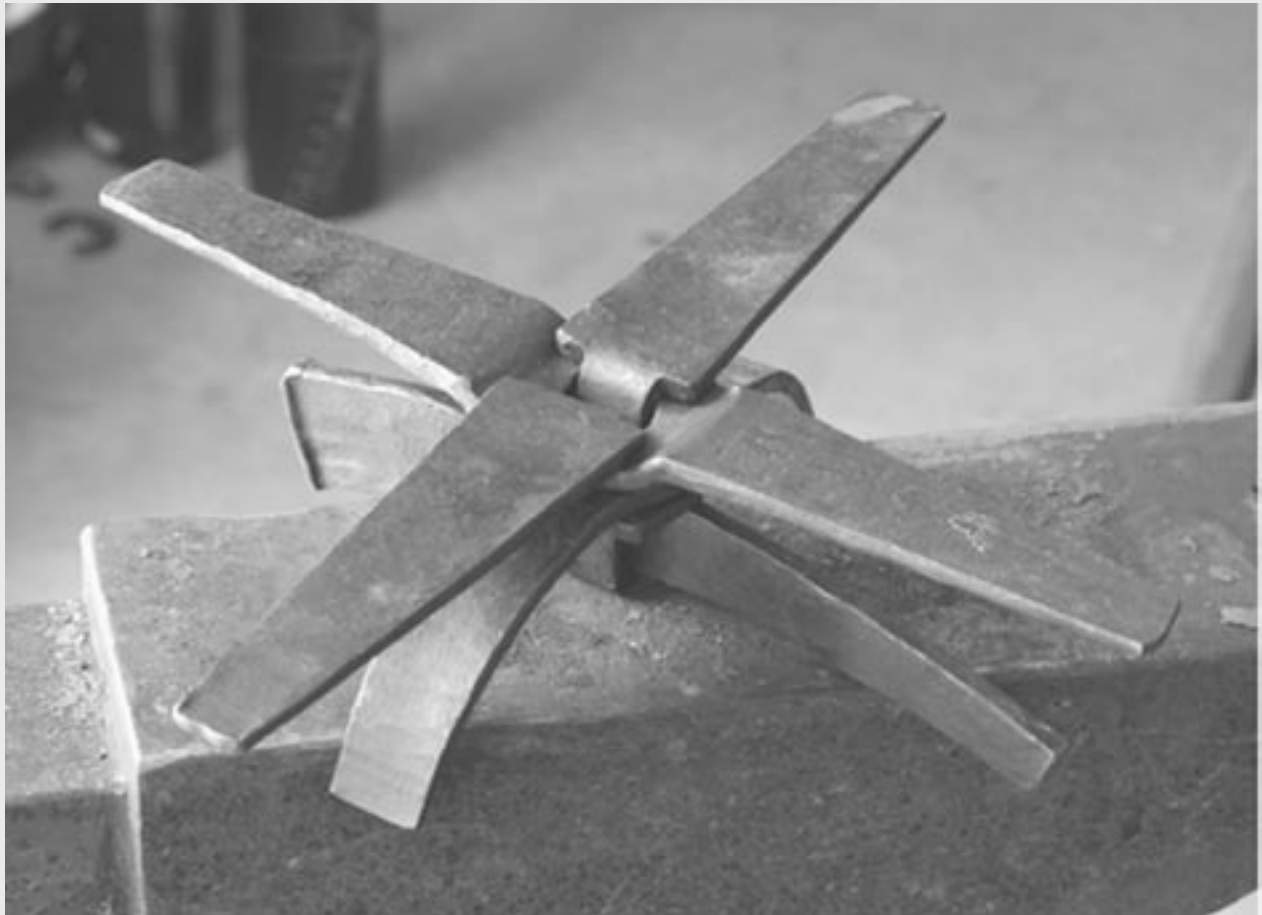


RAM

JULY/AUGUST 2014



*Trivet From the June Meeting Demonstration
By Ian Wille*

Contents

Editorial	5 From the Editor
Hams Prairie, MO	6 Minutes from the June meeting
The Prez Says	7 Phil Cox's President's letter.
Hamilton, MO	8 Minutes from the July meeting
Trivet	10 Ian Wille trivet demo
More Hammers	12 June Trade Items
Flint Striker	14 Bob Ehrenberger Flint Striker demo
Mini-Anvil	16 Phil Cox Mini-Anvil demo
Scratch my Back	18 July Trade Items.
Homemade Anvil	19 Ken Jansen's RR anvil.
Helve Hammer	20 Bernie Tappel makes a helve hammer.
T Bolt	22 Phil Cox T Bolt demo
Classified Ads	24 Ads - Personal / Business
Coal map	26 BAM Coal locations.
Scheduling	27 Upcoming Events and new members.



Homemade anvil pg. 25



Helve Hammer pg. 20



August 13-16 ABANA Conference



COAL Map pg 26



Meeting Map pg 28

**Newsletter of the
Blacksmiths
Association
of Missouri**

Volume 31 No. 4

July-August 2014

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Bernie Tappel

Bruce Herzog

President's Message

Phil Cox

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@charter.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

Since the conference we have had two regular meetings At Ned Digh's and Phil Cox's. We had great weather for both meetings, both had better than usual attendance and trade item participation.

At Ned's meeting, Ian Wille demonstrated a trivet. It was very nice and more elaborate than most, which gave Ian a chance to use some advanced joinery. Ned and Esther again used their lunch as an opportunity to collect food and donations for the local food bank.

I started off the demonstrations at Phil's meeting by showing how to make char cloth and a flint striker. This is a primer for those that want to make a trade item for my September meeting but don't know how. For years there has been talk of demonstrating the next trade item at a meeting, maybe this will get things going. How about it, Don, do you want to demo your trade item at my meeting? Anyway my flint striker came out pretty good and really threw a shower of sparks. I think that is because I ended up normalizing it about 4 times while Phil tried to get his digital thermometer to work. I ended up using a plane old magnet which worked just fine.

Then Phil took over the demonstration with a talk about different types of power hammers. He showed how each design had it's advantages and was the best choice for different types of work. He then proceeded to make a 'T' bolt for a Little Giant toggle arm. It is easy to see why a forged part is stronger than one that is fabricated. Finally Phil demonstrated making a mini anvil under the power hammer. He had demonstrated this at one of the Warrenton conferences, and I missed it. I've been bugging him for years to do the demo again.

For my meeting on September 13th, I have plenty of room for campers, but no hook ups. Feel free to come early. We are not providing a meal so bring a sack lunch to the meeting. The trade item is a flint striker and there will be an article about making them later in the newsletter.

We are looking for a demonstrator for the January meeting in Higbee. Dale is a great host, but he's not a blacksmith, so help us out.

Here at Ehrenberger Forge, things are moving along. I have my new fly press in place and have started to make tooling for it. Though I haven't really



put it to good use yet. Maybe by September I'll have something to show on it. The big news is, I have applied for Social Security and it starts in October. So I should be able to start making things for fun and not just to pay the bills. My main wholesale buyer was not real happy with the news and I have agreed to continue part time until she finds a replacement. If you are interested in doing some wholesale work give me a call and I can tell you about it.

BAM NEWS:
Tony Brooks has his new shop built and is having a grand reopening on August 9th. We

are all invited.

Clay Spencer had a heart attack and is recovering from surgery. Ned Digh got hit by a car while visiting grand children in Florida. After a couple of surgeries, he is back home.

I'm still looking for pictures and stories about homemade anvils. If you have one, please send me the info on it.

I'm planning on having a beginner's class in my shop in Shelbyville this Sept. 6th and 7th. I thought we would have both days on the same weekend to cut down on student travel. You can camp here if you like. If you are interested contact me, 573-633-2010.

The 2015 meeting schedule is full.

The Traditional Arts Apprenticeship Program (TAAP) is taking applications now. The deadline to apply is August 22, Call Deb Bailey for more information ph: 573-882-3653. Also Matthew Burnett is looking for an apprentice, see ad pg 25.

Jerry Darnell has come out with Forging Colonial Ironwork book 2. I got a copy from Bernie, but you can get yours directly from Jerry.
(910) 464-3888 (Shop)
(910) 464-2636 (House)

The next Newsletter submission deadline is September 20th.

BAM Meeting Minutes June 14th 2014

Phil Cox called the meeting to order by thanking Ned and Esther for hosting the June 2014 meeting. He also thanked all the 2014 conference volunteers and especially Mike McLaughlin for his dedication to a successful conference, again.

Bruce Herzog presented the treasurer's report. Conference attendance was 164, up 20 from last year. The Conference did well financially in part due to a reduction in fairgrounds expenses resulting from not having to have the swine pens taken down and put back up. Our membership started this month at 557 with 28 new members and a loss of 34 members for current count of 551 members. Our current balance is good. However, Bruce cautioned that some of that is committed to predictable expenses, such as insurance and coal costs, that come due before we have another major income source. He also reminded everyone that our balance is always very volatile from one time period to the next. Bruce also suggested adding more advanced classes to the MTS program since the current classes available at the conference seem very well attended.

Esther Digh presented information on the results of recent scholarship committee meetings. The new 5 point program is identified below, but Esther noted there are more details to be worked out in the future.

Blacksmith Association of Missouri Scholarship/Grant Program

1. It is proposed that the title of the Scholarship Program be changed to a Scholarship/Grant Program to better reflect educational objectives of BAM.
2. Scholarships and Grants will be only avail to BAM members in good standing.
3. A scholarship of \$1000.00 will be granted by the scholarship committee to an individual annually requesting funds to attend an educational program for the purpose of learning new blacksmithing skills upon submission of an appropriate application.
4. Grants of \$250 or \$500 can be made by the scholarship committee to individuals to fund a workshop in their own shop or to complete a mentorship with a skilled craftsman.
5. This Scholarship/Grant Program supersedes the current program.

The new proposal was voted in after a motion was made to adopt it, and was then seconded with a majority voting for the plan. Phil mentioned the scholarship committee has the responsibility to approve, or deny grant/scholarship applications.

Phil noted that we need a volunteer to be conference chairman for next year, adding that we need to get back to the committee structure for all aspects of the conference, i.e. each conference activity needs a committee with committee chairman to ensure the overall conference chairman doesn't get overwhelmed with details. He also suggested the various committee meetings and conference organizational meeting could follow the regularly scheduled BAM meeting to maximize and simplify attendance at the planning sessions. We need to get volunteers lined up very soon to solicit the demonstrators for the 2015 conference.

Phil gave Karen Bouckaert raffle tickets to sell for the ABANA conference. BAM gets to keep 50% of the ticket sales money.

Phil also mentioned the next meeting will be at his shop on July 19th and the trade item is a back scratcher. He noted the trade item program is a real chance for individual education and trade items should incorporate some kind of forge work on every piece. The host of each meeting is encouraged to demonstrate the trade item at the meeting previous to his meeting to give everyone an idea where to start. Bob Ehrenberger will host the September meeting and will provide flint for flint striker trade item.

Bruce mentioned that he feels the MTS program needs more advertising about when the MTS classes are being presented. A case in point was MTS classes being held at Lou Mueller's shop concurrent with the June BAM meeting. A number of meeting attendees were not aware of the MTS classes that were scheduled. Bruce also presented some information about a craft shop Lou Mueller's family is starting. They

are looking for blacksmith items to add to their shop and are looking at the possibility of having a gallery for display of BAM members work and possibly a demonstration opportunity. They also offer craft classes at their shop. For additional information you can call 636-326-1287 or email info@guildedcrafts.co. Their website is: <http://www.guildedcrafts.com/>

Karen Bouckaert talked about new books that were donated by Mike Gentsch and purchased during the conference. The new checkout procedure is working well as there are only two books that are unaccounted for.

Bob Alexander, 636-586-5350, is taking orders for the 2nd version of Jerry Darnell's book and will pick them up on his trip to John C. Campbell to save you the postage.

The coal supply is getting low, but not critically low as of now.

There was also a brief discussion of raising the BAM membership dues, but nothing certain was decided. Raising dues incrementally seemed more popular than a large single increase. The meeting was adjourned.

Trade Item -- Hammer Made By:

Lou Potts
Don Anders
Chris Miller
Bob Ehrenberger
Don Nichols
Walter Murphy
Pat McCarty
Mel Robinett
Phil Cox
Larry Lutz
Steve McCarthy
Bob Stormer
Dan Wedemeyer

Traded To:

Walter Murphy
Lou Potts
Steve McCarthy
Don Anders
Dan Wedemeyer
Chris Miller
Bob Ehrenberger
Larry Lutz
Bob Stormer
Pat McCarty
Mel Robinett
Phil Cox
Don Nichols

Iron-In-The-Hat Donated By:

Conference
John Huff
Phil Cox
Don Anders
Don Forlow
John Wilding
Mike McLaughlin
Jim Holland
Don Nichols
Tim Patterson
Don Nichols

Pat McCarty
John Wilding
Ray Scott

Bob Ehrenberger
Tim Patterson
John Wilding
Karen Bouckaert
Ray Scott

Donald Davies
Chris Miller
Don Nichols

Dan Wedemeyer

Esther Digh
Earl Million

Unknown
Ned & Esther Digh
Ned & Esther Digh
Bob Alexander
Bob Alexander
Lou Potts
Don Forlow

Won By:

Don Forlow
Mike McLaughlin
Karl Haak
Lewis Allder
Mark Clifford
John Huff
Mike Gentsch
Bob Stormer
Bill Tull
Jamey Holland
John Huff

Disc Pins & Square Stock
Bottle Opener
6 MO-PAC RR Spikes

Hardening & Tempering Book

Pat McCarty
Mike Gentsch
Don Anders
Mel Robinett
Don Anders
Colonial & Early American Lighting Book
Mark Clifford
Tim Patterson
Earl Million

Conversion Charts -- in to mm

Lewis Allder
Plow Share, CV joint, Coil Spring, Brake Drum
Mel Robinett
Don Forlow

Bearing Races and Bearings

Rob Ahrens
Chris Miller
Rob Ahrens
Don Nichols
Bob Stormer
Chris Miller
Ned Digh

Item:

Curly Oak Wood
Horseshoes
Fire Pot Kit
Brake Drum
Assoc. Bolts & Stuff
2 Hay Rake Teeth
Key Rings
Large Taps
Farm Collectors Magazines
Diamond Burrs
Flint
12 oz. Missouri Honey
Plexiglas Rod
Magnetic Dish
Shop Apron
Very Hard Steel
Car Wash Set
Right Hand Gloves
Combo Square Set
Tape Measure
Mini Anvil
Blacksmith Gauge
Soldering iron
Assorted Bolts & Stuff

President's message;

By Phil Cox

As always, Ned & Esther put on a good meeting. Best guess is about 90 people. Ian did a great job with his demo. I really liked his outside the box concept of a unique trivet. I love that style of joinery.

That is the theme of the ABANA conference. Ian I think you should submit that to the gallery at the ABANA conference.

We were a little short on trade items at Ned's but had really good ones. I am always pleased to get the first of something that a person has made. This time I got the first hammer that Bob (the knife) Stormer made.

While On the subject of trade items Bob (the editor) did a nice demo on a flint striker at my meeting. That will be the trade item at his meeting, I am hoping this gets to be a regular happening at each meeting. My hope is that this will encourage more participation in the trade item. Bob also showed us how he makes char cloth remember to use 100% cotton.

Thanks to everyone that helped to make the meeting here so enjoyable for Margie and I. Having a meeting is a lot of work but it is so great to get to see all of our friends, and make a few new ones. I know there were at least 6 new people here. Margie said we fed 87 people so that makes 2 meeting in a row with about 90 in attendance. I hope that trend continues.

Margie counted up 23 women here, she is pleased to see more of her lady friends at the meetings and of

course, was thankful for all the help with the meal. The desserts were wonderful.

I lit the forge with flint and steel. I almost always use a coal forge in the summer as it doesn't put as much heat in the shop as a propane setup. If you must use your gas forge consider moving it just outside the door to reduce the heat in the shop. It is getting pretty hot in the shop now so be sure to drink plenty of water and have some air moving. Take breaks often.

There is currently a lot of talk about more meetings. In years past, several people would have regular scheduled hammer-ins or open forging in their shops. This can be a very good thing and offers lots of opportunities for education and fun. On the down side I know in at least one instance this became an unpleasant experience. The biggest problem was the lack of respect for the shop owners consumable items such as coal, propane, steel, sanding belts etc.

I would like to encourage more talk about hammer-ins and such. We all need to keep in mind the pros and cons to all parties. I know the Kansas guys have a very good system worked out for open shop with some clear rules about the use of the shop and equipment. It seems to work well for them. I will try to get with Bill Moffet to get more details. Anyone interested in local hammer-ins can e-mail or call and I will start a list.

Thanks again for everyone who attended the meetings at Ned's and here. Until next time take care in the heat. Keep your anvils bright and your fires clean.
Phil

BAM member Seth Lancaster is on a missionary trip to Africa. He sent us this picture of some African metal art.



BAM Meeting Minutes July 19th 2014

Submitted by Bob Stormer

Phil Cox called the meeting to order at 12:55PM by thanking Margie and all who provided the lunch goodies.

Phil noted that we still need a volunteer to be conference chairman for next year, once again adding that we need to get back to the committee structure for all aspects of the conference, i.e. each conference activity needs a committee with a committee chairman to ensure the overall conference chairman doesn't get overwhelmed with details. Mike McLaughlin graciously has already taken care of some of the major arrangements, but needs someone now to organize the demonstrators for next year. Steve McCarthy volunteered to be the demonstrator coordinator. We also need the overall chairperson for the conference so Mike can step back. Mike could not attend this meeting but had previously said he will help ease the new person into the job.

Bob Alexander is getting another load of coal. A date for delivery wasn't available, but is expected to be good coal based on the experience of some members.

Chris Miller couldn't attend this meeting but sent word through Phil that he would be willing to do all the paperwork necessary to register BAM as a "Tax Exempt" organization at no cost to BAM. The benefit would be that anyone donating money to BAM would be able to claim a tax deduction, and therefore encouraging more contributions. Bruce mentioned that BAM is currently registered as a non-profit organization, which might complicate registering for tax exempt status. Bernie made a motion to let Chris pursue registering BAM and provide a report of the details prior to approval to proceed. Kent Harbitt 2nd the motion and it passed in the membership vote.

Phil brought up the notion of raising membership dues before we fall behind on income. A motion was made and 2nd to raise dues from \$25 to \$30 beginning with any dues paid after January 1, 2015. The motion passed the members vote. Bruce will try to provide information when each person's dues are due in the next roster to be released this fall. If your dues are not due until after January 1, 2015, but you pay them before that date, the cost will be the pre-increase price of \$25. Any dues paid after January 1, 2015 will be \$30/year.

A number of benefits related to being a BAM member were listed, not the least of which is receipt of our BAM Newsletter. Bob Ehrenberger got a well deserved round of applause for his efforts in publishing the newsletter.

Ken Jansen is organizing his Black Friday agenda for this year and would like for everyone who wishes to participate to make a drawer pull that will fit within a 2" by 2" square. They will be mounted on 3/4" wood drawer fronts, so if you put a shaft on it, it needs to be long enough to be threaded and attached through the drawer front. Current plans are to make 20 drawers, but if enough people participate, a second chest may be made. The drawer pull can be any design you like, and needs to be delivered to Ken by his Black Friday Hammer-In November 28th 2014. If you have a question, contact Ken at 636-295-5844, or email at kjjansen@butchercreekforge.com.

Mike gave an update on Ned Digh's condition after being hit by a pizza delivery truck while he and Esther were visiting in Florida a few weeks ago. Ned is back in Columbia and welcomes email correspondence, but not phone calls yet. The various surgeries he's had have gone well and the prognosis is good.

Kent Harbitt has State Fair tickets for those who are going to demonstrate this year at the fair. The fair dates are August 7 - 17. Please contact Kent for details at 660-647-2349.

Bernie Tappel mentioned the First State Capital in St. Charles is still looking for a demonstrator and may be willing to pay some expenses for the right person. Contact the First State Capital organization for details. The phone number for the site is (636) 940-3322.

There is a Steam & Gas show at Chillicothe, MO in September 26th - 28th that is open to blacksmith demonstrators. Contact them at: <http://www.livcosteamandgas.com/>
The Hamilton Steam & Gas Show will be the third weekend in August and you are welcome to demonstrate there as well. If you need help getting equipment to use at the show contact Phil at 816-583-4337. Information about the show can be found at <http://www.northwestmissouristeamandgas.com/NWMOSteam.html>

Karen mentioned the new library lending procedure for the benefit of the new members who might want to take advantage of our extensive book and video collection. She also mentioned that Steve Austin, one of the founding members of BAM, donated some very early BAM Newsletters to the library. Bernie is working on getting all newsletters scanned and added to the BAM website.

Phil encourage new members to call any of the older folks for help, as we were all new to this at one time, and benefitted from other's experience. Young folks wanting to start in blacksmithing should be encouraged to join BAM and take advantage of the many training opportunities, including the Mobile Teaching Station (MTS) and local hammer-ins.

Bob Ehrenberger still has room for a few more in the MTS class September 6th & 7th at his shop in Shelbyville, MO. Contact Bob at 573-633-2010 for details.

Bruce Herzog gave the Treasurer's report. We currently have \$30,365 in the bank but will be spending about \$8,000 on the load of coal and the next newsletter publication and mailing. Our membership has grown to 563 from 551 at the prior meeting. The meeting was adjourned.

Trade Item – Back Scratcher Made By:

Bob Ehrenberger
Bob Stormer
Don Anders
Don Nichols
Larry Lutz
Lou Potts
Mel Robinett
Pat McCarty
Phil Cox
Steve McCarthy
Walter Murphy
Dale Crabb
Mike Gentsch
Justin Bell
Mel Robinett
Mike Nave
Jack Nettleton
Colton Kiso
Bernie Tappel
Dawn Shields
Ken Jansen
Steve Austin
Matthew Burnett
Fred Arnhold
Mark Sampsel
Mike O'Neil
Tim Shields
Denny Quinn
Kate Dinneen

Traded To:

Bob Stormer
Dawn Shields
Steve McCarthy
Lou Potts
Don Anders
Tim Shields
Justin Bell
Don Nichols
Fred Arnhold
Bob Ehrenberger
Jack Nettleton
Mel Robinett
Walter Murphy
Ken Jansen?
Colton Kiso
Mel Robinett
Mike O'Neil
Mike Gentsch
Phil Cox
Mike Nave
Larry Lutz
Denny Quinn
Pat McCarty
Kate Dinneen
Bernie Tappel
Mark Sampsel
Matthew Burnett
Dale Crabb
Steve Austin

Iron-In-The-Hat Donated By:

Scott Stager
Tom Patterson
Scott Stager
Don Forlow
Don Forlow
Fred Arnhold
Mark Sampsel
Matthew Burnett
Bernie Tappel
Rick Meyer
Matthew Burnett
Donald Davies
Bob Ehrenberger
Don Anders
Pat McCarty
Earl Million
Earl Million
Earl Million
Dale Crabb
Mike Gentsch
Scott Stager
Ian Wille
Don Nichols
Tom Patterson

Won By:

Earl Million
Mike Gentsch
Isaac Lancaster
Steve McCarthy
Earl Million
Mark Clifford
Don Anders
Tim Shields
Mark Sampsel
Isaac Lancaster
Mike Gentsch
Bob Stormer
Cole Lewis
Steve McCarthy
Karen Bouckaert
Karen Bouckaert
Karl Haak
Mark Clifford
William Miller
Bob Stormer
Karl Haak
Ben Collins
Mike Gentsch
Mel Robinett

Item:

Grinding Dish II
1 lb. Wild Flower Honey
Grinding Dish I
??
??
Lead
Re-Bar
Railroad Clips
Grinder
Metal box of Misc
Railroad Spikes
Apron
Flint Striker Kit
Strap
Copper Bracelet
Rake Tine
Rake Tine
Rake Tine
??
2 Boxes Cyclone 22LR
"Make a Twister" Wrench
T-Burner
Various Disc & Magnet Holder
4 Railroad Spikes

The June 7th and June 14th MTS Workshop Report at Lou Mueller's in Sunset Hills, Mo.

By Don Birdsall

The June 7th. workshop eight members attended.

Kai Braadbaart, Santo, Richard Potts, Corey McLane,
Robert McLane, Tom Tacker, Charley Carpenter,
Janson Garner

On June 14th. four members returned to take the
second workshop.

Santo, Corey McLane, Janson Garner, (The fourth
member did not check the sign up sheet)

The weather was good for both workshops, it rained
part of the time on June 7th and that helped cool
the temperature down. On the 14th, it was ideal
temperature all day.

For those that left early on the 14th, you missed
out a tour of Lou's blacksmith area. He explained
and showed us several pieces of tooling and several
different types of forging hammers.

The standard MTS Workshop pieces were made:
On the 7th, a leaf hook was made in the morning and
a heart hook in the afternoon.
On the 14th a coal forge poker with the pineapple
twist was made.
Don

Proposed new policy for the Blacksmith Association of Missouri Scholarship/Grant Program

By Esther Digh

1. It is proposed that the title of the
Scholarship Program be changed to a
Scholarship/Grant Program to better
reflect educational objectives of BAM.
2. Scholarships and Grants will be only
avail to BAM members in good standing.
3. A scholarship of \$1000.00 will be
granted by the scholarship committee to
an individual annually requesting funds
to attend an educational program for the
purpose of learning new blacksmithing
skills upon submission of an appropriate
application.
4. Grants of \$250 or \$500 can be made by
the scholarship committee to individuals
to fund a workshop in their own shop or
to complete a mentorship with a skilled
craftsman.
5. This Scholarship/Grant Program
supersedes the current program.

The next MTS work- shop is September 6th and 7th in Shelbyville, MO

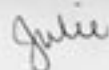
Check page 27 for details.

Dear Blacksmith Association of Missouri:

On behalf of the Callaway Action Network and SERVE, Inc., thank you for your second quarter donations of \$143.95 and 70.8# of food given on 6-16-14 and \$20.00 given on 6-18-14 for our Food Pantry! Your donations to our Food Pantry are priceless because in these difficult economic times, we are experiencing more and more first-time clients in need of food services. Without private support like yours, we would not be able to provide the quality of services that we do to these individuals and families in Callaway County.

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

Sincerely,



Julie Roark
CAN Director
SERVE, Inc.

Ian Wille Trivet demonstration

By Bob Ehrenberger

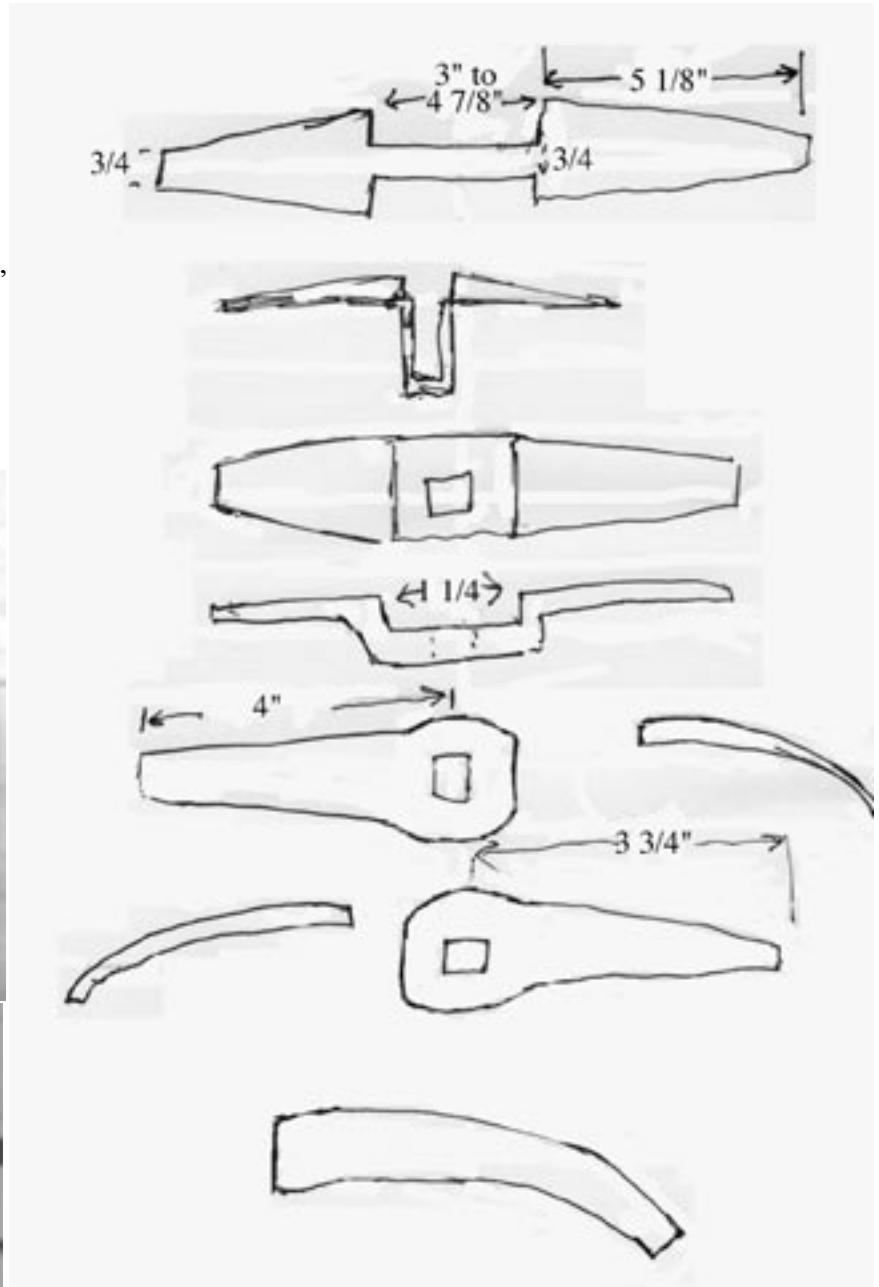
Ian demonstrated how to make his unique trivet which assembles with a locking key which also acts as two of the legs.

All of the parts are made from 1 1/4" by 1/4" flat stock. The cup list going from the top piece to the bottom is: 10 7/16", 9 5/15", 4 3/8", 4 1/4", 6".

The top piece has two fullers 3" apart and then the center section is drawn down to 4 7/8" by 3/4".



Above, Top piece after first fuller.



Right, Both fullers are done, starting to narrow down the center section.



Ian Wille Trivet demonstration



After the center is drawn down the ends are tapered. When all the forging is done the piece is bent using a 1/4" spacer bar and the vice.

The second piece is slit and drifted (round then square) and the ends are tapered. It is then sunk so that when the first piece is inserted into the hole the tops line up.



The legs are also slit and drifted. They are then bent into a gradual curve. The upper leg is slightly longer because it has further to go to reach the same plain.

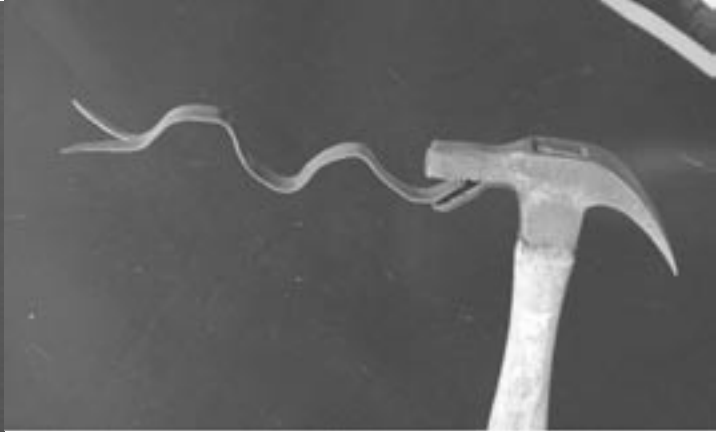
The final piece, the key, is given a gradual taper over the entire length. Keep the thickness under 1/4" so it will fit into the slot. I didn't get a measurement for it's final length, but I would guess around 8" so it had the same spread as the other two legs combined. It is given a gradual bend so that it ends up in the same plain as the first two legs when it is installed.



June Trade Items



Pat McCarty



Don Anders



Mel Robinett



Chris Miller



Bob Ehrenberger



Larry Lutz

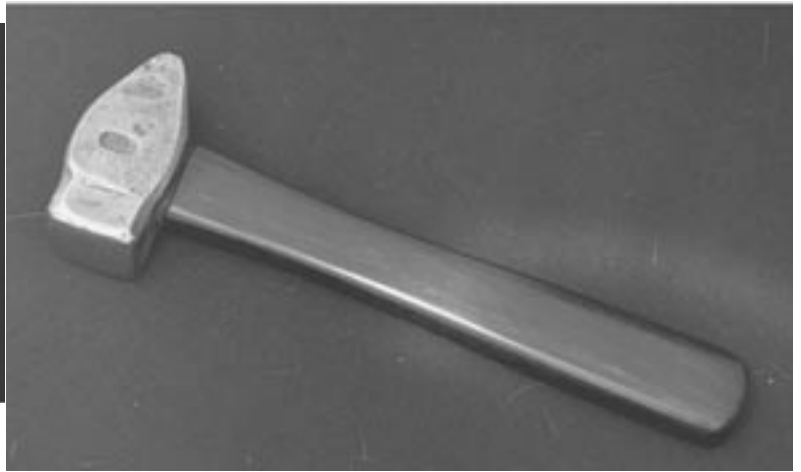


Steve McCarthy

June Trade Items



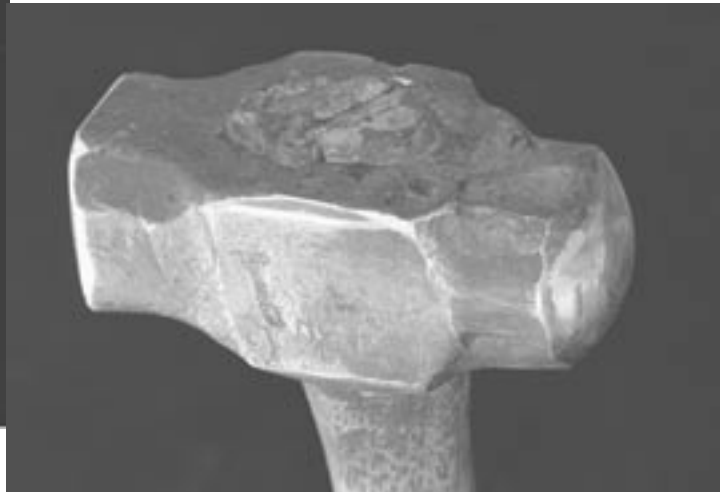
Dan Wedemeyer



Phil Cox



Bob Stormer



Don Nichols



Lou Potts



Walter Murphy

Flint Striker Demonstration

By Bob Ehrenberger

I started out by showing how to make char cloth. You need char cloth to start a fire with flint and steel it catches the spark and keeps it alive. To make char cloth you need to start out with regular cloth. It needs to be a natural material such as 100% cotton, I use old bluejean material, Phil said he uses gun cleaning patches. The cloth is put into a metal can that has a small hole in the lid. For the demonstration I had a Bag-Balm can. The can is then put on a fire and heated. After a little bit white smoke will come out the hole in the lid. Watch it until the smoke stops. Take the can off the fire and let cool. Keep it closed until it is cool, if you open it up while it is hot the char cloth will burn down to ash.



For the flint striker itself I use old hay rake tines. They are a good steel and easy to heat treat. The tines start out as 3/8" round, I flatten out a section and taper it to a thin blunt round edge. I then flatten out more of the bar until I have a section flat that is about 8" long. I cut it off at 8" and taper that end the same as the first. It should be about 9" at this point.

I make a small curl and hook on each end. The hooks should have about a 1" inside diameter and come close to meeting in the middle.

Once you have the shape you want, it needs to be heat treated. If the steel isn't hardened it won't throw sparks (or not very many). I

heat the face of the striker up to critical temperature and quench in water. You know that it is at critical temperature when a magnet won't stick to it.

Note: You can use other steels for strikers, such as old files or garage door springs. You could even buy new steel, such as 1084 or 1095. Ken Jansen said that he quenches his strikes in oil instead of water, and has less trouble with them cracking. Also any shape will work (see next page), this is just the shape I like.



Flint and Steel

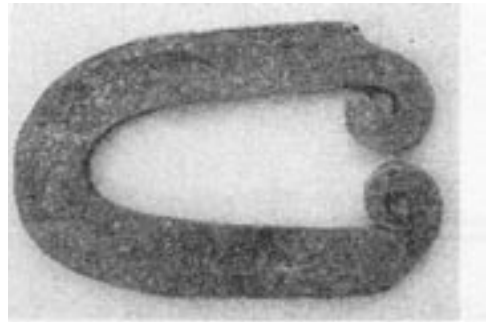
Phil started the fire at the meeting with flint and steel. His method was a little different than I had seen before but it worked real well. He puts a handful of cedar shavings in the fire pot and then some natural lump char-



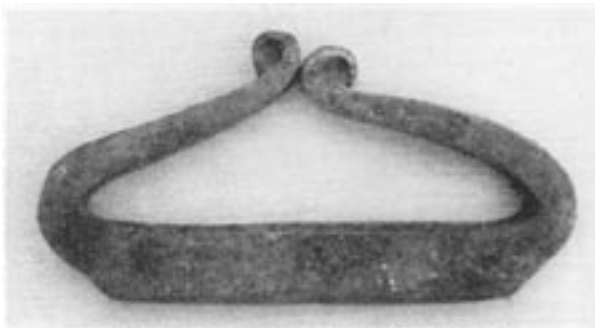
coal on top of it. Finally some of the coke from the forge on top of that. He gets a spark on his char cloth and shoves it under the cedar shavings and starts the air. After a little bit there is smoke, then some flame, finally a roaring

fire. Notice the sparks in the air when the flame first comes through, that is typical of the way the lump charcoal burns. Also note the way his super sucker forge vent draws the flame up the chimney, that's an endorsement for how well it works.

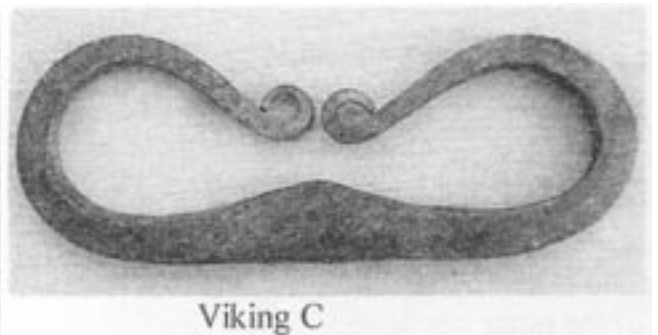
Editor's Note: The following examples of fire steels came from the July/August 2014 issue of the Illinois Valley Blacksmith Association newsletter, except for the last one which I made. Bob



Spanish Colonial



Ildstaal ~ Viking-Era Fire Steel



Viking C



American Civil War

Phil Cox Mini Anvil Demonstration

By Bob Ehrenberger

Several years ago Phil came up with a method to make miniature anvils under his 25lb Little Giant. He showed how to do it at one of our Warrenton conferences. It was a big hit, but I missed it. In 2011 Phil showed me the tooling he uses and talked me through the process, but no more. So when Phil asked what we wanted to see at his meeting last week, I was quick to request a mini anvil demonstration. He wasn't real hot on the idea, but the crowd liked it. It took him a little bit to gather together every thing he needed, and then it was a go.

Starting with a cube that was 1 1/4" square by 1" tall he fullered a 5/16" groove all the way around the block about 1/3 of the way up.

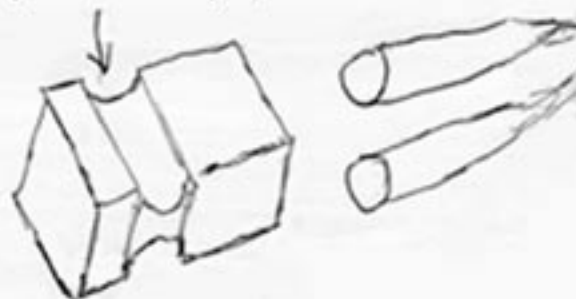
The groove was then deepened with a 3/4" spring fuller to where the web inside was about 1/2" across. This will be the waist of the anvil.

The top of the anvil was flattened out to where it was also 1/2" thick and lines up with the waist. Make sure to work it from both sides so that it stays centered on the waist. He used a fuller as a

Steel block 1 1/4" sq. by 1" long



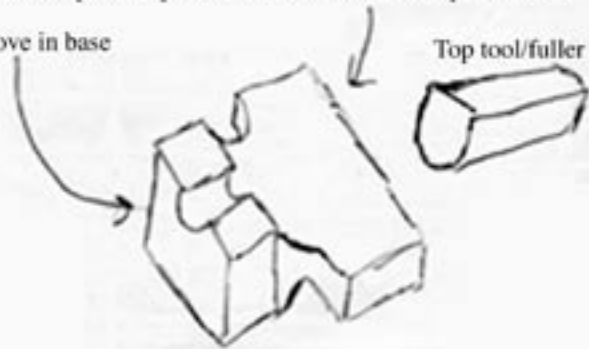
Fuller a small groove 1/3 the way up all the way around
Then deepen it with a 3/4" spring fuller



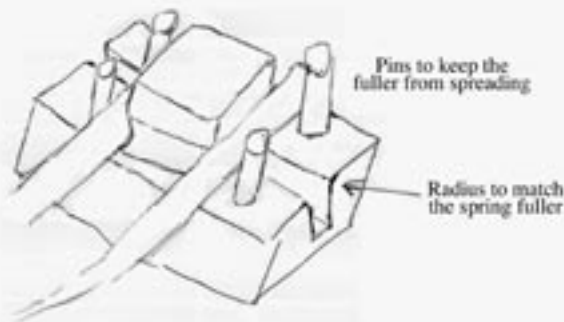
Use fuller to spread top and then draw down to depth of waist

Fuller groove in base

Top tool/fuller



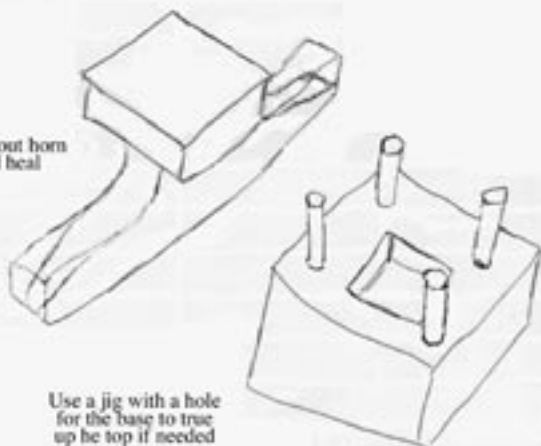
Use spring fuller and space block to true up the base
and the transition to the waist



Pins to keep the
fuller from spreading

Radius to match
the spring fuller

Draw out horn
and heel



Use a jig with a hole
for the base to true
up the top if needed

top tool to spread the top side to side so it wouldn't get any taller than necessary.

The base is then fullered to define the feet.

The spring fuller is then used to support the base in a special jig while the bottom is flattened out. The jig has pins to prevent the fuller from opening up. Then the fuller is removed and the sides of the jig are used as the

Mini Anvil demo continued....

rest of the base is cleaned up.

Once the base is trued up the horn and heel need to be drawn out. Phil started by fullering a groove in the center of the face. This groove was used to hook the edge of the bottom die on the power hammer while the face is being drawn out.

Initially, when he was ready to flatten the face he chilled the base so he could hammer straight down on it. He had to decide which would be the horn and which would be the heel. He chose the side with the most material to become the horn.

Being very careful, he drew out and rounded up the horn under the power hammer. Any spread on the width of the top was corrected by placing the top directly on the flat dies and bring it back to the desired 1/2".

As a final step, Phil trued up the base in the first jig again and used a second jig that had a hole (for the base) to clean up the top of the anvil. The second jig had stops to support the fuller so the fuller could be used to hold the anvil by the waist while the top was being cleaned up.



Right: The rough forged anvil



Above: The two jigs and spring fuller that Phil used

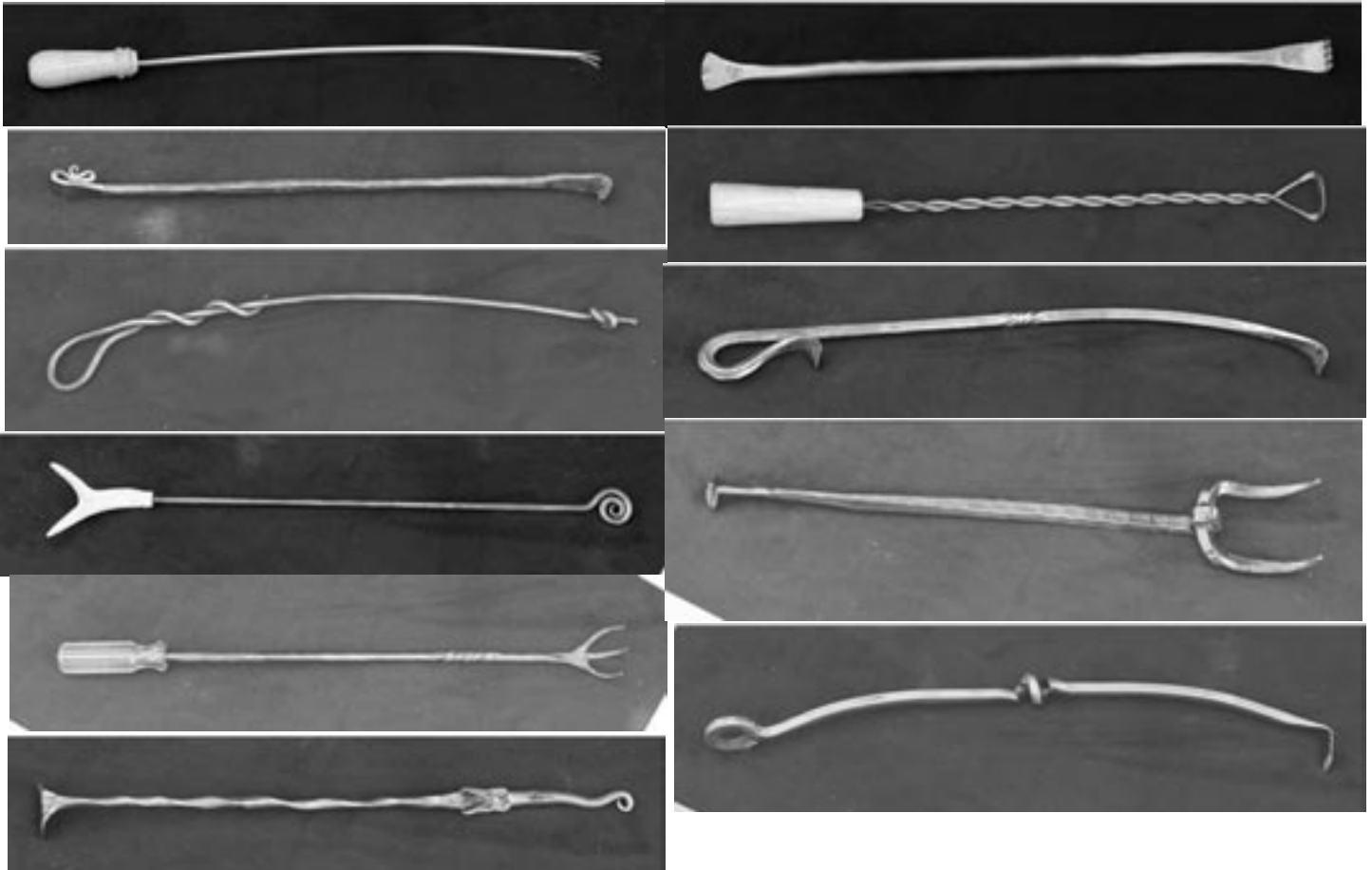


Left: The cleaned up anvil

July Trade Items



July Trade Items



Homemade Anvil

Ken Jansen brought this anvil to conference to sell. He said that he had rescued it out of someone's scrap heap and thought he would try to give it a new life. I didn't notice until I was editing the picture, but this anvil has an extremely long horn. It is almost like a tinner's bick anvil and with a little more dressing could work as one for a fraction of the cost.



The Little Helve Hammer

- Bernie Tappel

Jr. Strasil of Falls City, Nebraska designed and built a small helve hammer several years ago and posted some pictures of it on the internet. I saw the pictures and talked to him several times about it. He emailed me some pictures of the build progression and I had been thinking about building one of these for several years.

I didn't need another small hammer so the idea didn't go any further until Terry Smith started talking about wanting a small power hammer. I had most of the material for the hammer either in my scrap pile or stored around in the shop. The only major pieces I didn't have was the plate steel for the base and the wood for the helve. Terry came up with these and we started the build this past winter.

Our goal was to build the thing with no machine tools, only using the drill press, torch, welder, band saw, etc. that I had in my shop. We had no actual measurements to go by as this hammer is based on materials available, not on an actual set of plans.

Terry came up with a piece of 1 inch plate that we used as the base of the hammer, the eccentric wheel, and the base of the dies. I had a 36 inch piece of 5 inch solid round stock for the anvil and some heavy walled 4 inch pipe for the Samson post. The Samson post is filled with sand.

We used a piece of 4 inch by 6 inch white oak for the helve. Hard maple probably would have been better, but the oak is what we had access to. I believe that Jr. used oak on the one he built too. The 4 inch piece also fit nicely into the 4 inch channel iron that we used for all the mounting points. For the pivot point on the helve, we used a piece of 1 1/8 inch shaft with pillow block bearings. The eccentric shaft is a piece of 1 inch shaft, also with pillow block bearings. These sizes were determined, again, by what I had laying around the shop. I had picked up a big box of pillow block bearings at an auction several years ago for a couple bucks, so this is what we used.

The helve spring was a new takeoff from a pickup truck. We used the existing center hole to bolt it to the helve. I reamed out the bushing in the eye to 3/4 inch for the pivot bolt. The pivot bolt is bored through the head for about 2 inches and then counter bored and tapped for a grease zerk fitting in the head, to allow for lubrication to the bushing.

We torched out a circle from the 1 inch plate and center drilled it to 1 inch for the shaft. To figure the offset for the pitman, we determined how much hammer throw we wanted and then measured the resulting travel on the spring eye which was 4 inches. Half of this amount gave us the pitman offset. So we drilled another 1 inch hole with a 2 inch offset from the center shaft. I welded the shaft to the eccentric wheel first. Then I cut a piece of the 1 inch material for the pitman shaft long enough to protrude through both sides of the eccentric wheel long enough to clamp it parallel to the main shaft on the one side and long enough to serve as a pitman shaft on the other. I wanted to be able to clamp it parallel to the main shaft while I welded it on both sides of



The Little Helve Hammer continued ...

the eccentric wheel. After it was welded, I cut it off flush with the eccentric wheel on the main shaft side.

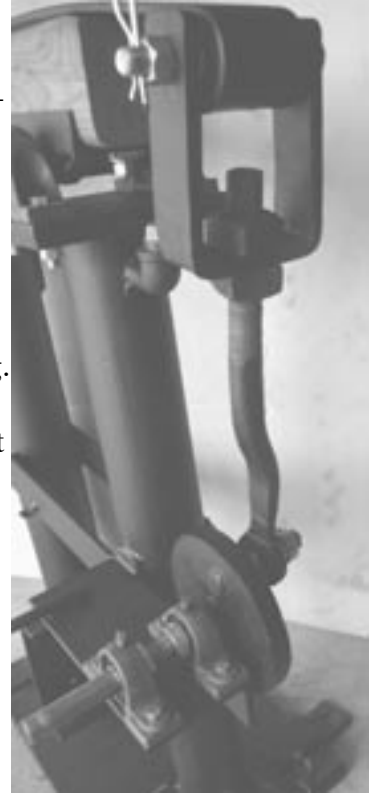
We used the threaded end of a railroad rail j-bolt bolt for the pitman arm, using two nuts and a yoke arrangement at the top for the connection to the spring and for the hammer throw adjustment. The hammer can be adjusted for various thicknesses of metal by adjusting the two nuts up or down. For the connection to the pitman shaft, we decided to go with a weld-on Heim joint (the ball joint used on tractor hitch links). This would compensate for any out of parallel in our eccentric shaft and pitman shaft. We bored the pitman shaft for about 1 ½ inch and counter bored it and then tapped the end for a zerk fitting for lubrication to the Heim joint.

For the drive system, I used a 12 inch V belt pulley that I had on the eccentric shaft. For the motor drive pulley, I welded a piece of pipe onto an old 2 inch steel pulley to make a flat belt pulley. The idler pulley is from a mower deck. A couple of points here, we are using a V belt to drive this, but the motor pulley needs to be a flat pulley to allow it to slip. A V belt pulley on the motor will not allow enough slip to get good control at slower speeds. The other point is that as in any slack belt system, the idler pulley should always be on the slack side of the belt. So the idler pulley position depends on which direction the motor is rotating.

Terry picked up a ¾ horse motor for the hammer, but I think a ½ horse would be more than adequate for this one. We think the total hammer head weight is around 18 pounds. The dies are bolted on and can be easily changed. We used some 4140 2 inch square stock welded to 1 inch plate for the dies and heat treated them.

This was a fun winter project. The hammer is very responsive and has good control. It does tend to move around a bit if not bolted to the floor, but I think a lot of smaller hammers do this. We will be doing some additional tuning, adjusting spring tension, etc., but so far the hammer seems to work very well.

Thanks definitely go to Jr. Strasil for all his work on the original concept.



Phil Cox T Bolt demonstration

By Bob Ehrenberger

The toggle arm on a Little Giant seems to be a common point of failure. Some people try to make a new T bolt by welding a cross bar onto the end of a bolt, but few are good enough to get a bolt that will hold up. For the Little Giant hammers that Phil rebuilds he forges his own T bolts from a solid piece of steel.

First a section is isolated on the end of a bar that will become the T.

Then the shaft is drawn down behind the section.



The shaft is cut off and taken down close to finished size. It is finished in a spring swage under the power hammer.



Once the shaft of the bolt is cleaned up it is time to make the T head on the bolt. Phil flattens it out between the flat dies on the power hammer so it will fit into the special bolster that he has made to form the head. Phil recruited Bernie Tappel to help him forge the head. They each started in the center of the head and pulled the material towards them. After each session in the block Phil would take it back to the power hammer to correct any side to side spread. He said that when he is doing this by himself he uses his hydraulic press to forge the head. And surprisingly it still takes 3 heats to get the job done because you can still only go so far before you have to correct the spread.



The block wanted to rotate as they worked it so Matthew

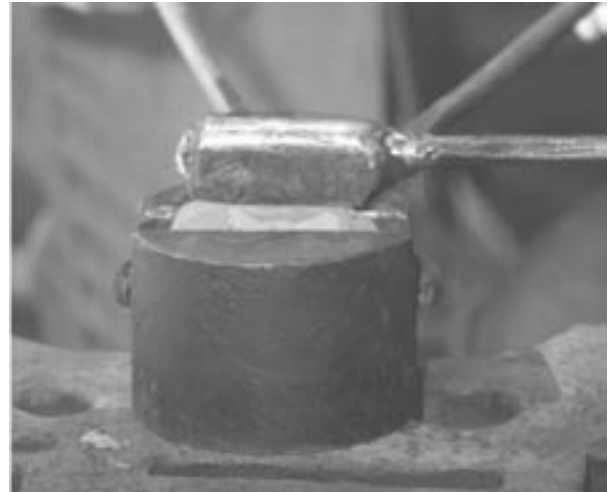
Phil Cox T Bolt demonstration

Burnett was recruited to hold the block with a pair of tongs as they worked.



When the head got close to the top of the block Phil used a hand held fuller to further control the spread and to force the top of the head into the block.

Once the head of the bolt was forged Phil used the large flat dies on one of his Bradley hammers to straighten the bolt section again.



Normally the bolt would be annealed at this point so he could cut the threads, but he just cooled it so we could pass it around. Phil said that after the spring swage the bolt is close enough to the right size that he can cut the threads without any finish machine work.



*T bolt bolster and
rough forged T bolt*

Finished T Bolt



Buy, Sell, Trade

Individual Classified ads

For Sale: Anvil's Ring Magazine collection Sept '73 thru Present. \$350 Bob Woodard Edwardsville, IL 618-692-6508

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 Roger Rice, Midwest Machine, 6414 King Road, Nebraska City, Nebraska 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:

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.

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

New England School of Metalwork

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 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

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

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Buy, Sell, Trade, Continued ...

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D.L. Schwartz Co. **Blacksmith and Farrier supplies.**
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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

Wanted: Blacksmith Apprentice wanted for Missouri Traditional Arts Apprenticeship Program. If interested, contact Matthew Burnett, Cameron, MO at (816) 575-2798

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

July-August 2014

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

Homemade Anvil

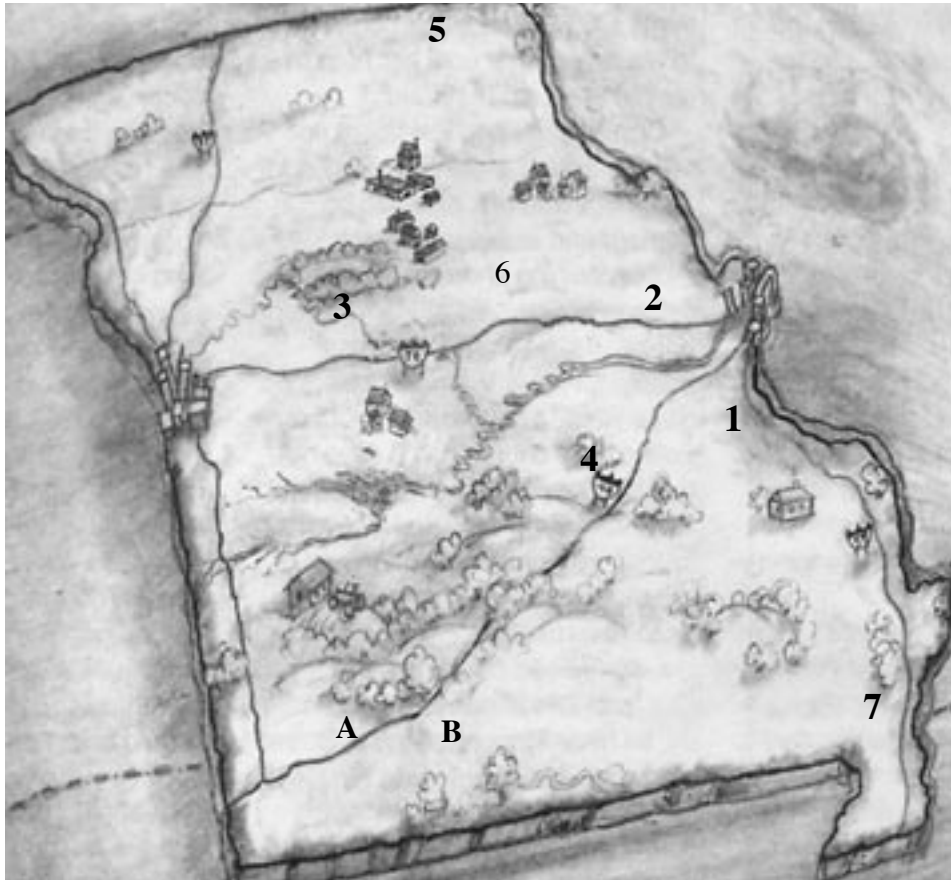
Tony Brooks brought this anvil to conference. It is quite unique. Tony said that he got it at a friend's garage sale and doesn't know who made it or for what.



Need Coal ?

Check on Availability

Coal Captain: Bob Alexander



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14009 Hardin Rd,
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2. Ken Jansen, (636) 366-4353
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3. Doug Clemons, (660) 595-2257
29377 Durango Avenue
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

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:

August 7-17 - Missouri State Fair Sedalia, MO contact Kent Harbit (660)-647-2349 to volunteer

August 13-16 - **ABANA Conference** Harrington Delaware, The Delaware State Fairgrounds

August 15, 16, 17 Hamilton Steam show,

September 6,7 - Beginner's Class, Bob Ehrenberger, Shelbyville, MO 573-633-2010

September 13th 2014 - BAM meeting Bob Ehrenberger, Shelbyville, MO 573-633-2010 Trade Item: flint striker, Bring a sack lunch

September 20th - Newsletter submission deadline

October 1 - Application deadline for November Scholarship awards.

Nov

January 1 - Application deadline for February Scholarship awards.

January 10th 2015, - BAM Meeting A & K Cooperage, Higbee, MO 660-456-7561 Food will be available

March 2015 - BAM meeting Chris Miller, Doniphan, MO

April 1 - Application deadline for May Scholarship awards

April 30th - May 3rd 2015 -**BAM Ozark Conference**, Sedalia, MO

May/June 2015 - BAM meeting Ned Digh, Ham's Prairie, MO 573-642-9502

July 2015 - BAM meeting Matthew Burnett, Cameron MO ph: 816-575-2798

September 2015 - BAM meeting Rolla, MO Don Birdsall

November 2015 - BAM meeting, Phil Cox, Hamilton, MO 816-583-4337

MTS Workshops (Mobil Training Station) Beginner's Class

Number 1 beginner workshop Saturday September 6th 2014.

Number 2-beginner workshop Sunday September 7th 2014.

Location: Bob Ehrenberger's Shop, 6192 Hwy 168 Shelbyville, MO. 63469 Phone 573-633-2010

Start time 8:00 am. Sharp. Students should be there and ready to go at 8:00 am. Both days.

Students must wear safety glasses while instruction and workshops are being run.

Students need to bring a lunch both days. Water will be available.

Students should wear cotton or wool clothing, no synthetic type of clothes. Gloves and aprons are not provided.

Must be a BAM Member (Insurance requirement) \$25.00 dollars for a one year membership.

Cost of each workshop is: \$25.00 dollars per student per day.

Instructor: Bob Ehrenberger PH; 573-633-2010 e-mail: eforge@centurytel.net

If not a member, sends membership dues (\$25.00 dollars) to: Bruce Herzog, 212 Aileswick Drive, St. Louis, MO.

Send payment for workshops to: Bob Ehrenberger's Shop, 6192 Hwy 168 Shelbyville, MO. 63469

Any questions call: Bob Ehrenberger PH; 573-633-2010 e-mail: eforge@centurytel.net

New Members

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

Baumer, Clif
6306 S Old Villiage Road
Columbia, MO 65203
cjbbaumer@centurytel.net
573-442-8454

Burchett, Matthew
804 Hardy Street
Knob Noster, MO 65336
rfx55@hotmail.com
660-238-2070

Frazier, Dale
13448 Drake Ave
Pattonburg, MO 64670
dalefrazier46
@hotmail.com
660-367-4775

Kell, Clovis
601 S Jefferson Street
St. James, MO 65559
ckellAcharter.net
636-284-0661

Mason, Eric
541 County Road 4403
Boss, MO 65540
pryor317@yahoo.com
573-247-7696

Milner, Martin
711 Rogers Avenue
Stoutland, MO 65567
martyml@aol.com
417-286-3330

Bowen, Joey
RR 1 Box 146
Mt Sterling, IA 52573
joeybowen2000
@yahoo.com
660-342-1282

Burns, Clarke
20403 Hwy M
Brookfield, MO 64628
660-258-7389

Jackels, Charles E
14878 Sycamore Manor
Drive
Chesterfield, MO 63017
jackelsc@live.com
636-751-2413

Layton, Patrick
6104 Old State Road
Imperial, MO 63052
redvettman63@aol.com
636-464-5119

McCarrin, Michael
21096 Hickory Street
Grafton, IL 62037
618-786-3846

Overcast, Alexander
1461 N Frisco Ave
Springfield, MO 65802
alexander.overcast
@gmail.com
417-543-2625

Braadbaart, Kai
501 Oak Street
Webster Groves, MO
63119
kbraadbaart@mica.edu
314-435-5266

Webster Groves, MO
63119
brettd@wustl.edu
314-918-8218

Karakas, Anthony
57 Graeser Acres
St. Louis, MO 63146
anthonykarakas
@gmail.com
314-220-5555

Lee, Christopher
301 N 11th
Broken Arrow, MO 74012
cbweider04@hotmail.com

Miller, William
6021 NW Glenwood Drive
Topeka, KS 66617
wcmiller@topeka.org
785-213-5804

Whisenhunt, David
1924 South Clairborne
Olathe, KS 66062
mongo909@hotmail
913-208-8327

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@charter.net

Next Meeting: September 13th Shelbyville, MO



Location:
Shelbyville, MO.

(North East corner of MO)

Host: Bob Ehrenberger

Phone: 573-633-2010

Food: No, bring a sack lunch

Trade item: Flint Striker

Other: There is room to camp, but no hook-ups