

# RAM

MAY/JUNE 2013

## 2013 The Frozen Forge Conference



*Ken's portable forge covered in snow Friday morning*

# Contents

**Editorial**

**5** From the Editor

**Sedalia, MO**

**6** Minutes from the May meeting

**The Prez Says**

**7** Doug Clemons' President's letter.

**Steve Culver**

**8** Knife Maker Demonstration

**Key Ring Tree**

**11** Mike McLaughlin's key ring project.

**Gallery**

**12** Gallery pictures.

**Gerald Boggs**

**14** Cutler's hammer and the tools to make it.

**Randy McDaniel**

**16** Dragon head demonstration.

**MTS/Hammer**

**18** Beginner and hammer classes.

**Ham's Prairie**

**20** Bernie Tappel teaches a beginner class..

**Forging Contest**

**21** Let's make tongs.

**Family Crafts**

**23** Pictures of the family crafts at conference.

**Classified Ads**

**24** Ads - Personal / Business

**Coal map**

**26** BAM Coal locations.

**Scheduling**

**27** Upcoming Events and new members.



Another picture of the snow.



Rim-A-Que page 27



No room for ABANA this time



COAL Map pg 26



Meeting Map pg 28

**Newsletter of the  
Blacksmiths  
Association  
of Missouri**

*Volume 30 No. 3*

**May - June 2013**

**Editor**

Bob Ehrenberger

**Contributing Writers**

Bob Stormer  
Ned Digh

**Photo Contributions**

Bob Ehrenberger  
Ned Digh  
Bob Stormer  
Bruce Herzog  
Bernie Tappel  
Scott Stager

**President's Message**

Doug Clemons

**Mailing Labels**

Bruce Herzog

The Newsletter of the Blacksmiths Association of Missouri is published six times a year and is mailed to members of BAM. The annual fee for regular membership is \$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

What a conference. When I got there Thursday for setup the temp was 45deg and dropping. This was a shock because it was in the mid 80's the day before. The wind and rain came in the afternoon. There was still a cook out get together in the Ken and Phil play area. The food was great, but the weather continued to get worse and forced people to look for warmth. The temp dropped further through the night and we woke up to a blanket of snow. It continued to snow most of the day, very unusual for May 3rd.

The weather continued to make an impact all weekend, though Saturday and Sunday were not as bad. One good thing was the boutique had BAM logo sweaters for the first time. I saw a lot of members wearing BAM sweaters.

For Iron-In-The-Hat, Ned out did himself in getting donations for the tool boxes. They were so full you couldn't see it all just by looking in. The good thing this year was that Ned got donations of three of everything so all three boxes were just as full.

Phil Cox did a good job with the forging contest this year. He provided one side of a pair of tongs and we had to make the mate and put them together. It was a lot of fun. I wish I had done better but my first hit was in the wrong place and there was no recovering from a mistake like that. I think that only one contestant didn't finish his tongs. We even had a grudge match where Don Nichols challenged Ken Jansen to make a pair of tongs after the official contest was over. I'm a little disappointed that more of you didn't participate, Phil had materials for 20 contestants and we had about half that. Come on guys, it's a lot of fun and even if you make a mistake, like I did, you can learn

something in the process.

The demonstrators were all real troopers and didn't let the adverse conditions affect them. Gerald Boggs said that he scoffed when his wife packed all the warm clothing, but was glad to have it. We had three demonstrators instead of the usual four so Gerald filled the time. I'm not sure it was always intentional. There were a couple times that he was finishing up from a previous demonstration or getting ready for the next one, when someone would ask a question. As he would explain a crowd would gather, and the next thing you knew there was a demonstration happening.



*New Grand Twins*

We had a new auctioneer this year, Kevin Whitworth from Higginsville, MO. Kevin didn't have much experience with blacksmithing or iron work, but he more than made up for it with his skill as an auctioneer. So as usual we had an entertaining and profitable auction.

We had something new this year. The Key Ring Tree. Mike McLaughlin made the tree and asked the members to make key rings or other small items to decorate it. The tree wasn't full but it looked pretty good. Check it out on page 11. Bruce provided close up pictures of several of the items.

The big news on the home front was that my daughter, Tiffany, delivered her twins the Monday before conference. She was developing high blood pressure so they thought it was best to take them early. Jan and I got to see them the week after conference. Mother and babies are all doing well.

On a sad note long time BAM member Todd Kinnikin died recently. Todd was a high end knife maker and had been willing to give Daniel advice when he was starting out. Todd had also served on several BAM committees.

The June meeting is at Ned Digh's and the map is in the March/April newsletter. You can also get a map to Ned's on [bamsite.org](http://bamsite.org).

Doug Clemons is hosting the July meeting at his shop near Malta Bend. I missed a turn last time and did a lot of extra driving. I would suggest you look at a Missouri map to get you close and then the map in the newsletter to find the shop.

**The next Newsletter submission deadline is July 20th**



*All Tiffany's children*

## **BAM 2013 conference minutes**

By Don Anders

Motion was passed to keep all existing BAM officers.

There was talk that the State Fair wants BAM to help out with some iron work for a new project, additional information coming.

2013 was another good conference chaired by Mike McLaughlin. Mike has chaired the conference for several years now and needs someone to step up and take over for next year. Mike will provide support and assistance.

Meeting adjourned.

Bob, the editor, tracks the award and activities at the BAM conferences, so I don't include them in the conference minutes. I do appreciate all the effort that Bob puts into the newsletter, even the reminders that he sends me needing the meeting minutes. However, I do have something to say about one award in particular. The Heart of Missouri Blacksmiths group established an award a few years ago to augment the existing BAM awards. This year it goes to Larry Hulst. Larry has co-chaired and chaired several BAM conferences, served on the scholarship committee, headed up a gas forge clinic, and latest worked on the BAM face book page. Larry was not able to make it to the conference this year so I accepted the award for him. If Larry can make it to the June meeting I will consider letting him have it then. Otherwise he needs to make arrangements to get it or I may mount it on my wall and he may have a difficult time getting it then.

## **Conference Awards:**

### **Forging Contest:**

- 1st Charley Comstock
- 2nd Matthew Burnett
- 3rd Bob Chambers

Nathan Robertson gave Karen Bouckaert a custom made (and engraved) sledge hammer as a thank you for her part in organizing the conference. (It was kind of an inside joke that carried over from last year.)

**Founder's Award** was given jointly to Don Anders and Karen Bouckaert.

### **Life time membership awards:**

Patty Tappel was given a lifetime award to correct an oversight from last year. She should have been a corecipient with Bernie who got the award last year.

Ned and Esther Digh were given lifetime membership awards for all they do to support BAM.

**Vender Award** was given the Dick and Jo Nietfeld who have consistently support our conference.

### **Raffle results:**

- Anvil - Mike Gentsch
- Tool Box 1 & 3 - Mike O'Neil
- Tool Box 2 - Dan Wedemeyer
- Gas Forge - Dan Wedemeyer
- Treadle Hammer - Mark Clifford

# President's Message

Greetings,

I guess the biggest news lately in our world of blacksmithing is our recent BAM conference that was held May 2 thru May 5. We had a fairly decent turnout considering the weather. It was unusually cold all four days. It actually snowed Friday morning. I should have taken a picture of the forge Ken Jansen had set up in the back. It had a pretty layer of white snow with just a bit of black coal showing through.

I live about fifty miles north of Sedalia, MO where the conference was and it was worse there. On the way down Friday morning there was one vehicle upside down on the side of the road and couple of others pulled over. The highway was shut down to one lane most of the way there.

I was able to get around and watch part of the demonstrations between trying to help wherever help was needed. I actually helped at the beginning class for a short time. It will probably take the father of the young lady I was helping a while to reeducate her properly. It's a good thing that he's a real blacksmith.

On Friday evening we held a short business meeting and election. There was a motion to reelect the current officers for one more year. The meeting was followed by the forging contest. Each contestant was given one half of a pair of tongs and a piece of round stock and a rivet and had to finish the tongs to hold a piece of flat stock in a set amount of time.

I think the auction did pretty well also. I have not heard any figures about how much money was raised but we had a lot of items and most seemed to bring a fair price. I also believe the boutique did fair considering the weather. Actually the cold may have helped because they were selling hooded sweatshirts this year.

We had several items to raffle including three tool boxes with tools that were either made or donated by BAM members. This year the boxes were packed with tools. It says a lot about a group that has that much participation.

Overall I think we had a successful conference. Many thanks to everyone that helped with it. It takes a lot of work and a lot of volunteers to put on a conference like that and I'm sure we never get around to properly thank everyone that deserves it. There is so much that goes on behind the scenes that most people are never aware of.

Our next two meetings are scheduled fairly close together time wise with Ned and Esther Digh hosting the next meeting June 8 and Nancy and I hosting the following one on July 13 so there may not be a newsletter between them.

Ned and Esther will be hosting the June 8 meeting at Ned's shop at Ham's Prairie. That's just south of Fulton. The trade item is a candle snuffer.

Nancy and I are hosting the July 13 meeting at our farm near Malta Bend. Malta Bend is on Hwy 65 about ten miles north of Marshall, MO. Our trade item is a campfire poker. A campfire poker is kind of like a fireplace poker only longer.

Hopefully we will see you at one or both upcoming meetings.

Doug Clemons

## An Unexpected Honor

It was a totally unexpected honor to be awarded Life Membership in BAM at the recent conference. Our thanks and gratitude to the President and Officers for this recognition. It is a humbling experience to be placed among those who have contributed so much to BAM.

Ned and Esther Digh

# BAM Conference 2013 Steve Culver Demonstration

By Bob Stormer

Steve Culver, ABS Master Bladesmith, was one of the demonstrators at the BAM 2013 blacksmithing conference. His demonstration centered around forging blades, grinding blades and making a Damascus billet. His discussion periods dealt a lot with heat treating methods.

Steve gets most of his blade steel from Aldo Bruno at New Jersey Steel Baron (973) 949-4140), and uses 1084 for most of his carbon steel blades. He uses 1084 and 15N20 for a lot of his Damascus blades.

Steve started his demonstration by forging a small clip point bowie knife using 1084 steel. The stock size was 1 ¼” wide by ¼” thick, and the length was long enough to work it without using tongs. He started by hammering the corners in and drawing the end to a short point, roughly a 45° angle from both sides. Be careful not to create a fish mouth at the point or “fold overs” at the corners. You can use a belt grinder to knock off the corners before rounding them if it helps prevent fold overs. If you get fish mouth on the point grind it off before proceeding. You can now set the length of the blade by “setting” the ricasso using the peen on the hammer and the rounded edge of the anvil. Keep it centered on the edge. Also keep in mind that the blade length will grow a little as you forge the edge. Steve forged a distal taper in the blade to improve the balance. This even taper runs from the front of the ricasso to the point of the blade, and is about 60% thinner at the point than at the ricasso. He then began forging the edge, from the ricasso to the point. The important part is to keep the blade flat and don’t let it curve up too much before straightening it. Forge the edge from both sides, making sure to have it centered with the spine of the blade. Steve used a wooden mallet for helping to keep the blade straight.

He then set the length of the ricasso by fullering approximately ¾” behind the ricasso. See Figure 1. Steve refers to the “Golden Mean” to help define this length. The golden mean refers to a ratio of proportions that occurs frequently in nature and is very pleasing to the eye. The ratio is generally 5 to 3. In this case the ricasso length (plunge line to the guard) is 3/5<sup>th</sup> the width (top to bottom) of the ricasso. The depth of the fullers was about 30% of the blade width. The tang was then drawn out with a slight taper in both directions, width and thickness. The ricasso is left flat on both sides. The length of the tang should run to within 1/2” of the end of the handle. This helps ensure the handle won’t break when using some of the more exotic materials. Steve files a .010” shoulder where the ricasso meets the tang. He then mills a slot in the guard to press fit over the tang. See Figure 2 for the forged blade.



*Figures 1 & 2*



Following the forging, Steve does thermal cycling (normalizing) to relieve the stresses that have built up in the steel during forging. Thermal cycling also reduces the size of the grain structure in the steel. His process is to heat the blade to just below critical (non-magnetic) and let it air cool to a black heat. This is repeated 3 times. The old methods of annealing the blade (cooling it slowly in wood ashes or vermiculite) following forging is no longer believed to be necessary.

Next was the grinding demonstration. Steve uses a 2HP, variable speed KMG grinder with a flat platen. He replaced the standard flat platen with an O-1 steel plate. It does not need to be hardened. Before starting on the belt grinder, Steve uses an angle grinder to remove most of the scale from the blade. The first step using the belt grinder is to profile the blade. He was using a 60 grit Klingspor CS411 belt for all the initial grinding. Make sure the spine is 90° to the ricasso. He then ground the ricasso flat on both sides. The ricasso must have flat parallel sides. At home Steve uses a micrometer to make sure of this. He also scribes two parallel lines on the edge that are about .020” apart, and centered with respect to the ricasso. These are grinding references. His next step was to grind a 45° bevel on both sides of the edge. This bevel was



ground down to the previously mentioned scribed lines. This provides an easy visual reference when you're getting close to the scribed lines at the edge when flat grinding the sides.

At this point Steve installed his work rest to provide an easy way to get the 90° plunge line for the ricasso. See Figure 3. The next grit was a 3M Cubitron 967, 80 grit belt. With the work rest on, he started grinding the side with a flat at the plunge line, about half way between the edge and the spine. After getting the flat centered, start pulling the blade across the belt to extend the flat along the entire side. You must keep it flat and if your grinding gets too close to the spine or the edge, apply more pressure on the top or bottom of the blade to remove more material and center the flat. Completely grind one side before starting the other. After you've ground both sides using the 80 grit belt and the plunge lines are even you can switch to the Trizact A300, which is also an 80 grit belt. Follow this with a Trizact A100, which is 180 grit. After you finish both sides with the A100, use a 320 grit J-Flex belt on both sides to get it ready for hardening. This 320 grit belt is also used to clean up the plunge line by extending it over the edge of the platen by about the height of the plunge line at the bottom of the ricasso. At this time the edge should be about .020" thick for a small to medium knives and about .030" for larger knives.



Figure 3

There are three basic ways to harden the blade. Heat the whole blade to critical and edge quench it. This would give a visible temper line, but would be Steve's last choice for hardening the blade. The next method is to heat just the edge and plunge the whole blade point first into the coolant. This method will also show a temper line. The last method is to heat the whole blade to critical and plunge the whole blade point first into the coolant. Using either of the last two methods requires you to move the blade back and forth in the coolant from edge to spine. DO NOT move the blade from side to side. The quenching oil should be about room temperature, about 70° to 80° or warmer. You can use Satanite in a paste form to get a fancy temper line, much like the Japanese do on their swords. To draw a temper, a kiln or a regular cooking oven can be used to temper the entire blade. A piece of angle iron set on the edge of the angle and closed off at both ends then filled with water can be used to draw the spine without over heating the cutting edge. Drawing the spine should be done three times. After heat treating to harden and temper the blade, Steve uses the Trizact A100 belt to final grind the blade. He also used this belt to roll the edge to begin the process of sharpening a blade. To do this he uses a spot on the belt where it is a little slack. Final finishing of the blade is done by hand sanding with wet-or-dry sanding papers. The blade will be hand sanded up to grits ranging from 600 through 2000, depending on the final finish desired.

Steve showed how he uses a special fixture for grinding the false edge on bowie knife clips. He also uses it to grind the flats on dog bone handles. See Figures 4 and 5.



Figure 4



Figure 5

Continued on page 10

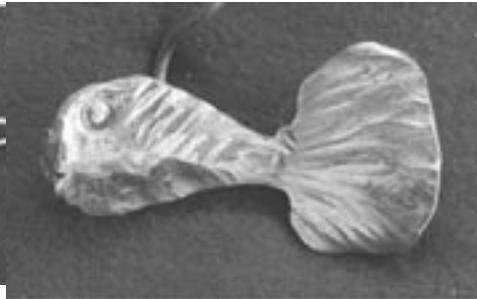
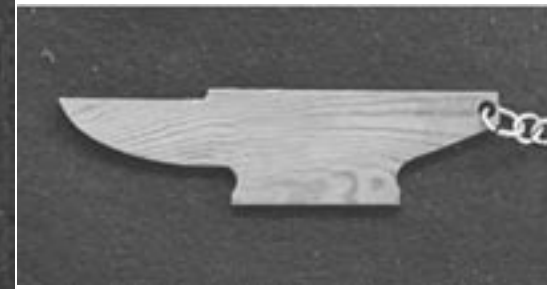
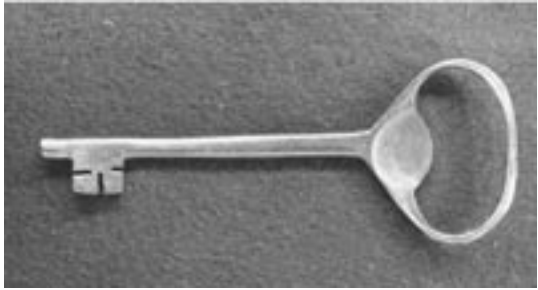
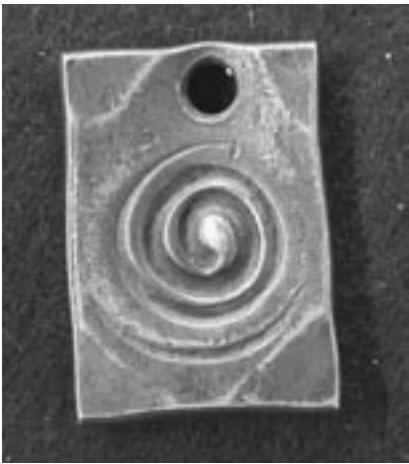
## Steve Culver Demonstration continued from page 9

Steve brought a Damascus billet with 7 layers of alternating 1084 and 15N20 to demonstrate some forge welding techniques. Time didn't allow him to do much other than forge the billet and draw it out a few times. The first weld was made using only kerosene as a flux. He also uses 20 Mule Team Borax, sometimes adding charcoal dust to it. He soaked the billet in kerosene for about 5 minutes to ensure it goes in between all layers before heating it to temperature. A small portable pyrometer was used to measure the forge temperature. It was a model Therma K made by Thermoworks. It's very handy for reading forge temperatures, and can read 2500°F with the type K probe. After folding his billet once, which resulted in 14 layers, he then turned it on edge and drew it out to prepare for folding again, but this time 90° to the original billet. See Figure 6. Repeatedly doing this would result in the popular "W" pattern. He uses ferric chloride for an etchant, but mentioned that some metalworkers use copper sulfate with good results.

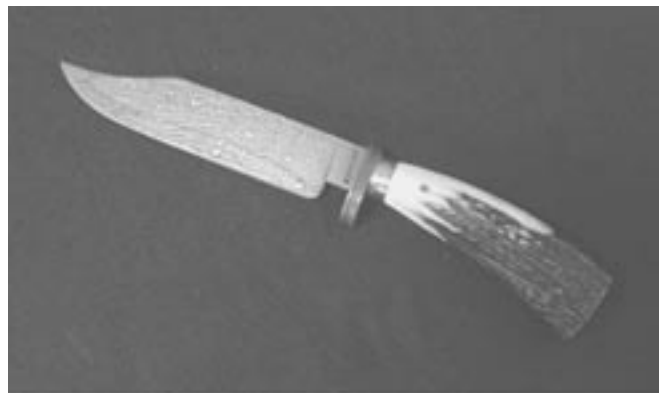
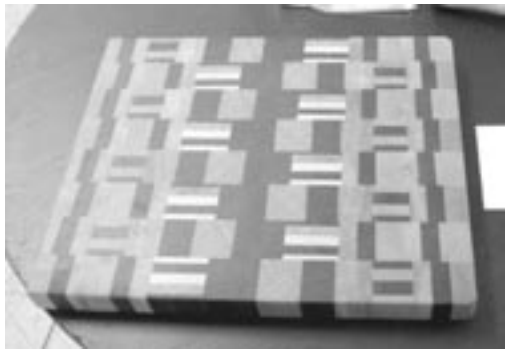
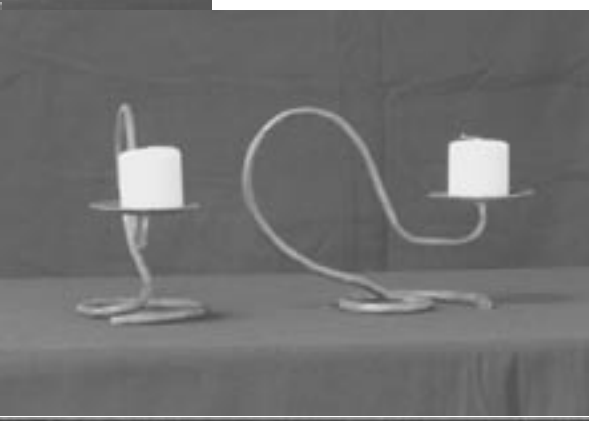
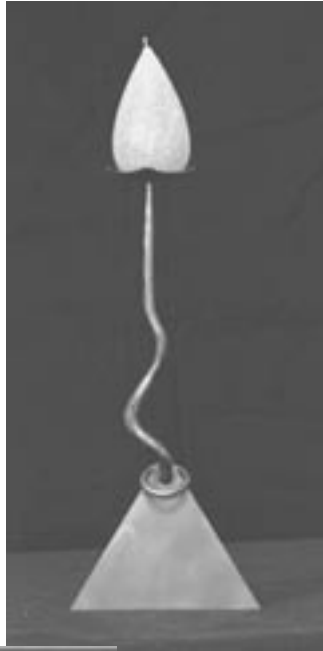
We also had time for a short discussion on his homemade forge. He used two 12" pieces of cardboard concrete forms, one 8" and one 10" to make a 12" high cylinder of Mizzou Plus castable refractory. This is good to about 3000°F. He also made two discs to cover the top and bottom. He then wrapped the sides with a layer of 2" Inswool, and then made a sheet metal covering over the Inswool so he could attach doors, supports etc.. His burner goes in at a tangential angle near the bottom, and is made of 2' black pipe with a 1" hole in the pipe plug nozzle. The nozzle sets against the outside surface of the Inswool wrap. The pipe has a 90° elbow that goes down to a 148cfm blower. The blower has a damper over the intake to control air flow. He has 1/8" gas pipe that goes through the 2" black pipe elbow to supply propane. A small valve is installed on the 1/8" pipe to control gas flow.



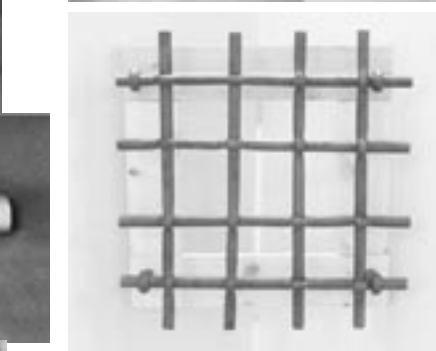
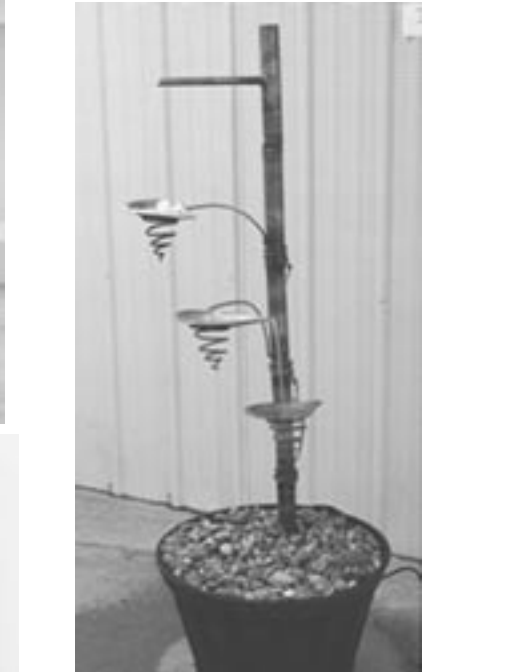
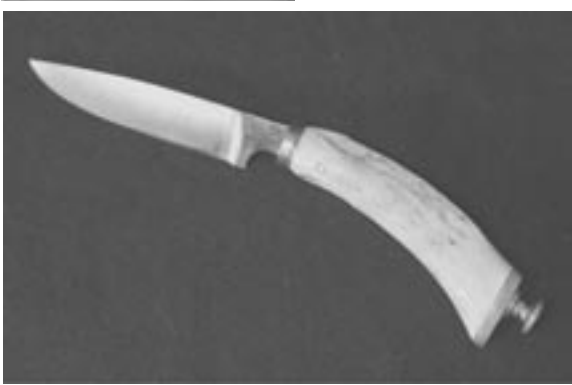
# Key Chain Tree



# Gallery



# Gallery



# Gerald Boggs Demonstration

By Bob Ehrenberger

Gerald hit the ground running. On set up day he had a fire going in his demonstration area and was making the things that he would need for his demonstration. Gerald had trained under Mark Aspery and you can see a lot of similarities in the way that he approached his work. Like Mark, Gerald started with making the tools and then progressed to using the tools.

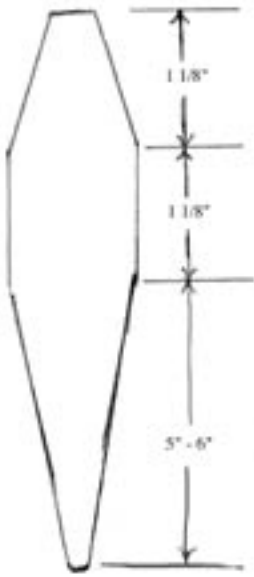
When making hammer eyes, he made the initial hole with a slot punch and then proceeded to drift the hole to size. The slot punch was made from 7" x 3/4" rd. of 4140. 4140 was his tool steel of choice because it would get hard enough to do the job but there was little chance of it getting too hard and breaking. To make the punch he started out by chamfering the struck end. He then created an index for your hand using a rounding hammer over the horn of the anvil. This helps you keep the tool oriented to the slot you are making. Next taper the indexed area into the main bar. Before making the working end of the pinch, he tapered the end a little to get ahead of the spread. As he shaped the end, he would check the width frequently to make sure that it didn't spread too much. Since this punch was going to be used to make slots in 1" material the working area only needed to be slightly longer than 1". The final dimensions of the working end of the punch needed to be 1/8" x 3/4" with slightly rounded edges.



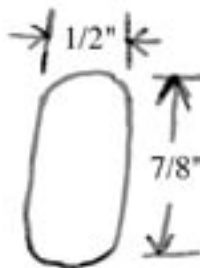
*Punch end*

*Punch grip*

To make the drift, he started with 6" x 3/4" rd. of 4140. Taper the top as far as the thickness of the material you are going to drift. The fat section also needs to be as long as the material you are going to drift, in this case 1". Shoot for a 1/2" x 7/8" cross section. Flatten the whole blank to 1/2" x 7/8". Chamfer the struck end. Finally make a long taper on the working end.



*Drift Profile*



*Drift Cross Section*

When pinching a hole for a normal hammer, Gerald had a very precise procedure. He would hit the punch 3 times, cool the punch, tap off the excess water, rotate the punch, and repeat. He took his time and only worked while the bar was at a high forging heat. He did not use a lubricant or coal dust and didn't

have trouble with the punch sticking. You can tell when the punch bottoms out and it is time to flip the bar over and knock the slug out.

When drifting the hole, he did not cool the drift between heats. The drift tends to suck heat from the bar and you don't want it to cool the bar any more than necessary. Again he went slow and didn't work the piece when it had lost its high heat. As he drifted the hole, he would dress the sides of the bar with the drift in place to reduce the swelling sideways.

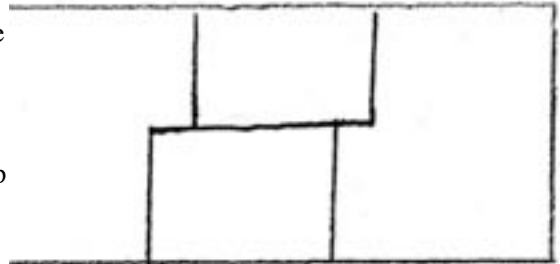


# Gerald Boggs Demonstration

By Bob Ehrenberger

Gerald made lots of stuff, tools and decorative items. But one thing that I had never seen made was a cutler's hammer also called a dog's head hammer. These are distinctive because all the weight is on one end and they frequently have a handle that is set at an angle to the head. He told us that the trick to making the angled hole was to stagger the location of the slot punch and only go half way through from each side. This required a careful layout because the holes are only offset by 1/8".

When you are half way through from both sides, you can see a bulge in the area where the two slots overlap. At that point, you put the drift in at an angle and drive it through. It is important that the tip of the drift is smaller than the overlapped section. Our punch is 3/4" long and there is an 1/8" offset on each side so that leaves an overlap of 1/2". So the tip of the drift has to be less than 1/2".



When the drift is driven through and the sides are dressed the transition between the two slots will smooth out and become a continuous angled hole. Because of the angle you have to drive the drift through either using a large hole in a swage block or by supporting the work on the tip of the anvil horn.



*Close up of hammer head*



*Finished Cutler's hammer*

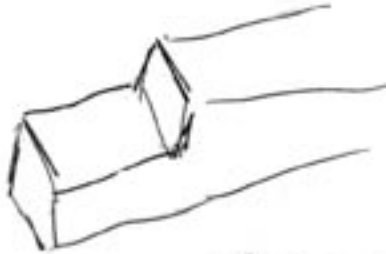


# Randy McDaniel Demonstration

By Bob Ehrenberger

Randy did a lot of character forms. I'm going to describe what he called his simple dragon. He did a more elaborate dragon later when I was elsewhere.

Use half face blows to establish the transition between the nose and the head.



A hollow eye punch is used to make the eyes and sockets.



A ball punch is used to make the nostrils.



A straight chisel is used to open up the mouth, make it pretty deep.



Use another chisel to make the teeth.



The ears are lifted up with a chisel. And then shaped with a ball punch.





## Randy McDaniel demo.

The back of the neck is tapered to start the scales.

The scale affect was achieved by working the back of the neck over the edge of the anvil.

Finally the head is positioned using bending forks.



*Left, side view*



*Finished dragon.*

*Right, head on*



Randy also taught the Sunday morning bonus class. Where he helped 10 lucky members make a colonial meat fork.



# MTS Class



# Hammer Making Class



# Ham's Prairie Basic Blacksmith Class

By Ned Digh

The Heart of MO Smith had a basic blacksmith class at Ned Digh's shop in Ham's Prairie on April 6<sup>th</sup>. Bernie Tappel was the instructor and 8 aspiring smiths were in attendance for a 6-hour class. Bernie had 4 projects for the students to complete with exercises in forging, scrolling, splitting, and heat-treating.

Gas forges were used and Mike Gentsch, Mike Maddox, and Tom Patterson were there as assistants to assist as needed. The class had three ladies and two male teens. Most of the students had some hammering experience but this class was designed to emphasize basic skills.

Nikki Wade, gift shop owner in Rocheport and her son, Kevin, took the class. Nikki sells items made by Mike Maddox and Don Nichols. Kevin had no previous blacksmith experience but his smooth hammering reflected that he inherited some skills from his steel-worker dad, now deceased. Rosemary Heinen, new to hammering also took the class. The two teens, Chad

Maupin and Aaron Arms have both have participated in a local demo or spent some time in my shop. This was the first structured class for both; they did well and are hooked on blacksmithing.

Four new members of BAM were in the class; Olin Hatfield, Gary Boyd, and the Kilburn husband and wife team (Erin and Terry). Erin and Terry were here recently for a hammer-in and Terry did not hammer then but he participated in Bernie's class and did well. His day of observing at the hammer-in paid off.

Esther Digh hosted lunch for 18 people, which included students and family members, and the instructor group. With new blacksmiths at the lunch table, conversation flowed about what they have learned and bringing up additional topics about forges, blowers, metal, future classes, etc. Their desire for blacksmith experience makes the more seasoned smiths refresh their own knowledge and forging techniques.



*Bernie Tappel*



*Gary Boyd  
&  
Kevin Wade*



*Olin Hatfield*



*Erin Lillburn  
&  
Rosemary Heiner*



# Forging Contest



# Conference Follow-up

Hi All. I hope everyone enjoyed this years conference. Even with the cold and snow I think it came out well. I would like to thank our demonstrators, Randy McDaniel, Gerald Boggs, and Steve Culver. Also like to thank their helpers. Bernie Tappel, Steve McCarthy and Chris Owens I think everyone did a good job under the circumstances. I thought it was another great forging contest from devised by Phil Cox. The Beginning Blacksmith class was extra full this year. Good job teaching by Don Birdsall and Mike Camden. Thanks to the ladies who taught classes Mary Jo McCarty, Jo Nietfeld and Margie Cox. Kent and Deanna Harbit made registration extra smooth. Patti Tappel and the ladies kept the boutique going great. Thanks to Walt Hull, John Sherwood, and Scott Stager for the Gallery.

Karen and Don have always done a great job with vendors and iron in the hat, raffles, and purchasing the T-shirts and hats for the boutique. I was happy to see them honored at the banquet. They are a great asset. The Sledge from Nathan for Karen was pretty cool also. I was glad to see the extra help with iron in the hat and the raffle.

I would also like to thank our vendors who sat at their booths in the cold.

Bob Alexander of Scrub Oak Forge representing Blacksmith supply.

Alan from Astragal Press

Dick Nietfeld of Shady Grove Blacksmith Shop with his anvils.

Jo Nietfeld with Brooms and Broom classes.

Ray Carpenter and family with Forged 26

Roger Degner with his videos and auction help

Nathan Robertson with hammers. And his always full hammer class.

Sid Suedmeier and Keri From Little Giant.

Mona Pieron, Pat McCarty and others who brought items for sale.

I'm sure I forgot some.

Thanks to NC Tool for the discount on the Whisper Momma forge and other items for the raffle.

Thanks to Terry And Bob at Oldworld anvils for the discount on the anvil.

And Blacksmith Depot for their donation of items also.

I know I forgot to thank someone. So I really want to thank everyone who helped set up and tear down and did anything else that needed to be done. You all pitch in and that helps make this event a success.

Mike McLaughlin

## **We would like to thank the following members for participating in the gallery.**

Chris Miller

Walt Hull

Heart of Missouri Blacksmith

Al Stephens

Don Birdsall

Jim Ratliff

Don Nichols

Tony Howard

Joe Hurley

Pat McCarty

Bill Moffet

Mike Curran

Bernie Tappel

Ken Markley

Doug Knight

Randy McDaniel

Rick Meyer

Bob Ehrenberger

Vernon R Grashorn

Mark Clifford

Don R Neuenschwander

# Family Crafts



# Buy, Sell, Trade

## Individual Classified ads

**For Sale:** Used Fire Brick. From disassembled pottery kiln.  
70- low density bricks 4 1/2 x 2 1/2 x 9 " plus some broken ones.  
60- Higher density bricks same size plus some broken ones.  
6- 1 1/2 x 4 x 8 inch. all bricks \$1.00 each or best offer.  
Rob Ahrens, ([573\) 221-7556](tel:5732217556) (Hannibal, MO area)  
[ahrensra@gmail.com](mailto:ahrensra@gmail.com)

**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](mailto:gkobermann@att.com) 314.892.2527

## 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)

**oldschoolcrafts** Blacksmith School, Joe Davis 12625 Lawrence 1175, Mt Vernon, MO 65712 phone 417-461-0387 on the web [www.oldschoolcrafts.org](http://www.oldschoolcrafts.org) E-Mail [oldschoolcrafts@hotmail.com](mailto: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](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



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

### 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

**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) 794-5175. 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

### 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.

**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

### Shop Top

Donald Davies

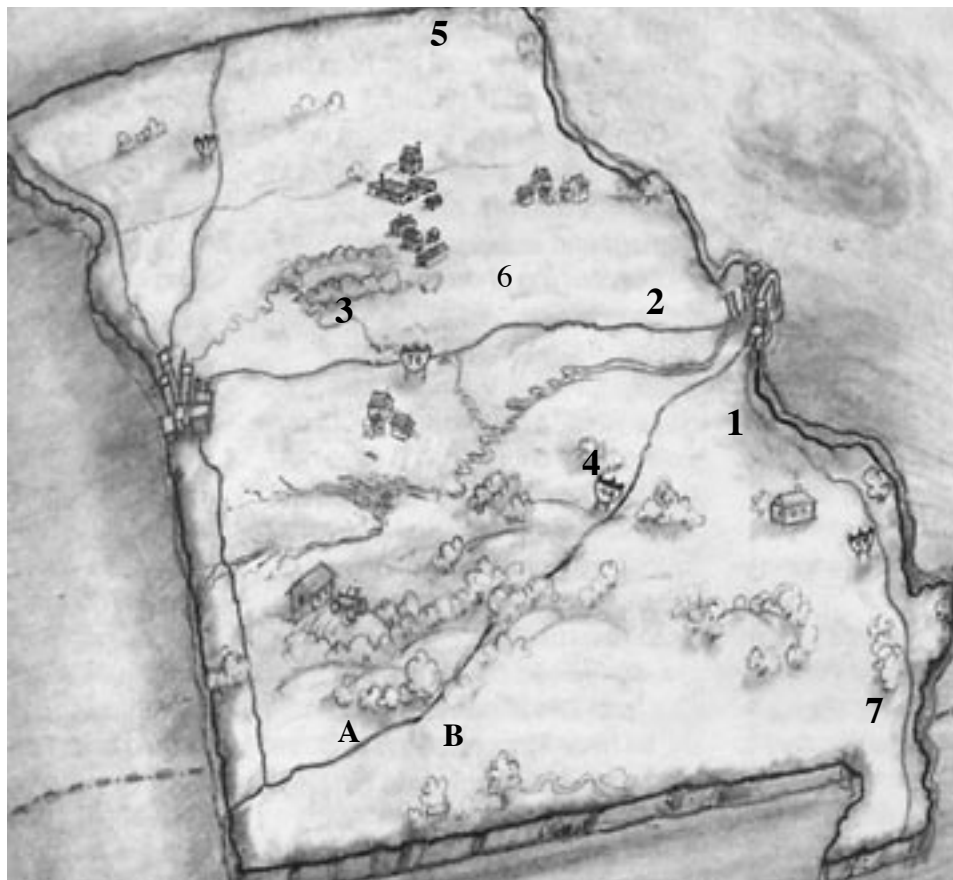
I buy this at dollar tree (make sure it says oxygen) for \$1.00 per bottle I like to use dial liquid for a final wash. Then use the empty bottle for home brew 50/50 (Acetone / ATF oil). It is primarily a degreaser, it seems to work better than Go Jo you can use in the shop and wipe off with a paper towel, but it works better at a sink with a finger brush.



# 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:

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](http://www.caniron.ca)

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

## July 20th Newsletter submission deadline

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

April 1 - Application deadline for May Scholarship awards

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

May/June 2014 BAM meeting Ned Digh, Ham's Prairie 573-642-9502

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

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

November 2014 - BAM meeting OPEN If you can host contact Bob Ehrenberger or Doug Clemons

## Project Idea

Mike Gentsch calls this a *Rim-A-Que*. It is a tire rim that has three short legs and a plate covering the hub hole. They were using it for heat at conference, but you could cook on it by throwing on a grill. Mike said that the fire is high enough that it doesn't usually scorch the grass.



## New Members

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

Fowler, Chad  
16294 SE Vermont Road  
Kincaid, KS 66039  
cjfowler@kwikom.net  
620-439-5457

Lee, Brennen  
13845 Hunter Court  
Platte City, MO 64079  
kristinlee29@yahoo.com  
816-853-7876

Sharpe, Kevin  
543 Van Brunt  
Kansas City, MO 64124  
816-830-6629

Van De Mark, Harold  
1200 East 12th Street  
Lamar, MO 64759  
417-682-3246

Giffels, Matt  
P.O. Box 371  
Marinette, WI 54143  
mgiffels@gmail.com  
907-570-8280

McCray, Gary  
9600 State Road C  
Mokane, MO 65059-1207  
ditchman@ktis.net  
573-676-5617

Tanner, Scott  
5929 Foxfire Lane  
Lohman, MO 65053  
Tanner3310@aol.com  
573-635-0151

Vassmer, Brad  
15849 Fishing River Road  
Lawson, MO 64062  
blt59@hotmail.com  
816-510-1113

Kiso, Jeremy  
11151 Hwy J  
Nelson, MO 65347  
jeremy.w.kiso@us.army.mil  
660-229-1016

Moore, Calvin  
1402 Trexler Road  
Texarkana, TX 75501  
terryandcalvin@windstream.net  
903-838-4144

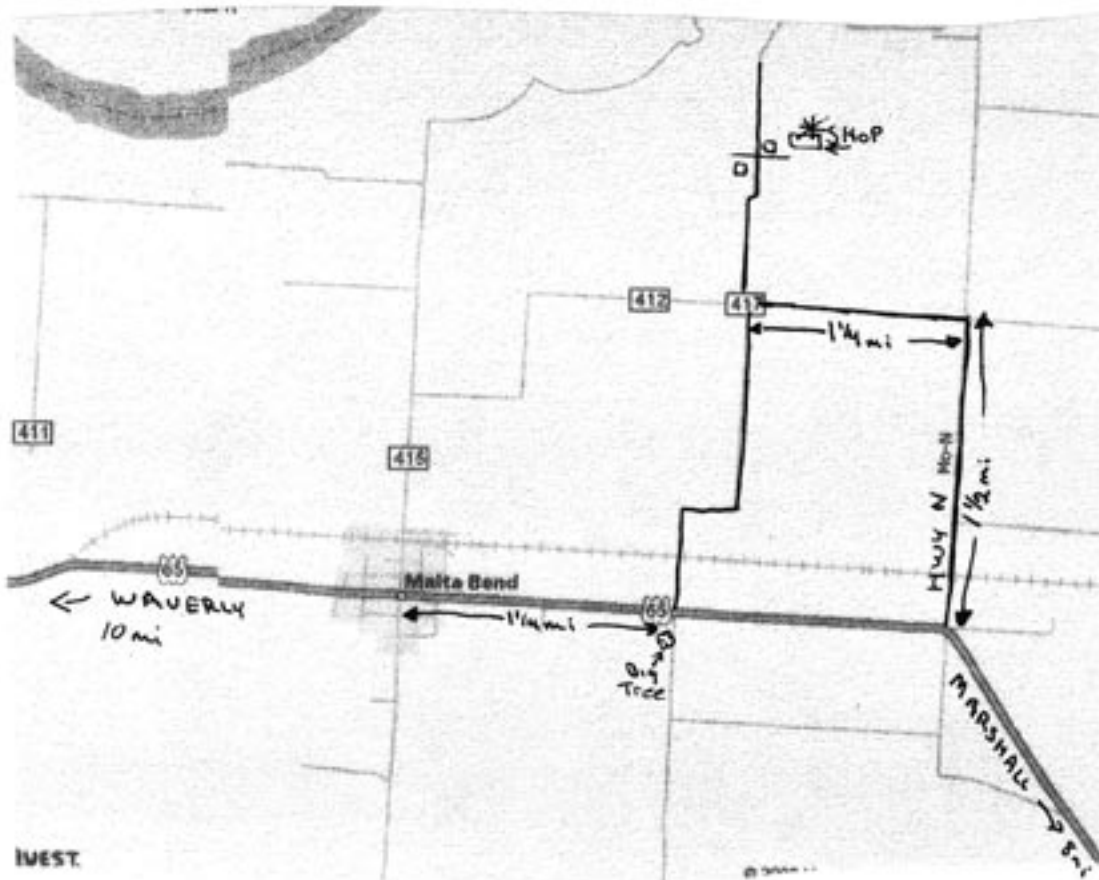
Tipton, Kristin  
3176 Bradley Drive  
New Bloomfield, MO 65063  
kristintipton@msm.com  
573-230-4101

## 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: July 13th - Malta Bend, MO



### Directions:

From the North, take 24 to DeWitt, go South on Hwy 41. Go West on County 412.

From the West, Get to Waverly, take 65 to County 417 or Mo-N

From the East, Get to Marshall, take 65 to Mo-N.

**Host:** Doug Clemons

**Phone:** 660-595-2257

**Food:** Yes

**Trade item:** Camp fire poker