

BAM

MARCH/APRIL 2013



Display of BAM corkscrews at A&K Cooperage

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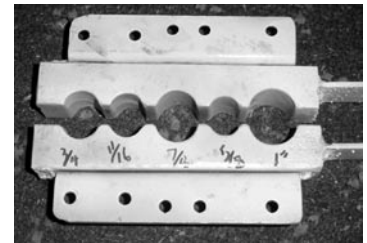
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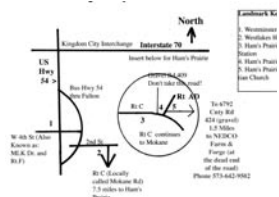
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**Newsletter of the
Blacksmiths
Association
of Missouri**

Volume 30 No. 2

March - April 2013

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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.

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See reverse

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MasterCard VISA Check/Money Order

Card Number

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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

We had a great day for a meeting. I didn't know what to expect, so dressed real warm. It turned out that Marvin's horse shoeing room not only was insulated it was heated. Again we had a good turnout for the meeting and a lot of real nice trade items. Unfortunately since Bruce didn't make the meeting you have to put up with my pictures which are lacking when compared to Bruce's. Marvin also had some interesting stuff to look at. There was Bar-B-Q grill shaped like a revolver, a 615 pound anvil and a rather large bridge anvil.

The demonstrations started out with Marvin's son Leonard resetting the shoes on one of their horses. After Leonard was done, Don Nichols took over. Don brought a homemade anvil he had put together from a piece of rail road track. He wanted to show some of the beginners that you didn't need to have an expensive anvil to get started and do nice work. Don really showed a lot of stuff, he did a braided handle with a marble trapped in it, a decorative twist with some chisel work, several tapers, a new design for a nail header, a pig head, and some interesting shapes from the scrap pile. Like usual Don had lots of tooling ideas that will make our lives and work a little easier. Don also tried to convince us that his tools were painted Hunter Purple. I don't know, Don, they still looked pretty pink to me.

Part of the wait is over. Daniel's wife had a boy on February 5th. 7 lb. 15oz. named Connor Alexander Ehrenberger. My daughter's twins are due in May, with 3 months to go she was as big as she usually is at delivery. What a wild time.

I have had a busy winter. I've had plenty of work in the shop, in fact I worked harder in January

than I have for many years. As a result I haven't had the time to cut wood that I usually do and have been buying my firewood for the past 2 months, which is the first time ever. I am glad to say we made it through another winter without any frozen water pipes. Unfortunately when I checked my cellar this spring I found that the sump pump had quit and it was flooded. I really do need to add access to the cellar from inside the house so I can keep a better eye on things.

I have managed to make some improvements to the shop by adding the jib crane and tapping machine as well as some small tooling. I also picked up a new



Connor Alexander Ehrenberger

slack tub in Higbee, the old one was starting to look pretty tough after 15 years use.

A reminder to all of you, if you do something to improve the efficiency of your shop, please take some pictures and share it with the group.

Reading the newsletters from the other groups it sounds like most of the editors have to do it all by themselves. You all have been good to me, and I get something from the membership for most

newsletters. A big thanks this time to Ned Digh and Bob Stormer for the articles they have submitted.

Walt sent me a note after the last newsletter. He took exception to the idea that only grandsons were potential blacksmiths. Walt said that he has taught lots of girls in the craft, and some of them have been very good at it. Sorry, I didn't mean to offend or exclude the girls that want to hammer iron.

Correction: Scott Stager wanted me to point out that his twisting wrench with the removable handle that was pictured in the last newsletter was actually made by Mike Gentsch.

There seem to be a lot of other conferences on the same weekend as our Ozark conference. I'll put them on the schedule for our members that live out of state. But if you are in or near Missouri, we expect to see you in Sedalia this May.

The next Newsletter submission deadline is May 18th



*Key ring tree,
Please bring a contribution.*

BAM MEETING FOR March 2013

Hosted by Marvin Martin and Family
Minutes by Don Anders

Thanks to Marvin and family for another really interesting meeting. Marvin had the meeting in an operating Farrier/saddle repair shop. A shoeing demo was done and Don Nichols made a braided handle and did several bends on electrician's conduit benders showing how hot tubing and rod can be bent on the conduit bender.

Mike McLaughlin gave a conference report, everything on track, please make something for the auction, or boutique. Don't forget if you have made something you are proud of to bring for the for the gallery. Mike said that there is always room for more volunteers. Please make something for the ring tree, Mike brought it to the meeting and he really did a good job on it. The tree and decorations will be sold at the conference auction. Contact Mike for details.

Phil Cox is heading up the forging contest. He said that it will involve making a small half tong piece to match an existing half that he has already made, closest match wins.

Ned Digh is again making tool boxes for raffle at the conference, he needs items and tools to fill 3 tool boxes.

Chris Miller was talking about a Civil War reenactment in Doniphan, check it out if you are interested.

Dennis Yates needs volunteers for the Boy Scout camp blacksmith program. He was alone several days last year and had a big class help would be greatly appreciated.

Treasures report given by present Doug Clemons for treasurer Bruce Herzog, BAM membership holding steady at 557.

Bar-B-Q grill



Trade Item: Spatula with a fancy handle

Made by
Mike McLaughlin
Tony Brooks
Ken Jansen
Wayne Colhour
Erin Kilburn
Josh Helm
Don Birdsall
Steve McCarthy
Matthew Burnett
Bob Ehrenberger
Randy Hughes
Denny Quinn
Colin Ward
Don Nichols
Julian Carrier
Bob Stormer
Bernie Tappel

Traded to
Denny Quinn
Don Birdsall
Mike McLaughlin
Matthew Burnett
Bernie Tappel
Tony Brooks
Don Nichols
Randdy Houghes
Julian Carrier
Steve McCarthy
Ken Jansen
Bob Stormer
Bob Ehrenberger
Wayne Colhour
Colin Ward
Josh Helm
Erin Kilburn

IRON IN THE HAT

Donated by	Item	Won by
Donald Davies	farm imp.	Mark Sampsel
Harry Weber	wooden corners	Dennis Quinn
Mike McLaughlin	Key rings	Don Nichols
Dennis Quinn	Gum coal	Karen Bouckaert
Karen Bouckaert	Cat buckets	Scott Stager
Don Nichols	Demo piece	Micah Hasholder
Dennis Quinn	BAM Mug	Josh Helm
Ray Scott	B.S. Mags & books	Dennis Quinn
Harry Weber	wooden corners	Dennis Quinn
Donald Davies	candle cups	Steve McCarthy
Dennis Quinn	2 BAM mugs	Karen Bouckaert
Don Nichols	metal disks	Erin Kilburn
Bob Ehrenberger	feathers	Mike Gentzsch
Don Birdsall	bearing braces	Tom Patterson
Mike Gentzsch	anvil tester	Mark Sampsel
Don Birdsall	?	Mark Sampsel
Matthew Burnett	RR spikes	Scott Stager

Key Ring Tree

The goal of the tree is to have an auction item that the entire membership can participate in. The high bidder at the auction will be able to take home an item that could have something from everyone. The rules for making an item are simple. It needs to be able to fit in an approx. 3" x 4" area and be able to hang. It can be anything that you want. Key ring, bottle opener, Christmas ornament, or use your imagination. All of them will be numbered and names will be put in a book. If you can't make it to the conference, you could send it with someone who is or mail it to me.

Thanks, Mike McLaughlin

President's Message:

Greetings,

It's a good thing that I have a calendar. Otherwise I may not have known it was spring already. Hopefully by the time you read this, the snow will be gone and I will be back to doing farmer stuff.

We had a really good turnout at the meeting March 23. Thanks to our hosts the Martin Family for having us there and showing us a bit about shoeing horses. Also to Don Nichols who arranged the meeting and demonstrated. Don is a good demonstrator and does well at explaining what he is doing and why.

Most of the business meeting was centered around the upcoming conference. Most of you have received a conference bulletin by now but for those who read our newsletter online I should mention a little about it here.

The conference is held at the Missouri State Fairgrounds in Sedalia, MO. The dates are May 2 thru May 5. We have three main demonstrators lined up. In no particular order they are Randy McDaniel, Gerald Boggs and Steve Culver.

This year we will also have a Key Ring Tree as an auction item. Everyone is asked to make a small item to hang on the tree. It needs to fit in a 3"x4" area and be able to hang. The item can be a key ring, bottle opener, Christmas ornament or nearly anything.

There will also be a traditional forging contest Friday evening. Sign up before 7:00 p.m..

There will be a lot more going on as well such as workshops, iron in the hat, raffles and the gallery. There is not enough room here to mention it all.

If possible, try to bring something to donate to the auction or to the boutique.

The conference is the only fund raising opportunity we have. Our dues barely pay for our newsletter and conference registration sometimes does not even pay for all of our conference expenses. So the auction and boutique are where we make the money that allows us

to operate all year.

In other business, Denis Yates has asked to use the MTS teaching trailer again this year for his program with the Boy Scouts at Camp Hohn. The program will run for four weeks beginning June 16 and running thru July 13. Denis has asked for anyone who is able to help any of those days to volunteer. The busiest days are Tuesday thru Thursday. They have a lot of participation with many scouts receiving merit badges. If you can help, please try to contact Denis Yates.

Also there will be a hammer-in at the Doniphan Community Forge at the Tom Kennon Blacksmith Shop during the Civil War Days festival in Doniphan, Mo April 19 & 20.

The forges will be open both days for demonstrations by the local BAM Members. All visiting BAM members are welcome to join in an impromptu hammer-in. For more information, contact Chris Miller at 573-996-2090 or for area tourism information go to www.doniphanmissouri.org.

Well the clock is ticking. I better get this off to Bob the Editor. He gave me a little bit of an extension until after the March meeting. I better not press my luck. I like to try to get this in before his second e-mail reminding me.

Our next event is our conference. After that, our next meeting is June 8. It will be hosted by Ned and Esther Digh. Trade item is a candle snuffer.

I hope to see you there.

Doug Clemons

Horseshoeing Demonstration

By Bob Ehrenberger

Leonard Martin showed us how to shoe a horse. He picked one of their own, a large black stallion that was extremely gentle. Having 50 people crammed into the room didn't phase him at all.

The first step was to cut the clinched ends off of the nails. After the nails were cut off, the shoe was pried off with the nippers. While Marvin cleaned up the shoe and removed the old nail heads, Leonard went to work on the hoof. He cleaned the frog, clipped off the excess hoof material, and filed the bottom of the hoof flat.

Before nailing the shoe back on he made sure that the hoof set right on the floor. Adjustments were made to the angle of the hoof by filing. Before setting the shoe, flats were filed on the hoof that matched up with the clips on the shoe and the shoe was adjusted cold at the anvil.

Leonard showed us how the nails had a flat side and a beveled side to make it easier to drive them in at an angle, so they only went through the outer wall of the hoof and missed quick. As soon as each nail was driven in it was bent over to prevent it from getting snagged on the horse-shoer.

Once all the nails were in place Leonard backed up the hoof with a small hand anvil as he tightened up all the nails.

As a final step, he put the hoof on a small stand. I couldn't see very well from where I was but I think he filed the outside of the hoof to match the profile of the shoe and finished clinching the nails.



I got distracted and didn't see the rest of the demo, but the guys on Around-The-Anvil filled in the gaps.

When he put shoes on the front feet he put the shoes in the gas forge and forged a clip on the front of the shoe and then adjusted it for the width of the front foot. Basically the hot shoeing was for adjusting to the size of the horse's hoof. He used commercial shoes but they need a little fine tuning every now and then. Mike Gentsch

He demonstrated drawing toe lips for front shoes & side clips for hind shoes, When he did the shoeing demo (resetting the hind shoes) he showed how to rasp a flat spot where the clips fit on the outer wall of the hoof. With new shoes, the clips are often heated and burnt in for a real tight fit. I have known Marvin for several years, He told me 4 or 5 years ago they averaged 3200 to 3500 a year, Leonard told me at the meeting they had started closing 2 days a week & cut back to around 2400 or so a year. Take it from an ex-horseshoer, "that's still a lot of work" Tony Brooks

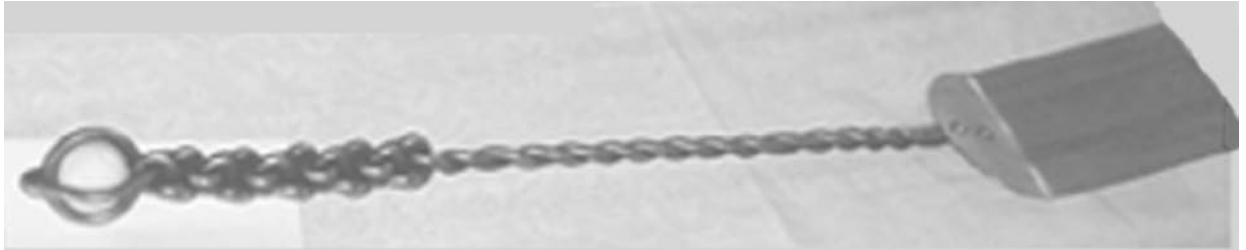
While I was not at the meeting, I am a Farrier. Clips are burned into the hoof wall. It will usually be sunk to the depth of the width of the clip. I generally only use them on hooves with crack issues and on draft size horses to help support the weight of the horse on the shoe. The pressure is huge as you can imagine on the nails.

Dave Dow

Don Nichols' Demonstration

By Bob Ehrenberger

Don always has lots to show us, he never runs out of interesting ideas and shop tips. He started out with a braided handle with a marble trapped in it. You can find the instructions on the braided handle technique in the March/April 2005 newsletter. The only difference in Saturday's demonstration was Don started both pieces over the 1" form so that when they were put together they created a cage to hold the marble. Then when the handle was done he bent one of the loops out of the way to make room for the marble. I took a picture of this last step but it was blurred. Below is a picture of Don's trade item which has the same handle.



Don then went on to one of his favorite past times, creating decorative twists. For the one he demonstrated this time he put several cuts on each side at a 45 deg. angle. Then when the bar was twisted the cuts lined up to make it look like they were wrapped around the bar in the opposite direction from the twist.

Don also showed off his new twisting jig which holds the end of the bar while it is being twisted without the use of a vice.



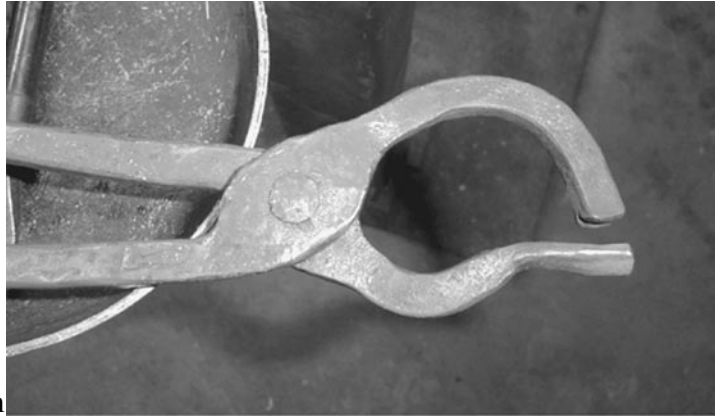
Next Don talked about how drawing tapers is a good exercise for beginning smiths. They teach hammer control and don't use much material. You can taper the end of the bar and then cut it off and do it again. Don went ahead and tapered the bar with the decorative twist and a couple more small bars.



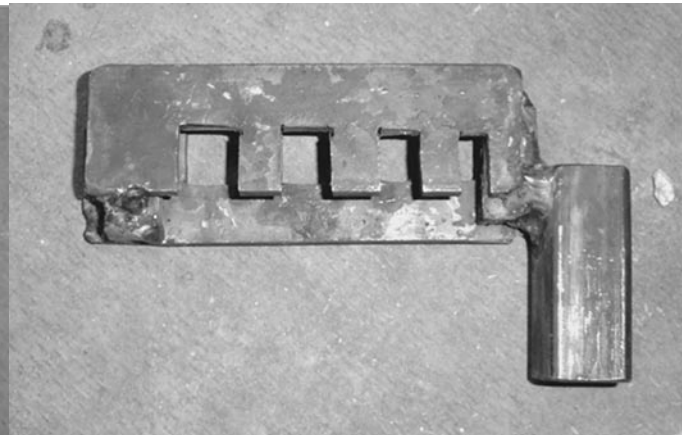
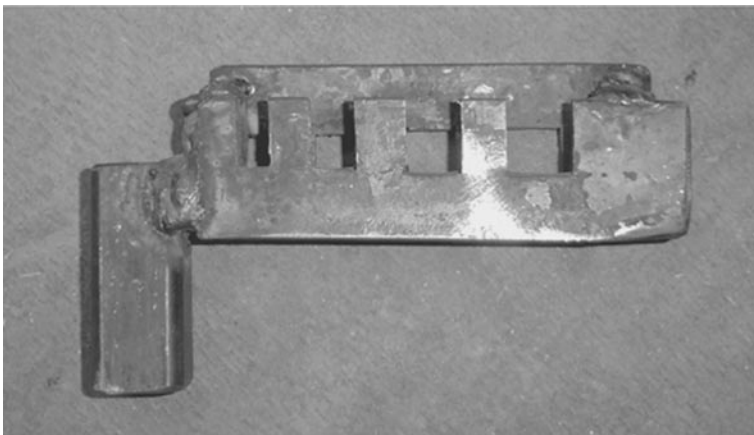
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Don Nichols continued..

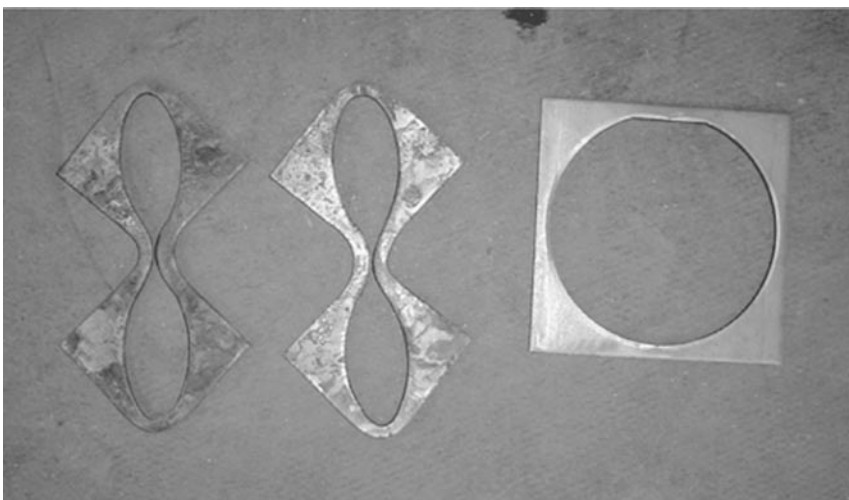
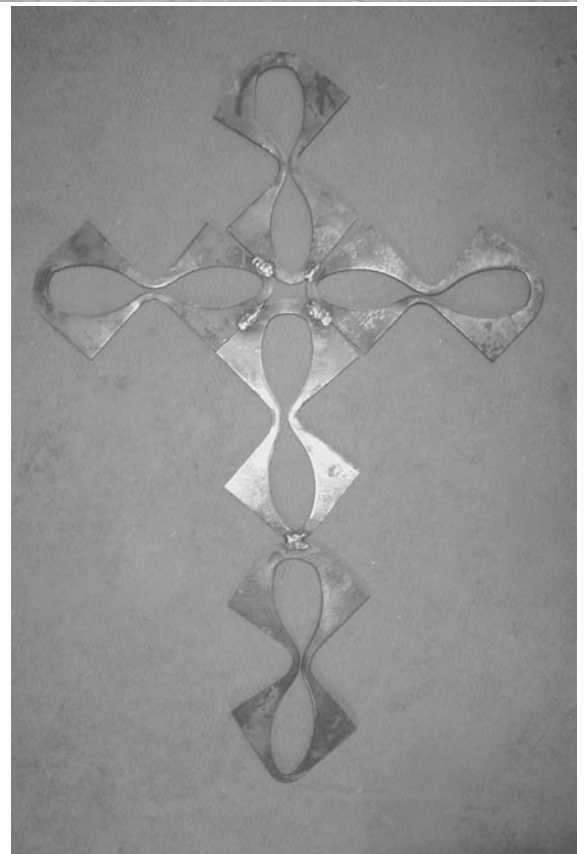
Don talked a little bit about the tongs he was using to hold the tapered end of a bar. They have a long "V" groove on the bottom and a short "V" groove on top. The affect is it holds the piece by pushing it into the long groove, and it doesn't matter whether it is straight or tapered the effect is the same.



His twisting jig is created by tacking two flat bars together and making several different sizes of notches in them. Once the notches are done the tack weld is ground off and one side is flipped over. They are welded back together with a spacer between them and welded onto a stud that fits your hardie hole. When in use, the side that is upside down holds the bar to be twisted and keeps it from jumping out of the groove.



Don showed how he plays around with the scrap he picks up at work. He had some square pieces with holes punched in them that when heated can be collapsed into some interesting shapes. He was then able to put these shapes together into some interesting objects. One he brought to show us was a cross.



Don Nichols continued...

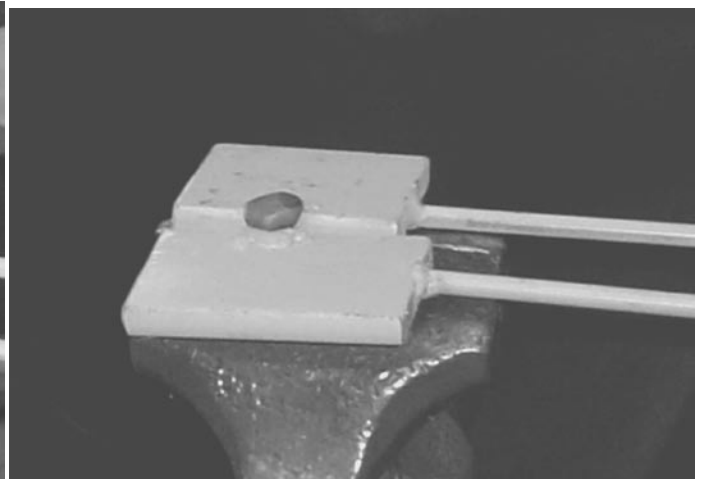
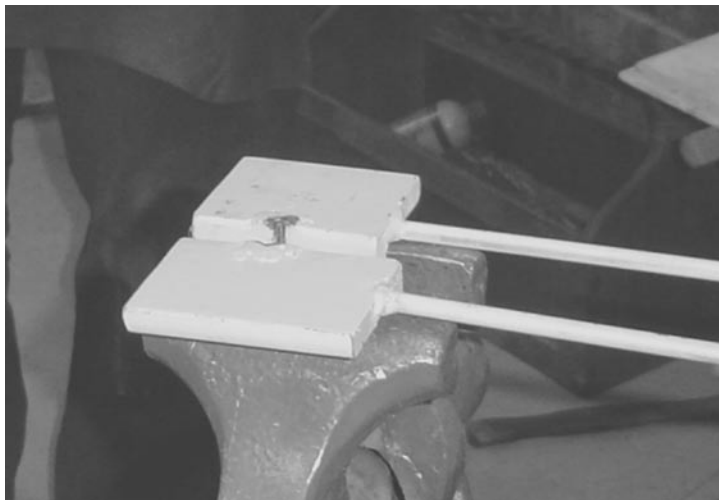
Don also brought some conduit benders that had their handles shortened and showed how they could be used to bend hot steel. He showed how to bend square stock on the diamond, square tubing on the diamond, and angle iron both with the open side out and the open side in. They each had their own affect and made interesting design elements. Depending on how big the stock was to bend and the radius that you wanted you would use different sized benders. So keep an eye out for them at flea markets and garage sales.

Don made an interesting little pig head on the end of a bar. The steps are as follows:

1. Start by isolating a small piece of material on the far side of the anvil.
2. Then use a hollow ball punch to make the eyes and a center punch to give them pupils.
3. With a sharp chisel the ears were cut from back to front and kind of folded over to lie on the face.
4. A straight edged chisel was used to cut the mouth and put wrinkle lines in the snout.
5. Finally the nostrils were punched to finish the head.



Don's next item of interest was a new way to make a nail header. Instead of punching a hole in a large block as is normal, he used two pieces of angle iron with matching "V" notches and a spring handle. The idea was that instead of having to get the nail tapered to exactly fit a hole in the block, you just have to get them close. You can then clamp them in the header in the vice and you are good to go. One angle iron header could be used for a range of nails like 1/8" to 1/4", and you wouldn't have to have a header for each size. It also has the advantage that the nails never get stuck in the header, when you open the vice the header releases the nail.



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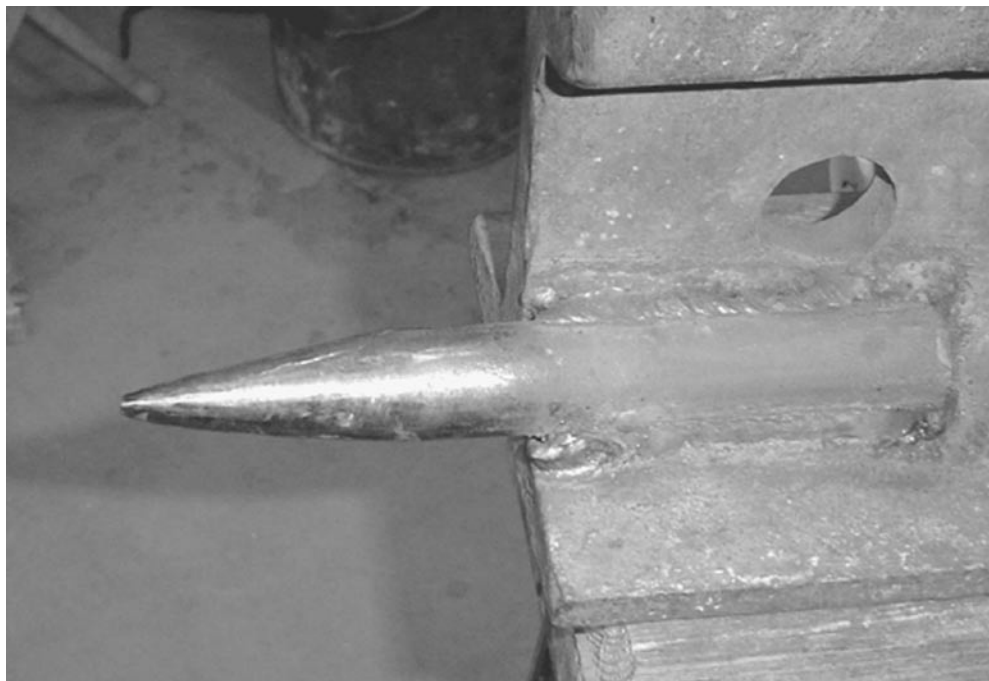
Don Nichols' R.R. Track Anvil

By Bob Ehrenberger

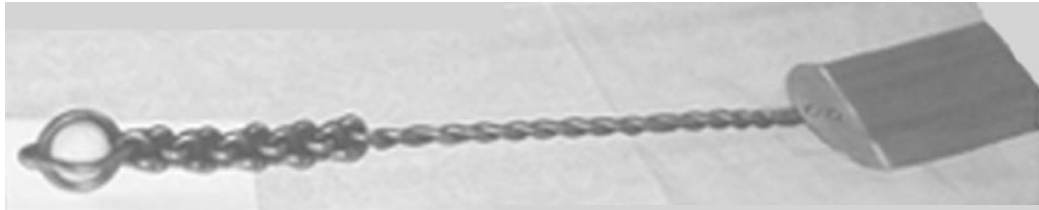
Don brought a home made anvil to the meeting to show that you could do good work on any hard smooth surface. While the idea of pounding on a rail road track isn't new, Don showed how you could make it into a fully functional anvil with very little work. First, he added a hardie hole to it by welding a piece of square tubing to one end and welding a reinforcing strap over it to help it hold it's shape and make it more stable.



On the other end, instead of trying to grind a horn into the track as you sometimes see, he forged a large round bar to a long taper and welded it to the base of the track to be used as a horn. He also ground part of the track flat and left part of it with a radius to be used for heavy drawing operations.

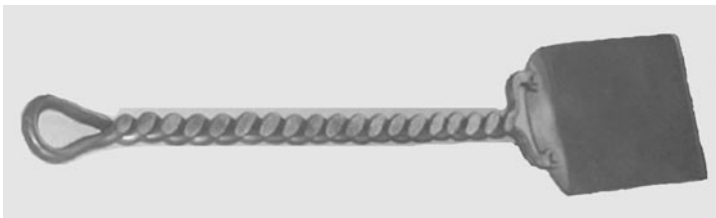
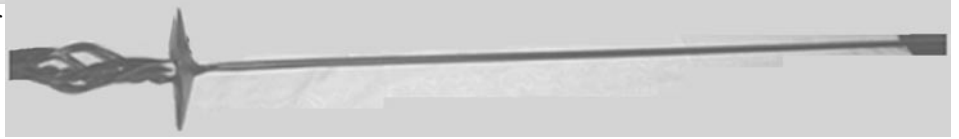


March Meeting Trade Items



Don Nichols, Used the same braided handle with a marble as he demonstrated.

This one was so long that it stuck off both ends of the table. Sorry I didn't get it all in the picture.



BAM Scholarship Article Part 1

By Bob Stormer

This article is being submitted as required after I received a BAM scholarship to work with Pat McCarty on some blacksmithing skills I've wanted to improve/develop. The primary goals were to develop the basics on hinges and latches, chest handles, mortise and tenons, and critters and wizards. As with any new skill, additional effort on my part will be required to "perfect" the techniques I learned during my time with Pat. I decided to break the write-up into two parts so it wouldn't get too long and possibly use up too much space in a single newsletter. This part will cover the hinges I learned to make, the modified bolt heads to go with the hinges, the gate latch, and the wreath hook I made during the class

Since I have three gates to build to help toddler proof the house, I was most anxious to work on hinges, so that's where we started. The material we used for the practice hinge was 3/16" stock and 1 1/4" wide by roughly 20" long. For this example we chose what Pat calls a "ball and spear" finial. Whatever style you choose always start with the finial since it requires the most work and provides the more chances for ruining the project. We started by marking the location of the ball about 2" from the end and fullering both sides of the ball. Be careful not to go too deep with the fullers as you can deepen them later if needed, but going too deep may weaken the finial. As you deepen the fullers you must also keep the piece flat around the fullers. The fullers resulted in a square "ball" that needs to have the corners rounded. This is done on the corner of the anvil as shown in Figures 1 & 2. Once the ball is rounded the way you want it, you can draw the spear point out, again keeping it flat as you hammer the edges down. In this case we wanted to draw the ball out so we turned the piece over so the hammer marks resulting from drawing it out would be hidden when the hinge is mounted.



Figure 1



Figure 2

Figure 3

This is where you cut the back end off to result in the length you want your hinge to be. Make sure you leave enough material to make the loop for the pintle. To create the hinge eye we beveled the back side of the edge as shown in figure 3. The eye is created by curling the end over the edge of anvil. You have to keep the curl even for the full width of the hinge. If you want eye to be 1/4" diameter as we did, keep the eye tighter than the desired eye size. The drift/mandrel will be used to get



Bob Stormer Scholarship report continued

exact size. To keep the eye sized right it is necessary to “pack” it around the mandrel to maintain the hole/pintle size. See figure 4 for the installed hinges. You’ll notice I still have the “store bought” bolts holding the hinge on.



Figure 4

The gate wouldn’t be a very good deterrent if it didn’t have a latch the young ones couldn’t figure out. In this case I copied one that Pat used in his house for the same purpose. The primary part is a ring that is about 2 1/2” diameter. The ring Pat had was forge welded using traditional scarfing techniques. I believe it started as a piece of 5/16” round stock. If you look at figure 5, which shows the installed latch, you can see that it is a very simple latching mechanism. The ring has to be loose so it can pivot around the rivet that holds it in the latch.

The hole has to be located so the ring can only pivot in one direction, which is what keeps the gate closed until you lift the ring from the back. Figure 6 shows the latch in the “locked” position. The tab that is bolted to the post keeps the gate from opening until you lift the ring, and the tab bolted to the gate keeps the gate from going too far beyond the post when it is latched.



Figure 5



Figure 6

The next element of the hinge project was to make decorative bolts to fasten the hinge and latches. In my case I was going to use lag bolts so that is what we worked in. A critical part of this aspect is to clean the plating off, whether it’s zinc or galvanized, before forging. Pat soaks the bolts in ferric chloride and water mixture to do this. I didn’t ask him for the ratio, but I think 50/50 would work fine. We worked on two bolt head designs, the dogwood, which I concentrated on, and the beveled head, which looks a lot like forged nail heads. Refer to Figure 7.

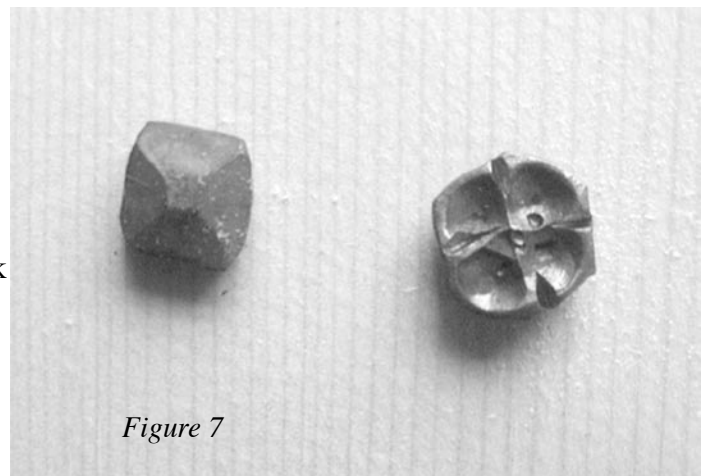


Figure 7

Continued on page 16

Bob Stormer Scholarship report continued

As with a lot of blacksmithing projects, some special tools are helpful, if not necessary. For the dogwood bolt head the only special tool is a ball end punch. We used Pat's punch for the class, but after I got home I was able to make one using a Harbor Freight dapping block. The first part of making either the dogwood or the beveled bolt heads is to square the head by hammering two opposing points of the hex head flat, rotating the head 90° and dressing the bulges. Then use the ball punch in each of the four corners. This bulges out the sides near each corner to shape the four petals. The next step is to put a small dimple in the middle of each petal by using a center punch. Use a sharp chisel to put a groove between each petal, which essentially separates them from each other. It is also necessary to use the center punch to texture the center of the flower with a couple of small dimples. To use these bolts I would recommend using a regular bolt to cut the threads in the wood before trying to install the dogwood head bolts.

One of my projects involved making a wreath hanger for the wall over the fireplace. I brought along stock that was 3/16" x 3"x36". I needed a fishtail scroll on the short, curved end that the wreath sets in, and split curls on the part that bolts to the wall. We started by slitting the split curl end about 8" down the center. I then folded one side over so I could forge a taper on the other side. I then reversed the folded/straight pieces to draw a taper on the second side. Getting the tapers and lengths the same was time consuming, but, as with anything, practice will make it go faster next time. I shaped the curls over the anvil horn and tweaked them until they were symmetrical. Next, I worked with a cross peen hammer to widen the stock and make the fishtail on the other end. I wanted the hammer marks to show, so it was important



Figure 8

that I had the correct side up when drawing out the fishtail. After the fishtail was spread out the way I wanted it, I rolled it over the edge of the anvil, keeping it even across the entire width. Since I wanted the loop of the hanger to be about 8" diameter, Pat found a piece of pipe and welded a piece of square stock across one end to mount it in the vise to be used as our bending jig. When I had the piece heated well enough we clamped the fishtail end to the pipe and bent the other around the pipe, and hammered it flat against the pipe. I forgot to take a picture before I hung it on the wall, see Figure 8.

Another important tidbit I learned was the hammer handle can make all the difference in control. The hammer I took had a head similar to Yuri Hofi's style, but it had a fairly long round handle. I used Pat's hammer with the same type head, but his had an oval handle with flat sides that was shorter. I retrofitted a spare handle Pat had to my hammer head, and it made a world of difference in the way it feels and the control I have.

Editor's Note: The ring latch is based on a Francis Whitaker design. You can find directions in BAM newsletter July/August 2005.

Ham's Prairie Winter Hammer-In

By Ned Digh

The Heart of Missouri Smiths converged on my shop on February 9th. Several of our regulars could not attend but 6 people fairly new to blacksmithing were present and all have joined BAM. Bernie Tappel, Ken Jansen, Mike Gentzsch, Mike Maddox, Tom Patterson, Scott Stager, Terry Smith, and Lou Degginger all were busy coaching or hammering on personal projects. The objective for the new smiths was that each one would go home with something they made. Ken J. and Bernie T. assisted in making tongs, Mike Maddox coached on making the decorative small items that he does so well. In addition to coaching the newer smiths, a number of items were made for the BAM Conference toolboxes for the Iron in the Hat drawings.

Terry Smith recently had neck surgery and his lifting limit was ten pounds. The first hour or so, he only carried his coffee cup around but he soon was hammering like he didn't have a limit. His wife, Debbie was in Mexico on vacation so he figured he was safe from being squealed on and hammering is more fun than just drinking coffee.

Erin Kilburn, a new lady smith had coaching by Bernie T., Ken J., and Mike M. She pretended to be a newbie but admitted later that she had been going to the Scout camp for three years and had hammered under the tutelage of Dennis Yates and Don Birdsall. That explains her smooth rhythm when striking for Bernie Tappel. Gary McCray has a welding shop near Ham's Prairie and has been to my shop several times, as an observer. This time he decided to join BAM and add forging to do in his spare time. He brought a friend, Jeff Smithee, who also joined BAM. Alan Davis from Wellsville made tongs with instruction by Ken Jansen. As usual, Esther Digh prepared a big lunch of Italian Sausage Soup and Tomato and Corn Chowder and there was no left over food for the dog.

Reminder: Tools are needed for the BAM Conference toolboxes. Three boxes will be there with each one having a cast "Blacksmith Shop" sign (custom cast aluminum plate with raised letters) attached. The cast sign can be taken off and used in a favorite spot in your shop or hammering area. Make a tool, buy a tool, or better yet, three (3) tools so you can put one in each box. You don't have to be at the conference to put tools in the boxes, bring it to the next BAM meeting or send to the conference by someone who will attend.



Post Drill Tapping Machine

By Bob Ehrenberger

Back when BAM was still holding our conference in Potosi and I was pretty much a newbie. I remember someone making a tapping machine out of an old post drill and donating it to the auction. I filed the idea away with so many others that I didn't have time for. At Ken's Black Friday Hammer-in I picked up a small post drill and decided that it was time to bring this idea to the front of my to-do list. The drill press itself was in pretty good shape, and almost complete. It was missing the work table which is the most common problem with post drills.

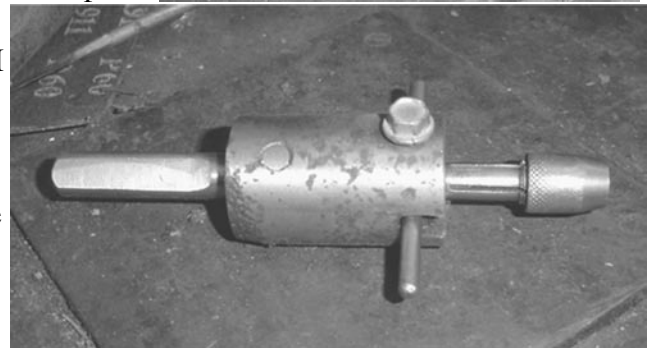
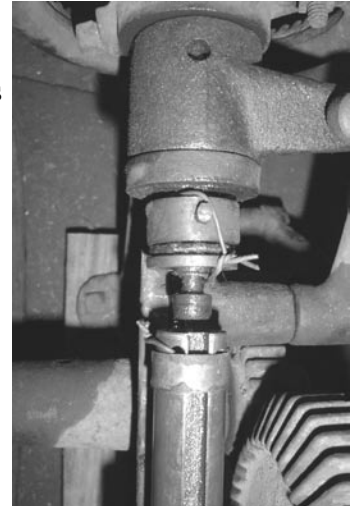
After cleaning and oiling the drill press, I decided that I had three things to do on this project. Make the drill free floating so that it could feed itself into the work as the threads were being cut, figure out how to hold a tap (taps have a square end and drill chucks have 3 jaws), and make a new work table.

Making the drill free floating turned out to be pretty easy. There was a brass collar and two pins where the main shaft met the feed screw. By moving the collar out of the way and driving out the pins, the shaft was independent from the screw. I wired the thrust washer and bearing to the screw so the parts didn't get lost in case I ever wanted to change it back.

To hold the tap, I considered trying to make some kind of 4 jaw chuck. Then it hit me I already had a tap handle that held the taps, I just needed something to hold the tap handle. A much easier project. It turned out that the body on my small tap handle was 1/2", the same as the internal diameter of the old style chuck that was already on the drill press. By drilling a 1/2" hole all the way through a large rod I was able to pin a short piece of 1/2" rd. in one side to go into the old chuck. I made the other end into a tap handle holder by cutting a groove in the end for the cross bar of the handle and drilling and tapping a set screw to hold it in. The tap handle I used for this chuck is the one that holds taps from 0 to 1/4". If I want to use my larger tap handle (for larger taps) I will need to make another holder with a larger hole on the tap handle side.

The final and most time consuming part of this project was the making of the work table assembly. This consisted of a bar, a bracket to hold the end of the bar, a bracket to hold the table, and the table itself.

It turns out I had a bar that was a pretty good fit in the socket at the bottom of the drill press, and a piece of pipe that fit pretty well over the bar. To get it lined up with the drill press I laid the drill press on the floor. Put the bar in the socket and then shimmed the end of the bar until it was level. I was then able to slide the pipe over the end and figure out how much shim stock was needed to put the bracket into the right position. To provide a set screw, I drilled a 1/4" hole in the pipe and then welded a 1/4" nut to it. I could then use a 1/4" bolt to clamp the bracket to the bar.



To make the bracket that holds the table I cut two more pieces of pipe. One to slide on the bar and one to hold the table. I slid one of them over the bar and then held the other one up so that it lined up with the chuck. By measuring the space between them I was able to determine how long to make the spacer between them. Assembling the bracket was a bit frustrating since my welding table isn't perfectly flat, I couldn't just lay everything down and weld it together. I ended up clamping the spacer in the vice and then using a small level to make sure that both ends were plumb before tacking them in place. This got them pretty close, good enough. I think next time I would go get a plate that was big enough and flat enough to clamp everything to. Again I drilled the pipes and welded on nuts to give me a set screw. This time I also welded a short piece of 1/4" rd. to one of the bolt heads to make it into a "T" handle bolt so I can adjust the height of the table without a wrench.



For the table itself I found a piece of 1/4" plate that was a good size about 6" x 8". I cut another piece of the bar that I used for the vertical rod, and welded it on the bottom. Again the alignment wasn't great, but the error on the table offset the error on the bracket and the table ended up almost perfectly square with the chuck. Sometimes



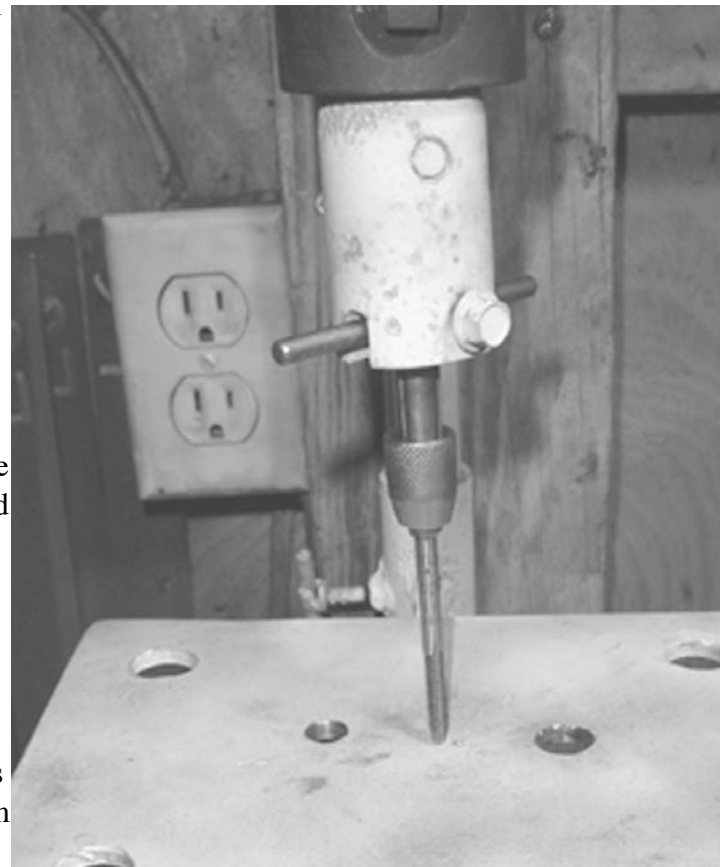
you just get lucky. This table is a bit light for general drilling, but there isn't much pressure involved in tapping.



After painting, I bolted the whole assembly to a 2x6 which I then bolted to a stud on one of the two walls in my shop. I used a level to make sure that the drill press and table rod were plumb.

My drill press has a handle but I find that I like to hold onto the fly wheel while tapping. It gives me a good feel for what's going on and I have more than enough power.

This took two days, unless you count think time. Then it took 18 years.



My New Jib Crane

By Bob Ehrenberger

I'm getting to a point in my life where I think more about working safe than about working fast. When I got my power hammer a few years back I built a gantry crane to move it around while I worked on it. The gantry crane is fine for most of my lifting needs in the shop but it doesn't help with stuff outside the shop or to get them in. When Mara started to sell off Ed's stuff, one of the things I got was a jib crane that was mounted to the frame of the door to his shop.

Somewhere along the way the crane had been overloaded. The main tube that the arm mounts to had a bad bend in it and the bearings that supported an angle brace were broken. So the first thing that I had to do was straighten the main tube. The tube is a thick wall 1 1/2" steel pipe and go through the primary bearings that support the crane. Because of the bearings I couldn't just start pounding on it for fear that I would knock it out of round. So I suspended it from my gantry crane and used a log chain and hydraulic jack to bend it back in a controlled manner.

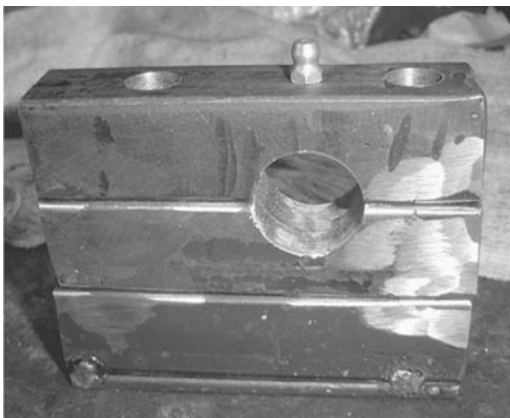
Once the tube was straight I decided to reinforce it by running a solid steel bar down the center of it. I had a 15/16" rod that was a pretty tight fit and in case the tube wasn't perfectly straight it gave me a little wiggle room on the 1" ID tube. I also decided that instead of having a separate shaft and set of bearings supporting the diagonal brace I would have the steel rod extend above the tube far enough to connect to the brace. So I cut the bar 20" longer than needed to fill the tube and proceeded to drive it in. It turned out to be a very tight fit and it took me a half hour with a sledge hammer to get it in.

The main support bearings are quite substantial and their base is wider than the support posts on my door frame. Ed had overcome this by mounting a large steel plate to the post and then mounting the bearings to the plate. I decided to take a different tack, since I have a substantial frame for my roll-up door I decided to mount one side of the bearing to the post and the other to the roll-up door frame. Finding the balance point on the crane I was able to hoist it into place and attach the bearings to the door frame.

I then made a support for the top of the bar out of some 1" sq. stock in which I drilled a 1" hole. I also drilled and tapped the support for a grease zirk. I didn't figure that it needed a real bearing up there because it was just to help out under extreme loads.

To keep the crane from hitting the door when not in use, I mounted a hook and chain on a spring which holds the end secure then the crane isn't being used.

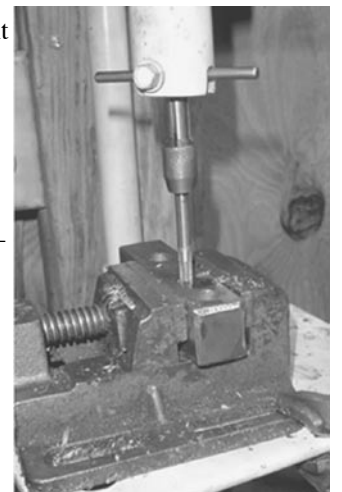
The crane swings from 8' outside the shop to 8' inside the shop and should help a lot.



Left, close up of rod support assembly



Close up of bearing setup



Tapping the support cap



Right, Finished working crane in place.

Round Bar Vice Jaws

By Bob Ehrenberger

I recently needed to bend some large round bars, on my first attempt, I clamped a bar in the vice hot and hammer it over. It developed a nasty burr where the jaw of the vice dug into the bar. I decided that I needed to make set of jaws that would match the shape of the bar and hold it tighter to prevent the burr. Many years ago I made a set of jaws to hold small round bars to make rivet heads on them. I cleaned and painted the old tool for this article. Now I needed a larger version for my current project.



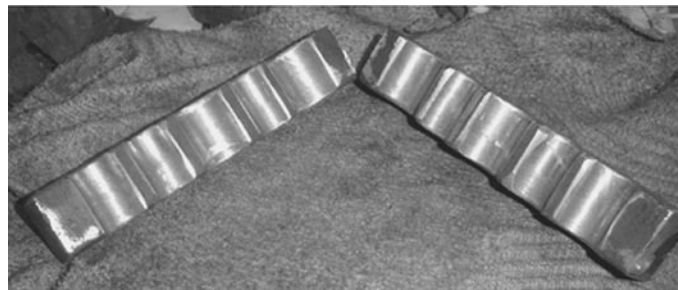
Old vice jaws to hold 3/16" thru 9/16" round

I selected some stock that was 1" x 1 1/8". I cut 2-6" long pieces, since my vice is 6" wide. I made an 1/8" shim to fit between them and tack welded the two pieces together with the 1/8" shim between them. The shim is to assure that the jaws will not hit before making contact with the piece to be clamped. My drill press is a little under powered so I needed to drill the holes progressively starting with 1/4" and working my way up to the largest drill that I have which is 1". In order to make the tool more versatile I created 5 different sizes 5/8, 11/16, 3/4, 7/8, and 1". 11/16" was the one that I had to have, the rest were just so I had a variety for future projects.



The bundle is drilled and chamfered

After the block was drilled and chamfered, I welded a pair of angle irons on to them before grinding off the tack welds.



Inside the dies after the sharp edges have been filed.

I then opened them up so that I could file and sand all the sharp edges off of the two halves where they meet.

I made a handle for the tool out of 1/8" x

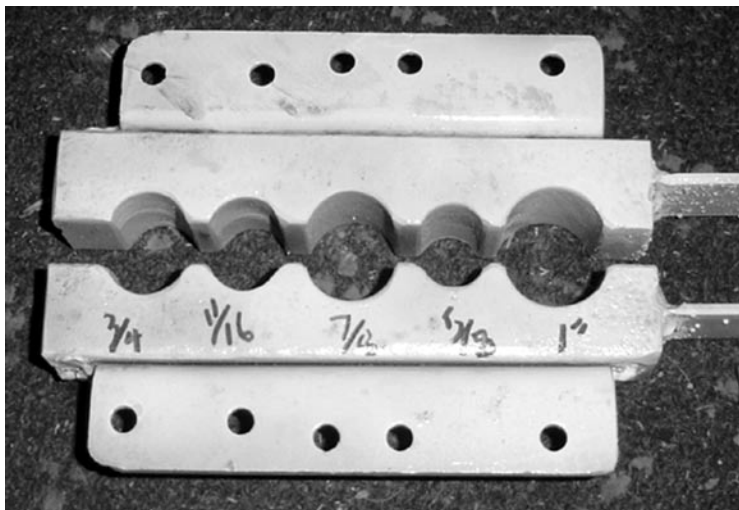


Clamped together ready for the handle

1" strap material which keeps them aligned and gives them some spring.

In order to get them aligned

to weld the handles on, I clamped them together with the 1" and 3/4" mandrels in place. This lined up the grooves and gave the proper spacing.



Finished tool, with sizes labeled

NC Tool 2 Burner Forge Reline

By Ned Digh

My NC Tool two burner forge has been used for 13 years and had lots of abuse. The back wall developed a big hole from being poked so many times through the insulation. Several years ago I read on Anvilfire an entry that Jock Dempsey and Paw Paw Wilson, and I think one other smith, rebuilt three forges in a weekend. The report of taking a weekend influenced my thinking that maybe this would be difficult and time consuming so I have been delaying this project for some time.

The forge was looking really sad and neglected, I kept stuffing insulation in the back wall hole but it was obvious, it needed to be relined. I ordered a reline kit from NC Tool for about 1/3 the price of a new forge and invited Mike Gentsch to assist me with the project. We expected the screws in the forge cabinet to be rusted in place and difficult to remove but not so. I sprayed Kroil on the sheet metal screws and they turned out easily, the kit contained new screws for reassembly but the ones we took out were in good shape.

The reline kit is a drop in kit requiring little work to make it fit. The old insulation in the top of the forge was in good shape and can be used for another forge project. The insulation in the sides and rear was not in good enough shape to retain. The floor or bottom insulation was cracked and deteriorated but at the suggestion of BAM member Neil Porte, I kept it covered with crushed fire brick, with that remedy, the floor insulation probably had years of useful life remaining.

The forge housing has three sides, top, bottom, and back made from one piece of sheet metal and had to be sprung a bit to remove the old liner and put the new one in but the new liner easily pops in place. A hole was cut for the rear door opening and Mike made a new-hinged rear door as the old rear door was beyond repair. The new rear door and a piece of sheet metal was attached to the exterior of the rear wall. This covered the damaged rear wall and was attached with sheet metal screws, making it easy to replace if the need occurs again.

The project took between 2 and 3 hours but part of that time was making a rear door replacement. I guess you could say that Mike and I talked a bit, drank lots of lemonade, told jokes, etc so the actual repair time could probably be reduced to about 2 hours. A final step will be to coat the new liner with ITC 100 and I couldn't find the container. If you have seen my shop, you probably wonder how

something could get lost or more likely how it could be found if misplaced. As I say at every meeting at my shop, my wife says I have lots of junk, I prefer to call it assets.



*Left,
Back wall of forge
before repair.*



*Right,
The NC Forge
rebuild kit.*

“My Passion for ABANA’s Mission Runs Deep”

President’s Message

Winter 2013



I am honored to have been elected to serve as ABANA’s President for the 2013 year. Peyton Anderson, the outgoing President, is a wonderful example of how easily words can flow from an experienced and educated orator. His messages in the Anvil’s Ring have shown an aptitude for saying things well, and for leading our membership and board to new heights. I would like to extend a personal “thank you” to Peyton for his actions as president and for his encouraging words to our members. As an experienced and working farmer, however, my words are not quite as eloquent. But my passion for ABANA’s mission runs deep. It is my belief that, together, we can plow, sow, nourish, and raise new opportunities for our membership to grow. Our Board of Directors will be working hard to solve issues and establish goals for ABANA during this coming year. Our board members are from 11 different states and Canada, giving ABANA a good cross section of our members. The contact info for all the board members is listed on the web site. If you have any suggestions or concerns please let us know. We know our web site needs help and we are working on improving it. ABANA is a member-run organization with elections for 5 board members each year. Consider running for the board. The details are on the web site or contact George Matthews. ABANA is almost 40 years old and I would like to thank all the founders and past board members for their leadership and service to ABANA. This March we are celebrating the 40th anniversary where it all started at Westville, GA. Join us the and see some of your friends and make some new ones. I am looking forward to working with this board and the membership to advance ABANA’s goals this year.

Sincerely,

David Hutchison

Here is a snapshot of our Committee Structure

Executive Committee

President.....David Hutchison
1st Vice President.....Jack Parks
2nd Vice President.....Peter Renzetti
Secretary.....Bill Clemens
Treasurer.....”Vacant”

Committee Chairs

Affiliate Relations.....Ray Nager
Bylaws & Procedures.....Peter Renzetti
Education and Professional Development.....John McLellan
Elections.....George Matthews
Finance.....Jack Parks
Grants and Scholarships.....George Matthews
Insurance.....”Vacant”
Internet.....Jeff Dunkelberger
Membership Services.....Bill Clemens
Professional and Academic Outreach.....Gerald Boggs
Publications.....Amy Pieh
Public Relations CommitteeGrant Haverstock
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2013 Convention.....Lance Davis
2014 Conference.....Bill Clemens

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Individual Classified ads

For Sale: 25pound Little Giant, new style, in great working condition \$2800 obo, a work table 4x4x1 3/8inch thick on casters \$400 obo, a gas forge on stand \$100 obo, 4 inch post vice on stand \$125 obo, and lots of smaller equipment (too much to list) all reasonably priced in good condition. Calico Rock, Arkansas, 870-291-0366 Chris Padelford

For sale or trade; forges, fire pots, blowers, anvils, hardy tools, tongs, hammers, vises, etc. call with your wants & for prices. Bob Lock 417 847 6708.

For Sale: Firepot Centaur Vulcan with dumping ash gate never used new condition. \$250.00 Shafting 5" diameter 36" long weights ~200# \$50.00 Anvil horn 3" diameter 16" long can be mounted in pipe vise or machinist vise. \$50.00 Gary Kobermann at gkobermann@att.com 314.892.2527

For sale: ~ ~ Blacksmiths post drill \$30, ~ Petrogen oxy-gasoline cutting torch bottle 2.5 gallon cost \$880 new asking only \$200, Seth Lancaster (573) 789-0300 paultressa@netzero.net

For sale: Champion 400 Blower on Stand \$100

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Ready for forge pot and tuyere. 35 L. x 29 W. x 6 deep. 4'

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For Sale

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Anvil - Peter Wright 124 lbs.;\$175

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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

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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, or call 636-586-5350.

Information / Education:

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

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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.

Mathias Penn is offering introductory & beginning blacksmith classes. 417-683-9000 Tytheblacksmith@yahoo.com

oldschoolcrafts Blacksmith School, Joe Davis 12625 Lawrence 1175, Mt Vernon, MO 65712 phone 417-461-0387 on the web www.oldschoolcrafts.org E-Mail oldschoolcrafts@hotmail.com

David Norrie blacksmithing school in Colorado David Norrie 303-859-0770 <http://www.forgewithintention.com> or <http://www.davidnorrie.com>

The Upper Midwest Blacksmiths Assoc (**UMBA**) **video library.** An index list can be viewed at 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.

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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 for price. 256-558-3658. Tire Hammers for sale contact me for current price.

Buy, Sell, Trade, Continued ...

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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 Ralph Sproul

Rochester Arc & Flame Center! Featuring Blacksmithing, Welding & Glass Blowing Over 30 classes available for all levels of interest, 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

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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

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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) 794-5175. For more information, go to www.persimmonforge.com and click on both "Pedal Hammer" and "Video Demo of Pedal Hammer."

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Bruce Herzog
2212 Aileswick
St. Louis, MO 63129

Help Wanted:

I need blacksmiths to make small decorative items from my designs in your shop. Kathy Nugent 913-897-9411

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 it's 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.

Check out back issues of BAM newsletter on www.bamsite.org. It now has a search feature to help you find old articles.

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

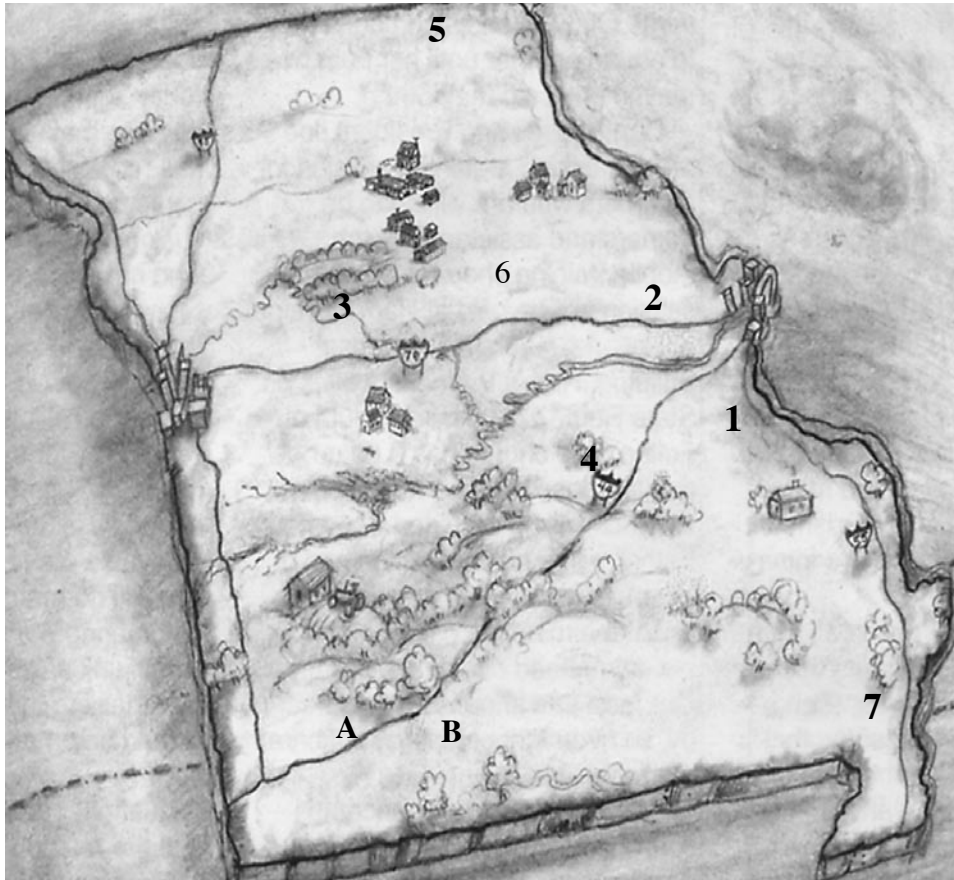


615 lb anvil at Marvin Matrin's shop

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. Good blacksmithing coal for sale \$13 a 50# bag with bulk delivery available. .
Matthias Penn Rt. 1 box 479-S Ava, MO. 417-683-9000 E-mail: tytheblacksmith@yahoo.com

Upcoming Events:

April 1 - Application deadline for May Scholarship awards

April 13,14 31st Annual New Salem Hammer-in, Peter Ross demonstrator, Springfield IL. Application in Jan/Feb newsletter

April 19 & 20 Civil War Days festival in Doniphan, MO Chris Miller, Doniphan, MO. 573-996-4931

May 2nd-5th **-BAM Ozark Conference**, Sedalia, MO contact Mike McLaughlin cowpie42@hotmail.com

May 3, 4, 5, Northeast Blacksmiths Association - SPRING MEET demo by, Frank Turley, Olivebridge, NY www.northeastblacksmiths.org

May 4-5 5th Annual Jim Campbell Hammer-In Touchstone Center for Crafts, Farmington, PA visit www.touchstonecrafts.org

May 11-12, 10 Year Pieh Tool Anniversary Camp Verde, Arizona info at www.piehtoolco.com 888.743.4866

May 18th Newsletter submission deadline

June 8th BAM meeting Ned Digh, Ham's Prairie 573-642-9502 Trade item: candle snuffer

June 16 thru July 13 MTS Denis Yates, Hohn Boy Scout Camp, Boy Scout merit badge, Volunteers needed 573-480-7737

June 29-July 1 **Caniron IX** Quebec, Canada Caniron IX .Uniting Blacksmiths Across Canada, Please check the website www.caniron.ca

July 13th - BAM meeting Doug Clemons, Malta Bend, MO 660-595-2257 trade item is a camp fire poker

August -2013 Missouri State Fair Sedalia, MO contact Kent Harbit (660)-647-2349 to volunteer

September 21 - BAM meeting Matthew Burnett, Cameron, MO. 816-575-2798 Trade item: a tomahawk or hatchet.

October 1 - Application deadline for November Scholarship awards.

November 2nd - BAM meeting Don Birdsall, Rolla, MO. 573-364-7223 trade item [art object]

January 1 - Application deadline for February Scholarship awards.

January 2014, - BAM Meeting A & K Cooperage, Higbee, MO 660-456-7561 Food will be available

March 2014 - BAM meeting Chris Miller, Doniphan, MO 573-996-4931

July 2014 - BAM meeting Denis Yates, Hohn Boy Scout Camp 573-480-7737

September 2014 - BAM meeting Bob Ehrenberger, Shelbyville, MO 573-633-2010

New Members

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

Bequette, James
10329 Sansoucie Road
Cadet, MO 63630
j.d.bequette@gmail.com
573-436-0877

Krasuski, John
P.O. Box 141
Mountain View, MO 65548-0141
417-247-0164

Pugh, Ronald Christopher
110 East 5th St P.O. Box 171
Adrian, MO 64720
circlecpblacksmithing@gmail.com
660-424-3779

Short, Derrick
P.O. Box 49, 502 Church Street
Hematite, MO 63047
dshort147@gmail.com
636-937-6682

Collins, Jeff
Route 2 Box 2710
Birch Tree, MO 65438
573-292-8230

Lambe, Alvin
8514 W Farm Road 34
Walnut Grove, MO 65770
417-742-4735

Raulston, Matthew
10646 Hwy 19N
Salem, MO 65560
573-247-6744

Short, Michael
P.O. Box 49, 502 Church Street
Hematite, MO 63047
mshort64@charter.net
636-937-6682

Dickerson, Mike
12835 Waggoner Road
Festus, MO 63028
midie1@hotmail.com
636-931-6715

Lucke, John
236 CR 209A
Fayette, MO 65248
hicsligit@yahoo.com
573-819-5368

Reynolds, John
HC1 Box 816
Fairdealing, MO 63939
johnreynold27@yagoo.com
573-429-3224

Smithee, Jeff
4399 Co Road 121
Fulton, MO 65251
573-220-5170

Ijames, Steve
1020 East University St
Springfield, MO 65807
lesslethal@aol.com
417-838-4274

Mehnert-Meland, Ralf
3207 S Rivershore Drive
Moorhead, MN 56560
rmehnert@ibsadvisors.com
701-893-2091

Schulze, Garry Lee
1014 Perrine
Farmington, MO 63640
schulze1050@gmail.com
573-756-5486

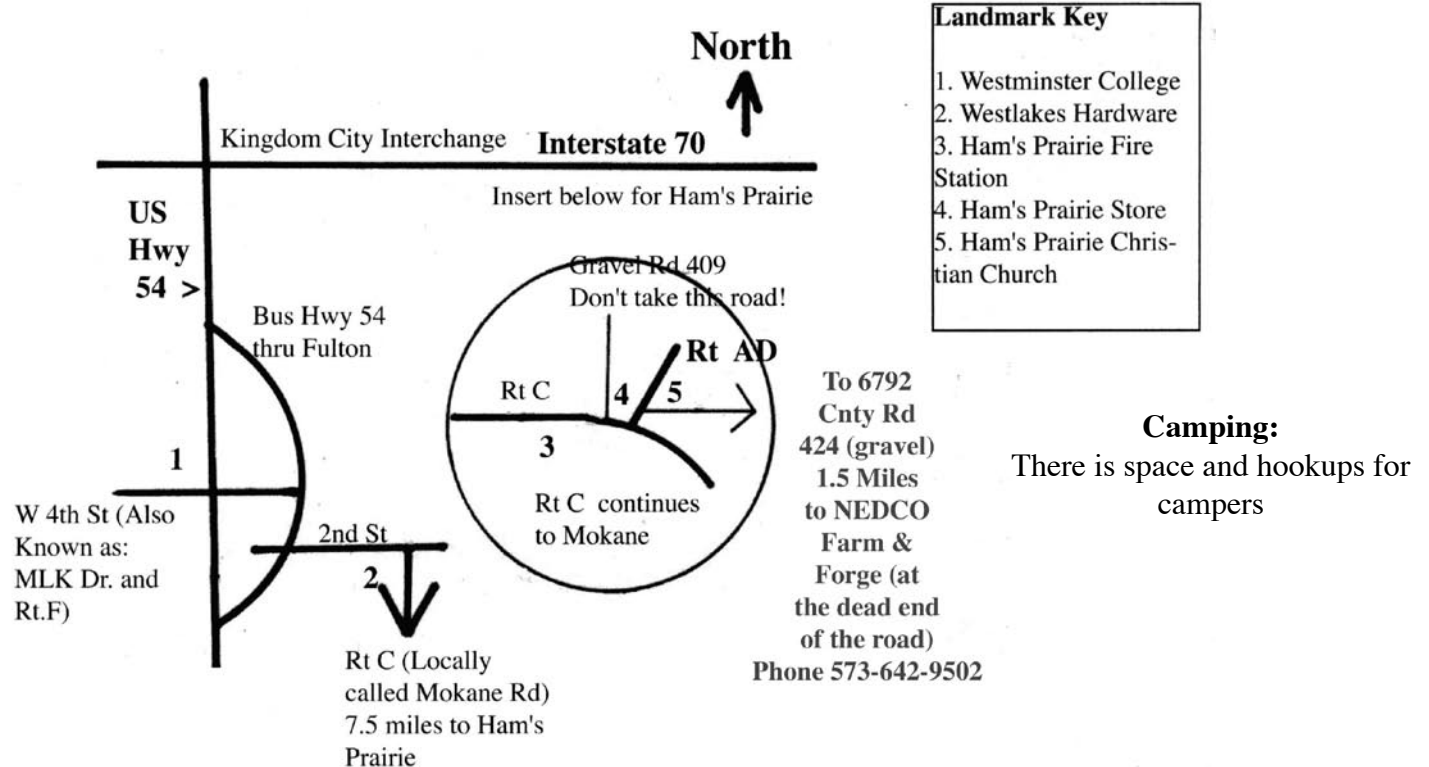
Taylor, Robert & Deborah
RR2 Box2626
Birch Tree, MO 65438

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

Next Meeting: June 8th Ham's Prairie, MO



Location:
NEDCO farm & forge
Ham's Prairie, MO

Host: Ned & Esther Digh

Phone: 573-642-9502

Food: Yes, bring 2 cans of meat product food as payment.

Trade item: Candle Snuffer