



SOFA SOUNDS

SOFA
SOUTHERN OHIO FORGE & ANVIL

Artist-Blacksmiths Association of North America

JUNE/JULY 1990

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NEWSLETTER EDITOR:

Bud Rupe (299-3378 after 4pm)
*ABANA Board Member

MARK YOUR CALENDARS: Unless otherwise noted, all meetings will be held at the Studebaker Frontier Homestead on Rt. 202, about 4 miles north of I-70 near Tipp City. Please don't park on the grass, or block access to the production buildings. Donations of items for the newsletter support raffle are always welcome. Please bring your work or tooling for display. The public and guests are welcome. Finger food and cold drinks to be provided on a break-even donation plate basis. The forges at the homestead are available before or after meetings for individual projects.

July 14, 1990
1:00pm
2nd Saturday
of the month

Business meeting followed by a Hammer Along on the basics of Blacksmithing. The Hands on event will be located in the "U" forge area. If you have been wanting to try some blacksmithing, introduce the Black Iron craft to a friend, or show one of your tricks, or just mentor from the side lines to a willing, unexperienced believer in the old ways, this is a day you will not want to miss. There will be basic tools, vices, and forges set up along with materials for your efforts.

Special Note: If you have a bit of spare time before and after the event, we could use a bit of help setting up and cleaning up.

August 4, 1990
1:00pm

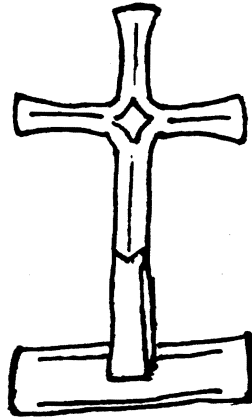
Business meeting followed by an Animal Head Workshop. Ken Scharabok will lead a workshop, with 4 forging stations, for the type of animal head he specializes in. Ken will do a head, and then lead the first 4 people to sign up for the workshop on the making of a similar type of head. Ken has only 2 volunteers at this time, Phil Trickey, and Bud Rupe. NOTE: 2 more volunteers are needed to man the other 2 stations. To sign up call Ken at 429-3967. We do need your help.

September 2, 1990
1:00pm

Open for suggestions. Bring some to the July meeting.

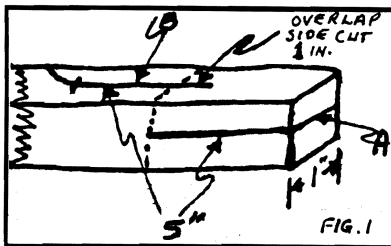
FRANCIS WHITAKER visits the STUDEBAKER HOMESTEAD
APRIL 1990

FRANCIS CAME TO VISIT EMMERT AND DEMONSTRATED HIS MASTER TALENTS MAKING A CROSS SIMILAR TO ONE MADE BY CHRISTOPH FRIEDRICH OF SWITZERLAND AT THE ABANA CONFERENCE.



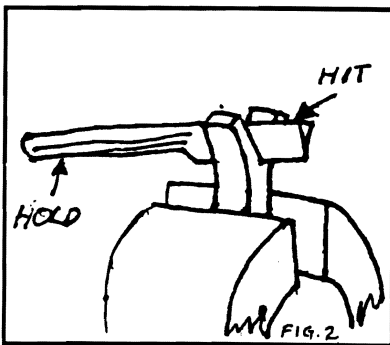
STOCK SIZE: 3/4, 7/8 OR 1 IN.

LENGTH OF CUTS ARE
EQUAL TO 5 X STOCK SIZE.
IE; 1 IN STOCK = 5 IN CUT.

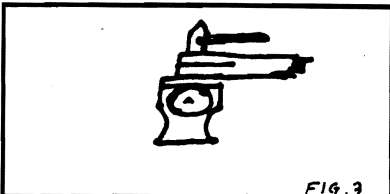


OVERLAP CUTS EQUAL TO
THE STOCK SIZE.

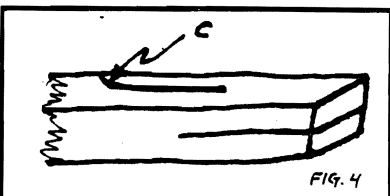
1. MARK ALL CUTS WITH COLD CHISEL BEFORE HEATING THE IRON.
2. CUT END (A) FROM BOTH SIDES USING A HOT CUTTER.



3. TRIM ALL BURRS.
4. USE A SIDE CUT CHISEL TO SQUARE THE BASE OF THIS CUT.



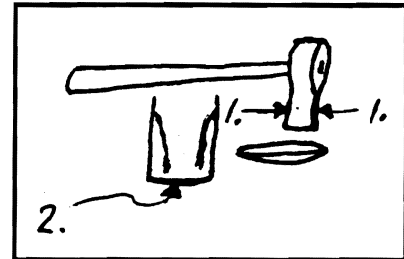
5. HAMMER THE TWO SIDES BACK TO SQUARE. DON'T FLATTEN THE BEVEL MADE WHERE THE TWO CUTS MET.



6. HOT CUT BOTH SIDES OF SECOND CUT FIG. 1(B) STARTING AT CURVE (C) USING A CURVED HOT CUTTER.
7. TRIM ALL BURRS.
8. SQUARE BASE OF CUT USING SIDE CUT CHISEL. SEE FIG. 2

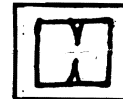
FRANCIS'S HINTS

1. TAPER THE SIDE EDGES OF THE HOT CUTTER TO PREVENT UNWANTED MARKS.



2. A SLIGHT ARC ON THE CUTTING EDGE WILL MAKE FOLLOWING OF THE MARKS EASIER.

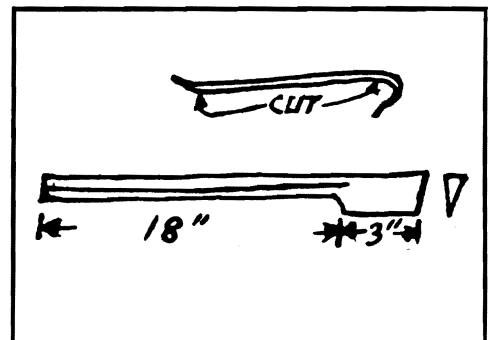
HAVE SOMEONE EYEBALL YOUR ALIGNMENT OF THE CUTS.



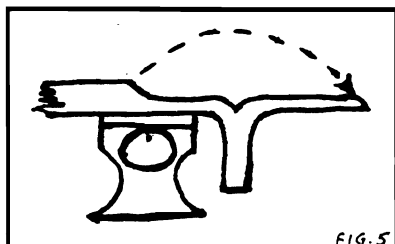
USE A LARGE COFFEE CAN OF WATER NEAR YOUR WORK TO COOL TOOLS AND HANDS.

ALWAYS CLEAN YOUR IRON AFTER REMOVING IT FROM THE FIRE. A BUTCHER BLOCK CLEANING BRUSH IS GREAT FOR THIS JOB.

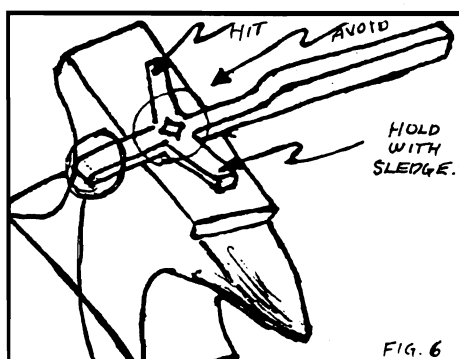
MAKE A SIDE CUT CHISEL FROM AN OLD OR NEW CROWBAR. CUT OFF THE ENDS. FORGE THE END INTO A BLADE SHAPE. TEMPER TO A POSSUM EAR BLUE.



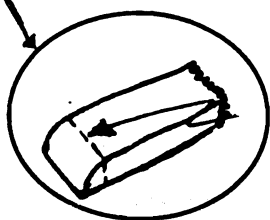
COMMENT OVERHEARD AT THIS SESSION:
"PETE WILL COME OUT OF THIS SMELLING
LIKE A ROSE".



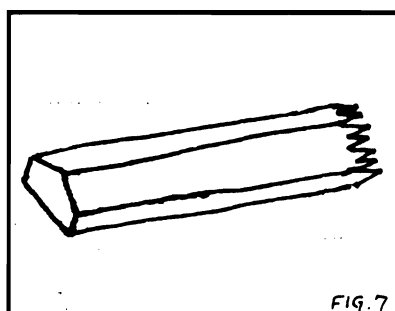
9. UNFOLD THE CUTS TO FORM THE VERTICAL PORTION OF THE CROSS.



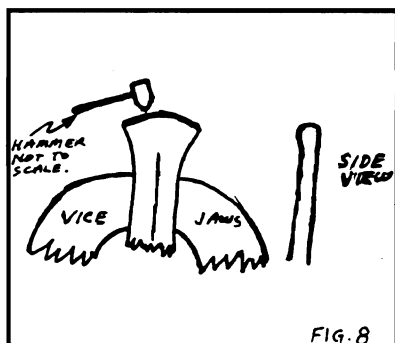
- A. TURN OVER AND OPEN THE HORIZONTAL ARMS.
B. THIS SHOULD PRODUCE A DIAMOND SHAPED HOLE AT THE CENTER OF THE CROSS, WITH NICE TWISTS ON THE EDGES. DON'T HIT THIS AREA.



- C. CUT TOP OFF SQUARE.



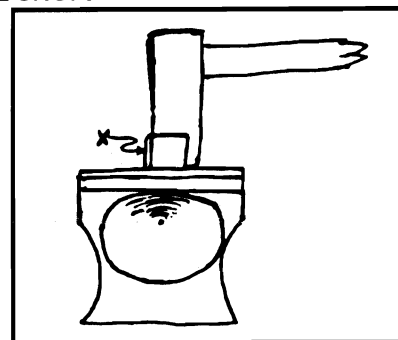
10. BEVEL THE FACE OF THE CROSS USING THE SMALL BEVEL FROM THE CUTS ON THE VERTICAL AS THE REFERENCE. NOTE: THE CUT BEVEL ON THE HORIZONTAL ARMS IS ON THE BACK SIDE. SO BEVEL THE FRONT ALONG THE CENTERLINE. CAUTION: DON'T BEVEL THE DIAMOND (TWISTED) AREA (CENTER OF THE CROSS).

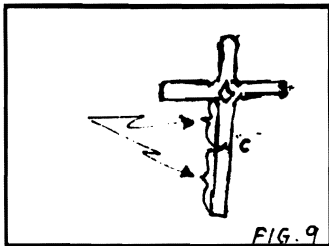


11. UPSET AND ARC THE THREE ENDS OF THE CROSS. FRANCIS STARTS THIS EFFECT WITH A CROSS PEEN AND FINISHES IT WITH THE FLAT FACE OF THE HAMMER.

FRANCIS'S HINTS

SAFETY HINT; WHEN CUTTING OFF A PIECE OF IRON, LEAVE A LITTLE STOCK AT THE EDGE (X), INSTEAD OF AT THE BOTTOM. IT IS EASIER TO CONTROL AND THE PIECE DOESN'T FLY ACROSS THE SHOP.

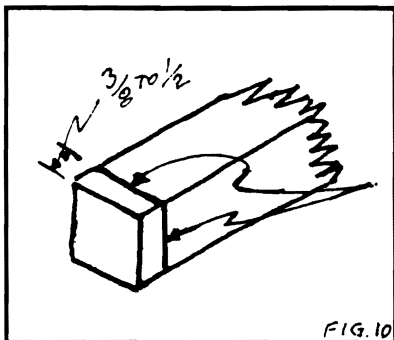




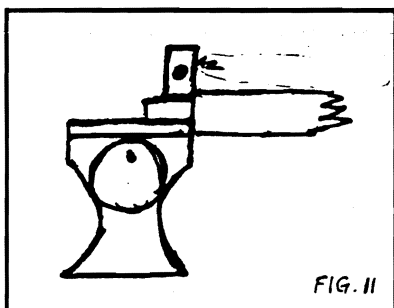
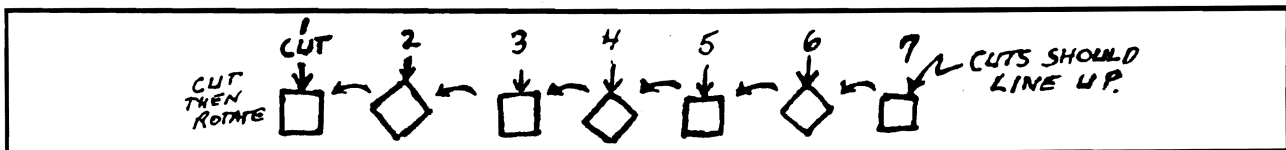
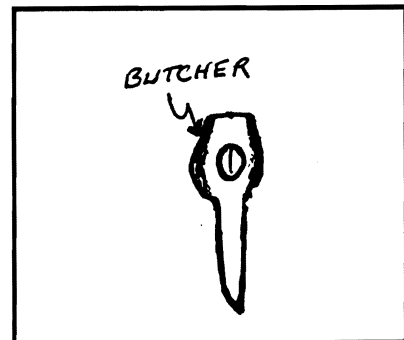
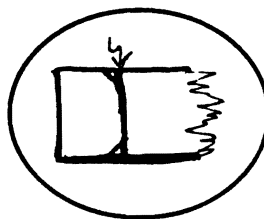
TENON

12. CUT OFF THE STOCK WITH A SAW. THE DISTANCE FROM THE CURVED CUT FIG. 4 (C) TO THE DIAMOND SHOULD BE EQUAL TO THE DISTANCE FROM (C) TO THE CUT.

FRANCIS'S HINTS



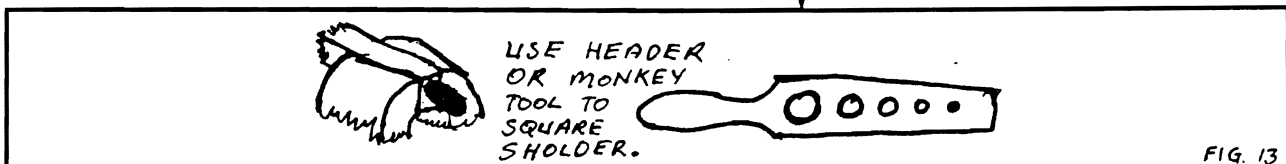
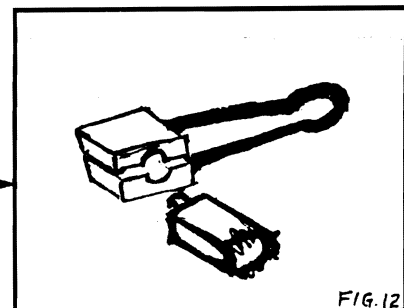
13. CUT SHOULDERS FOR TENON WITH A BUTCHER.



14. USER SET HAMMER AND EDGE OF THE ANVIL TO DRAW OUT THE TENON.

15. SWEDGE END TO FORM.

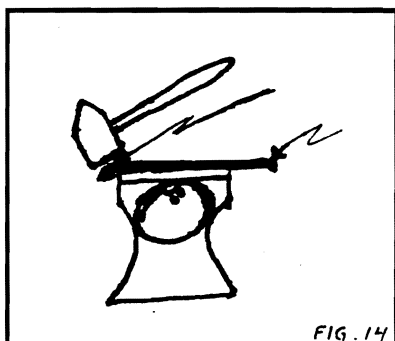
16. USE HEADER OR MONKEY TOOL TO SQUARE SHOLDER.

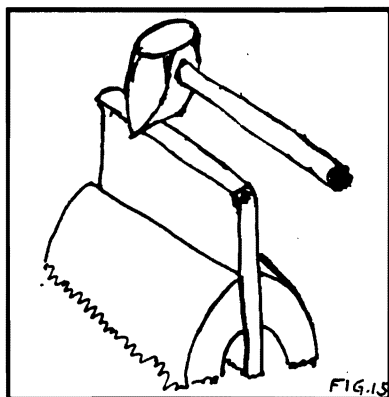


CROSS BASE PLATE

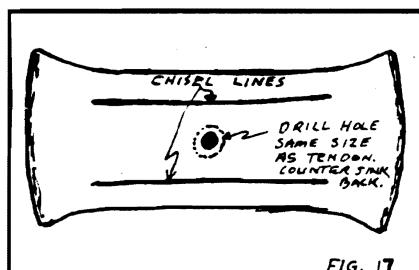
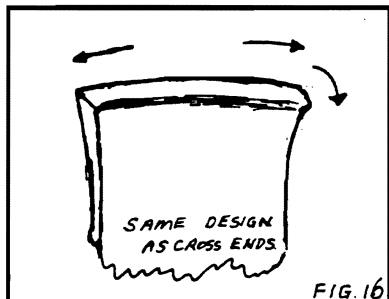
STOCK: 3/8 X 3 X 9

17. TURN ENDS DOWN A LITTLE TO MAKE THE OFFSET TO THE FRONT EASIER.





18. UPSET AND ROLL TO FRONT.
KEEP BACK FLAT. SPREAD SIDES.

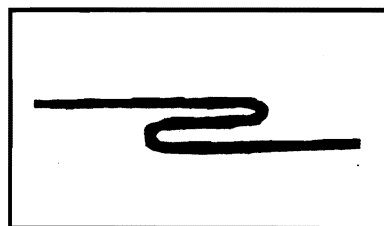
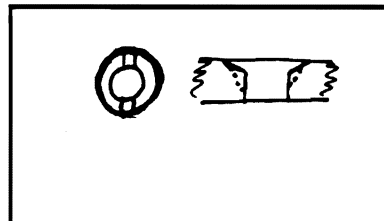


19. CHISEL LINES. DRILL A HOLE
THE SAME SIZE AS THE TENON.
COUNTERSINK THE BACK.

20. RIVET THE CROSS TO THE BASE.
FRANCIS DID THIS COLD WITH A
BALLPEEN HAMMER. ALIGN THE
TO THE BASE PLATE PRIOR TO
TIGHTENING THE RIVET.

FRANCIS'S HINTS

CUT KEYS IN THE HOLE TO
PREVENT TURNING.



MAKE A TWISTING TOOL FROM
MILD STEEL. HEAT TO ORANGE,
QUENCH.

FRANCIS EXPLAINED BACK-
BENDING ANGLE IRON TO
PREVENT THE TOP EDGE FROM
MOVING TOWARDS THE INSIDE
OF THE ARC WHEN BENDING.
THE TECHNIQUE IS HARD TO
UNDERSTAND IMPOSSIBLE TO
DRAW. SEE LARRY WOOD.

FRANCIS'S COMMENT ABOUT HIS
STRIKER; "YOU CAN ALWAYS TELL
A BEGINNER BY THE WAY HE AL-
WAYS PUTS HIS HAMMER ON TOP
OF THE TOOL BEFORE HE HITS IT."

P.S. ASK LARRY WOOD IF HE
ENJOYED STRIKING FOR FRANCIS.

I KNOW MY NOTES AND SKETCHES DO NOT REPLACE A DEMONSTRATION BY FRANCIS WHITAKER, BUT I HOPE THEY MAY BE OF SOME BENEFIT TO SOMEONE. IF YOU HAVE QUESTIONS, PLEASE ASK. MOST EVERYONE KNOWS FRANCIS IS A MASTER BLACKSMITH AND A TALENTED TEACHER, I ALSO FOUND HE HAS A GREAT SENSE OF HUMOR. THANK YOU VERY MUCH FRANCIS AND EMMERT.

LWS

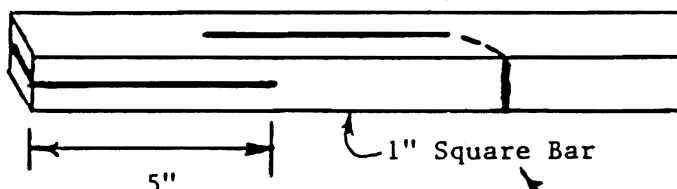


Three Champion No. 101 post drills; unused in preservative and complete with all accessories including wrenches. Two in near factory new condition with 98%+ paint finish at \$450. each. One with patches of light storage corrosion on cast iron body (steel parts are O.K.) and termite-eaten oak mounting board at \$250. Misleading reference to "ball-bearing" in period advertisement below refers to a ball-bearing between the shaft and feed screw; as in all such drills, the shaft bearings are bored cast iron. Prices include careful packing and post office Parcel Post shipment; air shipment extra. Prefer selling to museums or working smiths, rather than tool collectors. For more information contact: Glen M. Winterbottom, Post Office Box W, Naalehu, Hawaii 96772. My telephone number is (808) 929-9080.

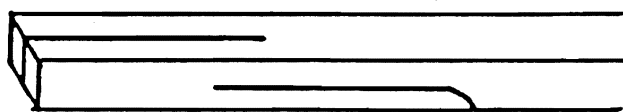
Blacksmithing

Split the Middle second
5"

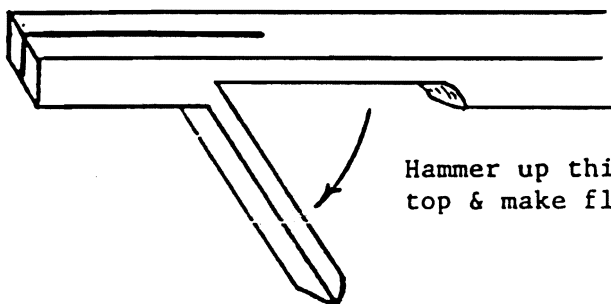
1" overlap



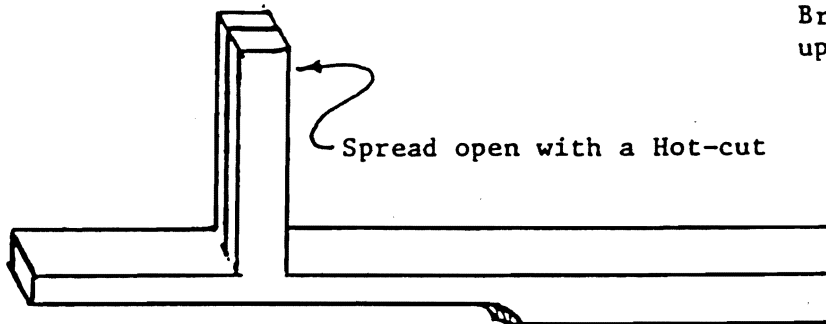
Split this End First



Hammer down on top to start to open up bottom

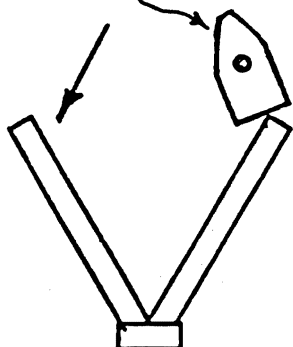


Hammer up this part to top & make flat with Bar.



Spread open with a Hot-cut

Hold down with a Hammer on this side to make it stationary.



Flatten the Cross & square up
Hammer down ridge at splits.

Hammer down on this side.

1" Overlap on 1" Sq. Bar
3/4" Overlap on 3/4" Sq. Bar
1/2" Overlap on 1/2" Sq. Bar

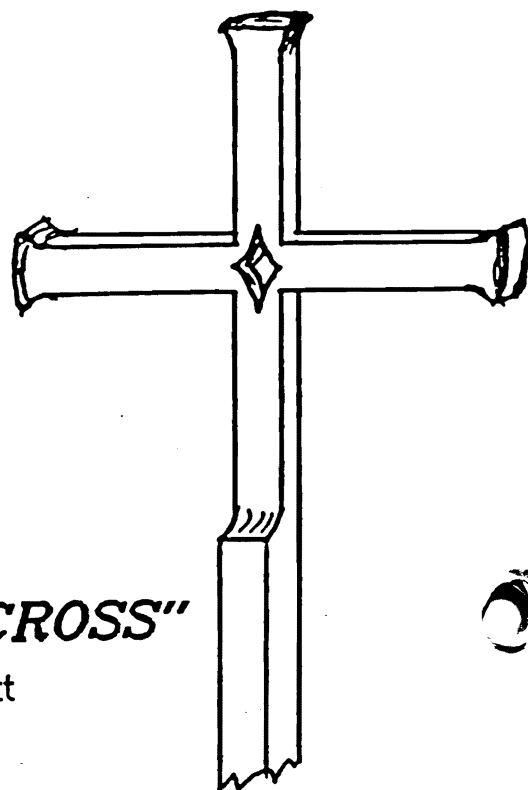
Split with a 1" narrow Hot-cut
Hold the Hot-cut Straight
Take the edge off of the
Hot-cut so it won't make
grooves.

Clean sides of Split. Don't Leave Burr:

Make this Split Third-Use a thin Gouge
Split from both Sides.
Mark all cuts first on both sides before
splitting.
Always after making splits close up
cuts & straighten up.

Make sure all cuts are clean &
all the way through & even to
the Ends.
Open up to make even splits across
bottom & top on the Middle Split.

Bring Ends to a white heat &
upset Ends about 1/2" on all 3 Arms.



"BLACKSMITH CROSS"

By Dwain Pruett

MAKING A TOMAHAWK
Demo by Bob Zeller

For this Bob Zeller used a piece of old boiler plate for the head of the tomahawk.

- 1) Heat and bend the metal plate over on itself to form the basic shape of the tomahawk. Make sure as you bend the two edges together that the edges match each other. Once you have the basic shape true up the folded piece.
- 2) Using a drift, form the eye of the tomahawk head for the handle. This will provide the tapered shape needed to hold the wooden handle in place.
- 3) Using a wire brush clean the surface of the metal and add borax flux to the surface of the metal.
- 4) Forge weld starting near the eye moving toward the blade edge of the stock. By starting near the eye, the weld will be fused and moved toward the blade of the tomahawk. This will produce an even weld with no contamination or voids in the weld area. It may take several heats to finish your forge weld. This depends on your skill and the cleanliness of the metal.
- 5) True up the eye using the drift. After forge welding you will distort the eye. This will correct the shape of the eye and test the integrity of the weld.
- 6) Cut to length a piece of an old file about 1/4" wide. The piece of file will become the cutting edge of the tomahawk blade.
- 7) Open the end of the fold in the blade end of the stock and insert the steel bit. Flux and forge weld the file piece into place. True up the edges and produce the final tomahawk shape.
- 8) Oil harden. Place in a tray of oil. Do this quench quickly. Do not move it while it is in the tray of oil. If you move the stock while in the oil, the blade may bend. This will cause the blade to warp.
- 9) Temper. Using an old piece of scrap iron tubing; perhaps 1/4" thick walls, and 3-4" in diameter, and 9-12" long; place the tube into the bed of hot coals. The heated tube will become an oven which will heat the blade evenly and produce an even temper. Take a chunk of some brick clay or go out and dig up a bit of clay out of the ground; place this clay over the blade end of the tomahawk. Heat the head to a dull red. Air cool leaving the clay on the blade. The clay protects the blade and will help keep the blade from warping and twisting.
- 10) Special Note: If you are making a knife, cover 1/3 of the knife blade with the clay. Place the cutting edge of the knife in the oven with the clay side up. This method will produce a straight blade.
- 11) Bob showed us how they used to perform a hardness test in the old days. This test was called Sclero Scope. This device consisted of a hollow tube in which a small ball bearing was dropped through. The metal being tested was placed under the tube. The bearing would fall through the tube and bounce off the metal being tested, and back into the tube, where a gauge measured the height of the bounce. The higher the bounce, the harder the metal. This test could also be used to measure the temper of a piece of metal.

MATERIAL:

WROUGHT IRON
SIMILAR TO WAGON
TIRE IRON

THE MAKING OF THE HATCHET

1800
CIRCA TO
1870

T.R. 1989 ©

SAKE PRINCIPLES FOR BROADAXE.
GOOSE WING, FELLING AND TRADE AXES. (TOMAHAWKS.)

TWICE THE
HEIGHT - BLADE
TO POLL

SHEAR STEEL
BLISTER OR
CASE HARDENED

SHAPING:

TAPER INTO WEDGE
OR SHIP

NOTE:
OPTIONAL
STEEL
POLL
MAY BE
ADDED IF
NEEDED

HARDEN
TEMPER
AND SHARPEN

FLATTEN
SHAPE - PARE & TRIM
OFF EXCESS
FILE TO SHAPE

INSERT MANDREL
FROM BOTH ENDS
FOR DOUBLE TAPERED
EYE SOCKET

ORIGINAL THICKNESS
DON'T CHANGE YET

FOLD
OVER
MANDREL

FULLER
OR DRAW OUT
THE BLADE

MANDREL
SAKE SHAPE
OF HATCHET EYE
TAPERED IN LENGTH

REINSERT MANDREL

FORGE
WELD

INSERT
STEEL SLIP

HEAR YE! HEAR YE!

FOR SALE:

- * Cast iron forge 4'x 3' with built in water tank, electric blower, new SOFA fire pot, and hood.
- * Hardwood stand for craft display or demonstration.
- * Railroad irons cut to be used for anvils, \$5.00 each.
- * Misc. chisels, punches, files, benders, hardy tools, antique hand tolls, cast iron.

Call M-F after 4pm at (513) 473-2149.

- * Leg vise with 4" jaws. Good condition and has all parts. \$40.00, Ken Scharabok, 513-429-3967.

- * 25 lb. little giant, rebuilt, 1 hp. 110 volt motor, \$1200.00
 - * Cast iron forge w/hand crank blower, \$120.00
 - * Champion hand crank blower w/stand, \$40.00
 - * 4 1/2 leg vise, excellent condition, \$80.00
 - * 6" leg vise, heavy duty excellent condition, \$100.00
- Call Doug Fink 898-2139

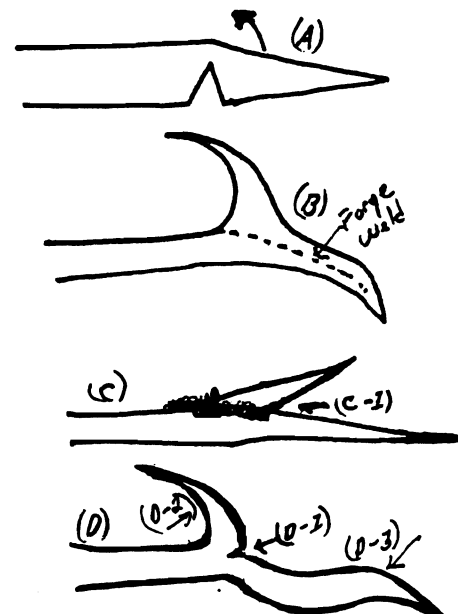
- * Old hand cranked lever rivet forge. \$100.00
 - * Grinding wheel w/18" wheel, old anvil and anchor
- Contact Darrell Harris, 890 Pinecreek Dr., Centerville, Ohio, 45458

- * 50 lb. little giant trip hammer, 2 hp motor, reworked, excellent condition available after July 31, 1990. Pick up Xenia, Ohio. \$1600.00
- Call R. Kern, (513)372-9100

NOTES: Insuring your shop! The fire at Larry Wood's shop emphasizes the importance of having adequate insurance. When discussing insurance with your agent, it is recommended you refer to it as an "Artist Studio" or shop. The latter has a connotation of either industrial use or a commercial welding operation.

Remember: If you borrow a vidio of one of SOFA's demonstrations that Denny Bischoff has filmed for the club, be sure to bring/return it the next month. These vidios are for all members to view. It takes a long time to pass them among the members so it is important to return them as soon as you can.

POKER ENDS: For several years I have been finishing my poker ends by the method shown in (A) & (D). The end was drawn to a point, cut about 3/4th through, folded back and faggot welded. The folded over area was then drawn into a new point. While this method is useful in a demonstration, I didn't think the proportions looked quite right. I have recently changed my ends to that shown in (D). The pointed end is cut completely off and the taper from the cutoff hardy forged to a 45 degrees or so angle with the angled edges slightly chamfered to allow a good arc weld. This piece is then arc welded onto the shaft (after it has been drawn into a long point.), as shown in (C). The weld build-up is hot forged flat and then ground smooth at both the sides and front. Note the piece is only arc welded on three sides. The fourth side can be cleaned up with a hacksaw to allow a deep "V" transition as shown at (D-1). (D) is about twice the size of (B). The hook at (D-2) is about 1/2 the length of (D-3). Ken Scharabok.



ABANA

Artist-Blacksmiths' Association of North America



P.O. Box 1181, Nashville, Indiana 47448
Executive Secretary, Janelle Gilbert

Office Hours: 7:30-11:30am & 1:30-4:30pm
Phone: (812) 988-6919

PRESIDENT'S MESSAGE MAY 1990

Dear Friends,

By now all of you have received your conference pre-registration packets and I hope you have been able to take advantage of the savings offered to those who registered early. Charlie Orlando has worked very hard with his crew to make this a truly international event and we hope you will find that the standards of the ABANA biennial conference will be even higher this year.

UPDATED DEMONSTRATORS LIST

ABANA board member, Clayton Carr, is updating the ABANA demonstrator and school list. As you know, the last demonstrators list is years old and clearly outdated. If there is anyone in your chapter that would like to be included, please get the names, addresses, phone numbers, fees, and 100 words or less to Clayton Carr before the end of July.

While the demonstrator list includes many fine smiths from Europe, most are blacksmiths from Chapters of ABANA in America; like you and I who demonstrate in their own areas and are willing to come to regional events to share their knowledge. We will be repeating the update every other year or so. If you are currently on the list, please update. If you want to be removed from the list, please let Clayton know. Also include information on schools or on-going courses in your area for the schools list. Contact: Clayton Carr, RFD #2 Box 2911, Kennewick, WA 99337 - eve. phone (509) 586-9278.

CHAPTER AUCTION PIECES

We've received word from several chapters that they are busy on their ABANA Conference auction piece and we hope that most chapters will be represented whether or not you are able to attend. You can be creative! One chapter is making an elaborate croquet set that I'm sure will be a big hit.

GALLERY PIECES

Don't forget the June 13th deadline for gallery pieces to be shipped to Alfred State College for inclusion in the main gallery. Remember-- it is not necessary that you be in attendance at the conference. It is a long way for people to travel but we'd like to see your ironwork anyway. The registration for ironwork is included in the registration packet. It is our hope that as many blacksmiths throughout the nation as possible will be represented.

I'm looking forward to a great time at the conference to see some world class forging as well as reacquainting with old friends and making new ones.

Warm regards,

Dorothy Stiegler
Dorothy Stiegler
ABANA President

ABANA

Artist-Blacksmiths' Association of North America



P.O. Box 1181, Nashville, Indiana 47448
Executive Secretary, Janelle Gilbert

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PRESIDENT'S MESSAGE June 1990

Dear Friends,

This month's message to the chapters is devoted to an issue concerning the reprinting of Anvil's Ring articles --a discussion that may address future questions and that has most recently come to our attention via the Appalachian Area Chapter.

The controversy concerns the decision by the ABANA Board not to allow Mr. Albert Cannella of the Appalachian Area Chapter to use articles from 10 years of the Anvil's Rings for the purpose of producing a booklet for sale. Mr. Cannella has already compiled excerpts from his chapter newsletter and sold the booklet entitled "Blacksmiths Helper, Vol. 1" for \$8.00 each. \$2.00 went to the Appalachian Area Chapter and \$6.00 was retained to cover his out of pocket expenses. Mr. Cannella contacted me to request using articles from the Anvil's Ring for a second volume using "Tips & Techniques" and "Building Blocks" which after his publishing would entitle him to copyrights. Enclosed is a copy of Mr. Cannella's initial letter which I answered by telephone conversation.

I am very surprised by the misunderstanding that came about after I went to great lengths to explain ABANA's position on the issue to Mr. Cannella. Letters to the editor published in the Appalachian Area Chapter newsletter from Mr. Joe Humble and Mr. Cannella question the educational objectives of ABANA. It is evident that the direction of the ABANA Board on this issue was misinterpreted and I find it necessary to outline the background on the decision in this mailing. I think you will find that there are many facets to this seemingly simple request.

FIRST AND FOREMOST, it is absolutely imperative that ABANA retain a Not-For-Profit status with strictest guidance to disapprove any activities that would jeopardize the organization's qualification with the IRS. While ABANA does not OWN the contents of the Anvil's Ring it falls within the IRS code 503-C3 for the Board of ABANA to oversee and control the use of articles. This means that even a small amount of "reimbursement" for out of pocket expenses by an individual from the sale of a publication does not fall within the IRS guidelines to retain the organization's Not-For-Profit status.

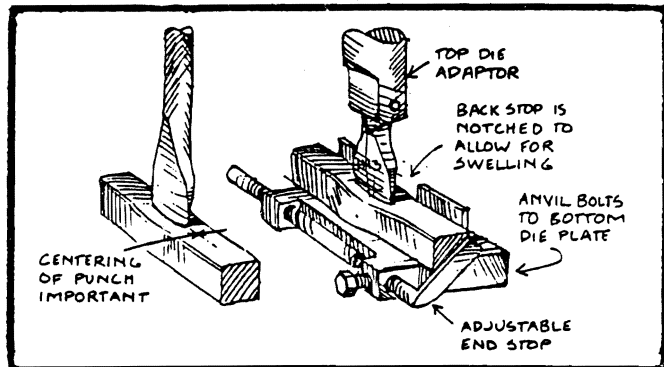
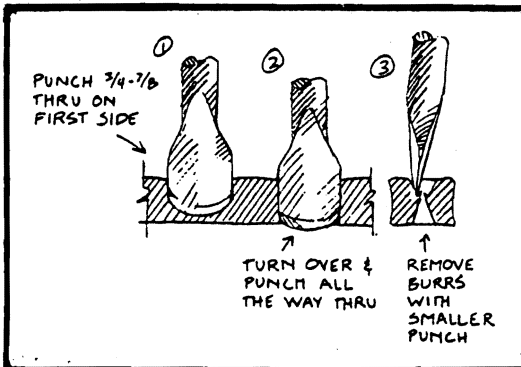
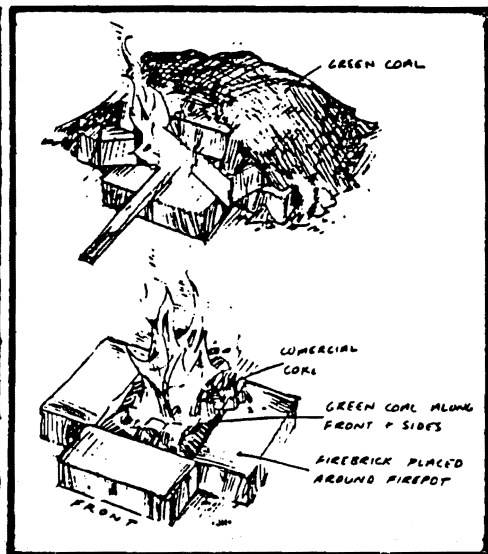
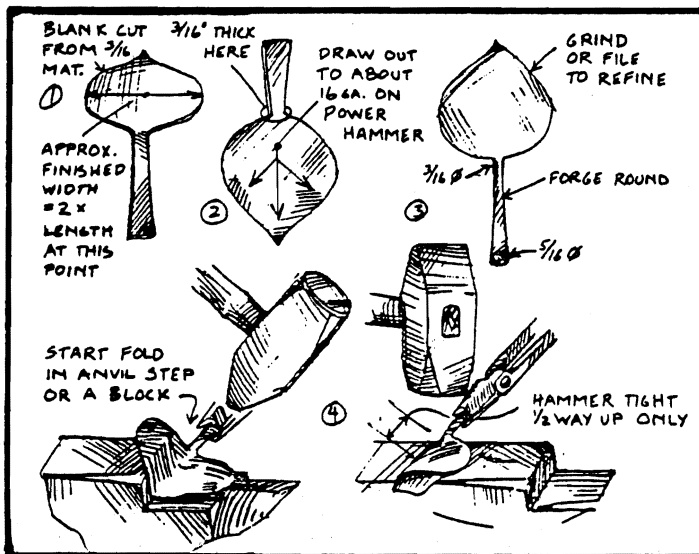
SECONDLY, proceeds from any sale of a publication such as the booklet proposed must be returned to benefit the ABANA membership as a whole since the source of the content is donated to ABANA as shared educational material (i.e. Anvil's Ring articles).

Hans Peot, Secretary of ABANA, as many of you know is currently compiling tips and techniques to have ready for our members. This volume will be targeted for the beginner blacksmith. Hans has been working on this for almost a year now. Proceeds from this project will be put back into our educational funding to benefit ALL the membership and ALL the ABANA Chapters. There are other people who have donated articles to the Anvil's

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ABANA DIRECTOR ELECTIONS ARE COMING SOON!

Nomination to fill the five vacant positions are due July 1, 1990. The five positions are for three year terms. Candidates must be members of ABANA in good standing and be nominated by letter or petition by at least ten members of ABANA. Candidates should write a short statement about why they wish to serve on the Board and should include a small, portrait-type photograph which will be published with their statement. All nominations should be postmarked by July 1, 1990 and sent to ABANA, P.O. Box 1181, Nashville, Indiana, 47448. The schedule for election is as follows:

July 1 -Nominations Closed
 August 7 -Ballots mailed to members
 September 17 -All ballots postmark deadline for return
 September 30 -President will notify new members

Any questions may be directed to Janelle Gilbert, ABANA Executive Secretary by phone (812)988-6919, calls leaving a message will be returned promptly.

ABANA Membership Application

Name: _____
 Address: _____
 City: _____ State: _____
 Phone: () _____ Zip: _____
☐ New Member ☐ Renewing Member
 How did you learn about ABANA?

Regular Member	\$35.00 yr
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Overseas Membership	\$45.00 yr
Contributory	\$100.00 yr
Library	\$25.00 yr

I hereby apply for membership in the Artist-Blacksmith's Association of North America and enclose \$ _____ as my annual membership dues for one year.

MasterCard ☐ VISA ☐ Check/Money Order ☐
 Card Number: _____
 Exp. Date (Month/Year) _____

(Check must be in U.S. currency)
 SEND TO:

ABANA
 P.O. Box 1181
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 (812) 988-6919

Does this include:
 1 Year Subscription Annual Rate: \$9.95 \$14.00
 Admin. Office & Other ABANA services (if indicated on) \$1.50 \$11.00

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SOFA SOUNDS
 c/o Bud Rupe
 2812 Chinook Lane
 Kettering, Ohio 45420

NOTE: YOUR SOFA MEMBERSHIP EXPIRES WITH THE DATE ON YOUR LABEL.

Richard A. Franklin
 7158 Klyemore Dr.
 Dayton, OH 45424

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