

RAM

July/August 2021



July/August 2021
Volume 38, No 4

Blacksmith Association of Missouri

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The Newsletter of the Blacksmiths Association of Missouri is published six times a year and is mailed to members of BAM. Editorial inquiries should be addressed to: Mike McLaughlin, 122 Milwaukee Ave., Lawson, Mo. 64062 816-296-3935 or send an email to: bameditor2015@gmail.com

The annual fee for regular membership is \$30/year; a portion of this amount is for a subscription to this newsletter for one year. BAM membership inquiries should be addressed to: Dennis Marshall 13410 A Highway, Liberty, MO 64068 busyman512@outlook.com 816-645-7237

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Membership Application

Name: _____

Address: _____

City: _____

State: _____ Zip: _____

Phone: () _____

E-mail: _____

New Member Renewal ABANA member
\$30 per year

Are you interested in taking a class?

How did you learn about BAM?

Memberships are for one year from receipt of dues. Dues are \$30, which includes a subscription to the bimonthly BAM newsletter. Please make checks payable to Blacksmith Association of Missouri

ABANA Membership Application

Primary ABANA Charter Affiliation: _____

Name: _____

Address: _____

City: _____ State: _____

Phone: () _____ Zip: _____

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New Member Renewing Member

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

Membership: Renewal **New Membership** *For Annual Membership-Renewal Date in One Year*

Digital \$55 / yr. Available world-wide, including North America. Publications will be sent digitally to the member's e-mail address on file. No print copies will be mailed.

Print \$65/ yr. Available in North America only (USA-Canada-Mexico). Publications will be mailed.

Membership includes FREE placement in a searchable 'Find a Blacksmith' database to connect to opportunities.

Check here to be included in the searchable on-line 'Find a Blacksmith Directory'

Send this form in an envelope with your payment to:

BAM
C/O Dennis Marshall
13410 A Highway
Liberty, MO 64068

I _____ hereby apply for membership in the
Artist-Blacksmith's Association of North America and enclose
\$ _____

MasterCard Visa Check/Money Order

Card Number

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Exp Date:

--	--	--

(Required)

Checks must be in U.S. Currency
SEND RENEWAL TO:
ABANA Central Office
PO Box 462
Johnstown, PA 15907-4817

(814)-254-4817
www.abana.org To join online.

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Dennis Marshall

Treasurer/Conference

TBD

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Don Anders

Librarian

Karen Bouckaert

Conference Chair

Michael Gorzel

Ashley Farnsworth

Coal Captain

Bob Alexander

The Blacksmiths' Association of Missouri is an affiliate of the Artist Blacksmiths' Association of North America, and is devoted to the preservation and advancement of blacksmithing and to communication among blacksmiths in Missouri and surrounding areas. The Newsletter of the Blacksmiths' Association of Missouri's goal is to support these aims. Letters to the editor, tech tips, tools for sale or anything else which furthers these ends will be considered for publication.

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President's Report

By Santo Guiffrida

Hello BAM Members, we have had a lot activities through July and August. There were two BAM Meetings, a Hammer In, and we outfitted and staffed a Blacksmith Tent for 12 days at the State Fair. The Newsletter will share more of these events in greater detail.

I am heartened for all those in attendance and all the support provided at each of the above these events. Special thanks to Hollis Harbit for his dedication by overseeing the Blacksmith Tent at the State Fair for all 12 days.



In addition, several BAM members helped at the Missouri Statehood Celebration in Columbia, MO and St. Charles. Check August Meeting Minutes for the names. I also want to thank all of those BAM Members demonstrating at various festivals around the state.

There is a lot to look forward to. Our next couple of meetings will be at venues we have not been at for a while. We are hard at work trying to make the next conference special as it is the 30th BAM Conference. We are offering a special deal on registration for members (reference the enclosed meeting minutes or our website). We also will have three demonstrators instead of two as well as two beginning blacksmith classes instead of one at the conference.

Remember to keep the rust off the anvil by using it.

Santo



This is Paige Thomas. She sold 5700 boxes of Girl Scout Cookies this year. She has won National Awards and Prizes for her efforts. Congratulations on a job well done.

Little Giant Hammer Rebuild Class

October 15th. - 17th. 2021

This will be the last class taught by Sid.

It will be in Nebraska City, Nebraska.

Call 402-873-6605

Email:sidsshop@windstream.net

BAM Meeting Minutes July 10th, 2021

Submitted by Bob Stormer

Santo Giuffrida-President thanked Ken Jansen for bringing all his equipment and doing demonstration for the meeting.

Santo also gave the membership report for Dennis Marshall-Membership Chairman, who couldn't attend. Dennis reported he removed 35 and added 43 members since conference. Subsequent membership total is 557.

Chris Miller-Treasurer presented the treasurer's report and was able to provide a complete summary of the conference since all bills have been received and paid. Santo then provided more details about the conference financial status, brought up an idea Bob Alexander had mentioned to him a few months ago. Since we had a surplus, of about \$10k from the conference and registration fees, not counting meals, classes, etc., were about \$7K, the BAM officers decided to ask the meeting membership if they would agree to offer free registration to BAM members for 2022 Conference which would be our 30th conference. Assuming all other expenses and incomes are similar to 2021, we would not operate at a loss. This would be a reward to our members and entice others to become members. The officers proposed offering free 2022 registration (not meals, not classes, etc.) to members that register early and \$15 late registration for members missing the early registration date. Non-members would need to join or pay normal non-member registration fees. This would be only for 2022. Santo opened the idea for discussion with the meeting attendees. Bruce Herzog noted that many years ago BAM offered something similar, by giving free conference registration to any member who extended their membership by one year. He also expressed concern that by offering free registration, we might see people registering, but then not showing up. Since meals and classes would still require a monetary commitment, it was suggested that "no-shows" would have minimal impact on conference expenses. The motion was presented to the meeting attendees, seconded, and then voted on. The motion was approved with no nay votes.

Santo continued by presenting some 2022 conference organizational details for Michael Gorzel-Conference Chairman, who could not attend the meeting. The dates are April 28th through May 1st, 2022. The fairgrounds have been reserved and two demonstrators are locked in. Lin Rhea, ABS MasterSmith, will be the knifemaker demonstrator, and Kirk Sullens, past BAM president (alias El Presidente) will be the traditional blacksmithing demonstrator. A third demonstrator is being pursued. Additional plans are to have two beginner blacksmith classes, instead of one beginner and one intermediate. As time permits there may also be some open forging time. Ken Jansen and Steve McCarthy will be organizing the forging contest, which, at this time, will consist of duplicating an item that the contestant won't see. The item will be in a box and each contestant will be able to reach in feel the item for a short time, but not see it. The contestant who most closely duplicates the item will be the winner. Additional forge from the MTS will likely be used allow for more than two consecutive contestants.

The BAM Officers have sanctioned the Hammer Ins to be held at Bernie's shop in July 2021, Ken Jansen's in November 2021, and Pat McCarty's in January 2022 as official BAM events.

The September 25th BAM meeting has been changed to October 9th. Location is the same. Trade item is a nail header. Bernie Tappel will be the demonstrator and asked for demonstration suggestions. He has a wide variety of talents, so get creative with your suggestions.

The date has been set for January/February 2022 meeting at Dale Kirby's shop in Higbee, Mo for February 5th. BAM Officers have authorized purchase of a spare regulator for the MTS trailer. We are also considering a spare propane tank as long as there is no limits on propane quantity on our trailer.

Several BAM members re-insulated the propane forges on the MTS Trailer and created an anvil stand to be used with a previously donated anvil by Don Nichols for the conference and State Fair booth.

Bob Stormer-Secretary has asked to be replaced by the next BAM Conference. Anyone interested should contact Steve McCarthy-Nominating Chairman at 417-260-1861, or contact Bob Stormer at 636-734-2693 if you have any questions about the duties.

BAM is now available as a Charitable Organization , Blacksmith Association of Missouri, on Amazon Smile.

A new member asked if there is directory of where other smiths in the area close to him may live. He was told that a directory is published in the BAM Newsletter in January February. Another option for finding local BAM members was noted as posting a request on Around-The-Anvil. Details for joining Around-The-Anvil are on the BAM website.

Karen Bouckaert thanked BAM for her selection as a life member at the 2021 BAM Conference. She also announced she purchased some additional books for the BAM Library as well as receiving a lot of books from Lou Mueller's collection. She is in the process of cataloging the new books now which will be available on the BAM website.

Karen also asked ideas for the 2022 BAM Conference t-shirt design. The theme is Igniting Fire and Passion. Contact Karen at 636-673-1996 or karen.bouckaert@bjc.org if you have design ideas.

At the meeting Santo accepted a floor model drill press for use at the conferences and state fair as a donation from Gary Kobermann. It will come in handy at both locations. Many thanks to Gary. Due to the urgency of weather coming, in Santo did not get a chance to thank Gary during the meeting.

The meeting was adjourned.

Editor Notes:

Well this is another full one. I had to cut a little out of each article to be able to get everything to fit. I hope what is in there will help you learn what you would like to know.

Don Birdsall sent me an email and recommend a book that we have in our free book download section on our website. Metals for Engineering Craftsmen. It is written in easy to understand language. It covers ferrous metals, non-ferrous metals, copper, bronzes and others. It tells if the alloy can be forged, machined, cast, and weldability. There is a lot of free books in there with a lot of goods information.

Ken Jansen Demo: Wedges July 10th. 2021

Written By Mike McLaughlin Photos: Bruce Herzog, Bob Stormer, Mike M.

The August meetings trade item was going to be anything with traditional joinery. Ken's second demo was two different types. The first one was a type of tenon using keys and wedges. For this he used 5/8" and 1/2" square bar. The 1/2" bar is going to pass through the 5/8" bar and be held in place by a key and a wedge. I didn't get all of the fine points that were demonstrated in this article. This should give you a start. Make many test pieces.



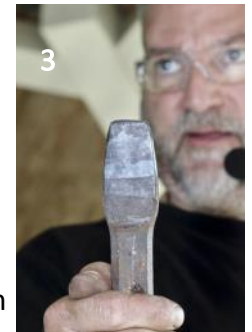
Starting with the 1/2" bar he used a 3/4" slitting chisel to cut through the center of the bar appx. 3/8" from the end. Slit from both sides and use either a plate or the hardy hole to keep from dulling your chisel. Keep punch cool.(1)



Ken made two drifts to help size the slot. One to get the slot started (long one) and one to finish (short one). (2) The finish one was appx. 1-5/16" wide by appx. 3/16" thick.(3) Make the edges of your drift radiused to help prevent cold shuts. Use your post vise opened just a little to drive your drift into the bar.(4) Thin the sides of the bar with the first drift, working to get and keep the bar its original 1/2" size.(5,6) It will grow in length. It will take a few heats. Make sure to drive the drift in from both sides. Then use your finish length drift and drive it in from both sides and finish the sides. Do not drive the drift past your size mark. Forge the sides to size it.



Make sure you keep the height 1/2" also.(7)

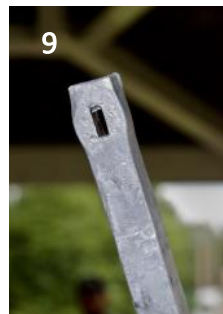


Make sure you keep the height 1/2" also.(7)



Punching and drifting the 5/8" bar is next. Ken used a 7/16" slot punch to start the 1/2" square hole. Ken used Bernie Tappel to hold down to keep the bar steady to punch it.

(8) If you don't have a "Bernie" you will have to use someone else. Rotate your punch to help keep the hole even. Punch halfway then flip bar over and punch from the other side.(9) It helps keep the bar thickness even. Then drove a 1/2" drift in through the hole.(10) Drive the drift in from the fat side first if your punched hole is uneven. Square up and flatten the bar then drift again. Check the fit with the bar that needs to pass through.(11)

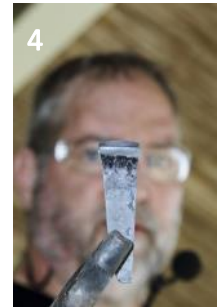
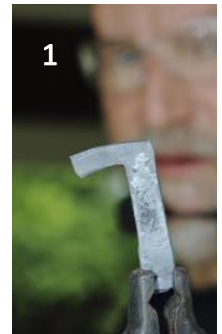


The Key.(1) The slot in the $\frac{1}{2}$ " bar is appx. $\frac{3}{16}$ " wide so your key needs to be that wide. It is also radiused on the side to match the radius in your slot. The one Ken made is shaped like an L. You can make your key however you like.



The Wedge.(2) The wedge needs to be flat on the side that will be against the $\frac{5}{8}$ " square. It will have a slight taper on the other side. It will need to be radiused to match the slot also.

Length and width will be determined by how much slot you need to fill. You will have to do a couple of test fits.(3) Ken likes to upset the top of the wedge. (4) It makes it look a lot better.



Assemble. Insert $\frac{1}{2}$ " bar into the $\frac{1}{2}$ " punched hole in the $\frac{5}{8}$ " bar. Put in the key insert the wedge and hammer in tight. Back up the bar when driving the wedge in.(5)

Mortise and Tenon

Ken used $\frac{3}{4}$ " and $\frac{5}{8}$ " bar for this joint. He used a round punch to punch a hole in the $\frac{3}{4}$ " bar. I did not get the size. Then used a $\frac{1}{2}$ " square drift to size the hole. Drift from both sides. Ken used a guillotine type tool to forge the tenon on the $\frac{5}{8}$ " bar. The tool had flat dies. You should butcher first, but those dies were still at home. I did not get any pictures of this process. He put about $\frac{7}{8}$ " of the bar into the dies and forged all the way around to establish the shoulder. Then went to the anvil and forged it down a little more. He went back to the guillotine to refine and finish it to size. Use the hole you punched in the bar as a gauge. During this process these words were spoken. "Especially because it is really too high up." Referring to the height of the guillotine tool in the post vise. After getting the size right he heated it up and drove it into the square hole in the $\frac{3}{4}$ " bar. He did this to make the shoulder fit the bar. Then heated it up and peened the end to make a pyramid shape.



Ken Jansen Demo: Leaf bottle opener July 10th.

Written By Mike McLaughlin Photos: Bruce Herzog, Bob Stormer, Mike M.

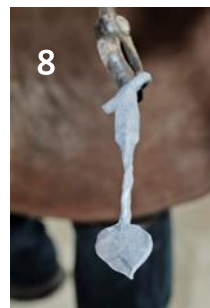
The Trade item for this meeting was a bottle opener. Ken's first demo was making his trade item.

He started with a piece of ½" Sq. about 5" long. To make the opener end he punched a hole appx. 3/8" of an inch from the end with a 7/16" long slot punch. (1) Then drifted it round big enough to fit over the horn of the anvil. Rotate around the horn hammering on the top until you have a ring appx. 1 to 1.25" diameter. (2) Knock down the corners to relieve the sharp edges and make it look nice. Use a round punch to create the lid lifting nub. (5) Don't make it stick out too far if you do it could catch the glass on the neck of the bottle and break it. Hammer from the end and make it an oval. Offset it a bit to help with opening. (6)

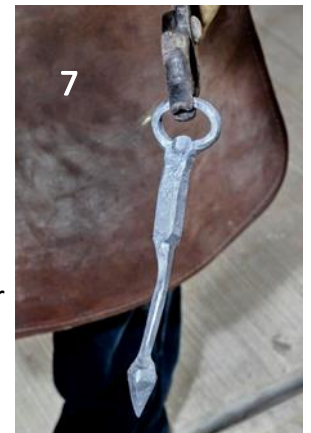
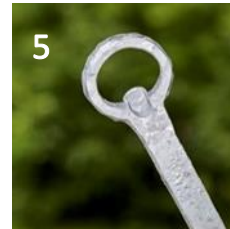
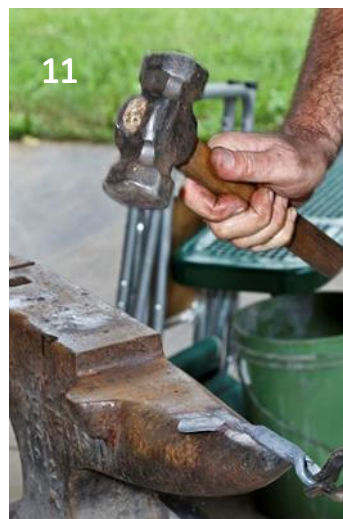
To make the leaf end Ken drew it to a point on two sides of the bar. (4) The length of the point will kind of determine the type of leaf you are going to make. This is where you get to make the style of leaf that you want to make. Do what makes you happy.



Next, he drew out the stem using half face blows and the horn to decrease the diameter of the bar. (7) Length can be whatever you want. He used the round face of a rounding hammer and the radius of the horn to create a rough spiral around the stem. (8,9,10) You would hammer on the stem as you are pulling it towards you and rotating it as you go down the length of it. The round of the hammer and the radius on the horn fullers the bar from both sides to create the effect. Ken flattens the leaf out on the diamond then uses the horn to draw the sides out using the round side of his rounding hammer. (11,12)



Use scroll tongs to bend the stem around 180 degrees. Bend it into a shape pleasing to your eye. Wire brush it and finish with your favorite finish.



BAM at The Missouri State Fair

Photos: Mike McLaughlin, John Sherwood, Jessica Stephenson

If you have never volunteered for the State Fair you are missing out. It is a great place to learn.

Thanks to every one that came and helped.

Many thanks to Hollis Harbit for taking care of all the arrangements.



Trade Items: Bottle opener

July, 10th. 2021



Ken Jansen Demo piece. to: Bob Stormer



Nathan Schwarze to: Joseph Popin



Steve McCarthy to: Dale Cannon



Chris Miller to: Chris Bopp



Randy Carrier to: Ken Jansen



Bernie Tappel to: Paul Talaski



James Brown to: Randy Carrier



Santo Guiffrida to: Nathan Schwarze



Chris Bopp to: Santo Guiffrida



Allen Radthe to: Mike Morton



Mike Morton to: John Dilsaver

Trade Items: Bottle opener

July, 10th. 2021



Don Anders to: Bernie Tappel



Paul Talaski to: James Brown



Dale Cannon to: Allen Radthe



Howard Clark to: Steve McCarthy



Joseph Popin to: Chris Miller



John Dilsaver to: Howard Clark



Bob Stormer to: Don Anders

July 2021 BAM Meeting Iron-In-The-Hat

Donated by

Mike McLaughlin
 Karen Bouckaert
 BAM Boutique
 Karen Bouckaert
 Don Anders
 BAM
 Burr-King
 Ken Jansen
 Ken Jansen
 Ken Jansen
 Randy Carrier
 Karen Bouckaert
 Ken Jansen
 Centaur Forge
 Lou/Jeff Mueller
 Chris Bopp
 John Huff

Won By

Bob Stormer
 Mike Morton
 Randy Carrier
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 Randy Carrier
 Jon McCarty
 Dale Cannon
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 Dale Cannon
 Robert Riesmeyer
 Don Anders
 Dan Wedemeyer
 Chris Miller
 Mike Morton
 Santo Giuffrida
 Bob Stormer

Item

Trailer Hubs
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 Books
 BAM Thermal Mug
 Angle Grinder
 Starter Forge
 Belt Grinder Kit
 Demo Piece
 Demo Piece
 Demo Piece
 Spreader Tongs
 Backyard Torches
 Copper Leaf
 Hephaistos Magazines
 Art of Blacksmithing Book
 '70 Chevy C10 Leaf Spring
 Horseshoes

BAM Meeting Minutes August 28th, 2021

Submitted by Bob Stormer

President Santo Giuffrida thanked Willy & Tammie Bagley for hosting the meeting, and Bill George and John Dilsaver for the demonstrations.

The membership report was presented by Dennis Marshall. The current membership is 551. Dennis said that when you pay your dues, he will send you an email to acknowledge your dues payment and validate the email address he received. John Sherwood asked if the dues expiration date could be added to the mailing address label on the newsletters so each member would know when their dues are due again. Dennis will check on it and coordinate with Mike McLaughlin about any problems with our newsletter publishing process.

Santo gave the treasurer's report for Chris Miller who is traveling. He presented the current balance and concluded that we are in good shape financially.

Santo also presented 2022 BAM Conference status for Mike Gorzel. We have spent more time documenting the steps and completion dates, along with who's responsible, to make sure we address the lessons learned from last year. The current focus is on getting the flyer completed in a timely manner.

This will be the 30th BAM Conference and after checking last year's expenses, Santo and the officers have decided to offer free registration for BAM members. Members will need to register early to take advantage of the free registration. If members register after the early deadline, there will be a \$15 registration charge. All registrants will be responsible for meals or classes. This free registration will only be offered for the 2022 conference.

John Sherwood, curator of the Slack Water Gallery at the conference is asking all members to display any of their blacksmith work whether is for sale, the auction, or just for display. The People's Choice award will be voted on by all who come to view the gallery.

VOX magazine interviewed Santo at his home and many other members at the last conference for coverage in their magazine. They will be sending Santo a link once the article is published in September and Santo will share it on around the anvil once he receives it.

The conference teardown and cleanup starts on Sunday morning and can always use additional help to get thing loaded up and the areas swept. Following the cleanup the final raffles are conducted and you'll have time saying goodbye to your friends.

Santo acknowledged BAM participation in the State Fair, and offered a special thanks to Hollis Harbit for coordinating and supervising every day of the event. Hollis gave a brief summary of the state fair activities, and was pleased with results. He said there was 19 BAM members that showed up to help on various days. Those who showed up and brought items to sell were very pleased.

Santo, John Sherwood, and Denny Quinn represented BAM at the Missouri Bicentennial Celebration in St. Charles, Missouri. Santo acknowledged that Denny donated of his stipend from demonstrating to BAM. Patti Tappel mentioned that Bernie, Pat McCarty, Ken Jansen, Mike McLaughlin, and Bob Alexander represented BAM at a centennial celebration in Columbia with the Missouri Folk Arts program.

BAM is testing a credit card reader via the Square company. Santo tested it in Sedalia during the State Fair and Patti will be testing it at our meetings for anyone wishing to purchase items at the concession. Please note that currently we can only email a receipt. Of course, we will still take cash during testing and later. The hope is once we finish testing at the meetings, we will be ready to offer the capability at the conference. Stay tuned on that. The first test at a meeting was at this meeting and Patti Tappel had three credit card boutique sales that worked very well. The receipts were received by the customer via text very quickly.

At the State Fair Santo was informed we did not have spare tire for the conference/state fair trailer. The officers have approved the purchase expected to be around \$110.00. Also, Officers have approved obtaining table covers for displaying the items for sale for next year. We will purchase some black sheets and Santo's wife will alter them to fit 5 tables. The cost is estimated at \$75.00.

The next BAM meeting is in Booneville Mo on October 9th, and the trade item is a Nail Header. Please Bring Chairs and your lunch as no food on site. The officers have approved the rental of a porta-potty after hearing the restrooms would not be readily available to us.

The December 4th meeting is in Festus at Matt Dickson's body shop and the trade item is a candle holder.

The June 25, 2022 BAM meeting will be at a new venue, a pioneer homestead and village in Rosebud Missouri. More details to come, but something to look forward to.

Santo mentioned that the BAM Secretary, Bob Stormer, wishes to be replaced after seven years. Anyone interested contact Steve McCarthy or Santo. You can also contact Bob Stormer or Santo if you have any questions about duties. You'll need to be a member for one year and we recommend that you have internet access.

Santo also reminded the attendees that BAM is available for selection as preferred charity on Amazon Smile. Thank you for all those that have participated in Amazon Smile. Instructions for using Amazon Smile can be found on the BAM website under the tax-exempt information.

Dennis Marshall will send the BAM scholarship committee, currently called the Tuition Assistance committee, members a copy of the new roster in September so they can determine if the applicant has the required two years of membership. There was a question about whether a break in membership would impact a scholarship approval. The BAM Officers would have look at the specifics as to why and how long with the Tuition Assistance Committee to see if there was a legitimate reason such as military deployment. Another question about whether BAM sponsored classes, like the power hammer classes, qualify for tuition assistance money. Initially Santo said it would, but subsequent discussion needs to be had with the BAM Officers and past Tuition Assistance Committee members as this has not come up before. We have not done so in the past, as BAM classes are already heavily discounted and we need to determine how payback requirements would be addressed. Santo also mentioned that John C. Campbell and Missouri School of Blacksmithing and others are open again for classes

The meeting was adjourned.

Bill George Demo: Mortise, Tenons and Rivets Aug. 28th. 2021

By Mike McLaughlin Photos: Bob Stormer, John Sherwood, Mike M.

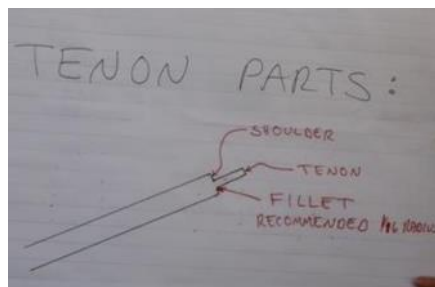
Bill highly encourages you to do a demo. He researched and learned how to do some skills he was not real familiar with. Some of his resources are the Mark Aspery books, The Skills of a Blacksmith Vols. 1 and 3. The Francis Whitaker Books, A Blacksmiths Craft, and The Legacy of Francis Whitaker Vol. 1. The CBA and ABANA. Various BAM mentors and friends. Bill said that joinery requires planning and the making of test pieces to be successful.

He explained the importance of a Monkey tool to help form the shoulder of a tenon. Also expressed the importance of making sure you have a Fillet or Chamfer on your tenon at the shoulder to make it stronger.

Bill was making a tenon on a rectangular bar. He started by knocking the corners down to prevent fish mouth. Then marked the shoulder of the tenon on the bar. Bill used a sharp corner on the anvil and a hammer with a small peen. A guillotine tool would be very helpful at this point. On this one the tenon was split. The bar with the mortise was punched with a slot punch. You will want to punch your mortise first then make your tenon fit. The split tenon was placed in the mortise then bent over in opposite directions. He had a few different samples to show.



The next tenon started out the same way but not split. It was sized and inserted in the mortise and peened over. Make sure to spread the material evenly and over the shoulders of the bar.



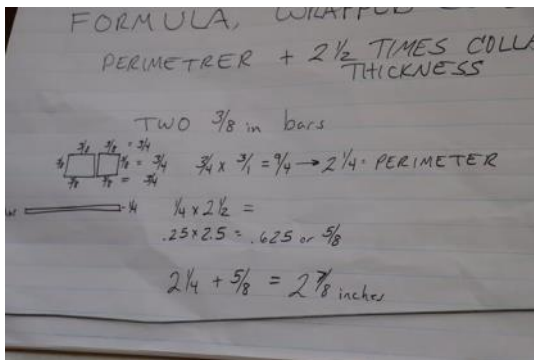
For the next part of his demo he did a pass through with 1/2" bars. He used a slot punch to make the hole. If you are using a slot punch you have to make sure it is centered and the sides parallel to the bar. Use a square drift to size the hole. Drift from both sides. He had a sample of a flat bar that was split and bent in opposite directions. This would make a nice decorative pass through element.



This bar shows the progression to make a form to create a collar. He drove a cold bar into the hot tool to create the round. Drove a hot bar into the round form. Cooled it. Shaped it. Heated the tool and drove the bar into the tool to create the final shape. In order to make a tool to create your collar shape you have to create the shape first. This helps create it. I think I just confused myself.



There was a lot of information Bill had that I did not get in here. I ran out of space. Please read some books ask other members and get out there and practice.



This is the formula from Bill for finding the length of your collar. The example is using 2 3/8" square bars. Add all dimensions of the outside measurements to get your perimeter. You also need to allow for the thickness of your collar. You will add this calculation to your perimeter length. The books Bill read said to add 2-1/2 times the thickness of your collar material. Bob Patrick had John use 2 times the thickness. Both are right. You need to make some test pieces to find out which will fit your need.



John Dilsaver: Collars Aug. 28th. 2021

Written by Mike McLaughlin Photos: Bob Stormer. John Sherwood, Mike M.

John was lucky enough to be able to participate in the Traditional Arts and Apprenticeship Program through the Missouri Folk Arts Program. The master he was able to work with was the famed Bob Patrick. One of the many skills he learned was collaring. We are grateful that he is sharing this knowledge.

The first step was to make the tool to make the collars.(1) This one was made by Bob Patrick. He took a piece of 1/4" round heated it and bent it into a zig-zag shape to get three rods right next to each other. He then mig welded them on the backside to keep them from separating. He heated this block and used a power hammer to drive it into it. I did require some grinding and filing to finish it. Don't forget to radius the edges.

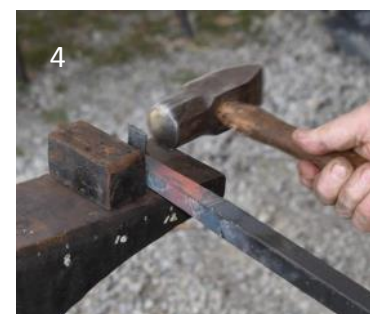


He used 3/4" x 3/16" stock for this collar. (2) You heat it and pull it through the tool on you power hammer. You could also use a flatter and a striker if you don't have a power hammer.



He created a mandrel the same size as the piece he is going to collar. You need to know the perimeter of what you are going to collar. (previous page) Cut your collar to length. Heat the collar. He used a swage block to start the "U" bend in the collar.(3) If you are going to be making a lot of these. Making a proper sized tool to bend the "U" would be helpful. Heat and use hammer and anvil to bend collar tightly around the mandrel.(4) Slide it off the mandrel.

John then used a set of tongs that are like snap ring pilers.(5) When you squeeze them they open instead of closing. He heated the collar used the tongs to open it up enough to get it around what he was collaring. If you can get to where you can hammer on it hammer it closed. If you can't you may have to make a set of these tongs to help with closing it.(6) If you have some loose collars you can use a torch and these tongs to help tighten them. Heat the corners.



Trade Items: Blacksmith Joinery

August 28th. 2021



Bill George to Jeremie Howell



Jeremie Howell to Willy Bagley



Santo Guiffrida to Ethan Benedict



John Sherwood to John Dilsaver



Ethan Benedict to Chris Bopp



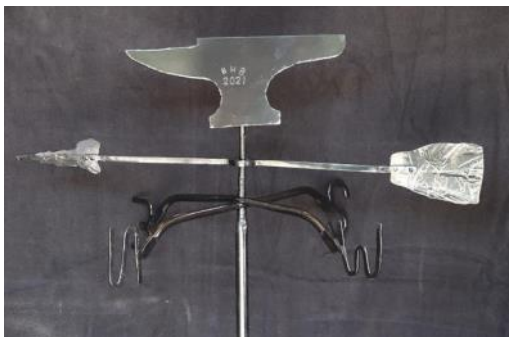
Dennis Marshall to Santo Guiffrida



Chris Bopp to John Sherwood



John Dilsaver to Mike Morton



Willy Bagley to Dennis Marshall



Mike Morton to Bill George

Bernie's Old Retired Guys and Anyone That wants to Take a Vacation Day Hammer In

Written By Mike McLaughlin Photos: Bruce Herzog, Mike M.

It was a hot day, but it was a fun day. The Food was fantastic. Thanks to Patti and everyone else that helped. Bernie started it off by making a Flint Striker. Then showed Robert Miller how to make a socket for a Fish Gig. Then Robert made one. Santo used "Vern" to rough out his trade item for the October Meeting. I made a fire poker with the help of "Vern." I am really starting to like that hammer. There was a lot of other projects going on hot steel was everywhere.



Bernie's 2021 Hammer-In Wire Inlay Demonstration

Performed and Written by Bob Stormer

Workspace – Obviously you'll need a suitable workspace for your silver wire inlay activities. Two major features are critical; good lighting and appropriate workbench height. Overhead lighting is generally not adequate since as you bend over to get better look at your work, you will cast a shadow right where you are looking. An adjustable desk lamp or an LED lamp that is strapped to your forehead are good choices. Another good option is a head mounted lighted magnifier light the jewelers use. The workbench height can be for sitting or standing as long as it's comfortable for you. Don't forget to take into account the height of the jeweler's vise/bowling ball fixture mentioned below.



Figure 1

Tools – You don't need a lot of specialty tools to do silver wire inlay. I don't know of anywhere to buy the chisels for wire inlay, but there are a number of websites that describe how to make them using #11 X-acto blades and various handles, like I did in Figure 1. As the website generally advise you, you can make many chisel sizes, but only couple are necessary. A small one, maybe between 1/32" and 1/16" wide for making sharp curves, and one about 1/8" wide for straight lines. Other than the sharp chisels you'll need to create the groove for the wire, tweezers, small side cutter (Figure 3), small needle nose pliers, a small tack hammer, Figure 2.



Figure 2



Figure 4

The hammer should have one end that's a small diameter, maybe 1/4". A flush-cut side cutter could be helpful but not necessary for cutting the wire to a more accurate length when mating up with another wire. If you are inlaying flat-work you will not need a jeweler's vise or equivalent.



Figure 3

If you are inlaying contoured pieces, such as knife handles, a jeweler's vise, Figure 4, could be very helpful. A wire inlay video on You-Tube by Joe Kessler shows how to make one on the cheap using a bowling ball.

Silver Wire Sizes and Suppliers – I still have the roll of silver wire, .015 x .053, I bought about 20 years ago, and I can't remember the supplier or the cost. The only current supplier I could verify to have the size most inlayers use is T.B. Hagstoz who calls it Sterling Silver Cloisonne/Inlay Wire, (T.B.Hagstoz.com). It comes in either .008 thick x .055 wide inches and .013 thick x .055 wide inches in various lengths. The .008 wire is harder and is used primarily for flat inlays since it doesn't bend well over convex or concave surfaces. The .013 is softer and therefore better for curved surfaces. I found other suppliers of wire on the internet, but their dimensions were either incomplete or confusing to me.

Wood Selection -- Curly maple is what I worked with until I saw Allen Newberry demonstrate at the 2021 BAM Conference. His work at the conference and what I saw on his You-Tube videos is walnut. Because of its darker color it is a good contrast with the silver wire. I found curly maple to be a little easier to use and if you choose a dark stain, it too will provide a good contrast to the silver wire. The walnut I was using for my demonstration was about 30 to 40 years old, and may have hardened over time like most wood. I soaked a few slabs of the walnut in water for about 6 hours, then let it dry overnight, and it seemed a little more workable.

Design Considerations – The fellow I first saw doing the silver wire inlay was Bill Moran, the guy who is responsible for starting the American Bladesmith Society (ABS). He used a collection of patterns (scrolls) he made from very thin brass shim stock so he could duplicate patterns easily. If you are going to be doing knife handles with the same pattern on both sides, it would probably be worth your time to you lay out a shim stock pattern. Cutting the grooves is easier when going parallel to the grain, rather than across grain. The point being, if you can lay out your pattern with the longer lines parallel to the grain, it would save you some time. Try to minimize the number of small pieces in the design, but don't compromise your design. Another design consideration is the use of the end grain such as the end of a knife handle or tomahawk handle. I believe any type of wood to be suitable for end grain wire inlay.

Inlay Technique – Trying to describe the inlay technique with my limited writing skills would be less than encouraging to get you started inlaying wire. This is a perfect application for You-Tube. Both Allen Newberry (ABS JS) and Joe Keesler (ABS MS) have very good videos on You-Tube. A Google search on either Allen or Joe and wire inlay will get you to their videos. In addition to actual inlaying of the wire they both address making some of the tools, as well as finishing techniques. I can give you some tips though. If you're using curly maple, use a pencil to draw your pattern. If you're using the darker walnut, a silver pencil would make the lines more visible.

When I start cutting the grooves, I do it in two passes. The first one is only about half the finished depth, maybe about .025". Once you have a shallow groove the second pass is easier to follow and get the final depth. Before you start laying the wire in the groove, draw it through a piece of 220 grit emery cloth to roughen up sides of the wire surface. If you are laying the wire on a curve, especially a tight curve, try bending the wire to match the curve pretty closely before starting it in the groove. To start inlaying the wire, use your finger as much as possible. You may have to tap the end in to keep it from popping out as you go further down the wire. You don't have to pound the wire in, gently tap it so you don't tear up the edge. After you have the wire inlaid to depth you want, dab some water on entire pattern with your finger to help close up the grooves against the wire.

Finishing -- When you're finished inlaying the wire, it should stick above the wood surface about 1/64" to 1/32", so you don't have to sand into the wood to get the silver wire sanded. Start sanding the wire using a block with 120 grit paper and switch to 200 grit paper before you get even with wood. You don't want to put 120 grit



Figure 6

scratches in wood. I usually stop sanding with 400 grit paper. The type of wood will determine what other finishing steps are needed. For curly maple I usually use a Fiebing's Leather Dye. Figure 5 shows the before and after finishing. After using the Fiebing's leather dye, I use a 0000 steel wool to rub Johnson's Paste wax on a couple times and then buff it to a sheen. I finished a walnut piece by rubbing Tru-Oil on it after sanding. I only used one coat on Figure 6, but I think a few more coats with sanding in between would be better. Figure 7 is the plaque I made for an attendance prize at Bernie's hammer-in. Its walnut, sanded to 400 grit and rubbed down with 0000 steel wool and Johnson's paste wax.

Good luck with your silver wire inlay efforts.



Figure 5

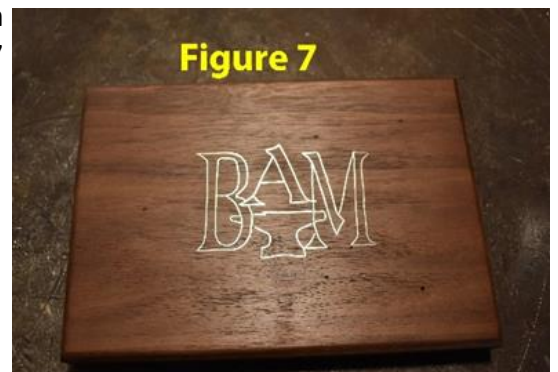


Figure 7

**Missouri School of Blacksmithing
Class Calendar Fall 2021**

September 15-18

**Traditional Swedish Axe Making
with Caleb Nolen**

September 30-October 2

Blacksmithing 100 - An Introduction

October 14-16

Introduction to Power Hammers

October 28-30

Blacksmithing 100 - An Introduction

Class prices, descriptions, prerequisites,
and skill levels are in the catalog.

Give us a call for more information, or to receive a catalog!

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3100 NW Winchester Road Cameron, MO 64429 816-575-2798

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To see class listings or to register for classes, visit our website, craftstl.com

For more information call 314-842-0796 or email;

Brendan@muellerstl.com

Matthias Penn is offering introductory & beginning blacksmith classes. 417-543-2148

Tytheblacksmith@yahoo.com Ava Mo.

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

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

Upcoming EVENTS

October 9th, 2021 - Meeting - The Blacksmith Shop at the Brady
Steam Engine Showgrounds Boonville, MO
Bring chairs and lunch. No food provided.
Trade item: Nail Header

December 4th, 2021 - Meeting - Matt Dickson
Caliber Collision Center 1532 Parkway West, Festus, Mo. 63028
Demonstrator: Bob Alexander
Trade Item: Candle Holder

February 5th, 2022 - Meeting - Dale Kirby - Higbee, Mo.
Trade Item: Trivet

30th. Annual BAM Ozark Conference, Sedalia Mo. April 28th. - May 1st. 2022 *
Demonstrators: Kirk Sullens, Lin Rhea, and John Lovin
More details will be published when they become available.

June 25th, 2022 - Meeting - Clyde Welch Welding Shop and Pioneer Village
3564 Hwy. T, Rosebud, Mo. 63091

***To Celebrate our 30th BAM conference, members who pre-register by April 1, 2022, will not need to pay registration fee.**

Members who register late will need to pay the late fee, but not registration fee. Members will still be responsible for fees related to meals, classes, or other conferences expenses.

If you are not a member you can join by paying the \$30.00 membership fee and avoid the registration fee. Registration flyer to be published later in the year.

Coal Stations

Coal Captain: Bob Alexander

BAM COAL

Price per bag:

BAM Members \$15.00

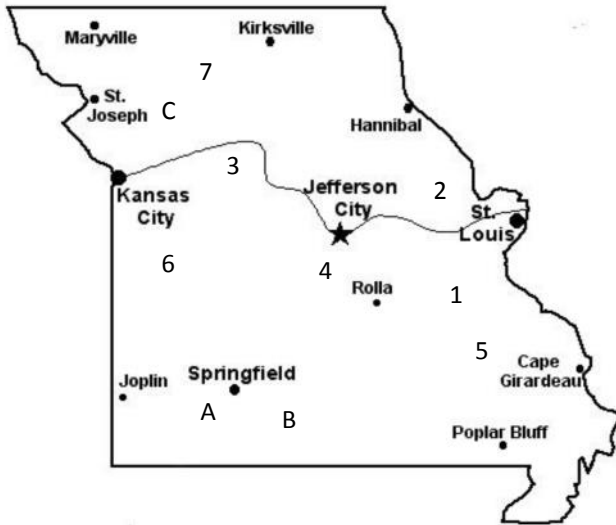
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Member's pickup at Bob Alexander's - \$13.00

Coal keepers earn \$3.00 per bag

Bags are approximately 50lbs. each

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2. Ken Jansen (636) 295-8490
2257 Carter Rd.
Moscow Mills, MO 63362
3. Doug Clemons (660) 631-1257
29377 Durango Ave.
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4. Bernie Tappel 573-496-3793
204 Hidden Valley Road
Jefferson City, MO 65101
5. Bob Maes (573) 866-3811
Route 1 Box 106 K
Millersville, MO 63766
6. Bryan Lillibridge (660) 638-4536
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A few notes on our coal:

- 1) Not all coal is created equal. The coal we buy is from the West Virginia to Pennsylvania vein and is a high metallurgy grade unlike coal from other areas.
- 2) Raw coal from the bagging company is stored outside which allows it to get rained on, (rain is water which weighs 8.4 pounds to the gallon). If the coal is bagged wet and then dries out the weight will change.
- 3) The coal fines which when mixed with water to form a paste burns along with the chunks of coal but during shipping and handling may sift out of the bags causing a weight loss.

So, the bottom line to all of this is we are selling coal in approximately 50 pound bags.

Non BAM Coal

- A. Tim Johnson @ Advanced Welding, Springfield, MO. 417-886-8032 - Pocahontas Coal \$.40/lb. cash, \$.50/lb. check/debit. Bring your own containers.
- B. Blacksmithing Coal for sale \$12 per approximate 50 lb. bag with bulk delivery available. Matthias Penn, Rt. 1 Box 479, Ava, MO. 65608. 417-543-2148. Or e-mail tytheblacksmith@yahoo.com.
- C. Coal for sale \$15 per approximate 50 lb. bag. Missouri School of Blacksmithing Matthew Burnett 816-575-2798, 3100 NW Winchester Rd., Cameron, MO. 64649

BAM Tailgate

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For Sale: 1 Steel layout table: 27 in. x 39 in. No stand. Asking price \$75.00
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Don Birdsall 636-293-6939

BAM Books from Jan/Feb 1994 - Present & binders for sale. Contact James Conway 563-366-4244

Commercial / Resource ads:

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.

Tire Hammer Plans by Clay Spencer
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Beverly Shear blades sharpened. Remove blades, mail in small flat rate box, include check/money order for \$50, Includes return postage. clay@otelco.net, 256-558-3658

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Beginner & Intermediate classes are being held at Mueller Industries (via Craft Central), 12951 Maurer Industrial Drive, St. Louis, MO 63127
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Blacksmith's Journal, Instructional back issues by Jerry Hoffman are available online at www.blacksmithsjournal.com

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David Norrie 970-215-4666 www.davidnorrie.com
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Power Hammer page

I've taken some time to collect and post old info, catalogs and brochures on power hammers. The link of our NEB web page to this information is: <http://www.newenglandblacksmiths.org>

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Demonstrator List

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

Around the Anvil BAM has its very own E-Mail news group. If you would like to participate there is a sign up link on the bamsite.org or send an E-Mail to Terry Humphries at thumphr@south40.org and he will get you signed up.

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 BAMeditor2015@gmail.com, or call 816-296-3935

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