. Send resume and letter of interest to: Jeff Fetty Designs, Inc. 1041 Lion Fork, Spencer, WV 25276. Or email jfetty@depotltd.com No phone calls please. Visit us on the web at [_www.jefffettyironwork.com_](http://www.jefffettyironwork.com) (file://www.jefffettyironwork.com/).

Around the Anvil BAM has it's very own E-Mail news group. If you would like to participate send an E-Mail to Ed Harper at aramed@grm.net and he can get you signed up.



Joe Szilaski, Pipe Hawk Illustration

Need Coal ?

Check on Availability

Coal Captain: Bob Alexander



1. Bob Alexander (636) 586-6938
14009 Hardin Rd,
DeSoto, MO. 63020

2. Ken Jansen, (636) 366-4353
2257 Charter Rd.,
Moscow Mill, MO. 63362

3. Doug Clemons, (660) 595-2257
RR1 Box 124,
Malta Bend, MO. 65339

4. Jerry Rehagen, (573) 744-5454
Rt1 Box 97,
Freeburg, MO. 65035

5. James Rumbo, (816) 625-8675
7223 Hardsaw,
Oak Grove, MO. 64075

6. Jeff Willard, (417) 742-4569
P.O. Box 416,
Willard, MO. 65781

Price \$10.00 per bag Coal keepers earn \$2.00 a bag

Across

Blacksmith puzzle answer key

3. SQUARE, 5. HAMMER, 6. TAP, 7. DIVIDERS, 16. BALLPEEN, 17. CONEANVIL, 19. WRENCH, 21. SCRIBER,
22. CENTERPUNCH, 23. STRAIGHTEDGE, 26. TREADLEHAMMER

Down

1. RULER, 2. METALWORKING, 4. CROSSPEEN, 8 DRILL, 9. CHISEL, 10. DRIFTPUNCH, 11. FILE, 12 SHOTPEENING,
13. SLEDGEHAMMER, 14. FORGE, 15. JIG, 18. DIE, 20. HACKSAW, 24. TOOL, 25. PLIERS

Upcoming Events

July 30th BAM Meeting at Ham's Prairie, MO. Host: Ned & Esther Digh
Trade Item : Bell, Lunch Provided

August 3-7 Rocky Mountan Blacksmithing Conference. Carbondale, Colorado
Registration John or Janet Switzer (719)485-3109, Cell (303)589-1767
E-mail at switz@mindspring.com

August 11-21 BAM booth at the state fair in Sedalia. Contact Peggy Williamson if you can participate and she will get you passes.

August 30-September 2 CANIRON V. Annapolis Royal, Nova Scotia, Canada.

September 10th BAM Meeting at Shelbyville, Mo. Host: Bob & Jan Ehrenberger
Trade Item : Measuring device (dividers, calipers,traveler), Lunch provided

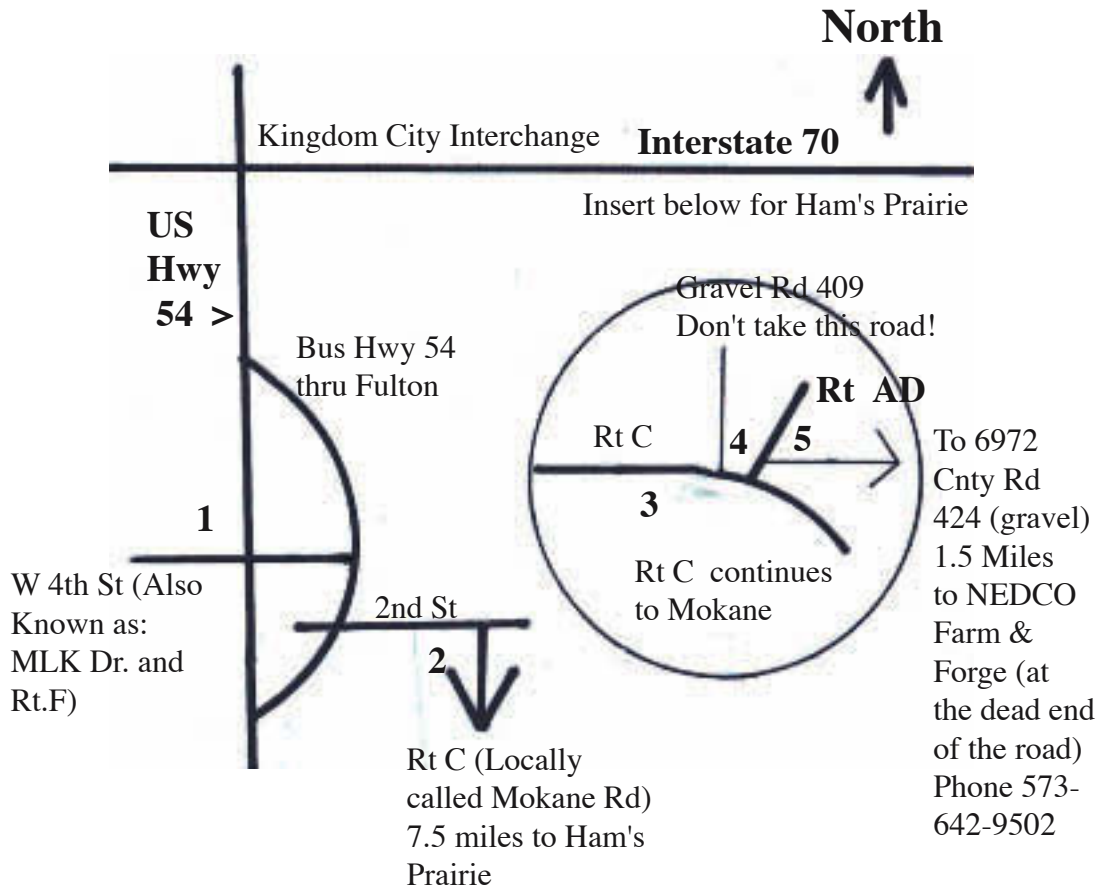
November 12 BAM Meeting at Bass Pro shop in Nixa,Mo. Host: Kirk Sullens
Trade item: is to be a sea creature, made of more than one piece, and put together with traditional joinery

New Members

If you know or live near one of these new members. Give them a call and invite them over to your shop. Most beginners don't have the equipment or experience to get going. You have both, please share. Sometimes they just need to see how things are set up to get them started.

Baird Kenneth	2705 Robin Street	Bloomington,	IL	61704	kwbaird@nwnc.net	309-827-7391
Bales Bob	P.O. Box 7	Eldon,	MO	65026		573-392-4969
Brooks Charles	RR 1 Box 96	Patterson,	MO	63956		573-856-4561
Campbell Gary	12901 E. 61st	Kansas City,	MO	64133		816-356-4369
Deines Ryan	7290 W. 197th Terr	Stillwell,	KS	66085		816-636-4854
Foster Joe	1142 NE 1000 Road	Windsor,	MO	65360	candjoe@earthlink.net	660-647-2045
Fry Kent	4513 Winged Foot Court	Lawrence,	KS	66049	kentfry@gmail.com	785-841-4362
Heth Carl	11570 CR 5160	Rolla,	MO	65401		573-364-6425
Hicks Kent	P.O. Box 574	Ava,	MO	65608		417-683-4281
Hoffman Thomas	819 West 4th Ave	Garnett	KS	66032		785-448-2229
Horton Donald	338 Legion Hall Road	Marthasville,	MO	63357		636-433-2113
Judd H. Daniel	3939 S.E. Stanley Road	Tecumseh,	KS	66542	midear01@yahoo.com	785-379-9660
Judd Matthew	3939 S.E. Stanley Road	Tecumseh,	KS	66542	mjautdtd@yahoo.com	785-379-9660
Kjellman-Chapin Benjamin	Two Dog Iron	801 Rural Street	Emporia, KS	66801		620-481-6216
Klos Mike	W. Hwy N	Wentzville,	MO	63385		636-332-6074
Million Earl C	4930 Jade Road	Kingdom City,	MO	65262		573-220-9338
National Ornamental Metal Museum	374 Metal Museum Drive	Memphis, TN		38106		901-774-6380
O'Connor Michelle	204 Bend School Lane	Union,	MO	63084	brewdog1@earthlink.net	
Phillips Marty	5705 E. State Rt A	Drexel,	MO	64742		816-657-4439
Resch Robert	3263 Cyclone Road	Paw Paw,	IL	61353-9537	bobresch@aol.com	815-627-2800
Robertson Nathan	52765 Robertson Road	Max,	MN	56629		218-4590
Spiller Ray	Mt Sharon Forge	4335 Mt Sharon Road	Greenbrier,	TN	37073	615-382-1464
Sullivan Christian R	1151 Lancaster Drive	St. Charles,	MO	63301	csulli1@artic.edu	636-299-2950
Troy's Ornamental Iron	320 S. 160th Street	Girard,	KS	66743		620-724-6784
Ventura John	904 S. 80th Street	Kansas City,	KS	66111-3113		913-788-5110
Watts Joe	8619 East 77th Terrace	Kansas City,	MO	64138	christiangamer08@yahoo.com	816-737-1732

Next Meeting: July 30 Ham's Prairie, Mo



Landmark Key

1. Westminster College
2. Westlakes Hardware
3. Ham's Prairie Fire Station
4. Ham's Prairie Store
5. Ham's Prairie Christian Church

BAM

2212 Aileswick Dr.,
St. Louis, MO 63129

Please send changes to Bruce Herzog, 2212 Aileswick Dr., St. Louis, MO 63129 or e-mail to bjherzog@msn.com