

# BAM

NOVEMBER/DECEMBER 2012



*BAM Members putting their trade items to use.*

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Neat stuff in Phil's shop Pg13



ABANA has nothing to say



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**Newsletter of the  
Blacksmiths  
Association  
of Missouri**

*Volume 29 No. 6*

**November-December 2012**

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**President's Message**

Doug Clemons

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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 \$25/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; (573)-633-2010 or send e-mail 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@att.net.** Occasionally some material will be copyrighted and may not be reproduced without written consent by the author. BAM welcomes the use of any other material printed in this newsletter provided the author and this organization be given credit.

**Membership Application**

Name: \_\_\_\_\_  
Address: \_\_\_\_\_  
City: \_\_\_\_\_ State: \_\_\_\_\_  
Phone: ( ) \_\_\_\_\_ Zip: \_\_\_\_\_  
E-mail: \_\_\_\_\_

New Member  Renewal  ABANA member?

Are you interested in taking a class?

How did you learn about BAM? \_\_\_\_\_

\_\_\_\_\_  
\_\_\_\_\_

Memberships are for one year from receipt of dues. Dues are \$25, which includes a subscription to the bimonthly BAM newsletter. Please make checks payable to Blacksmith Association of Missouri.

**ABANA Membership Application**

Primary ABANA Chapter Affiliation: \_\_\_\_\_

Name: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_

Phone: ( ) \_\_\_\_\_ Zip: \_\_\_\_\_

New Member  Renewing Member

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

- Regular Member .....\$55 yr.
- Senior Citizen (Age 65+) .....\$50 yr.
- Full time student .....\$45 yr.
- Overseas airmail .....\$80 yr.
- Overseas surface mail .....\$65 yr.
- Contributory .....\$100 yr.
- Public library .....\$45 yr.

*See reverse*



# From the Editor

By Bob Ehrenberger

We had a great time at Phil's meeting. He has a lot of neat stuff. Lots of old power hammers, both working and in the process of being rebuilt. I think we may have set a record for trade item participation. I think that I counted 37 forks, if that's not an all time high it has to be close. If we had put it in the newsletter that you needed to bring a fork to cook your lunch we would probably have gotten even more.

Ken Jansen was our main demonstrator in the morning. He showed us the versatility of the fly press. He showed how with some simple tooling it can be used for both hot and cold work. In the afternoon Bernie Tappel demonstrated how he starts a coal fire and talked about fire maintenance, fire tools, and touched a little on forge welding.

Fred Arnhold stopped me at Phil's meeting to show me the finished adz that he forged at the September meeting. It came out real nice, I'm sure that the guy that got it in the iron in the hat will be pleased how it turned out. Sorry, I didn't get a picture of it to show you.

Ken Jansen also invited us all to come to his shop for his black Friday hammer-in. The theme will be making punches and drifts. If you have your own steel please bring it, if not Ken will have some extra that you can use. Ken will also have a meal, usually venison chilli.

I hear that Mara Harper's auction went well and they managed to clean out Ed's shop and most of their basement. I wish that I could have been there, but my MTS beginner's class had been scheduled for that date for 8 months.

Speaking of the beginner's class. We ended up with 4 students for the first week and 3 for the second. I'm not sure that calling it

an MTS class is entirely accurate, since we didn't use the MTS equipment. I never liked the gas forges and since the class wasn't going to be full I didn't see any reason to drag the MTS trailer up here. I was expecting to have 6 students so I put together a third forge so we could have 2 students at each forge. Things went so well I'm thinking of scheduling another class next year. I won't set the date so far in advance this time since no-one signed up until the last month anyway. So be thinking about it sometime next fall.

My daughter sent me the picture below, with a hidden message in it. Hint: she isn't opening a shoe store.



Bernie Tappel continues to do a great job managing the BAM web site, and moderating the BAM news group. He wanted me to mention that the tailgate section of the web site has been real active, so if you are looking for blacksmith equipment you need to check it out on a regular basis.

Don Birdsall has volunteered to demonstrate at the January meeting. I think that he is going to show off some of his jigs and tooling. Dale Kirby, the host has promised me that the area with the forge will be insulated by the time we have the meeting. I didn't think it was all that cold last time, but I was kind of busy so that may have made a difference. Dale also provides a meal via a local service

group.

Long time BAM member Robert Baker has passed away. He was involved from the very beginning of the organization, and his son Steve was one of our first presidents.

As you will notice I wrote an article about making my conference auction item (Damascus Draw Knife pg. 22). I know that several of you will make something really nice for conference. Why not take pictures of it in progress and submit an article for the newsletter. We all like to see how things are done, and it might inspire even more nice stuff for next year's auction.

I'm finishing this up on opening day of deer season. It is way too warm (75deg.) for killing deer. It is just as well that the hunters on my property didn't get one, we wouldn't be able to hang it in this heat. They say we will have a 40 deg. drop by Monday, what a crazy year for weather.

I hope I see a bunch of you at Ken's on Black Friday, and in Higbee this January. If you have a little time consider making some tools for the Boy scout blacksmith shop. They need everything. See Pg23 for more information.

Joe Hurley would like to know if there are BAM members interested in participating in a knife cutting competition. Check out the details on pg 23. And contact Joe if you are interested.

**Note to editors:** If you don't send BAM a hard copy of your newsletter, this may be the last BAM you get. Check bamsite.org for a pdf of BAM.

**The next Newsletter submission deadline is January 19th.**

# BAM MEETING FOR November 2012 hosted by Phil and Margie Cox

Minutes by Don Anders

President Doug thanked Phil & Margie for hosting the meeting.

Treasurer's Report given by Doug Clemons for Bruce Herzog.

Mike McLaughlin gave a BAM conference report, plans are still on track, most of the demonstrators are lined up. Volunteers are needed for setup and tear down and various positions, no experience needed, please volunteer.

Items are needed for the Gallery, boutique, Iron in the hat, raffle and the auction please contribute. If you have an idea for a tee shirt design please draw it up and contact Mike McLaughlin. The local farrier group has been contacted about having a contest or demo and so have some knife people. Please remember our conference vendors and try to buy from them at the conference and throughout the year. It is expensive for them to come to the conference we need to keep them coming. The ring tree project is still on. There will be addition information coming on workshops, please consider making a decoration for it, something that will fit into a 3 or 4 inch circle.

Phil Cox and others organized a potluck get together, one evening of the conference last year and it was a big hit. Try to join next year, it is a good time to bond with other members. It doesn't need to be just one big get together, several smaller ones are just as good or better. BAM members need to talk and get to know one another and this is a fantastic way to do it.

Kate Dinneen is working to pull additional workshops together to finish the Black Jack Memorial Gate, contact her to help.

One of the boyscout troops is trying to pull together a blacksmith program and they need tools donated, contact Doug Clemons or Bernie Tappel for additional information.

Motion to adjourn, 2nd, meeting over.

Don Anders  
Mike McLaughlin  
Donald Davies  
Donald Davies  
Don Nichols  
Don forlow  
Colin Ward  
Don Forlow  
Don Nichols  
Donald Davies  
Donald Davies  
Donald Davies  
Bob Ehrenberger  
Tracy Johnson  
Don Nichols  
Harry Weber  
Don Nichols  
Ken Jansen  
Don Nichols  
George rousis

Key stock  
key rings  
big rebar  
burn barrel  
rubber mat  
plow spring  
fine sawdust  
sad iron  
rubber mat  
cable thimbles  
2 metal straps  
assort. bolts  
Guinea feathers  
patch knife  
conduit bender  
door spring  
saw blade  
demo item 6 leaves  
Mike McLaughlin  
Mike McLaughlin

Bill George  
Don Nichols  
???  
Colin Ward  
Kate Dinneen  
Fred Arnhold  
Don Anders  
Scott Stager  
Dale Crabb  
Mike Gentsch  
Mike Gentsch  
Mike Gentsch  
Bob L.  
Joe Hurley  
Dale Crabb  
Jon Householder  
Richard Camp  
Mike Gentsch  
Mike McLaughlin

## TRADE ITEM Toasting Fork

### MADE BY

Bob Evans  
Larry Lutz  
Mike McLaughlin  
Phil Cox  
Mike Gentsch  
Bernie Tappel  
Dale Crabb  
Josh Helm  
Bob Ehrenberger  
Jack Nettleton  
Don Anders  
Randy Hughes  
Bill George  
Bobby Chambers  
Doug Clemons  
Mel Robinett  
George Rousis  
Karen Bouckaert  
Don Nichols  
Don Forlow  
Mark Sampsel  
Burton Mannell  
Steve McCarthy  
Ken Jansen  
Matthew Burnett  
Roger Green  
Dan Files  
Fred Arnhold  
Erin Kilburn  
Colin Ward  
Jason Cranston  
Fred Arnhold  
Mike Curran  
Wayne Colhour  
Don Birdsall  
Kate Dinneen  
Wade Johnson

### WON BY

Wade Johnson  
Wayne Colhour  
Matthew Burnett  
Don Forlow  
Larry Lutz  
Steve McCarthy  
Don Nichols  
Karen Bouckaert  
Mel Robinett  
Kate Dinneen  
Mike Gentsch  
Bob Ehrenberger  
Erin Kilburn  
Phil Cox  
Mike Curran  
Bob Stormer  
Jason Cranston  
Colin Ward  
Don Birdsall  
Jack Nettleton  
George Rousis  
Josh Helm  
Mike Mud  
Dale Crabb  
Roger Green  
Ken Jansen  
Burton Mannell  
Bernie Tappel  
Mark Sampsel  
Randy Hughes  
Don Anders  
Bob Stormer  
Doug Clemons  
Bobby Chambers  
Bill George  
Bob Evans  
Dan Files

## IRON IN THE HAT

### DONATED BY

Harry Weber  
Josh Helm  
Karen Bouckaert  
BAM Library  
Fred Arnhold  
Dale Crabb  
Don Birdsall  
Karen Bouckaert  
Karen Bouckaert  
Karen Bouckaert  
Richard Stubblefield

### ITEM WON

door spring  
spring  
hotdog trays  
Bksmith J  
wrist pin  
spring steel  
bearing rollers  
BituminousBits  
BituminousBits  
BK Journal  
clamp hold

### BY

Mark Campeel  
Bill George  
Mike Gentsch  
Joe Hurley  
Mike Mel  
Mark Sampsel  
Mike Gentsch  
Harry Weber  
Dale ?  
Kent Harbit  
Mike Gentsch

# President's Message

Greetings again,

It is hard to believe that it is November already. Harvest is over and the ground is ready for spring so maybe now I can spend a little time at the forge again.

I did barely find time to make a trade item for our November meeting. It turned out to be one of many. I think at one time I counted 37 trade items on the table. There was a large turn out at the meeting. The weather was nice and I got to see a lot of people that I have not seen for a while. Thanks to Phil and Margie Cox for hosting us.

There were some comments about not having our sound system set up and I apologize for that. When we bought this last system for our meetings it was decided that the president should be responsible for getting it to the meetings. I have taken it to every meeting since we bought it. Sometimes it is not needed. When I get to a meeting I speak to the demonstrator or the host to see if they want to use it. At the last meeting Ken Jansen was the demonstrator and when I spoke with him there was just a small crowd there and we decided that we would probably not need it. Ken is a veteran demonstrator and usually speaks loud enough to not need a speaker. I was toward the back of the room and I could hear Ken ok, but later in the morning when the crowd got larger and they lit the gas forge it may have been harder for some people to hear. Once again, I apologize. If you have trouble hearing please say something to the demonstrator. Likewise during the business meeting. I know that I sometimes have my head in my notebook and am not facing the audience when I speak so if you have trouble hearing any of us, please speak up.

In October Nancy and I went to the Heritage Days Festival in Warsaw, MO. We had heard about it but had never been before. It was much larger than either of us had imagined. There were many demonstrators of nearly every old craft or art imaginable. The only thing we noticed missing was a moonshine still. Nancy told me not to get any ideas.

There were two blacksmith areas set up. Both were occupied by BAM members when we were there. At one end Ray Chafin had his shop set-up. Ray is from Warsaw and I think has been doing this festival for a long time. At the other end, near the visitor center, they have built a small shop equipped with some equipment so the demonstrators have a little less to have to carry each day. When we were there it was staffed by BAM members. Mel Robinett and Mark Sampsel were there when we first stopped by. When we came back by they had been joined by Fred Arnhold and Mike Maddox. It looked like fun.

I get contacted occasionally by people looking for demonstrators or help getting started blacksmithing. I try to help by putting them in contact with someone in their area that may be able to help. Here are a couple of the most recent requests taken from my email.

Michael Garrett works for Camp Gamble at the S-F Scout Ranch south of Farmington . They are trying to start a blacksmithing program at the camp and are in need of tools or any assistance you can offer. Contact Mike mtg216@gmail.com

Also,

Darryl Wagner with the Platte County Steam Engine Show is looking for a blacksmith to demonstrate at next years show August 9, 10, 11. In Platte County, MO.

Darryl Wagner  
Platte County Steam Engine Show  
Email: dwi@blitz-it.net  
Cell: 816-719-0801

Please contact these guys if you can help.

The meeting schedule is booked up through 2013 and partly into 2014. We book the meetings as people volunteer to host them. Whenever we can we try to spread them out across the state so they are not all in one area. It can be hard to travel 4 hours or more one way to meeting. I think it was over 6 hours one way for me to Lesterville earlier this year and I know there were some there from farther away than that. If you are interested in hosting a meeting or have any comments about the meeting schedule contact Bob Ehrenberger or myself.

Our next meeting is January 12 at A&K Cooperage in Higbee, MO. Trade item is a corkscrew. A&K is a barrel factory that makes barrels for the wine industry. The last two or three times that we were there some of the staff came in and let us watch while they made a barrel. I always have a good time when we meet there. They have also added a winery next to the factory.

Enjoy the Fall weather. I hope to see you in January.

Doug Clemons



Pictured at the Heritage Days Festival in Warsaw

Mark Sampsel, Fred Arnhold, and Mel Robinett. Not in the picture because he was standing next to me at the time was Mike Maddox.

## Official Notice: Call for Volunteers

BAM is an all volunteer organization so that means we select our officers from within a group of volunteers within our organization. The officers are also the board of directors and are in charge of steering our organization in the direction they feel the membership wants to go. All of the things we do are based upon what we as members want based on our feedback or our time spent as officers of the group. please consider volunteering for one of the posts to help spread the load. You can submit your name to any member of the nominating committee. The members are; Don Nichols, Chris Miller, and Ken Jansen.

Below is the section of our bylaws regarding officers of the association.

### Article VI Officers

The organization's governing body shall consist of the President, First Vice-president, Second Vice-president, Secretary and Treasurer. Any member, in good standing, that has been a member of the corporation for at least one year, is eligible for nomination to office. The term of office will be one year, with succession of office allowed by vote of the membership and approval of the officer in question. Their duties will consist of undertaking the daily business of this corporation as set forth hereof.

#### Section 1 President.

The president shall be the chief executive officer and as such shall preside over business meetings of the group. The president will also be responsible for appointing the editor of the Newsletter of the Blacksmith Association of Missouri. In the absence of an editor, the president will perform the duties of editor until one is found. The president, along with the vice-presidents will be responsible for setting the time and place of the bimonthly meetings. The president shall have the authority to make committee appointments other than for the Board of Directors.

#### Section 2 Vice-Presidents.

In the case of the death or the absence of the president, or of his or her inability from any cause to act, the first vice-president and then the second-vice president, in his or her absence, shall perform the duties of the office of president. Vice-presidents shall be appointed as chairmen of standing committees as appointed by the president.

#### Section 3 Secretary.

It shall be the duty of the secretary or his or her designated

representative to give notice of and attend all meetings of the corporation. The secretary shall conduct all correspondence and carry into execution all orders, votes, and resolutions not otherwise committed; keep a list of all members of the corporation; notify the officers and members of the corporation of their election; notify members of their appointment to committees; and generally devote his or her best efforts to forwarding the business and advancing the interest of the corporation. In case of absence or disability of the secretary, the Board of Directors may appoint a secretary pro tem.

#### Section 4 Treasurer.

The treasurer shall keep account of all monies received and expended for the use of the corporation and shall make disbursements only upon vouchers approved in writing by any member of the Board of Directors other than himself or herself. He or she shall collect the fees, annual dues and subscriptions; deposit all sums received in a bank or trust company approved by the Board of Directors, and make report at the bimonthly meeting or when called upon by the president and to make an annual report. Funds may be drawn only upon the signature of the treasurer or the president if the treasurer is unavailable. The funds, books and vouchers in his or her hands shall at all times be under the supervision of the Board of Directors and subject to its inspection and control. At the expiration of his or her term of office, he or she shall deliver over to the successor all books, monies, and other properties, or in the absence of a treasurer-elect, to the president. In the case of absence or disability of the treasurer, the Board of Directors may appoint a treasurer pro tem.

Section 4 Compensation of Officers. The officers may receive such salary or compensation as the Board of Directors determines.

Section 5 Removal. Any officer elected by the membership or appointed by the Board of Directors may be removed by the Board with or without cause whenever, in its judgement, the best interest of the corporation would so be served.

Section 6 Number, Tenure, and Qualifications. The number of the Board of Directors shall be five (5) and shall consist of the officers of the corporation. The tenure of the Board of Directors shall coincide with the terms of the officers of the corporation.



**Robert K. Baker, 87**, of Monroe City, MO. died Sept 15, 2012. He was a founding member of BAM and long time smith who enjoyed sharing his craft with young people. Robert demonstrated at area craft shows for more than 30 years. He helped and encouraged many new smiths in their start in the art of blacksmithing. He was a member of the Friends of Florida (birthplace of Mark Twain) and the friends of Arrowrock, where he demonstrated yearly at their local festivals.



**To: Members of the Blacksmith Association of Missouri (BAM) October 19, 2112)**

On behalf of the Callaway Action Network and SERVE, Inc., thank you for all of your third quarter donations: 130# of canned goods and \$60.00 given for our Food Pantry. Your donation to our Food Pantry is priceless because in these difficult economic times, we are experiencing more and more first-time clients in need of food services. Without private support like yours, we would not be able to provide the quality of services that we do to these individuals and families in Callaway County.

We deeply appreciate your concern for others and your willingness to share to help others in need. "Serving others is our mission," and you have contributed to helping us achieve that goal. Thank you for making a real difference in the lives of *many* in Callaway County!

Sincerely,

Julie Roark  
CAN Director  
SERVE, Inc.

CANNED MEAT FOOD  
COLLECTED AT JUNE 3<sup>RD</sup>  
MEETING AT NED &  
ESTHER'S SHOP IN  
HAM'S PRAIRIE

# Ken Jansen Fly Press Demonstration

By Bob Ehrenberger

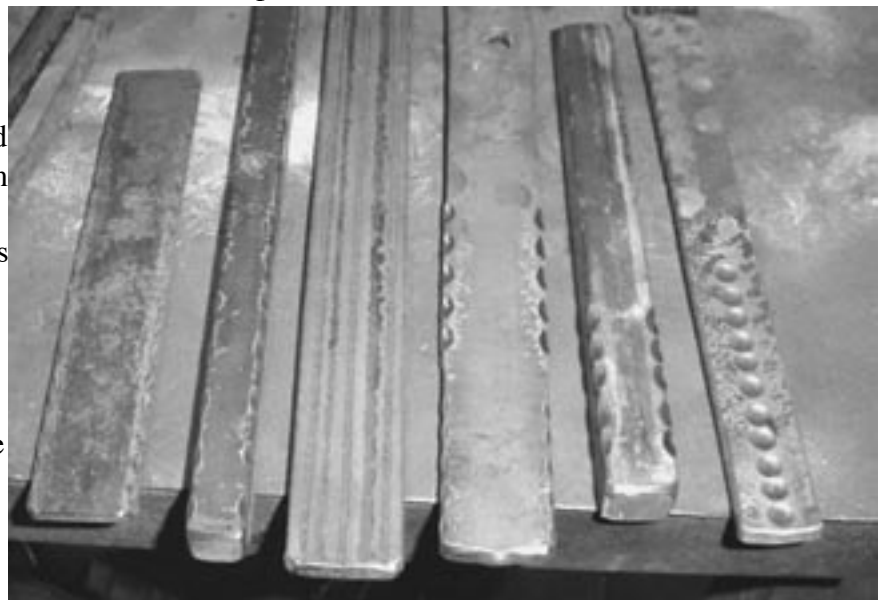
The fly press has been around for a couple of centuries. It has been a primary manufacturing tool in Europe. But like the English wheel it had fallen out of favor and use here in the US. Also like the English wheel there has been a revival of the fly press in the last decade. The blacksmith supply stores have started to stock them and we are starting to see more of them in fellow smith's shops. Ken said that he has had his for 4 or 5 years, but just recently has really put it to use. The key is to know it's capability and the willingness to make a few basic tools to go with it. Like any other tool in the shop you need to spend time using it to get good at it. Ken seems to have grasped how the fly press can fill a hole in his shop and make some of his jobs much easier.

So, what is a fly press? A fly press is a tool that does work using a rigid frame, a guided ram, a multi thread screw, and a large heavy fly wheel. The frame must be rigid because you want the energy generated to go into your work and not into deflecting the frame. The guided ram is needed to provide precision and repeatability to your work. The multi thread screw is needed so that the ram advances quickly when the fly wheel is turned, on Ken's press the ram advanced a full inch with 1/2 revolution to the fly wheel. The fly wheel needs to be heavy so that it can convert rotational energy into work when the die in the ram makes contact with the piece you are working on. The fly press that Ken was using also had a counter weight to balance out the weight of the fly wheel and ram. The counter weight serves two purposes, it helps you back up the press after each stroke, and it keeps the press from falling down on it's own which makes changing dies much safer and it holds the ram in position when you let go of it, so you aren't always fighting to keep it up. Ken and Phil Cox also claim that the counter weight does not detract from the power of the press. Phil thinks it gives it more power. It certainly gives it more controllable power.



Ken started his demonstration by showing how the press can be used to straighten a bent bar. Using a simple presser foot for a top die and two pipes welded to a base plate He was able to push a bar straight with very little effort and a great deal of control. He then used the same configuration to bend a ring on the fly press. This is made possible because the presser foot extends out in front of the ram, so the resulting ring can be closed up in front of the ram.

Ken then showed how the press can be used to texture and decorate objects. A fuller can be used to make a groove down the length of a bar to create collar stock. Ball bearings can be used either singularly or in pairs to either create a series of dimples or a scalloped edge on a bar. Round, square, diamond, star, or tear drop shapes can be used to decorate pieces either with a single strike or by walking them along and making each successive impression a little deeper than the one that it overlaps.



# Fly Press Demo Continued...

Ken then showed several ways to use the press to make leaves. He forged the point and made the rough form at the anvil just like usual, but then when it came to fullering the canter groove he went to the press. He put a small fullering die in the ram and then would hold the leaf up against it as he brought the ram down. He said that this gave you much more control than trying to put the leaf on the bottom plate and bringing the fuller to it. The side lobes of the leaf were then made the same way, starting with the one closest to the stem and working out to the tip. Each lobe was created with three hits, starting in the middle and working out to the edge.



The following story boards show the progression of steps required to make the three different leaf designs using the fly press.



Ken also showed how he makes ladle bowls using a rounded top die and a ring welded to a short piece of pipe. Once the ring is registered to the top die, the heated disk is placed over the ring and the die brought down. If the disk is well centered on the ring the bowl is made in one stroke. The edges are then cleaned up with a planishing hammer and a wooden block.

Ken showed how he makes right angle bends using an angle iron for a top die and a pair of angle irons welded to a plate for a bottom die.

A round punch with a center point was used to create an impression in a bar where the head of a rivet would set and the center punch where to drill the hole.



*Left to right  
Center points and ball  
bearings.*

*Bending foot.*

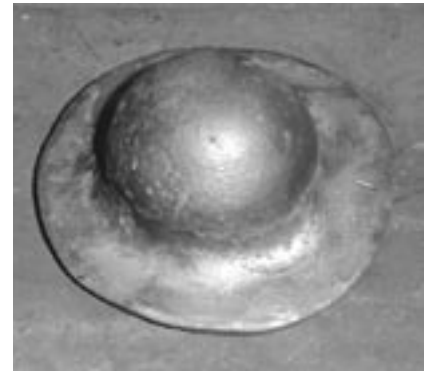
*Collar making jig.*

Continued on page  
12

# Fly Press Demo ... Continued from page 11

Ken used a small round tool and a slightly larger pipe to make a domed piece that fit onto some medieval armor.

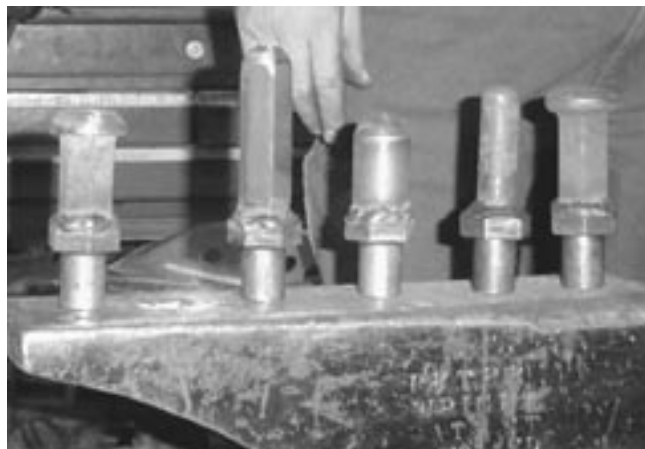
Some of the tools that Ken used were quite short. So in order to get them down to where he needed them, he had a ram extension, which was basically just a tool that had a 1" round stem on one side and a 1" round hole on the other. The tool was mounted in the extension and the extension was mounted in the ram.



For the posts that mounted in the ram it is important that they sit on a flange against the face of the ram, and not bottom out inside the ram. If they bottom out there is a chance that they will get upset in the ram and be almost impossible to remove. Ken said that he used to turn these pieces on his lathe and then weld the top die to them. He then came across a good deal on a bunch of one inch bolts. He could just cut the bolt off the length needed to fit up in the ram and then use the head of the bolt to weld the die to. This saved him about half an hour of lathe time for each die.

Ken's demo just scratched the surface of what is possible with a fly press. Let your imagination run wild.

*Right, Swage die sets for various sizes of tenons.*



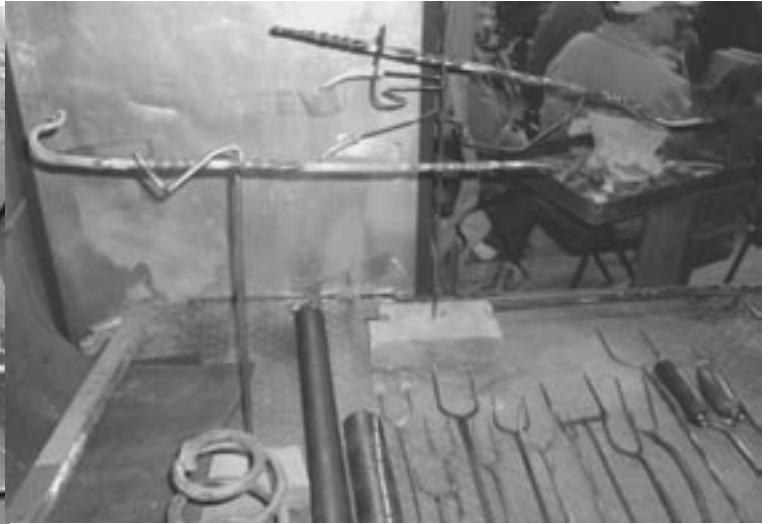
*Above, Round headed dies of various sizes.*

*Below and right, My kick press which has a similar die/ram set up as the fly press, but is foot operated instead of having a screw.*

*Below, Phil's press tooling, note the top die extender in the middle.*



# Pictures from the November meeting



# Beginner's Class

By Bob Ehrenberger

I had hosted the inaugural class for the MTS trailer some 10 years ago. While Don Birdsall and I enjoyed teaching the class, I was a bit discouraged that I only had one student. The trailer full of equipment was a bit of overkill, though it did give Don a chance to work out the bugs on how to pack the equipment and balance the trailer. Since then I had helped teach several more classes but hadn't hosted another one, choosing instead to host BAM meetings once a year. Two years ago, then president Ken Jansen, encouraged me to give it another try, noting that most of the MTS classes tended to be further south and that the North East region of Missouri seemed to be under served.

So last January I cleared the dates with MTS chair Denis Yates and started to publicize my class. Even though I whined about a lack of interest in all my editorials, I didn't have any one sign up until mid summer. Then in September I started to have a lot of interest and the week before the first class there were several more sign up. This was really going to happen. Unfortunately, I had not made firm plans with Denis to have the MTS trailer delivered to my shop and it was a bit late to expect him to get it here. So I decided to go ahead and have the class and use coal forges. I have my main shop forge and my travel forge so that would take care of 4 students with 2 at each. It was looking like I was going to have 6 students so I quickly through together a third forge. I had an extra fire pot that needed so repair and plenty of scrap metal to build the frame. I had also noticed that my closest neighbor had a blower setting unused in one of his sheds. When I called him to ask him if he would sell it to me, he said no, but I could borrow it. Also, I didn't quite have enough hand tools to go around, so I made a couple more pairs of tongs, a cut off hardie, and a couple leaf veining blocks.

The night before the first class one of the students from the St. Louis area, Eric Morris, came in early and hung around the shop as I finished up making the needed tools. By then I was intent on getting things ready, so I didn't put a hammer in his hand that night. He still got to observe how some of the tools were made.

The day of the first class I ended up with 4 students, one of them from St. Louis decided that it was too far to drive, and a Shelbyville local missed the starting time and didn't show up until noon. I was also able to get Make Maddox and Thomas Ratliff to come and assist. So we had 3 forges and three instructors, a pretty good set up.



*Week two students Rick Meyer, Bill George, Donnie Kamp*

We started out with an explanation of the zones of a coal fire, where to heat steel and where to avoid. This included a talk about the fire tools used and fire maintenance. I then demonstrated starting the fire in my main forge, and the students started fires in the other two forges.

Once all the forges were lit, the real work began. Square tapers, round tapers, simple hooks, and 'S' hooks. Being a believer in tong clips I showed them how to make tong clips and had them each make some for themselves. It turns out that it takes more control to make tong clips than I expected, but they all got some made.

I had them do flat tapers, an flat taper scrolls. They did a screw driver point taper. And a fish tail scroll.

We did a drive hook, and the final project for the first week was a heart hook. This required them to learn how to punch holes, how to split the top for the heart, and how to do a fuller decoration with a simple spring fuller.



# Beginner's Class

Week two, only three students showed up, so they each had their own forge. They also each got to start their own fires.

We made leaves and leaf hooks.

We did a simple half strike foot, and a more complex half penny round foot.

Finally, we made a pair of tongs. All of the projects this week required them to employ a half strike for part of it, which got them used to using the edges of the anvil. Unfortunately, neither of my helpers could be there the second week so I spent a lot of time floating between forging stations. I had really wanted Thomas there for the tong making because he has done a lot of striking for me and I wanted the guys to draw out the reigns by hand (with a striker). I had Bill George strike for me while I was demonstrating, and then I struck for all three guys when they were making their tongs. This really kept me moving.

We were running out of time so to finish up, I showed them how to form the jaws on a pair of bolt tongs, and how to heat treat a punch that had lost it's temper over the weekend.

Everyone had a good time, they all learned a lot, and are ready to strike out on their own.

This was a much better experience for me than the class 10 years ago, and I might even do it again. I don't have BAM meeting next fall so maybe I'll host another class, I just won't start pushing it so early in the year.



*Week one projects,  
Simple hook ends, "S" hook, drive hook, heart hook. Hole punch practice pieces, I told them they had to do at least 4 holes before trying the heart hook. Flat scroll, fish tail scroll, screwdriver point tapers, and tong clips (various stages of completion).*



*Week two projects,  
Leaf hook, half strike foot, half penny foot, flat jaw tongs, and the sample of the bolt tong jaws.*

# Beveled Scrolls

by James Bequette

Cadet, Missouri

This is a fun element that adds a bit of flare to a project. The ABANA National Curriculum Grille requires two C-scrolls that utilize this element as well as four beveled leaf scrolls which are very similar in style and creation. It is a little difficult to explain in two dimensional drawings so try a couple of test pieces. Practice makes perfect.

Start by forging a long, thin taper. Be sure to thin the tip down to a point as it will make it a little easier to scroll and require less work to bevel. I also like to chamfer the edges to get rid of the sharp edges, but you can make that call based on your needs. **(Figure 1.)**

Begin scrolling on the horn until you reach the desired shape. This part of the process will ultimately dictate the final shape of the scroll. Before you begin to bevel you must decide whether this will be a right or left facing scroll and make sure the scroll is facing in the appropriate direction (Right for right, left for left). **(Figure 2.)**

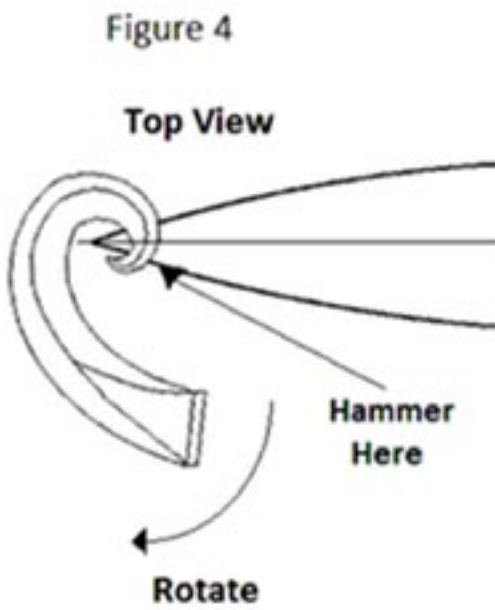
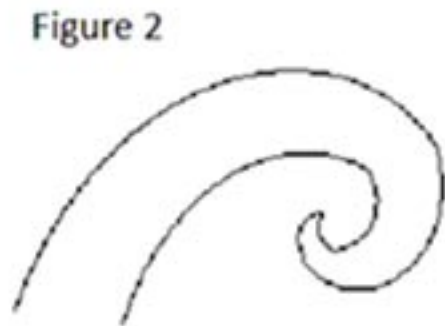
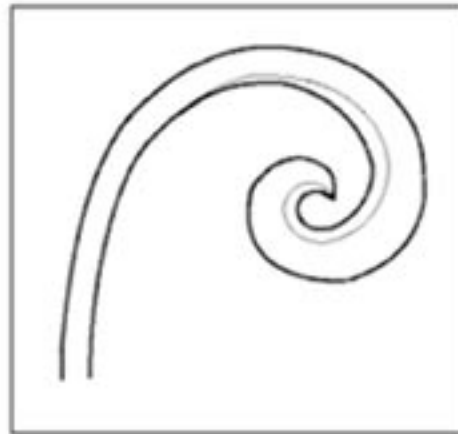
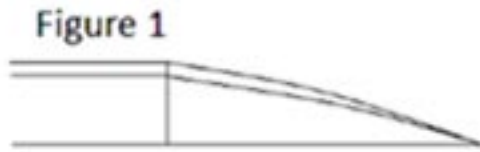
Now you are ready to bevel the the scroll. Establish a centerline through the scroll and begin to bevel each side a couple of inches back from the tip. As a general rule of thumb I bevel to the top of the scroll and then gradually reduce the bevels to the outside of the bar, but you may need more or less depending on the desired shape. You will notice that when you bevel the outside of the scroll it will tighten up and when you do the inside it will open. **(Figure 3.)**

The trick to turning the scroll 90 degrees to the parent bar is to keep the centerline of the scroll perpendicular to the center line of the anvil horn and rotate the scroll as you feed it over the horn. A wooden or rawhide mallet works well to protect the bevel during this process. Once you've made the transition you can finish the scroll using your preferred method. **(Figure 4.)**

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# Beveled Scrolls



# Upgrade your old Treadle Hammer

by Bob Ehrenberger

I made my treadle hammer at a big BAM workshop quite a while ago, 1997 I think. It is the old style with the head swinging at the ends of parallel leaf springs. It has been a great tool and I have used it a lot, almost every



*My old hammer and the BAM hammer at Ken's*

day. I do almost all my hot cutting with it, I use it for applying my touch mark, and if I resize stock I use it to clean up the transitions so that it looks like one uniform piece. When I go to hammer-ins at Ken Jansen's shop I have used the BAM treadle hammer stored there. It is the new style with the ram guided by roller skate wheels. The difference is night and day, with the new style hammer it is so much easier to change top tooling, it is especially good for things like chasing.

I started making plans to upgrade my treadle hammer several years ago. Like most things I do, this required a lot of thought and careful preparations. I took pictures of Ken's (BAM's) hammer and told my wife to look for a pair of used skates at garage sales and flea markets. It didn't take her long to find the skates, but I wasn't ready to jump into the project. The main draw back being that once I started, I would loose the use of my hammer until it was completed.

This summer I got caught up on my work and figured that I would have close to a week before the next order came in. The iron was hot, it was time to strike. I did a quick analysis of the materials on hand and tried to figure out what I needed. I had the wheels, I had lots of heavy angle for framing, I had a 3" OD pipe for the ram. What I needed was some 4" sq. tubing to extend the rear frame and to hold the ram guides. I also needed some light angle to act as ram guides I.E. hold the wheels. I figured that I could salvage half of the 4" sq. from the old hammer head, this would be used to extend the frame. I have some light rectangular tubing that could be used as ram guides in the place of the light angle. That just left the 4" tubing to hold the ram guides. A friend with a fab shop said that I could dig through his scrap, I didn't find the 4" tubing, but I did find a couple short pieces of 4" pipe. I decided to use the pipe along with some of my heavy angle to fabricate the piece that I needed.



*Materials on hand*



*Fabricated guide support*

# Treadle Hammer Conversion

I then cut the rectangular tubing to the length needed and notched each end to make room for the wheels. I made tabs to attach the guide holders and welded them on the tubes just in front of the notches. With these tabs in place I laid the tubes on top of the guide holder to determine where to drill the holes for the wheels. With the



wheels installed in the tubes I drilled and tapped the guide holder frame to line up with holes in the tabs to give me a way to attach the tubes to the frame and allow for adjustment.

Thomas Ratliff came over to help so I put him to work taking the head off of the old hammer and cutting the die holder off so that we could use it on the new ram. The end of the 3" pipe was squared up and notches cut in it to make room for the die eye. A piece of sheet metal was cut to make a stop inside the ram to prevent the lead from filling the key hole. The die plate was then welded to the 3" pipe (new ram). The plates that had been welded to the sides of the old head were cut off, cut in half, and welded to the new ram to give the spring an attachment point. On the BAM hammer they had drilled a hole in the ram to attach the lift arm to, but that required making changes to the spring. I figured that it made more sense to use all the original stuff in a new configuration.

Now came one of the harder parts, getting the lead out of the old head to pour in the new ram. I tried to drill it out which was time consuming and didn't work all that well. So I then started up my forge, created a frame for the head to sit on at any angle and put a pan under the low end to prevent spillage. I put a ladle in the pan to catch lead which I poured into the new ram. The ram came up lighter than the old head so I melted some additional lead to bring it up to the same weight.

Once the lead was out of the old hammer head I could use the 4" tubing to extend the rear frame. I had to cut an angle on it to match the curve of my Quonset style building, not wanting to cut off my anchors and drill more holes in my floor. Once the tubing was cut to match my building, I unbolted the frame and moved it over to my welder. I welded the frame extension on.

It was time to start putting things back together. I used "C" clamps to hold the die plate of the ram in line with the lower die on the anvil. I then threaded the ram guide over it and propped it up at the proper height. Heavy angle iron was cut to length and tacked into place, to act as ram guide supports. Once all the supports were tacked in place I started to burn rod and make it permanent. I'm not a very good out of position welder, but that day things went well and in an hour or so the ram guide was supported and I could take out the temporary prop.

About all that was needed to make it functional was to make the new treadle linkage. I had measured the location of the original rear pivots before taking the old adjustment rack out. I wanted the new rear pivot to come out close to that location. I had a nice piece of 1/4" x 2" flat stock which I cut in half to use as the swinging part of the rear pivot. The other plate that had been taken off of the old head was cut in half and welded to the rear frame. As soon as I had tension on the linkage, the swinging bars torked to the side and bound up the whole system. I figured that they needed a support to keep them apart and parallel.

*Continued on page 20*

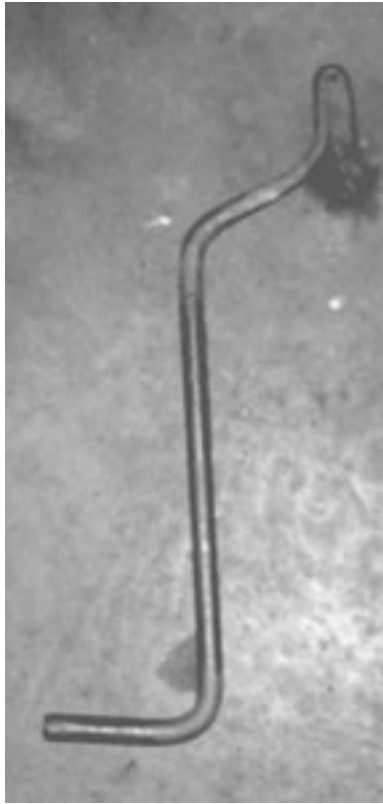
# Upgrade your old Treadle Hammer continued from page 19

I welded a piece of flat it in between the swinging pivot arms and it fixed the problem.

In the process of adjusting the treadle linkage I took out the bolt at the top of the lifting rod and discovered that it was worn most of the way through. This was a grade 5 bolt so I replaced it with a grade 8 bolt. I will also try to remember to oil it more frequently to reduce ware.



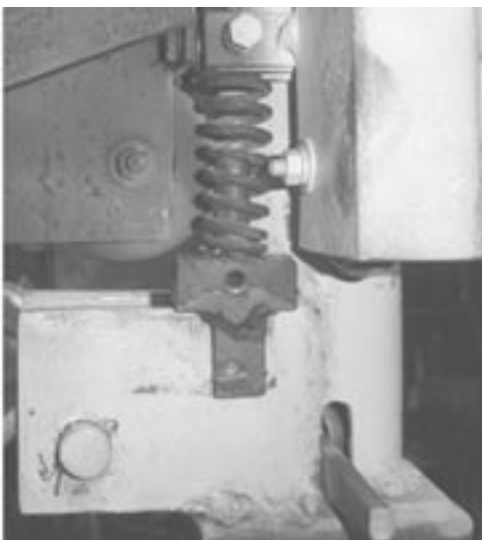
*Above, Treadle control linkage.  
Below, worn out pivot bolt*



*Above, shape of pull down handle.*



*Right, Double pull down handles installed on finished ram in it's guides.*



*Left, recoil spring assembly mounted on ram. This keeps it from slamming home at the top of the stroke.*



*Right, Parts left over from the old configuration.*

# Ohm's Law Chart

CLIP THIS PAGE, PASTE IT ON CARDBOARD AND HANG IT IN YOUR SHOP



Ever wonder how much power flows through your TV, air-conditioner or radial-arm saw? Or what the total power load might be if every appliance and light were turned on in your home at the same time?

You can find out by using the Ohm's Law chart above. In it, I stands for (Intensity), E for volts (Electromotive force), R for ohms (Resistance) and W for watts (Power). Thus it's easy to compute any of these four values by Ohm's Law if you know at least two of them. For example: You buy a new toaster rated at 1100 watts. You want to find out how much current it uses. Use the amperes section of the chart and

pick out the formula that uses the two elements you know — wattage (1100) and voltage (115). Substituting in the formula  $I=W/E$  you get  $I= 1100/115$  or  $I=9.5$  amps. Where you want to find power, use the watts section of the chart and pick the two elements you know,  $W = E \times I$ .

Every electrical device has a clue to its rated power on it. It is given in watts; amperes or horsepower (1 hp =746 watts). Use the appropriate formula and you can figure the electrical load at any point in your service.

*Reprinted from the Sept/Oct 2012 Illinois Valley Blacksmiths Assosiation newsletter*

# Damascus Draw Knife

By Bob Ehrenberger

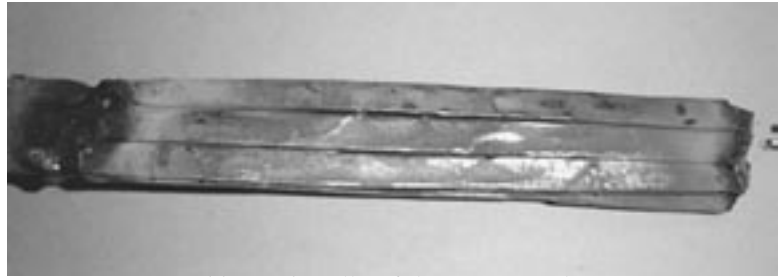
Each year for conference it is a challenge to come up with something nice for the auction. Last year I made the damascus anvil. As part of that project I actually ended with two bars of damascus (pattern welded steel), I used the larger one for the anvil, I decided to use the other one for a draw knife.

As a quick refresher, I had taken a bunch of damascus scraps and forged each one into a bar approximately 1/4" x 3/16". These bars were bundled together and rewelded. The larger bar was welded at Corbin Newcomb's hammer-in, while the smaller bundle I welded by hand using a swage block to keep the pieces from separating. I took this smaller bar to Corbin's hammer-in this year and rewelded it and folded it one time to reduce the number of inclusions in the steel.

I took this bar home to finish forging. First I flattened the whole thing down to the thickness I wanted for the blade. I then butchered in on each side and forged out the handles. Normally when forging on damascus, I do a minimum amount of hammering and a lot of grinding, for fear that the damascus will separate. But this time the quote from Jerry Darnell came to mind, "An extra 10 minutes of forging can save you an hour of file work." So I went ahead and used a set hammer to really work down the transition between the blade and the handle.

I took it to the belt grinder and ground out the hammer marks and as many flaws in the damascus as I could. I then hardened and tempered the blade. It has to be heat treated or the damascus won't etch right.

After the blade was heat treated I hand sanded it down to a 400 grit finish. The blade was then etched in ferric chloride. Every few minutes it was taken out and



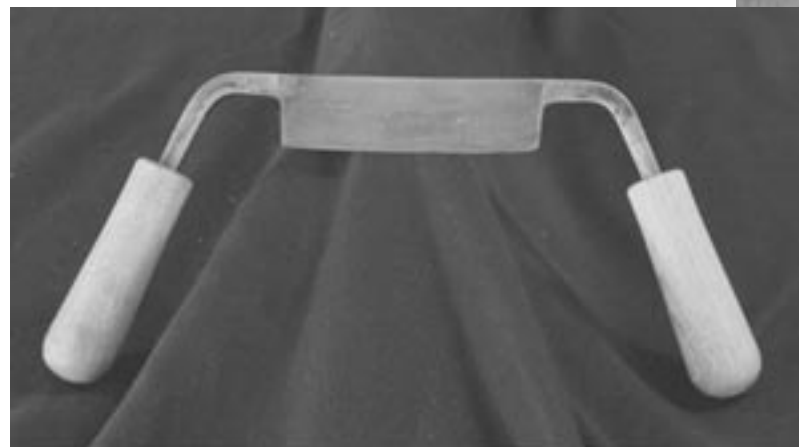
*Above, bundle of damascus rods  
Below, damascus bar after rewelding*



*Above, rough forged blade  
Below, blade ground and hardened*



*Above, Etched, sharpened, and the handles bent*



cleaned up until I got the etch that I wanted. After etching I spot heated the handles with a torch and bent them to the desired angle.

For the hand grips I split and turned an Osage orange fence post. I sealed the grips with linseed oil and epoxied them into place.

*Finished draw knife*

## Knife cutting competition?

We are wanting to know if any members are interested in doing a cutting competition. Steve Culver our knife demonstrator has offered to help us put on a demo here are some links he has sent us on the competition. If members are interested in making a blade and doing this please let me know as soon as possible by means of e-mail [acornridge3@yahoo.com](mailto:acornridge3@yahoo.com) please put knife in the subject line of e-mail .If enough members are interested we will do this at conference and there will be prizes. Thank you, Joe Hurley

Below are links to some cutting competition videos that are on the American Bladesmith Society's YouTube channel. They show a little of what we do.

The knife restrictions for the competition are:

Blade not over 10" long and not over 2" wide.

Overall length of knife, not over 15".

The handle must have at least one metal pin through the handle and blade tang.

There must be a retention lanyard on the handle to wrap around the wrist.

<http://www.youtube.com/watch?v=I6m50Up95aM>

<http://youtu.be/nwA34vuX11A>

<http://youtu.be/mDtQjIC2b80>

I can put together a variety of cutting challenges for the competition.

Steve Culver, President-Kansas Custom Knifemaker's Association

Culver Knives, Meriden, KS, [www.culverart.com](http://www.culverart.com)

### **Boy Scout Camp Needs Equipment**

Michael Garrett works for Camp Gamble at the S-F Scout Ranch south of Farmington . They are trying to start a blacksmithing program at the camp and are in need of tools or any assistance you can offer. Contact Mike [mtg216@gmail.com](mailto:mtg216@gmail.com)

Bob,

We are planing on having a station where we can demonstrate some basic things to the scouts and let them try their hand at blacksmithing and hammer on some railroad spikes. We are basically starting from nothing, so we would be needing tongs, hammers, a blower (hand crank) and an anvil. I am currently working on putting together a brake drum forge. I know asking for an anvil is a bit much as they are quite expensive. I wouldn't be needing these tools until the beginning of May. Also, I know I will be working at the camp this summer again but I can't be positive that I will be working at this position until the beginning of February. Even if I am not the one working this position, we still would like to do this program.

Thanks,  
Mike

### **Demonstrator needed**

Darryl Wagner with the Platte County Steam Engine Show is looking for a blacksmith to demonstrate at next years show August 9, 10, 11. In Platte County, MO.

Darryl Wagner  
Platte County Steam Engine Show  
Email: [dwi@blitz-it.net](mailto:dwi@blitz-it.net)  
Cell: 816-719-0801



# Buy, Sell, Trade

## Individual Classified ads

**For sale:** Here's a list of things I want put in the newsletter. ~ Farriers step vice mfg. By H.J. Boyce Fayette OH patented 1896 patent #558927 \$100, ~ Blacksmiths post drill, Silver mfg company no.668 \$30, ~Trenton anvil with a broken heel, stamped 199 lbs actual weight 110 lbs \$90, ~ Petrogen oxy-gasoline cutting torch bottle 2.5 gallon cost \$880 new asking only \$200, Seth Lancaster (573) 789-0300 [paultressa@netzero.net](mailto:paultressa@netzero.net)

**For sale: Champion 400 Blower on Stand \$100**  
**Buffalo Forge w/ Mounted Blower & Coal Bin \$100**  
Ready for forge pot and tuyere. 35 L. x 29 W. x 6 deep. 4'  
**Floor Cone \$600** No tong slot, **Tire Bender \$200** I. I. & Co. 19 R, Compound geared and adjustable, **Edwards #20 Compound Mechanical Shear \$100** Good blades, **Guillotine Style Blacksmith's Helper w/ H13 Die Blank \$250 NEW**  
Heavy duty CNC cut and fabricated tool with decorative design incorporated into the frame. Andrew MacDonald made these while at Southern Illinois University's Metal Smithing Studio. Roy Plumlee, Tamaroa, IL 618-534-2013  
Email: [royplumlee@frontiernet.net](mailto:royplumlee@frontiernet.net)

### For Sale

Anvil - Peter Wright 243 lbs.;\$400

Anvil - Peter Wright 124 lbs.;\$175

Tuyere - Heavy Duty;\$50

See pictures and more details "http://members.ktis.net/~jrogers/blacksmith.html" or email me at "old.anvils@gmail.com" with any questions. Thanks! J.D., Little Dixie Forge, Mexico, MO

## Commercial / Resource ads

### Services:

**Beverly Shear Blades Sharpened.** Remove blades from shear and ship to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670 \$41 includes return postage, additional cost for deep notches or blades previously sharpened at angle.

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

**Roller Blade Treadle Hammers** (Clay Spencer design) for Sale or Workshops led to build hammers. Bob Alexander, e-mail to [scruboak4@netzero.com](mailto:scruboak4@netzero.com), or call 636-586-5350.

### Information / Education:

**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, or (417)-321-2286 cell

Back issues of Jerry Hoffmann's **Blacksmith's Journal**,  
Call 1-800-944-6134 for more information.

**Classes offered,** The Ornamental Iron Shop  
Contact the instructor to register and customize your class.  
John D. Thompson – Metalsmith  
3923 Hwy 25; Hodges, SC 29653 864-374-3933

**Classes** at Pieh Tool Company, Inc. - Camp Verde, AZ  
The Bill Pieh Resource for Metalwork.  
Call now for more information and to enroll:  
(928) 554-0700 or (888) 743-4866. [www.piehtoolco.com](http://www.piehtoolco.com).

**Mathias Penn** is offering introductory & beginning blacksmith classes. 417-683-9000 [Tytheblacksmith@yahoo.com](mailto:Tytheblacksmith@yahoo.com)

The Upper Midwest Blacksmiths Assoc (**UMBA**) **video library.** An index list can be viewed at [www.umbaonline.org](http://www.umbaonline.org)  
They are VHS or DVD-R Cost is \$5 each with \$2 per order shipping There is no return date, you keep the video for this price. All videos are made at group demos, no commercial titles.

### Blacksmithing E-books on CD

Now eight titles are available on CD, \$4/each, or all eight books, \$24 postpaid. More books are in production and will be available soon- order on-line at [www.blacksmithingebooks.com](http://www.blacksmithingebooks.com), or check/MO to Brian Gilbert, 3404 Hartford Dr., Chattanooga, TN 37415.

### Ray Clontz Tire Hammer Plans by Clay Spencer

Send check/money order for \$30 to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Includes postage to US and Canadian addresses. Other countries e-mail [clay@tirehammer.com](mailto:clay@tirehammer.com) for price. 256-558-3658. Tire Hammers for sale contact me for current price.

### New England School of Metalwork

[www.newenglandschoolofmetalwork.com](http://www.newenglandschoolofmetalwork.com) 1-888-753-7502

### Power Hammer page

I've taken some time to collect and post old info, catalogs and brochures on power hammers. The link of our NEB web page to this information is: [http://www.newenglandblacksmiths.org/power\\_hammer\\_info.htm](http://www.newenglandblacksmiths.org/power_hammer_info.htm) Ralph Sproul

**Rochester Arc & Flame Center!** Featuring Blacksmithing, Welding & Glass Blowing Over 30 classes available for all levels of interest, [rocafc.com](http://rocafc.com) 585-349-7110

**For Sale:** Power Hammer instruction DVDs. \$125 per set. Clifton Ralph, 4041 W 47st, Gary, Indiana, 46408 (219)980-4437

### Products:

**Scrub Oak Forge:** We still have the Ozark Pattern anvils, and hand hammers. For more info on the tools contact Bob Alexander at 636-586-5350 or [scruboak4@netzero.net](mailto:scruboak4@netzero.net)



## Buy, Sell, Trade, Continued ...

**Heavy-Duty Fry Pan Blanks** 9" diameter, tapered sides 12 or 13 gauge steel (approx. 2 pounds) no predrilled holes for the handle \$12.00 each..1-4, \$10.00 each..5-9, \$9.00 each...10+. shipping:\$5.00 plus \$1.00 each frypan Bob Tuftee 563-332-4800 6 Hollows Court LeClaire IA 52753

**L Brand Forge Coke** now packaged in 50 pound bags on pallets. Send your zip code for a quote on price including delivery. 1-678-360-3521 or LBrandForgeCoke@aol.com.

Chile Forge- Next generation **gas forges**  
www.chileforge.com David Starr 520/360-2141

**Kayne and Son** Custom Hardware, 100 Daniel Ridge Road, Candler, NC 28715. (828) 667-8868 fax (828) 665-8303, e-mail: kaynehdwe@charter.net, web site: www.blacksmithsdepot.com. Offering a full line of blacksmithing equipment. We ship and accept Visa and Mastercard.

D.L. Schwartz Co. **Blacksmith and Farrier supplies.**  
2188 S. US 27, Berne, IN. 46711, 1-800-955-3064

**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

Persimmon Forge **PEDAL HAMMER** sit down treadle hammers for sale. Contact Dave or Betty Edwards by e-mail at djedwards@cableone.net, or write us at 3008 Hacienda Ct., Emporia, Ks., 66801, or call us at (620) 343-1947. For more information, go to www.persimmonforge.com and click on both "Pedal Hammer" and "Video Demo of Pedal Hammer."

USA Dealer for **REFFLINGHAUS ANVILS**, 77 to 1250 lb. European 2 horn with or without upsetting block & side shelf. Over 100 sizes and styles available. Guaranteed face @ HRC59 Dick Nietfeld www.blksmith.com Phone (308) 384 1088

### **Wanted:**

Blacksmith business cards. I would like to put together a collage of Blacksmith business cards. Bring them to a meeting or mail them to me with your dues.

Bruce Herzog  
2212 Aileswick  
St. Louis, MO 63129

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### **Demonstrator List**

Fred Weisenborn has started a list of members available for demonstrations, fairs, historic events, and festivals, etc.  
417-589-2497 e-mail: jweisenb@llion.org

**Around the Anvil** BAM has its very own E-Mail news group. If you would like to participate there is a sign up link on the bamsite.org or send an E-Mail to Bernie Tappel at bamweb@embarqmail.com and he will get you signed up.

We've been having a lot of activity on the BAMSsite tailgate page lately, lots of new listings. The stuff has been coming on and going off when it sells, so members should be made aware that they might want to check it occasionally if they are looking for tools.

Bernard Tappel

**Check out back issues of BAM newsletter on  
www.bamsite.org**

**Ad Policy:** Blacksmith related ads are free to BAM members. Personal ads will run for two issues. Resource ads are ongoing at my discretion. Send to bameditor@centurytel.net, or call 573-633-2010

**Job available:** A full time seasonal (about 10 months per year) blacksmith job is available at Silver Dollar City in Branson, MO. (a 1880's theme park similar to Dollywood). Looking for blacksmith/sandcaster with experience to make items for sale while demonstrating for guests. Would prefer someone with some blacksmithing skills as the sandcasting is much easier to learn. Helps to be a people person as most of the work is done in front of guests. Hourly wage as employee of Silver Dollar City, tools supplied, items sold in retail store. Hourly rate negotiable based on experience. If interested contact HR at 417 338-2611.

### **Artist-Blacksmith Career Opportunity:**

Got good skills in forging, welding and general shop work? Want to make it as a full time artist-blacksmith and designer-craftsman?

A master blacksmith with an established shop seeks a career-minded person to work into partnership with potential for full business ownership.

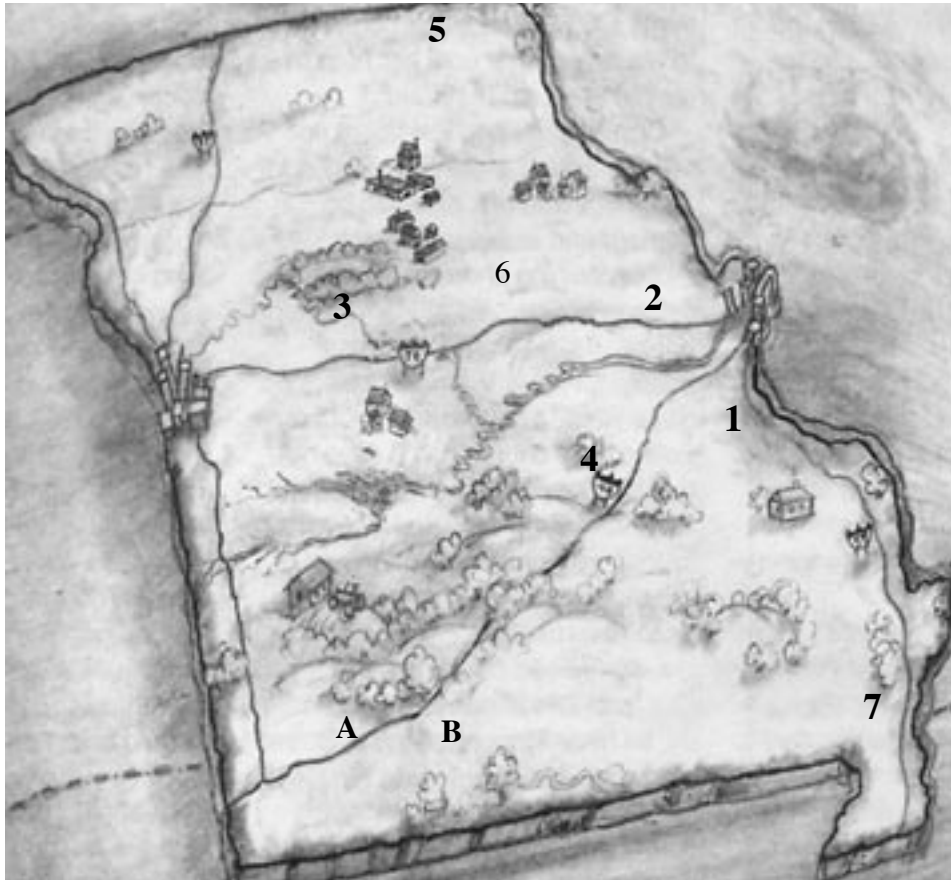
Serving clients throughout the Mid-Atlantic area, the 30' x 40' workshop is situated on a busy state route, within 100 miles from Baltimore and Washington, DC. The shop is versatile and well equipped for a variety of commissioned work. The flexible work schedule allows time between deadlines for purely creative work and recreational pursuits. Your own ideas, projects, clients and designs will be encouraged and welcomed into the shop. This opportunity has no preconceived structure or time frame - details can be worked out beginning with one or two introductory visits including a few days room and board, or longer if it's a good match and you return to begin settling in. Comfortable, convenient housing is easily available in the surrounding area, with relatively low cost of living and an active, supportive artistic community.

Contact: Artistblacksmith@frontier.com

# 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 Carter Rd.,  
Moscow Mill, MO. 63362

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

4. Jerry Rehagen, (573) 744-5454  
390 Bozina Valley Trail,  
Freeburg, MO. 65035

5. Joe Hurley (660) 379-2365 or 660-626-7824  
Rt1 Box 50  
Downing, MO. 63536

6 Paul Lankford, 573-473-7082  
25849 Audrain Co. Road 820,  
Mexico, MO 65265

7. Bob Maes, 573-866-3811  
Rt. 1 Box 106 K  
Millersville, MO. 63766

Note: Jeff Willard is no longer carrying coal.

Price \$14.00 per bag BAM members, \$19.00 per bag Non-members, \$12.00 per bag at Bob Alexander's  
Coal keepers earn \$3.00 a bag. NOTE: PRICE CHANGE

A. Non BAM coal \$.40/lb check \$.35/lb cash bring your own containers. Tim Johnson Springfield, MO 417-886-8032  
B. Matthias Penn Oklahoma coal Price, 25cents/pound for any amount. Located in Ava, MO. 417-683-9000  
E-mail: tytheblacksmith@yahoo.com

# Upcoming Events:

- November 23 - Black Friday Hammer-in at Ken Jansen's shop Moscow Mills, MO Theme: punches & drifts
- January 1 - Application deadline for February Scholarship awards.
- January 12th, - BAM Meeting A & K Cooperage, Higbee, MO 660-456-7561 trade: corkscrew Food will be available
- January 19th Newsletter submission deadline**
- March 23rd 2013 - BAM meeting Martin sale barn, Excelsior, MO, Don Nichols host 660-826-9252, trade item: spatula
- April 1 - Application deadline for May Scholarship awards
- May 2nd-5th -**BAM Ozark Conference**, Sedalia, MO contact Mike McLaughlin cowpie42@hotmail.com
- May 2013 - BAM meeting Ned Digh, Ham's Prairie 573-642-9502
- July 2013 - BAM meeting Doug Clemons, Malta Bend, MO 660-595-2257
- August -2013 Missouri State Fair Sedalia, MO contact Kent Harbit (660)-647-2349 to volunteer
- September 2013 - BAM meeting Matthew Burnett, Cameron, MO. 816-575-2798
- October 1 - Application deadline for November Scholarship awards.
- November 2nd 2013 - BAM meeting Don Birdsall, Rolla, MO.573-364-7223 trade item [art object]
- March 2014 - BAM meeting Chris Miller, Doniphan, MO 573-996-4931
- July 2014 - BAM meeting Denis Yates, Hohn Boy Scout Camp
- September 2014 - BAM meeting Bob Ehrenberger, Shelbyville, MO 573-633-2010

## Shop Tip

Dave Mudge posted this to the editor's list, I think he got it from Wayne Coe.

## Penetrating Oils

Machinist's Workshop MagT recently published some information on various penetrating oils that I found very interesting. Some of you might appreciate this. The magazine reports they tested penetrates for break out torque on rusted nuts.

They are below, as forwarded by an ex-student and professional machinist. They arranged a subjective test of all the popular penetrates with the control being the torque required to remove the nut from a "scientifically rusted" environment.

*Penetrating oils .....	Average torque load to loosen*
No Oil used .....	516 pounds
WD-40 .....	238 pounds
PB Blaster .....	214 pounds
Liquid Wrench .....	127 pounds
Kano Kroil .....	106 pounds
ATF*-Acetone mix.....	53 pounds

The ATF-Acetone mix is a "home brew" mix of 50 - 50 automatic transmission fluid and acetone. Note this "home brew" released bolts better than any commercial product in this one particular test.

Our local machinist group mixed up a batch and we all now use it with equally good results. Note also that "Liquid Wrench" is almost as good as "Kroil" for about 20% of the price.

Steve from Godwin-Singer says that ATF-Acetone mix is best, but you can also use ATF and lacquer thinner in a 50-50 mix.

## New Members

If you have a new member near you, welcome him to the group and show him the ropes.

Ashton, Fredric  
10750 W Walnut Grove Lane  
Rocheport, MO 65279  
fwashton@gmail.com  
734-323-2184

Couch, John  
6006 Culbertson  
Antioch, TN 37013  
papacouch@comcast.net  
615-941-1256

Poelker, Tom  
7237 Princeton Ave  
St Louis, MO 63130-3028  
tompoecker@aim.com  
314-725-7237

Bagley, William  
9940 Liv 2302  
Chillicothe, MO 64601  
t\_r\_bagley@hotmail.com  
660-752-6204

Myers, A. Leo  
8650 Hwy MM  
Hannibal, MO 63401  
lm.pm@live.com  
573-248-0384

Switcher, Don  
5324 Rocky Hill Road  
De Soto, MO 63020  
618-406-4062

Caleb, Cook  
19101 S Hey 63  
Rolla, MO 65401  
573-341-1982

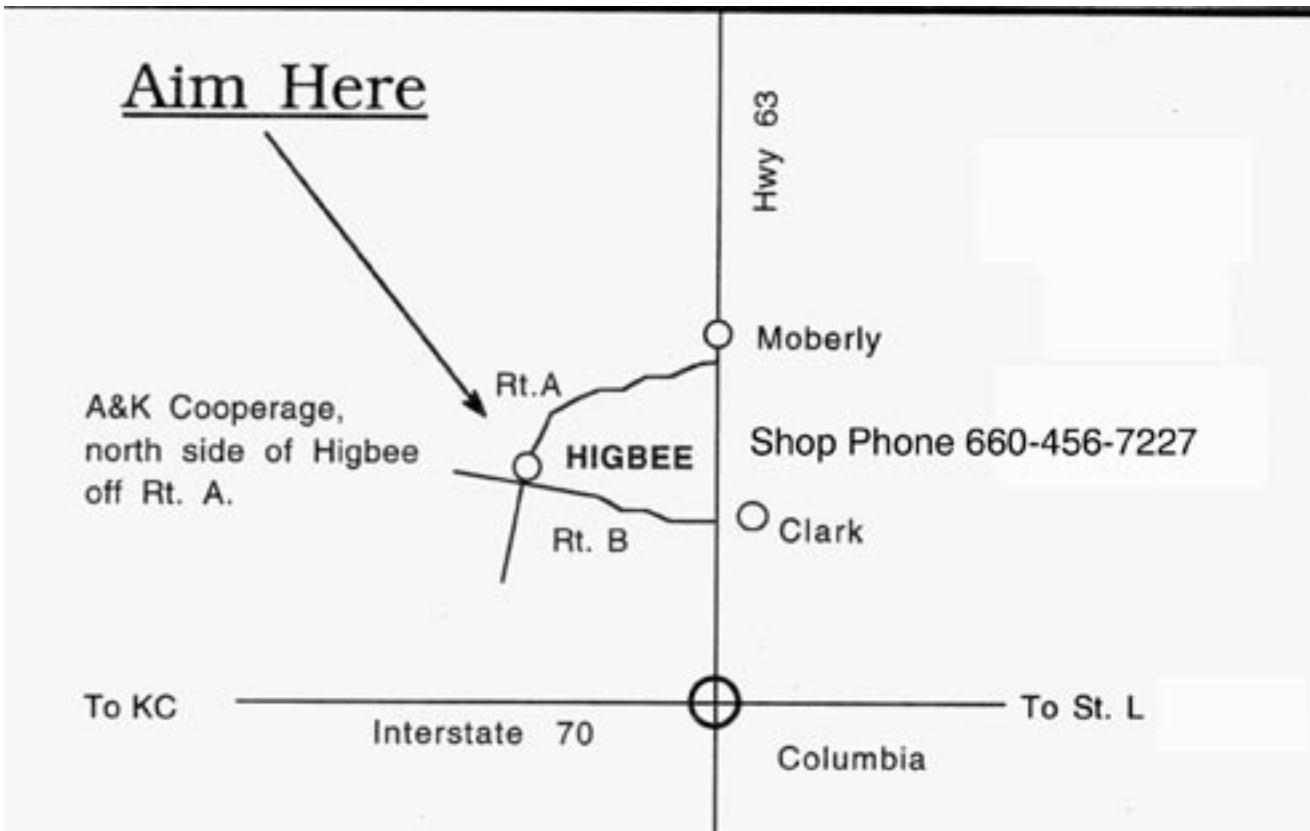
Pendergraft, Jim  
301 West Clark Street  
Versdilles, MO 65084-1821  
jjpend68@yahoo.com  
573-378-5861

**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@att.net](mailto:bjherzog@att.net)

**Next Meeting: January 12th, Higbee, MO.**



**Location:**

A&K Cooperage  
Higbee, MO.

**Host:** Dale Kirby

**Phone:** 660-456-7561

**Food:** YES

**Trade Item:**  
Cork Screw