



# SOFA SOUNDS

**SOFA**  
SOUTHERN OHIO FORGE & ANVIL

Artist-Blacksmiths Association of North America

AUGUST/SEPTEMBER

1989

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

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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.

August 5th, 1 pm

BUSINESS MEETING followed by a presentation by Ham Hammond on the basic principles of welding. Bring a welding hood if possible. Eye lenses will be for sale at \$1.25 each, for those who need them. OPEN FORGES BEFORE AND AFTER THE MEETING.

September 9th, 1pm

BUSINESS MEETING followed by a tentative demonstration by Larry Gindlesperger and Emmert Studebaker on making Clayton Knots. OPEN FORGES BEFORE AND AFTER THE MEETING. \*SECOND SATURDAY MEETING DUE TO LABOR DAY WEEKEND.\*

September 23rd-24th

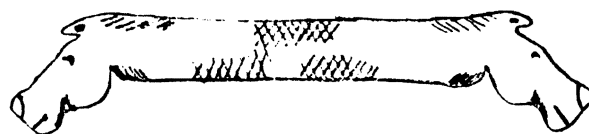
1989 QUAD-STATE BLACKSMITHING CONFERENCE.

October 7th

BUSINESS MEETING followed by a demonstration by Larry Wood and Hans Peot, on the making of a Vise Jaw and one leg of a Post Vise. OPEN FORGES BEFORE AND AFTER THE MEETING.

## MEETING NOTES: JUNE

John Jacobs brought in an interesting example of his work. After watching Doug Fink produce a horse head on a poker at the July meeting; John went home and took a piece of bar stock and put a horse head on each end of it. I'm not sure how he is going to use this interesting item, but it is sure nice to look at.



VISITORS AND GUESTS: JUNE

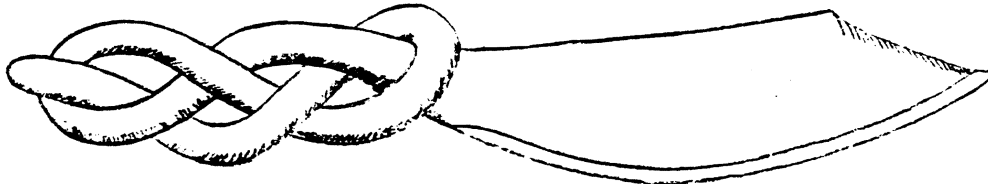
Steve McNew of Brookville is a history teacher. He said he got his interest in Blacksmithing from working in a machine shop. He now wants to develop an understanding for the basics starting with the forge and anvil. While living in West Virginia before his move to Ohio, he picked up a farrier's forge and an anvil, and collected coal from the sides of railroad tracks. His first visit was a productive one. He made a hardy tool and a hot cut hammer head under the watchful eye of Hans Peot.

RAFFLE: JUNE

Arther Holz won 2 hammer heads and Ed Rhodes won a fuller hammer donated by Bill Kauffman. Jeff Morrison won a sharpening stone donated by Larry Wood. David Clouse won 8 pieces of 7/16 sq. precision brand stock donated by John Baker, and Bill Ballis won 4 screw drivers also donated by John Baker. Jim Leistner won a handful of welding rods donated by Bill Ballis. Larry Gindlesperger won brass strips donated by David Clouse. Ron Van Vickie won a monkey wrench donated by Dick Franklin. Ed Hulihan 4 tines from a dump rake donated by John Jacobs. Ed Rhodes also won 1½ dia. steel hose donated by Dick Knopp, and a band iron wood rack donated by Larry Gindlesperger. Jevan Rupe won a trailer hitch donated by Larry Gindlesperger and a ball peen hammer donated by Larry Simms. Shawn Schivierking won a 3/8 stainless rod donated by Jim Leistner. Ralph Van Buskirk won a large open end wrench donated by the SOFA RAFFLE KITTY. Ed Rhodes also won a 1" x 4' steel tube donated by the SOFA RAFFLE KITTY. Hans Peot won steel slugs donated by Bud Rupe.

MEETING NOTES: JULY

Once again John Jacobs brought in a piece of his handy work. This time it was a knife. As you can see, this is an interesting conversation piece. It has a tapered handle woven into the shape of a loose knot. I for one, would like to see this in a demo. How about it John? Hint! Hint!



RAFFLE: JULY

Tom Kopp won a pair of tongs donated by Dennis Hoffer. Doug Fink won a can of hand cleaner and Pat Flinn won sandpaper donated by John Baker. Ken Dearth won a home made straight peen hammer head donated by Bill Vatler and magazines donated by Ken Scharabok. Larry Simms won hacksaw blades donated by Ralph Van Buskirk. Bob Cepluch won watchamacallits donated by Emmert Studebaker. Bob Willman won a spool of brass wire donated by Phil Trickey. Owen Vance and Jim Leistner also won a spool of brass wire donated by Phil Trickey. Pat Flinn won rake tine springs donated by Ralph Van Buskirk. Dan Dunbar won 2 pieces of square stock, and Tom Knopp also, all donated by the SOFA RAFFLE KITTY. Tom Knopp also won a telephone donated by an unknown individual. The following were all donated by Ken Scharabok: History Guide Booklet won by Don Dunbar, a small electric blower won by Ham Hammond, a small electric blower won by Ron Thompson, a multi wrench and bird house book won by Bud Rupe, and stand bases won by Ralph Van Buskirk. Ken Scharabok won a wood mallet donated by Ron Thompson. Bob Willman won 1" sq stainless donated by Jim Leistner and ½ 1075 steel strap donated by Doug Fink. Ron Thompson won 1" sq stainless donated by an unknown individual.

## DEMONSTRATION: JUNE

After the meeting SOFA held its annual workshop to help members produce hardy tools for their anvils. These hardy tools are made from various sizes of used jack hammer bits donated by some of our generous members. This activity is set aside to encourage black iron neophytes and armchair blacksmiths to take an active part in weekend activities. It is SOFA'S goal to help develop all interests in blacksmithing. All one has to do is step forward to the forge.

It was somewhat difficult for me to collect all the lingo while bouncing back and forth from the two shops while keeping an eye on my soon to be four year old son Jevan. The following notes would have been a bit more complete, but I had to watch the potato chip/pretzel intake ratio of the little two fist-ed eating machine. Thanks gang for keeping an eye out for him.

### SPRING FULLER TOOL

In the main shop Ron Van Vickle and Larry Wood produced a spring fuller tool. This tool is becoming quite popular due to the amount of illustrations I have seen in past newsletters.

Larry and Ron started with a 40" long piece of  $\frac{1}{2}$ " round stock.

STEP: 1 Mark the center of the stock, heat and form the spring area into a rectangle shape.

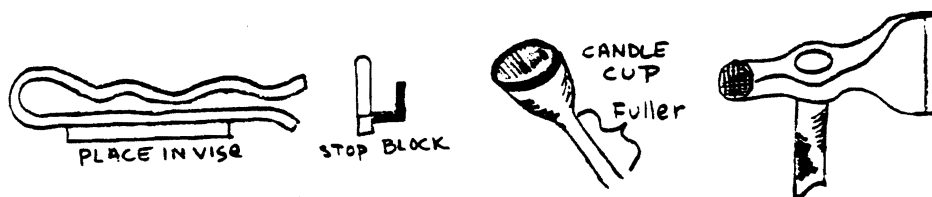
STEP: 2 Heat and bend to produce the spring area about  $8\frac{1}{2}$ ".

STEP: 3 Form the fuller areas for the top of the fuller about 4" apart from each other.

STEP: 4 Do not bend the fuller area of the bottom of the spring. Heat both tips of the hair pin shape and bend slightly away from each other to permit easy entering and exit of the stock you will later be forming.

STEP: 5 Weld a piece of bar stock on center of the bottom of the fuller tool to be placed in your vise.

If you would like to use this tool on mass production type products, weld a piece of angle to provide a stop block. You are now ready to fuller to your hearts content on such items as the following candle cup using the stop block.



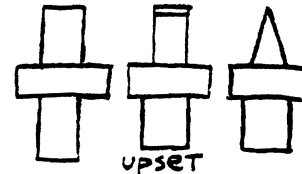
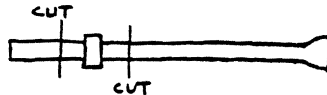
Larry used a  $\frac{3}{4}$ " piece of steel tubing and fullered down a neck for the candle cup using the stop block. Once reduced to a proportional size, Larry worked the cup of the holder on the point of the anvil horn. He formed a bit of a collar on the top of the cup and trued up the cup. Finish the shape as you see fit making sure the cup fits your homemade candle.

Ron and Larry helped Dave Clouse make a hot cut hammer head out of the chisel end of a jack hammer bit. They first punched the hole for the handle, making sure they stayed on center. They cut the hot cut head to length about 5" or 6" long and formed it to final shape.

\*TIP: When punching a hole through stock larger than the two holes in the anvil, set two pieces of thick square/rectangle stock on the anvil face, and punch through. Working between vise jaws works, however this puts your work a bit high for heavy hammering.

In the other shop, Hans Peot, along with first timer Steve McNew produced a hot cut hammer head and hardy tool. Hans showed Steve his tricks on making the hot cut out of a jack hammer bit. They started by cutting the bit to length. After heating they punched and opened the hole for the handle with a tapered drift. They formed the cutting edge of the chisel area and squared up the chisel face. Then finish forming the rest of the hot cut to proper dimensions. Then grind and temper the edge to provide a proper cutting edge.

#### DRIFT



The cut off hardy tool was also made from a jackhammer bit. They started by cutting the excessive metal off the end of the hammer bit. Hans used his 60 pt. carbon homemade cut off. To make the post of the tool fit a larger hardy hole than the actual stock, Hans used a simple trick. After heating the stock to bright red, he holds the cool end of the bar in both hands and slams the heated end into the face of the anvil; forcing the metal to upset. The technique is like using a spud bar to tamp dirt around a fence post. They cut it to length and formed the 60° cutting angle of the tool. Grind and temper to finish. Both items made were of a fine quality and will add to Steve's collection of tools.

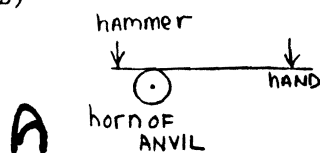
\*Always remove your hardy tools from the anvil. It's better to be safe a hundred times, than to be killed once. Mark Twain.

#### DEMONSTRATION: JULY

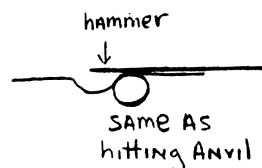
##### WORKING WITH SHEET BRASS

The demonstration by Dick Franklin on the working of 22 gauge sheet brass was enlightening. Dick said there is no big secret in working sheet metal into special shapes and designs. The best way to learn techniques is to just try it. The following is a collection of tips and techniques from his demo.

1) When we use the hammer and anvil we strike the opposite of the horn while holding the other end. (A) The same method is used when working sheet stock. (B)

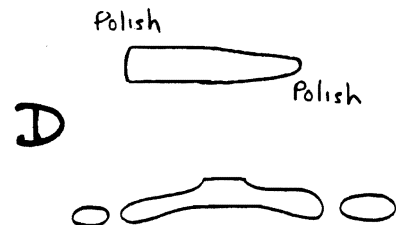
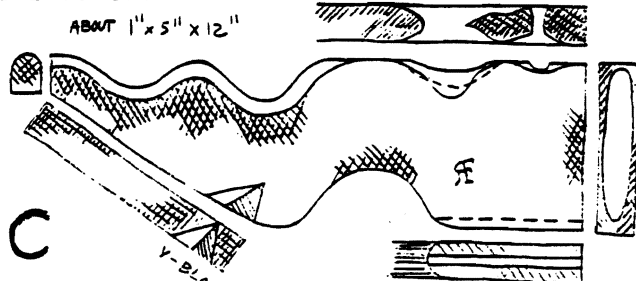


B



- 2) Buy your stock at hobby stores or metal supply houses in strips.
- 3) When working cold sheet use many light taps. You can obtain a very fine surface finish by using these light taps. **Take your time.**
- 4) A good source of light is important when working.
- 5) A good source of sheet is plumbing fittings split, flatten, and anneal before shaping.
- 6) You get a lot of motion with light taps. After having worked heavier material when blacksmithing, you don't think you are moving material but you are.
- 7) When working very small pieces, an eye piece may be helpful to magnify your work.
- 8) Brass and silver work about the same.

9) When working any shape, any wood block can be used that will provide the proper shape. Dick uses a special designed wood block that has many shapes and indentations to provide his results.(C)



10) Hammers are important. If your goal is fine detail, finish, buff, and polish the heads of your hammers. Dick uses a small cross peen with rounded heads.(D) He also has a set of body hammers and home made nylon hammers.

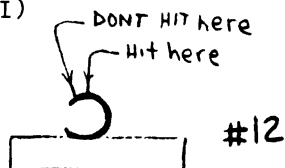
11) These steel hammers have a highly reflective polish to reduce damage to your work.

12) When hammering correctly, you obtain a proper sound. Always strike work into your blocks/plates and stake anvils. This will be the most effective if you use a hard hammer with a soft back-up plate or a hard plate with a soft hammer.↓

13) The trick in working sheet stock is to find a way to stress the metal to develop the results you desire. If a trick works, keep using it. If not try something else. No magic in it.

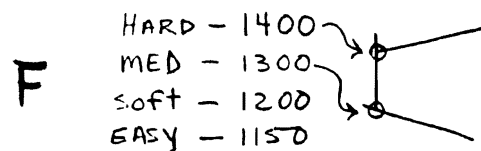
14) Plates: Dick has made a highly polished plate to aid in his efforts. Polish as you would hammer faces. If you are going to invest the time in surface finish, protect your surfaces. Wrap them up. This plate is about 3/4" x 6" x 8" in size.

15) Stake anvils: Once again Dick has put his blacksmithing skills into use. He has a series of stakes he has produced. Taking O2 tool steel, (could be of a lesser material due to the light work you use them for.), he turned them down 1" or 1 1/4" stock in to a long taper; could forge taper: then forging it into a serpent shape. These stakes can be bent into any shape to provide useful surfaces. Sounds easy doesn't it. Don't forget to buff and polish. With the work you will put into these tools, you will most likely save big \$ and end up with tools of the highest quality, and at very little cost to you. (E,I)



16) When soldering you need smooth clean metal contact, proper heat and solder. Don't forget to practice. If you are going to put the work into your art, do a good job soldering. You must have contact along the total edge. Use a small fine file if you need to before closing up to insure smooth contact from end to end.

17) Solder comes in several forms. Jewelers use 4 types with different melting range(temps are approx.). Hard-1400°, medium-1300°, soft-1200°, easy-1150°. This range is important because if you have several joints to connect you can reduce the chance of melting previous joints by reducing the melting grades of solder.(F)



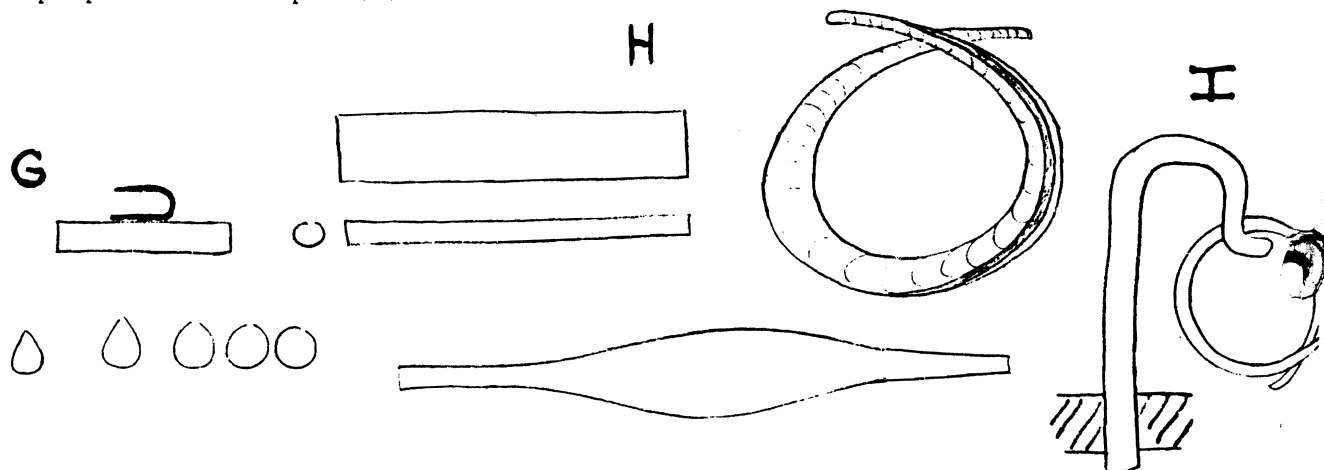
18) Silver solder is the proper choice. Comes in silver and brass(colors). The higher the temp, the more silver content. Comes in wire/chips/strips.

19) Use propane or butane (the best), as your heat source. Can not use a soldering iron because the melting temp is too high.

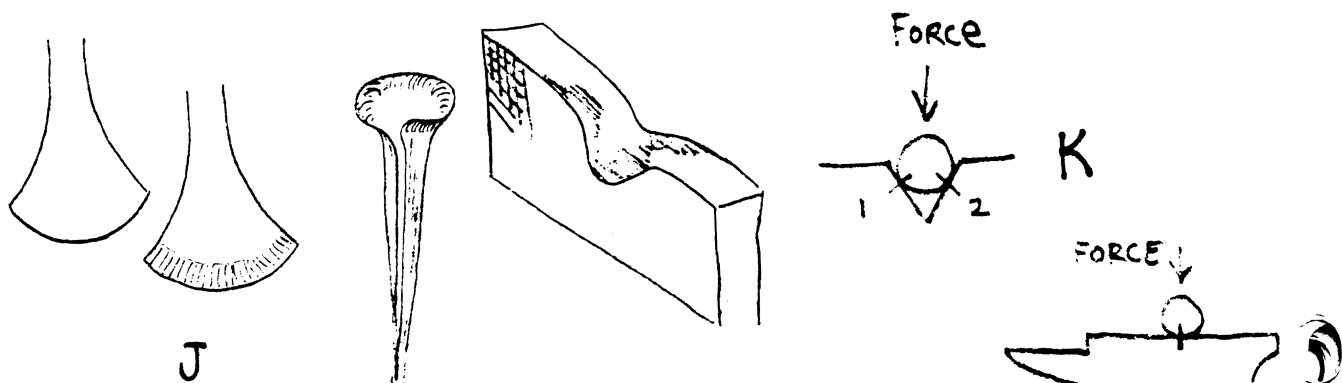
### LET'S GET TO WORK!

Dick showed how to produce several shapes. I will touch the high lights of each. Remember the best way to learn is to try it. Dick said he has taken a couple of classes. I'm sure that helps.

**TUBE:** Use a tapered or rectangle sheet and bend it into a V-shape using your wood block. Working it into a tear drop shape to a final round shape using a flat block or polished plate. (G) After final rounding of the shape, silver solder to connect the ends. Then buff. A good choice of items could be a bracelet. (H) Before bending the long tube, you pound it to produce an oval cross section on the polished plate, then bend the length which will kink around. Repeat several times to obtain the proper results. This will work to harden the metal. Anneal by heating to a dull red. Pickle to remove fine scale. Always remove the scale because it will be hammered into the sheet. You don't want to file if you can avoid it. You may need to work on a stake to provide proper wrist shape. (I)

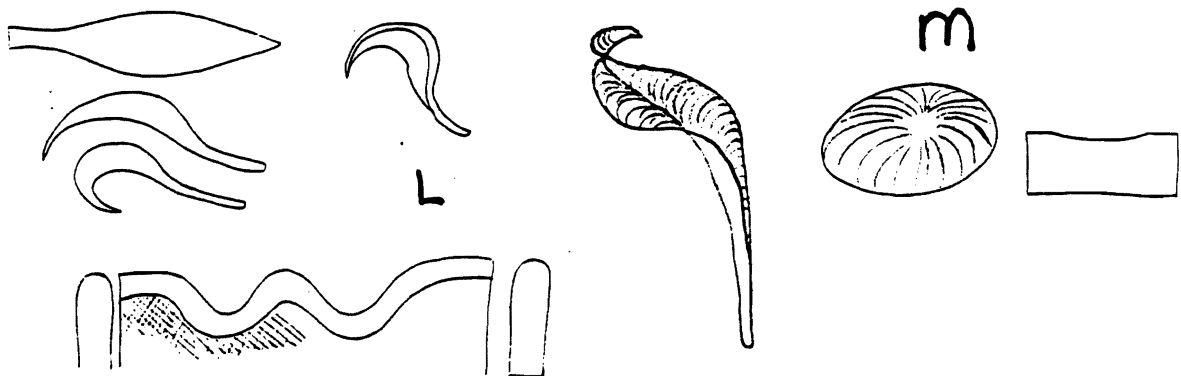


**FLUTE SHAPE:** Start with a fan shape. To form, curl end up by hammering one width back using the wood block. As you move your stock on the block, the curl will form. To increase move the edge out to increase the curl. (J) To close run it back like the tube. Use different grooves in the block to develop different stages of forming. \*When trying to taper pipe, place it into a V-block the process will go much faster. The V-block will let the metal react in 2 directions as to 1 direction with the anvil. (K) This shape would be great for a graceful candle holder or flowers.



**LEAF SHAPE:** Start with a flat leaf shape. Work in a V-block to fold the leaf. Open up and begin the final shape. If you try to make a large curl, bend more than you need in the final shape, because of the stress and spring in the metal. **STEM:** Finish like the tube. (L)

**TOP OF BELT BUCKLE:** Work from round/oval shape, working on a flat block with a slight indent. Work from center to the edge. Work on a circle motion. Watch for kinks. If oval, work oblong. (M)

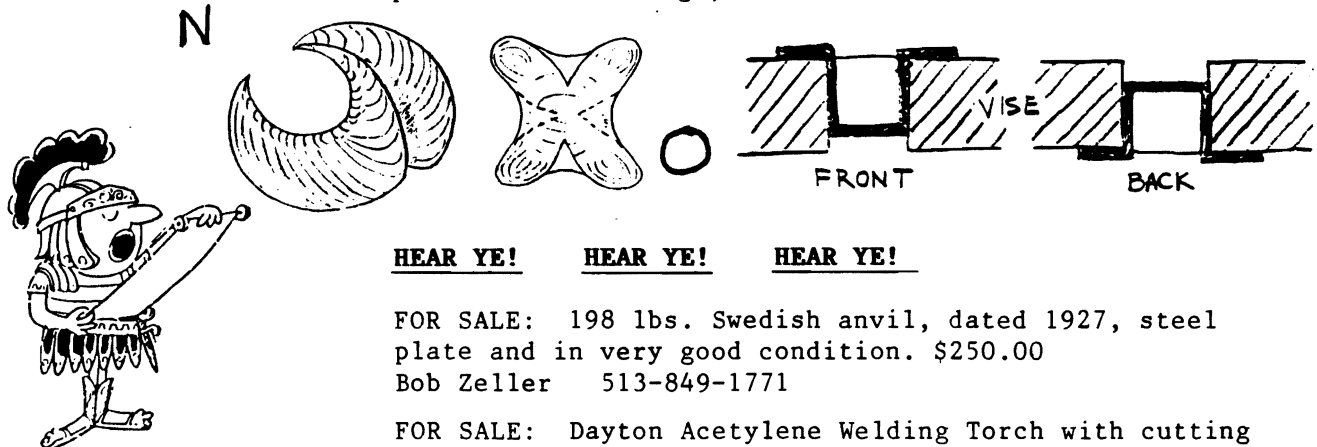


**DOUBLE ROUND SHAPE:** A bit hard to draw. The design comes to center at a 90°. Start with a flat piece of stock  $\frac{1}{2}$ " at end, 1" thick in the center and 6" long. (N) Work the 90° right angle on your curved area on your wood block, or serpent stake. I know that it seems nearly impossible, but I called Dick to make sure. He said the metal will move. When finished the object is quite nice. It could be used to suspend a rope for a hanging basket.

#### OTHER TIPS:

- 1) Fire scale after pickling produces a copper finish. A nice contrast.
- 2) Hold downs for horizontally held stake anvils. Make your self some steel U-clips to fit your stakes. Properly placed these will keep the stake securly in place. (O)

\*As a final note Dick claims that you will develop a great appreciation for the cost of hand made sheet work due to the work and time you will put in. Sounds like the work we produce at the forge; and all well worth it!



HEAR YE!

HEAR YE!

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FOR SALE: 198 lbs. Swedish anvil, dated 1927, steel plate and in very good condition. \$250.00  
Bob Zeller 513-849-1771

FOR SALE: Dayton Acetylene Welding Torch with cutting head and 5 tips, sizes 1 through 5, \$100.00. Victor model MR Acetylene Welding Torch with 3 tips, regulators, goggles, striker, \$100.00. Dick Franklin 513-233-4878

FOR SALE: 50 lbs. Little Giant power hammer in good working order with single phase motor. \$1200.00 delivered. Richard Kern 513-372-9100

FOR SALE: Wheelwright mandrel about 40" high. \$200.00 Emmert Studebaker.  
513-667-4451

FOR SALE: Blacksmithing starter equipment including forge, 112 lbs. anvil, leg vise and hand tools, \$400.00 for the lot. Treadle hammer, \$150.00 (can deliver locally). Hand cranked stand-up blower, \$75.00. Ken Scharabok 513-429-3967

FOR SALE: 150 lbs. Mouse Hole anvil; 200 lbs. anvil; post vises 4" and 5".  
John Baker 513-331-2471

FOR SALE: Swage blocks \$100.00, cones \$60.00. Ron Thompson 513-492-2259

FOR SALE: Cast iron rivet forge with blower. Needs Work. \$25.00 Ken Ullery  
513-837-2408

FOR SALE: 2 Bradley trip hammers. John Teslow 515-472-7390 Fairfield, IA.

FOR SALE: 500 lbs. anvil, Orvin Dussia 419-865-4837 Toledo, Ohio.

FOR SALE: 6' bellows, \$125.00 Sandstone grinder, large \$75.00 Gary Ameling  
419-862-2090

FOR SALE: 4" and 5" post vise, Lynn Spallinger, 3386 Road R, Pandora, Ohio  
45877

FOR SALE: Blacksmithing Video: Based on the popular PBS series - "The Woodwright's Shop" - Roy Underhill's 55-minute video demonstration on how to make a forge, anvil, spike dog, chisel, cant hook, splitting froe, and more. VHS only. Available for \$39.95 plus \$2.50 for postage or \$4.00 for UPS delivery, from Storey's Books for Country Living, Schoolhouse Rd., Pownal, VT 05261-9989. Write for a catalog and receive a \$5.00 gift certificate. Video is catalog #1249-X.

WANTED: Sheetmetal working tools, rollers, forming tools, etc. Call Ron Washburn. 1048 Hemlock, Lewiston, ID. 83501 208-743-0350

WANTED: Anvil, 150 lbs. or higher. Call Chuck Davis. 509-943-5843

WANTED: 1/2" or 5/8" table model drill press. Call Tom Honeycutt. 509-882-1403

WANTED: Older 5/8" floor model drill press. Call Joe Teal. 509-967-3929

#### **JOBS:**

OPPORTUNITIES: We recieved a letter from Walter P. Kenpper, Executive Vice President of Solida Corp.; P.O. Box 6803; Jackson, MS. 39212; a company who manufactures "High quality" jack hammer bits. They are looking for "Forges and/or Blacksmiths Companies" throughout the country, who would be interested in "reconditioning" their tool bits. If you are interested, contact: Mr. Kenpper at the above address, or by calling 1-800-748-8841 or 601-371-6702 for detailed information. (INBA NEWS)

APPRENTICE NEEDED: Blacksmith apprenticeship, one year, general all around blacksmith shop makes gates, handrails, furniture, and work in iron and bronze. Handforming, powerhammer, and modern metal working techniques. Contact Craig Kaviar at Kaviar Forge 502-561-0377.

BEGINNING BLACKSMITHING CLASSES: School of Homestead Living, Rio Grands College, 1989 Summer Program. Call the college for scedules and information.

#### **SPECIAL NOTICE:**

The 8th Annual Sweet Corn Festival will be on August 19-20 at Community Park East in Fairborn. Booth fee for crafts is \$25.00 - deadline is August 9th. Contact Ceil Marlin at 878-2556 for further information.



The City of Dayton's Division of Recreation and Parks is accepting applications for its 10th annual Mid-Town Arts and Crafts Show to be held from noon to 7 pm on Sunday, August 20th at Dave Hall Plaza Park, South Main and Fifth Streets. Entry fee for artists is \$25.00 before August 1st and \$30.00 after. The show is being held in conjunction with the Dayton Blues Festival and the Taste of Dayton. Call 263-8400.

\*\*\*\* Registration packages for the 1989 Quad-State Blacksmithing Round-Up were mailed in early July. If you did not receive a package, contact Dick Franklin at 7158 Klyemore Drive, Huber Heights, OH 45424. While day-of-event registration is available, we strongly encourage advance registration for both our planning purposes and to make the registration table process go easier by having your name tags, meal tickets, etc. ready in advance. The event will be September 23-24. Volunteers help to set up on Friday and take down on Sunday evening and Monday morning receive a partial or full registration refund.

Anyone attending the First International Festival of Ironwork in Cardiff, Wales, August 26th-September 3rd may be interested in a tour before the event offered by the Architectural Metalwork Department of Plymouth College of Art and Design. Contact Keith Radcliffe, Sutton Annexe, Plymouth College, Regent Street Plymouth, England PL4 8BQ for further details. Further information on the Festival is available from the ABANA national office as they are getting together a tour group.

#### OF INTEREST:

HOSSFELD BENDER PINS- Short on pins for your binder? Go to the nearest farm and home supply and look at the selection of implement hitch pins. They are of all sizes and are of good quality steel.

This comes from my American Family Insurance agent in response to a request for insurance while doing forging demonstrations for the public. According to my underwriter, about your blacksmithing demos, he said, "If this was a hobby, and you were not getting paid to do the demo, you would be covered for liability under your homeowners policy. If you are getting paid, then a separate liability policy would be needed". THE PREMIUM WOULD BE HIGH. (IVBA)

Cathy Washburn took the Broom Making class at the ABANA conference at Birmingham last summer. She would be glad to tie hearth brooms on your handles to match your pokers and shovels. For info call; 208-743-0350.

For information on surplus government equipment for sale in this area write to: Surplus Sales, Federal Supply Service Bureau, General Services Administration, 230 S. Dearborn St., Chicago, IL. 60604 or call 312-353-0246

Centaur Forge's 1989 catalog is now available. Includes custom logo stamps and firepots, anvils, handtools, coal, and gas forges and 146 blacksmithing related books. For a copy send \$2.00 for postage and handling to Centaur Forge, P.O. Box 340, Burlington, WI 53105.

Home-based businesses can advertise locally to Dayton's top 100 businesses, firms which employ 200 or more, and civic and social business organizations through "Workstead Communications", a directory published every six months. For rates, etc., contact them at 137 N. Main St., Suite 600, Dayton, OH 45402 or call 513-229-8858. Next directory will be out in the fall.

The 9-month tooling and machining course at Sinclair Community College is accepting applications for the next class starting Sept. 11. Toolmakers rank 7th among the top ten jobs with the highest net lifetime earnings. High school diploma is not required. The course has a 100% placement record with local companies. For further info contact Virginia Ripp at 226-2570.

To insure consistency and to speed up the process, Dan Boone uses jigs to bend round ends of planter hooks, extentions, and poker handles. Make the jigs from round black pipe in various sizes. The jig fits in your vise jaws.

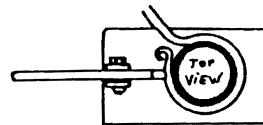
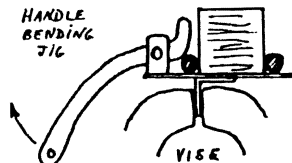
Speed is important if you are to make a living from your work. Dan tries to produce at least \$30 worth of salable goods per hour including the material cost.

Dan uses three sizes of crosspein hammer, 1, 2, and 4 lbs. All of his hammers have the edges ground rounded, and are then polished smooth so as to leave no unwanted forging marks on the work. His anvil is also polished.

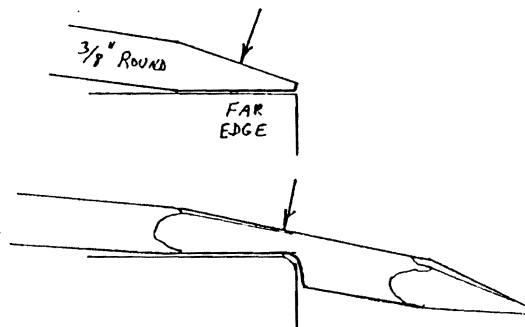
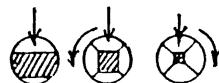
Dan doesn't bother to wire brush his dragon heads until the final heat. He spends about a half hour in filing the surface of his heads after he finishes the forging. Dan likes to use 6011 welding rod on forgings when it is necessary to electric weld. Chisel off the splatter, or use a spray available in welding shops to protect your work against welding splatter.

Dan has his shop outdoors under a shed roof. Here he has his 300 lb anvil, high and low vises, 50 lb power hammer, coal forge and gas forge. In his basement, he has an electric welder, welding table, vises and finishing type tools. All finishing operations such as filing are done indoors.

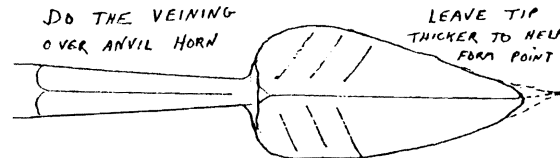
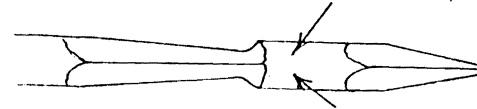
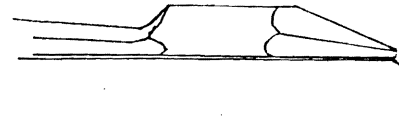
For finishes, Dan uses either a clear spray of lacquer, or stove black mixed with linseed oil. With the dark finish, he sands out the highlights and reccats with clear lacquer. Dan sometimes puts a brass finish on his work. Do this by rubbing a wooden handled brass brush on the work at a black heat. At the proper heat, not too hot, not too cold, a thin layer of brass will rub off on the hot metal surface. The brass brush will last a long time. Coat the metal with a clear lacquer finish.



Dan makes leaves to decorate fireplace tool handles out of 3/8" round. Make a blunt point by hammering on two sides only on far edge of the anvil. Hang the blunt point over the far edge about 2", and hammer down on far edge on two sides only, alternating sides with each blow. This gives a deep notch that you can draw out as the stem. Hammer out the point on the diamond, leaving a seam down the center. Spread to a long leaf shape. Vein using the crosspein of the hammer. Cup the leaf by hammering on a wood stump using a ballpein.

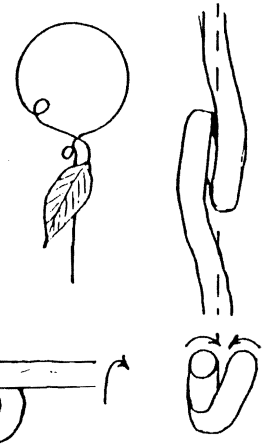


Flatten out the leaf on the diamond. Spread to leave a seam in the center. Leave metal thicker at point so it is easier to point and curl a little. Vein with crosspein and cup leaf on a wood block to give it life. Draw out the stem for a smooth transition into the handle stock.



Dan makes a handle using the leaf by putting in two "knots." Each knot is made by bending the round rod in a tight loop. Then using vise-grips, the rod is twisted to align the rod on each side of the loop. This gives a "viney," convoluted look to his handles. Dan has found that women tend to buy more of his wares with a leaf and vine motif, whereas men like to buy his dragon heads. This looping and twisting is hard to show in a drawing, and is hard to figure out even when you see Dan do it. Dan recommends practicing with solder until you get the hang of it. Hammer on bars of lead to practice making leaves too. Modeling clay is also very useful to practice with.

Dan always tries to do something different to make his work stand out from the other guy's work. He feels this is a good philosophy for anyone who wants to sell his work.

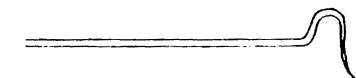


It is best to thin the leaf stem before completely forming the leaf, but don't thin it so much that it breaks or burns off. Work over a rounded edge of your anvil.

After finishing the leaf, work back from there to form each knot or bend in the handle. After making the loop for a knot, re-heat if necessary, and place the leaf end of the knot into your vise, and clamp vise grip pliers on the rod. Twist the rod to tighten the knot and align the rod on both sides of the knot. This may take some practice.

Bend the handle end around the end of the anvil horn to get the size loop you want. Grip the leaf end of the rod with vise-grips or tongs as you bend the rod around with your free hand.

After the handle is completed, cut off the rod the right length for a poker. Taper the point by drawing it out. Bend to shape.



# 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 July 1989

Dear Friends,

We have a couple of new and exciting things happening in ABANA that I want to tell you about and the first one deals with the library. Joe Pehoski, Director of the ABANA Library, indicates that the rent on slides and videos have been reduced as much as 40% and that new material is being introduced in the next issue of the Anvil's Ring. Also, the "First International Festival of Iron, August 27 - September 2, 1989" promotion video tape is now available through the ABANA Library at no cost other than postage (\$2.00). This is a tape that must be returned. The tape is very entertaining, professionally produced, five minutes long, and cannot be watched just once! This tape features American smiths and is a real hooker. Unfortunately, the tape will not be available after September 1st. If you wish to view this tape, please contact our ABANA Office very soon.

ABANA now has full sized, professionally drawn blueprints of a totally atmospheric propane forge. This forge is a regenerative heating type of unit that preheats itself to 1,000 degrees and will jump from room temperature to 2,300 degrees F in six minutes. It is not electric in any way and is a totally reducing fire atmosphere. It runs for eight hours on five gallons of propane and weighs approximately 30 lbs. The plans are for an entirely portable unit. The approximated cost to build the forge is in the neighborhood of \$175 and all the parts are easily accessible in all locations. It comes complete with full scale drawings and accompanying information sheet to explain the process and assembly. The forge plans were a gift to ABANA from the Sandia Laboratories Rocketry Testing Unit in Albuquerque, New Mexico and built under the guidance and supervision of Rob Gunter, blacksmith at Sandia Laboratories. The forge was under heavy use at Sandia for over a year and has been shown at many conferences in the U.S. in the last six months. All the blacksmiths who have used this forge or have seen it in operation have felt that it is indeed the Cadillac of the propane forges. Nothing has been left to chance and no technology has been spared in the completion of this project. Francis Whitaker recently used the forge at the Western States Conference in Carbondale, Colorado and thought that it was by far the finest propane forge he had ever worked on and the most practical and inexpensive of its type to build. If you would like a set of these plans, you may obtain them through the ABANA Office at a cost of \$15 for ABANA members or \$20 for non-ABANA members plus \$2.00 postage. It is hoped that any of you who are interested in changing to propane or are at this time using a propane forge will see the advantage of an economically produced unit.

Thank you to all editors for printing the ABANA monthly update and thanks to each of you members for continued support of ABANA and blacksmithing throughout America.

Sincerely,

Stiegler

DS/jg

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## PRESIDENT'S MESSAGE August 1989

Dear Friends,

Within the next few weeks you will receive your ABANA ballot to vote on the five positions open on the ABANA Board of Directors and to clarify some of the wording of the ABANA by-laws. We will be mailing these ballots by 08/07/89 from Nashville, IN in 3rd class mail. Since they will come from a central location, members on both coasts will have an equal amount of time to review the ballots and return them by 09/15/89.

As ABANA members, you have a great responsibility to select board members who will assist ABANA in our goal to move ahead into the future as a working team. We hope that each of you will realize the power of a single vote. Returning your ballot with your vote is a privilege and an honor that I hope you will exercise.

For those of you who have been waiting on hold for the new gas forge plans, bare with us for a short time as we get these blueprints printed and the pamphlets mailed off to those of you who have made the request.

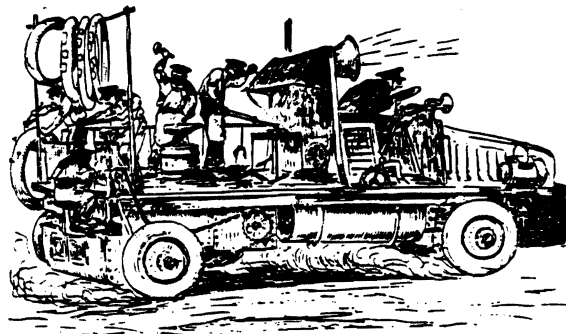
I received a letter from Pier Luigi della Bordella, Director of the eighth biennial national Dell'arte Fabbriile to be held August 28th to September 3rd 1989 in Tuscany, Italy. This is one of the most important festivals of metal to be held in Europe and it is open this year for the first time to masters outside of Italy. It will be comprised of an eight hour hands-on forging competition by masters of the world and the theme this year is "Medieval Combat Arms in Use at Campaldino's Time". The forging exhibition will be in a place properly supplied with tools in the open air and in the presence of the public. All masters will have two working periods lasting four hours each and within this time frame the work will have to be finished and consigned to the delegate of the judges. The participants will be allowed to use their own tools in addition to the ones supplied. The models to be executed will be put at the master's disposal, drawn on paper in life size. Preliminary sketches will be drawn by Tuscan Art students and will be extracted from historical finds, kept in a Florentine museum - Stibbert & Bargello. An award ceremony will be held and the winners of the prize will be designated by jury. To all the foreign participants, the contribution of expenses will be granted. For further information, write or phone the secretary of the organizing committee. "International Prize of Smithery" c/o Town Hall Stia - Inc. Mrs. Patrizia Batisti - 52017 STIA - (Arezzo) Italy Tel: 0575/58672 or 58673.

Due to the change in printers for the Anvil's Ring and awaiting approval on the location change for the 2nd class mailing permit, the spring issue will be mailed several weeks later than originally planned. It is our intention that you will receive this issue sometime during August. Thank you for standing by during this transitional period.

Dorothy Stiegler  
ABANA President

DES/jrg

To the right is an early cartoon published by the German Automobile Club, apparently portraying a traveling blacksmith who dealt with both the horse-and- buggy and the automobile trade. This Rube Goldberg contraption could have done an enormous business in the rural districts of America when the automobile was in its infancy. \*\*



Pioneer Village at Ceseur's Creek is looking for volunteers to man their blacksmith shop. I was down there a couple of weeks ago, and the site is very rustic and authentic. You will need to bring all your tools and iron, and perhaps coal. I would say that is you live in the area and don't have your own vise/anvil or forge, this could be a great opportunity. The Village needs all the help it can get, both in demos and trinkets to sell in their gift shop. For details call: Linda Lee at 897-1120 or write to her at P.O. BOX 329, Waynesville, Ohio 45068. There are a couple of festivals coming up very soon that need volunteers.

\*\* From "Those Wonderful Old Automobiles," by Floyd Clymer, 1953. THANKS EMMERT!

# ABANA

## Membership Application

Name: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_

State: \_\_\_\_\_

Phone: ( ) \_\_\_\_\_

Zip: \_\_\_\_\_

☐ New Member

☐ Renewing Member

How did you learn about ABANA?

<input type="checkbox"/>	Regular Member .....	\$35.00 yr
<input type="checkbox"/>	Family Membership (one Vote) .....	\$40.00 yr
<input type="checkbox"/>	Senior Citizen (age 65) .....	\$25.00 yr
<input type="checkbox"/>	Overseas Membership .....	\$45.00 yr
<input type="checkbox"/>	Contributory .....	\$100.00 yr
<input type="checkbox"/>	Library .....	\$25.00 yr

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

MasterCard ☐ VISA ☐ Check/Money Order ☐

Card Number \_\_\_\_\_

Exp. Date (Required) \_\_\_\_\_

Checks must be in U.S. currency.  
SEND TO:

ABANA  
P.O. Box 1181  
(812) 988-6919  
Nashville, IN 47448

Dues Distribution:  
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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.

