



SOFA SOUNDS

SOFA SOUTHERN OHIO FORGE & ANVIL

AUGUST/SEPTEMBER 1988

Artist-Blacksmiths Association of North America

BOARD OF DIRECTORS:

Emmert Studebaker (Director Emeratus)
Dick Franklin
Hans Peot
Ron Thompson
Ron Van Vickie
Larry Wood

OFFICERS:

Hans Peot (President) (513-845-9934)
Ham Hammond (Vice President)
Ken Scharabok (Secretary/Treasurer)

NEWSLETTER EDITOR:

Ken Scharabok (513-429-3967)

MARK YOUR CALENDAR: 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 to display. The public and guests are welcome. Finger food and cold drinks to be provided with a donation bucket.

August 6th, 1PM

BUSINESS MEETING followed by a demonstration by Hans Peot. What would you like to see demonstrated? Call Hans.

September 10th, 1 PM

BUSINESS MEETING followed by a demonstration by Emmert Studebaker. Note this is the second Saturday.

September 24th-25th

1988 QUAD-STATE BLACKSMITHING ROUND-UP. Details in this issue.

October 1st

No regular meeting this month due to Quad-State. However, if you would like help on a particular project or have a problem you need help with, we might be able to provide assistance.

November 5th, 1 PM

BUSINESS MEETING followed by a demonstration by Ken Scharabok on making a horse head fireplace poker.

MEETING NOTES:

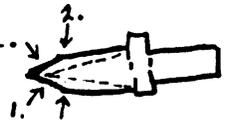
A short business meeting was held on June 4th with the following items discussed:

- SOFA is ordering pins for the chapter. These will be sold for \$3.00 each.
- SOFA T-shirts will be ready for sale at the Birmingham conference and at future meetings. Get your's early to be sure to get the size desired.
- We sold the last of the anvil charms (but may reorder in the future) and have less than a dozen ABANA pins left. When these are sold, you will need to order directly from the ABANA office.

Chapter of ABANA

Following the business meeting several members made hardy tools at the forges in the main shop and the Wheelwright shop. These were made out of used (and some new) jackhammer bits. Several hot cut offs, a bick and a hardy mandrel (to be used at the next meeting) were made. Next time we will probably set up additional forging stations.

Larry Wood stayed after to help assist my making the hardy mandrel. A piece of bit about 1½" round at the working end and 1½" six-sided at the attachment area was used. After the six-sided portion was cut off (shorter than the final length desired) it was forged down to square to fit the hardy hole. The round end was then cut off and drawn to a taper. Here Larry pointed out you should bring the end down to the taper end desired first and then forge the rest of the body to blend into this taper (see illustration). You have more control over the taper this way. As normal for a taper, it went from round to square to eight-side to sixteen-sided and then back to round.



* * * * *

The raffle brought in an additional \$46.00 to support the newsletter. I didn't keep track of winners and donators, but some nice items were in the raffle. I'm still looking for a volunteer to keep track of donators and winners for me.

A special thanks goes to Richard Knopp and others who brought in jackhammer bits. These are also used during the year for members who need a tool made.

* * * * *

At the July 9th business meeting:

- The group recommended the current slate of officers to the board to serve another year.

- Hans Peot spoke on the upcoming election for ABANA Board of Directors vacancies and solicited volunteers. Ham Hammon volunteered to run and the required 10 ABANA member signatures were collected.

Following the board meeting, Emmert Studebaker acted as judge for the completed pieces for heart shaped hooks. He had provided the blanks at the last meeting. Ralph Van Buskirk, Dennis Hoffer, John Baker, Dick Franklin and John Jacobs submitted completed pieces. Emmert judged Dennis Hoffers as the best of the submissions. John Jacobs had made hooks in three sizes, mounted them on a board and called them "The Three Bears". Following the judging Dick Franklin produced one he had made embellished with flowers and a grape cluster.

At one point the monies from the raffle, T-shirt sales and renewals got comingled. By counting remaining T-shirts, we sold eight at the meeting. When that amount and two renewals and one new members were backed out, \$119.00 remained as raffle proceeds. Based on attendance, I strongly suspect one or more people paid their Quad-State registration fees without it being recorded as such. Thus, I'm embarassed to have to ask, but if you paid your fee in cash at this meeting, please let me know so we can make sure our records are correct. Just drop a note to Ken Scharabok, P.O. Box 33399, Dayton, OH 45433-0399.

For the raffle itself, Ron Van Vickie won several high-carbon content rods out of a piece of farm equipment donated by Keith Sommer; John Baker won steel pins donated by Denny Bischoff and spring wire donated by Dave Clouse; Brian Thompson won a ornate pot holder; Jim Listner won gloves donated by John Jacobs; John Jacobs won a piece of plate steel donated by Bill Fleckenstein; Ken Scharabok won several sweat bands donated by John Baker; Bud Rube won a length of metal muffler hose donated by Al Lorenz, Dennis Hoffer won a bag of rivets donated by

Larry Wood; Ham Hammond won sanding belts donated by Doug Fink, Doug Fink won a length of H-21 steel donated by Hans Peot; Bud Rube won an ABANA 88 T-Shirt donated by Brian Thompson, Dennis Hoffer won an oil filter wrench donated by Ken Scharabok, Ray Armstrong, G.C. Mericle and Phil Trickey won newsletters donated by the Alabama Forge Council; Carey Alexander and Al Lorenz won wrenches; Art Wolfe won a router stand donated by Jim Leistner, R. Coning won a water barrel donated by Dick Knopp; Andrew Holly won large hammerhead wedges donated by SOFA and Dick Franklin won clean-up of a second water barrel donated by Dick Knopp, a cardboard drum donated by Bud Rube and a furnace poker donated by Ralph Van Buskirk. Thanks goes to all who donated items and bought tickets for this newsletter support raffle.

For the demonstration portion of the meeting, two forges were lit with chain links being made at one and punches or chisels made at the other. Keith Sommer oversaw the second station. As I recall, Bud Rube, Phil Trickey, R. Coning's female friend (I didn't get the name) and the son of one of the members make links while John Baker and others make chisels. R. Coning also tried to flatten a length of large spring steel from a railroad car using the 100 lb powerhammer. That metal didn't move much. Bud Rube also made a nice little hardy mandrel for his anvil.

1988 QUAD-STATE BLACKSMITHING ROUND-UP:

By now, most of you should have received a registration package for the 1988 Quad-State Blacksmithing Round-Up to be held at the Studebaker Frontier Homestead the last weekend in September (the 24th & 25th). If you have not received a package, contact Dick Franklin at 7158 Klyemore Drive, Huber Heights, OH 45424 and one will be sent to you. Please register by mail before the event as it makes the registration process much easier.

This year, the featured demonstrators will be Peter Ross, resident master blacksmith at Colonial Williamsburg, who will do colonial ironworking; Nol Putnam who will demonstrate projects someone with basic skills could make for craft fair-type sales; Hugh Bartrug who will demonstrate his style of Damascus pattern billets and mokume (a type of Japanese steel); Robert Maki who will demonstrate engraving; Duane Wegley who will demonstrate basic blacksmithing and Doug Fink who will demonstrate forging of tubing. We put together a fairly well rounded program.

The basic format for the Round-Up will be the same as the last several years. The Saturday evening meal will feature baked ham this year. We decided to do the tongs competition again this year so we are looking for one to two teams to represent SOFA. We also need volunteers to help set up on Friday and to take down on Sunday evening and Monday morning. The volunteers will receive a refund on their registration fee.

If you are interested in the tongs competition, please let your Editor know as soon as possible. Prizes will be \$50, \$25, \$15, and \$10 for first through fourth places, respectively. Judging will be on appearance and fit within a 45 minute time limit.

This year we will have SOFA hats, T-shirts and pins for sale so we need a volunteer to man a sales table from about 7-10 AM on Saturday and Sunday morning. Please let us know if your spouse or child would be interested.

The display area has always been a major focus of Quad-State. This year, we want to also emphasize tooling. If you have made a tool which facilitates a process, please bring it along with a explanation guide as necessary.

We would like to have VCR tapes of each of the demonstrators. If you have the necessary equipment and would be willing to tape and edit the demonstrations, please let us know to work out compensation arrangements.

1990 A.B.A.N.A. CONFERENCE SITE UPDATE:

No organization volunteered to host the next bi-ennial A.B.A.N.A. Conference at the Birmingham event. SOFA officials pretty well lost any interest we had when we found out the hosting organization receives no monetary benefits from staging the event. Our initial understanding was that the hosting organization, after returning the seed money from A.B.A.N.A., retained any profit or loss; but A.B.A.N.A. would be entitled to any profit from raffles, auctions or A.B.A.N.A. sponsored souvenirs or other items. A conservative SWAG is that hosting the national event would require at least 100 times the effort of hosting Quad-State.

NOTES FROM THE 1988 ABANA CONFERENCE:

- JIM BATSON (Madison, AL):

-- You should learn two colors at the forge, the point of which magnetization is lost (critical point) and where you lose (burn up) the metal. These differ depending on the type of metal.

- Spring steel 1/4" or more in thickness is almost certainly oil hardened.

- When grinding a piece of wrought iron, there should be no carbon bursts at the end of the streams.

- To estimate what an unknown piece of metal is, grind it and pieces of known content and compare the sparks.

- Heat Damascus-pattern billets from the side, not top or bottom, for the heat to penetrate into the billet.

- Work Damascus-pattern billets hot due to dissimilar metals. The layers can move at different speeds and shear if too cold.

- The importance of good forge welding in Damascus-pattern billets is illustrated by the fact a billet of five layers, 1" x 5" will have about 17 square feet of welded area between the layers for a 512 layer billet. A Japanese blade with about one million layers for the same size billet would have about 34,700 square feet of welded area - or about four-fifths of an acre.

- Heat billet to lower forging temperatures as it becomes smaller in size to avoid over compacting of the grain.

- When folding a Damascus-pattern billet over on itself, hold the handle side in a vise to avoid stressing the handle joint area as much as possible.

- If you want a high number of layers in a Damascus-pattern billet, but also want a bold pattern, insert additional pieces of high carbon steel during the fold-over process.

- Boil Damascus-pattern items for a brief time before etching to help prevent etching cracks.

- DAN BOONE (Greenbelt, MD):

- Just as a shop should have two anvils at different heights (one for heavy forging and one for finish work), it should have two postvises set at different heights, one at the normal height and one about 28-30".

- Round the edges of your hammer face so you can work in corners without leaving marks.

- DAVID COURTS (Northfield, NH):

- "Experience comes from bad judgement. Bad judgement comes from lack of experience".

- Wear at least a light-weight glove on your tongs hand to control perspiration.

- Joe Pehoski (Salado, TX):

- A good finish is one 1 lb can of Johnson Paste Wax, 1/4 cup of boiled linseed oil, 1 cup turpentine and 1 tsp Japan Drier. Mix in a double boiler.

- An interesting finish is to use four different colors of spray paint. Hold can about 12-15" away from work and spray lightly with each color emphasizing different areas. This gives a unique multi-color tone with thousands of individual color dots. Colors are overlaid on top of each other over a dark background.

- Jay Reakirt (Albany, GA):

(Note: The majority of Jay's demonstration concentrated on how to be successful in selling hand forged ironwork at craft shows or at places like pioneer villages.)

- When demonstrating for the public there are three always. ALWAYS let 'em know what you are doing. ALWAYS produce quality work. ALWAYS let 'em see you sweat.

- Your inventory should be three times what you expect to sell. What sells good at one place won't at another, or even from day to day at the same event.

- Tailor your sales inventory to the event, i.e., at Civil War enactments concentrate on period items, at craft fares concentrate on usable home hardware.

- Look like the blacksmith of people's memory or fantasy. Don't wear blue jeans, printed T-shirts and sneakers. Jay works weekends at Andersonville, GA and dressed in brown boots, grey work pants, gray long-sleeve work shirt, red suspenders, wide brim felt hat with a colorful hat band, leather apron and had a towel held in his apron belt. The apron bib area held a colorful handkerchief. He wear grey since Andersonville was a Confederate Civil War prison.

- Keep demonstrations short and simple. Choose 5-6 simple items to make in 15 minutes or less, repeat in order. 15 to 30 minutes is the maximum you can hold a crowd's attention.

- At the end of each demonstration, remind folks you have things to sell. Jay used a standard pitch of that's how they are made, it's how it was made 50 years ago or 1,500 year ago for that matter. The items produced are for sale and the viewers can't live without ten of each of them.

- While the item produced is the product, you are the show. Don't be afraid to interact with the crowd. Flirt with the ladies and joke with the men. Be a

clown but don't carry it too far. If the crowd reacts to you personally, it will open up their wallets.

- Stop demonstration for sales but make a show of it ... "OH MY GOD, A REAL LIVE CUSTOMER"...

- Take a break between demonstrations to make sales and interact with the crowd.

- Finding good shows takes time. Eliminate the poor ones and concentrate on the proven ones. Avoid flea markets and "festival days" although some long-running festivals can be good money makers.

- Keep careful records of what you sell and what your expenses are both for inventory and IRS purposes.

- If possible demonstrate an item produced, such as starting a fire from a fire striker just produced.

- At shows, keep your inventory in view as much as possible.

- Include sales tax in the final rounded price (e.g., whole dollars or 25¢ increments) as it makes taking in money easier. Take about 20 one dollar bills with you to be able to make change for the first couple of sales.

- While your demonstration should be authentic, use all the power tools or time saving devices you can at home since you will be doing your production work there. The items produced during demonstrations are mostly for show purposes.

- When doing production runs, divide the process into steps which can be done to a number of items.

- Precut demonstration stock to proper length.

- If you have a fairly extensive line, produce a catalog of your work. Give a free copy for actual sales but charge casual lookers twice the cost of printing. That way, your advertising costs for the catalog should about breakeven. The catalog doesn't need to be professional. It can be in 5 1/2" x 8 1/2" format with a cover, something about you, line sketches of the items, your address and the fact you can do custom work.

- If you produce an items which you thought would be a seller, but it turns out to be a dog, raise the price rather than lower it. Sometimes people will pay \$20 for an item but not \$10. It doesn't cost much to keep carrying it around with you.

- Write down stock lengths, directions and measurement for each item you produce so you can review them when you haven't make a run of a particular item in several months.

- Have a range of prices for items, such as fancy fireplace tools for \$35 each and less complex tools for \$10 each or BBQ utencils in blackened sheet metal versus brass for the spatula and spoon heads.

- Whether you intend to do craft-type sales part or full-time, set a goal and then calculate what it will take to achieve that goal (e.g., so much net profit per year). Jay does this full-time and tries to produce \$40 - \$50 in retail value for each hour at the forge to allow for time and expenses.



HEAR YE! HEAR YE! HEAR YE!:

The following local members usually have anvils, leg vises and handtools for sale: Mark Cucac - 473-3129, Joe Abele - 276-2977 and Steve Roth - 836-8520.

A reasonably current membership list is available from the Editor for a SASE with 25¢ postage.

The Rural Smiths of Mid-America is dedicated to preserving and documenting rural blacksmithing. Membership cost of \$25 includes their tri-annual publication, The Traditionalist Contact Fred Caylor, 3602 S. 800E, Zionsville, IN 46077.

THEN AND NOW is a combination buckskinning and blacksmithing magazine. 6 issues for \$15.00 from P.O. Box 842, Mt. Vernon, WA 98273.

DEMONSTRATORS NEEDED for SOFA meetings. Contact the Editor at 429-3967. The demonstrations don't have to be either elaborate or complex as we learn something in every demonstration.

FOR SALE: HEAVY-DUTY CAST IRON FIREPOTS. \$125. Contact Bob Zeller at 849-1771.

Carriage Hill's Blacksmith Shop needs weekend volunteers to demonstrate. Contact Dick Franklin at 233-4879. Located off Shull Rd. east of Rt. 201.

FOR SALE: 50 lb Williams-White power hammer, completely restored, \$1,850. Wheelwright mandrel about 40" high, \$200. Contact Emmert Studebaker at 513-223-3202.

FOR SALE: Detailed and illustrated plans for a homemade 50 lb power hammer. \$4 postpaid. Contact Hans Peot, 6425 S. Scarff Rd., New Carlisle, OH 45344.

BOOKS ON BLACKSMITHING are available from: Norm Larson, 5426 Hwy 246, Lompoc CA 93536; Jim Fleming, 156 Country Road, Beckenridge, CO 80424 and Centaur Forge, 117 N. Spring St., Burlington, WI 53105.

Reminder that classified ads for blacksmithing-related items in this newsletter are free. Send in your ad to buy, sell or swap.

BEGINNING BLACKSMITHING CLASSES. Contact Larry Wood at 233-6751.

The following offer one to two week (or longer) blacksmithing classes: Appalachian Center for Crafts, Rt 3, Smithville, TN 37166; John C. Campbell Folk School, Brasstown, NC 28902; Penland School of Arts & Crafts, Penland, NC 28765; Crafts Center, Ripley, WV 25271; Arrowmont School of Arts and Crafts, Gatlinberg, TN 37738; Peters Valley Crafts, Layton, NJ 07851; Haystack School of Crafts, Deer Isle, ME 04627, Hancock Shaker Village, P.O. Box 898, Pittsburg, MA 38902 and Turley Forge, Rt. 10, Box 88C, Santa Fe, NM 87501. In addition, many Pioneer Village-type operations seem to offer at least one short course a year. Contact those near you.

Hearth broomheads made for your iron handles. Village Broom Shop, RR #4, Box 8946, McConnelsville, OH 43756. Broomheads are hand-made.

Civil War Re-enactment, Aug 6 & 7, 88 and Aug 5 & 6, 89 and Trail of Courage, Sept 17 & 18, 88 and Sept 16 & 17, 89. At Tippecanoe River and New U.S. 31 in Fulton County Historical Society Woods, 4 miles north of Rochester, IN. Contact Fulton County Historical Society, 7th and Pontiac Sts, Rochester, IN 46975 - 219-223-4436.

EMPLOYMENT OPPORTUNITY??? Two years ago I visited Put-in-Bay on South Bass Island out in Lake Erie. My impression is that a blacksmith shop would do rather well there for the period between Memorial Day and Labor Day (the traditional tourist season there). There had to be several million dollars worth of sailboats, yachts, large cabin cruisers, etc. in port and I understand most of the season is that way. This would seem an excellent opportunity for a qualified blacksmith to perhaps demonstrate and sell his own (and possibly others on commission) typical retail merchandise (e.g., pot hangers, fireplace sets, candle holders, etc.) during the season and also to pick up larger commission ironwork (e.g., gates and grills) for the off-season period off of the island. A shop/retail sales area could possibly have living quarters upstairs. To check out this possibility further contact their Chamber of Commerce or, better yet, visit. One retail shop there called "The Blacksmith Shop" did not sell any ironwear.

We've got T-shirts, we've got T-shirts, we've got stacks and stacks of T-shirts... Now you can proudly wear your SOFA affiliation on a pastel colored T-shirt with a design similar to the illustration at the right. These will be available at the meetings for \$6.50 or by mailorder from the Editor for \$7.50. State size desired (XXL, XL, L, M & S). Color will be what is on top of that stack.

The ABANA brochures are a good recruiting device for new ABANA members. If you know of a place to give out brochures (e.g., during demonstrations), a supply can be obtained by writing to Janelle Gilbert, ABANA Executive Secretary, P.O. Box 1181, Nashville, IN 47448.

Attention Artists: Prior to passage of Section 263A of the 1986 Tax Reform Act, artists could deduct business expenses in the year incurred. Now artists must document and attribute all expenses to the creation of a particular project and claim deduction only when income has been realized from the project. Expenses for unsold works of art cannot be deducted at all. It forces artists to account for their supplies and creative output similar to a mass producer. The law may also apply to hobby smiths who make occasional sales. Artists are being urged by the Ohio Citizens Committee for the Arts to contact their two senators and congressman to solicit support to repeal this provision.

Elsewhere in this newsletter is a letter from Emmert Studebaker to non-ABANA members. If you are not an ABANA member, please read it carefully. If you are an ABANA member, it contains reasons why you should continue your membership.

Old wooden bellows, in good working order, \$250. Contact Arthur Mooneyham, 806 11th Ave., Conway, SC 29526 - 803-248-6525.

SOFA Pins are available for your cap, lapel or tie from the Editor for \$3.25 each by mail. The pins are about 1" x 1" and are the SOFA logo (see the newsletter masthead) with SOF&A running at a downward angle on the right.

If there were sufficient interest, there is strong possibly we could get Jim Rubley to conduct a Saturday and Sunday seminar on making knives out of files. Cost would be between \$20 and \$40, depending on the number of participants. Jim has made some beautiful knives using files and readily shares his techniques. If interested, please notify the Editor so we can determine the interest level. Jim was a demonstrator at the 1985 Quad-State.

The Smoke and Fire News is a bi-monthly newsletter covering 1800's crafts and lifestyles (including buckskinning). Has an extensive calendar of events. Also covers "medieval" events. \$8 per year from P.O. Box 166, Grand Rapids, OH 43522.



Ohio is sometimes referred to as "The Festival State" due to the number held each year. The Ohio Arts Council has numerous books, catalogues, brochures and pamphlets available to the public. The Ohio Festivals and Competitions Guide Book is free and valuable to traditional craftsmen since it lists festivals, requirements and contact points. The Directory of Appalachian Artists in Ohio costs \$5. The Traditional Arts Program Publications in Folklife is also free. To secure copies contact their Public Information Office, 727 E. Main St., Columbus, OH 43205-1796. To obtain the first publication listed, send a business-size envelope with 95¢ return postage.

Members desiring to display their work at art shows, etc. in the local area, or to be considered for grant/commission work, are encouraged to join the Miami Valley Arts Council, P.O. Box 95, Dayton, OH 45402 - \$10 per year.

Prescription didymium lens glasses are available from The Optical Shop, 6717 N.W. 11th Place, Gainesville, FL 32605. Cost is about \$45.00 for single vision and \$110 for bifocals. Telephone number is 904-373-1933. Clip-on didymium glasses are available through mailorder from Thomas Scientific Co., P.O. Box 33, Swedesboro, NJ 08085-0099. Order Nr. 5774-C60-F02C03 for \$31.00 plus \$2.00 S&H. However, the clip-ons do not fit frames over about 1½" in lens height. Regular safety glasses with didymium lens are available from most safety supply companies. Didymium lenses greatly reduce glare from the fire and block ultra-violet rays.

Another source for a yearly listing of festivals in Ohio is from the Ohio Arts and Craft Guild, 9 N. Main St., Mt. Vernon, OH 43050. Send a business size envelope with 95¢ return postage.

The following items appeared in the 5/26/88 "L.M. Boyd" column in the Dayton Daily News, "The happiest, healthiest human, says a psychiatrist, is the one who makes something from scratch, starting with completely raw material and crafting every phase to the finished product...". Hmmm? Except for manufacturing the steel, sounds like blacksmithing.

On demonstrating ... "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 demonstrations, he said, "If this was a hobby and you were not getting paid to do the demonstration 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". (By Doug Heritage from the newsletter of the Illinois Valley Blacksmith Ass'n).

FOR SALE: Little Giant powerhammer, 25 lb with motor, good shape, newer model, \$450.00. Contact Randy Welle, Rt 1, Box 95 B-1, Minburn, IA 50167 - 515-677- 2757.

FOR SALE: Little Giant powerhammer, 25 lb without motor, good condition, \$400.00. Contact John Lane, Rt 2, Cascade, IA 52033 - 319-852-3438.

Lindsay Publications (P.O. Box 12, Bradley, IL 60905-0012) carries a number of turn-of-the-century reprinted books on metalworking and other subjects. Catalog on request.

If you visit Washington, DC on vacation this year, be sure to visit the National Cathedral (which contains the work of Samuel Yellin and others) and the National Building Museum (which contains a permanent exhibit of some of Yellin's work). To get to the latter, exit the Metro at the Judicial Square stop - the museum is directly across the street (the old Pension Building).

Colonial Williamsburg offers two mail order services; one for books (P.O. Box CH) and audio-visual material (P.O. Box C) at Williamsburg, VA 23187.

Received a request for a demonstration on making a "three bladed spur bar". If you know what one is, a demonstration time can be arranged.

Uncle Burley's (P.O. Box 1327, Edinburg, TX 78540) has several styles of broom-heads for fireplace tools available, from \$5.50 to \$16.50.

A back copy of the newsletter of the California Blacksmith Ass'n contained a list of 49 suppliers of rolled steel caps, flanges, baluster ornamental ornaments, castings, pressed steel ornaments, locks, brackets, etc., and machinery, tools and equipment for the ornamental iron trade. For a copy send a 25¢ stamp.

For you smiths who sell on consignment, I have available a two-page article out of the newsletter of the Appalachian Blacksmiths Ass'n on a sample consignment agreement. R. J. Askren, Renfrew, PA developed it with his attorney to forestall some of the potential problems in this type of selling. For a copy send a 25¢ stamp.

About a year ago, the Siebenthaler Nursery was creating a craft center by renting out stall space to full-time craftsmen. A 20'x36' stall was about \$90 month plus utilities. Contact point was Dick Powell at 513-278-8697.

Richard Postman (10 Fisher Ct., Berrier Springs, MI 49103) is researching the history of anvils and may write a book on them. If you have an unusual or unidentifiable anvil, please contact him.

Reminder that the finger food and soda provided at the meetings is on a break-even basis from donations. Look for the donation basket on the table.

In the next issue, I would like to include a special section on sources. If you have a source you would like to pass along (e.g., knife cases, pieces of antlers, rivets, tool steel, etc.) please send the address and brief description on what they carry to me.

The May/June 88 issue of the newsletter of the Southwest Artist Blacksmiths' Ass'n includes a sketch of a portable blacksmith booth they are building for use at their annual State Fair. The basis is a 7'x15' trailer with a take apart forging and sales area. For a copy send me a 25¢ stamp.

FOR SALE: Heavy-duty post vise, 6" jaws, EC, \$110. Anvils from 115 to 150 lbs, about \$1 per pound, some need edges dressed. Assorted tongs from \$4 - \$8 each. Ken Scharabok, 429-3967 evenings/weekends.

FOR SALE: Anvils. Various sizes and condition. Contact Ryan Johnson, 7320 Foster-Hixson, Cementery Road, Hixson, TN 37343 - 615-842-9323.

EXPERIENCED METALWORKERS WANTED. Paley Studios, 25 N. Washington St., Rochester, NY 14614 - 716-232-5260. Contact Eugene Kehoe, Manager.

APPRENTICE WANTED. Gilmore Metalsmithing and Architectural Ironwork, 100 Industrial Drive, Box A4, Waynesville, NC 28786-2716 - 704-452-3566.

APPRENTICE WANTED. Kaviar Forge, 147 Stevenson Ave., Louisville, KY 40206. Living quarters available.

The International Damascus Society (c/o Fiorini Metalsmiths, 1590 Hwy. 16, La Crescent, MN 55947 - 507-895-2050) produces a newsletter relating to the Damascus-pattern process. Membership is \$5.00 per year.

At the 1988 ABANA Conference, one station used a small air hammer capable of running off any shop air compressor with 20 S.C.F.M. capability at 100 p.s.i. for maximum power. Ram weight - 40 lbs. Only two moving parts. Weighs less than 1,000 lbs and requires no special base or support. Very quiet both in idle and in use. For further information contact E&C Machine Inc., Rt 1, Box 1050, Lexington, NC 27292 - 704-249-4482.

Steel forgings for ornamental ironworking are available from Lawler Machine and Foundry Co, P.O. Box 2977, Birmingham, AL 35212 - 205-595-0596. Catalog \$3.00.

The Alabama Forge Council (171 Brentwood Lane, Madison, AL 35758) June 1988 newsletter is a special National Conference issue. In magazine size it includes articles on making a heart wall bracket, heart towel ring, iron rose, horseshoe, forge brazing with a penny, Haverhill knife, small tomahawk, tool making, horse-head poker, making tongs and twist drill (and more). For a copy send \$3.00 to cover printing and postage.

The National Ornamental Metal Museum (374 W. California Ave., Memphis, TN 38106) is seeking submissions for the exhibit "Fakes, Forgeries, and Frauds". The purpose is to replicate, pun, or ape the work of any metalsmith, living or otherwise. \$200 cash award for best-in-show submission. For further information contact them. Their long-term display schedule is: July 16 - Sept 11, 88 - Masters of American Metalsmithing; September 18 - November 6, 88 - Gary Noffke, Master Metalsmith and Fakes, Forgeries and Frauds; November 13, 88 - January 8, 89 - From Astrolabe to Zenith (roles metal has played in the development of measuring devices for weights, distances, sounds, light and celestial movements); January 15 - March 12, 89 - House Jewelry, II; March 19 - May 14, 89 - Ecclesiastical Metals; May 21 - July 9, 89 - Eloquent Resolutions: Jewelry by and for Women; July 17 - September 3, 89 - Contemporary Iron and September 10 - October 29, 89 - John Marshall, Master Smith. A special exhibit from November 5 - December 31, 89 will be Sameul Yellin: Metalworker.

Attention Little Giant owners: The June 88 issue of the newsletter of the Appalachian Area Chapter - ABANA contained a parts list for the five sizes of Little Giant powerhammers. I understand Centaur Forge bought out all remaining new spare parts from the manufacturer when they dropped this product. For a copy of the parts list send a 25¢ stamp.

The North Carolina Tool Company (6568 Hunt Road, Pleasant Garden, NC 27313) manufacturers four closed furnace gas forges from \$330 - \$475 (plus shipping). Ad indicates they reach 2,300°F. Gas furnace/forges are also manufactured by Mankle Blacksmith Shop (7836 Cannonsburg Rd., Cannonsburg, MI 49317). Before purchasing one for blacksmithing use, insure they will obtain forge welding temperature.

Craft items wanted to stock store in a new "frontier town" of the late 1800s in a busy tourist attraction. Send inquiries and picture and description of products to NSV, Rt 1, Box 45A, Hinckley, MN 55037.

Hope all of you noticed the embossed bracelet by SOFA member Gary Ameling, Elmore, OH in the Iron Jewelry feature in the Spring 1988 issue of The Anvil's Ring. On page 29 of the same issue there is a photo of sculptural supports for driveway driveway gates created by Mark Bokenkamp (Powell, OH).

Two items from the newsletter of the Rocky Mountain Smiths. (1) An interesting book I recently came across is entitled Guns and Gunmaking Tools of Southern Appalachia, 2nd ed., John Rice Irwin, Schiffer Publishing Ltd., Exton, PA, 1983, \$9.95 (write for availability). This book details the history and development of the

southern mountain rifle and contains excellent and extensive illustrations of the tools used by the blacksmiths and how they produced these now legendary weapons. (2) To continue on with the topic of blacksmithing and gunmaking, there are two excellent video tapes available from the Colonial Williamsburg Foundation (201 5th Ave., Williamsburg, VA 23187 - 804-229-100, ext. 2818). The first, entitled "Hammerman of Williamsburg" details the typical working day of the 18th Century blacksmith. The second, "The Gunsmith of Williamsburg" details the making of the traditional Kentucky rifle from the forging of the barrel through final finishing and firing. Both tapes sell in the \$60 price range. ----- If there were sufficient interest, SOFA might purchase these two tapes and then change - say \$5.00 - per checkout until the cost was covered.

FOR SALE: 50 rolls of 3/16" fireplace curtain mesh, each 25' long, heights from 20" to 36". This is a superior mesh, much finer than the standard curtain mesh. Unable to use due to the prohibition of new fireplaces in Aspen for environmental reasons. Will sell at cost, or maybe less for the whole lot. Contact Francis Whitaker at 303-925-3844.

FOR SALE: 50 lb powerhammer, reportedly better than a Little Giant, and works great. \$600. Contact Rantanen at 303-688-9428.

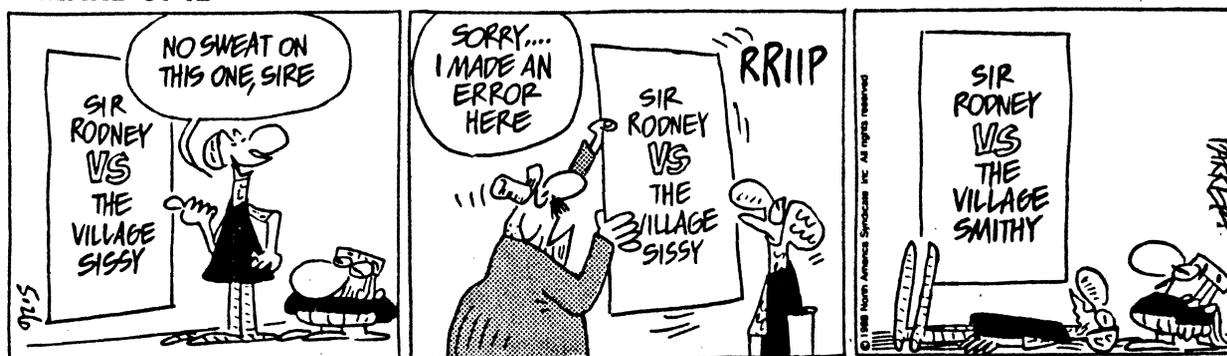
The Ohio Arts Council is accepting grant applications for their Major Fellowship Program from Ohio artists who have produced significant bodies of work and made a contribution to their artform and their community. For further information contact their Individual Artists Program at 727 East Main St., Columbus, OH 43205-1796 - 614-466-2613.

Larry Wood provided the following out of a paper, "In Russia, Jack Frost is known as Father Frost, a mighty smith who binds the earth and water with his chains".

For Vandalia's 150 birthday celebration they will put on "Pioneer Days" from October 8-9, 1988. They hope to have a number of crafts, including blacksmithing, represented along with a mountairman encampment. Location is 335 East Alkaline Springs Road, Vandalia. Contact Dick Cannon at his office at 898-5044 or home at 898-3408. Contact Ray Armstrong at 898-2157 if you need help getting equipment, etc., to the site.

American References is developing the next edition of American Artists, An Illustrated Survey of Leading Contemporaries as a reference for collectors, dealers, museum personnel and all those who follow contemporary art. There is no charge to have your contemporary work included. For further information contact them at 919 N. Michigan Ave., Chicago, IL 60611 - 312-951-6200.

WIZARD OF ID



Sir Rodney's reaction is understandable since they have him going against the local blacksmith shop! "Under the Spreading Chestnut the village SMITHY stood. The SMITH, a mighty man is he..."



AN OPEN LETTER TO ALL SOFA MEMBERS.

May 25, 1988

Dear Fellow Blacksmith:

A comparison of SOFA membership records with those of ABANA shows you are either not a member or have recently let your membership lapse. On behalf of Nol Putnam, the membership coordinator for ABANA, I would like to encourage you to either become a member or to renew your membership.

The most frequently heard complaint about ABANA membership is all you get for the money is four issues of The Anvil's Ring. I feel this view is very shortsighted since there is much work done behind the scenes to keep this revival of the blacksmithing craft going in the United States and Canada.

I started blacksmithing on my own with assistance from Larry Wood. Neither of us knew much about blacksmithing and there were few reference books or schools available at that time. A group of blacksmiths met in Lumpkin, GA in March 1973 and, as a result, formed ABANA with Alex Bealer as its first president. Encouraged by this Alex wrote The Art of Blacksmithing, now a classic book on blacksmithing. From that humble beginning, ABANA has grown to several thousand members. Frankly, if it had not been for the creation of ABANA, SOFA may not have started as a vehicle to encourage blacksmithing in the Kentucky, Michigan, Indiana, & Ohio areas (thus the term "Quad-State"). Without ABANA, blacksmiths may have become an endangered species.

As with any national organization, people are required to perform the multitude of tasks to keep it going and growing. Current and past ABANA Board Members have generously donated long hours and much cash in their enthusiasm to make this organization a reality. Your dues go to support their essential efforts, and other projects such as the ABANA library, seed monies to hold the bi-ennial national conferences, promotion of hand forged ironwork to professional builders and architects and the public in general, and support of two metalwork museums, as well as publication of The Anvil's Ring.

ABANA needs you, and SOFA strongly urges you to help in this drive to strengthen our organization and to keep this craft alive. Won't you please send in your membership dues to ABANA at P. O. Box 1181, Nashville, IN 47448 today? Cost is \$25.00 for full-time students, \$35.00 for a regular membership, \$40.00 for a family membership, \$25.00 for a senior citizen, \$45.00 for an overseas membership and \$50.00 for a contributory membership.

May your fires burn clean and your hammer strike true!

Emmert Studebaker
Director Emeritus
S.O.F.A

Creative & Friendly



National Ornamental Metal Museum

June 14, 1988

Dear ABANA Member,

On Saturday, September 24, the Metal Museum will host its fifth, annual barbecue and auction. Many of you have generously contributed your work to this important fund-raising event in the past and we hope you will lend your support again. For those of you who have never sent a piece, please consider donating one this year.

Last year's auction was an unprecedented success. Donations from ABANA members included a queen-size forged iron bed, tables, wall racks, fireplace tools, sculpture, a rose trellis, boot scrapers, candleholders, bookends, a weathervane, custom knives, a Damascus pendant, kitchen utensils, and a garden gate. Every piece, large or small, is important and deeply appreciated. In 1987 the auction raised over \$18,000 for the Museum's general operating fund. Just as importantly, all who attended left with a new appreciation for contemporary metalwork; many became collectors.

This year's budget anticipates revenues of \$20,000 from the success of the auction. Please help us achieve this goal. If you are able to send a piece, it should arrive at the Museum no later than Friday, September 9, 1988. This will give us sufficient lead time to prepare the auction program and to take photographs for publicity purposes. Please ship pre-paid. If you request, a reimbursement check will be sent to you; if not, shipping will gratefully be regarded as a part of your donation to the cause. Following the auction, each contributor will be sent the name and address of the collector who purchased his/her work.

Many thanks for your help and continuing support. In February, 1989, the Metal Museum will celebrate its tenth anniversary. ABANA members may take a great sense of pride in that accomplishment.

Sincerely,

James A. Wallace
Director

BOARD OF TRUSTEES

F. Jack Hurley
President
William R. Leonard
Vice-President
George Keeler
Treasurer
Ken Argroves
Secretary

David Brittain
March Hall
Scott Howell
L. Brent Kingston
Stanley D. Lawler
Joanne Maxwell
Sam Parrest
Mack B. Parker, Jr.
Diana Pleasants
Frank Ritchie
Ernest Wiemann
Bill Winterfield
Leon York

William Gasparini
Trustee Emeritus
James A. Wallace
Director

374 West California Ave.

Memphis, TN 38106

(901) 774-6380

- TIPS AND TECHNIQUES: These items were, for the most part, paraphrased from write ups or illustrations in other chapter/group newsletters. While all are believed to be valid, neither S.O.F.A. nor A.B.A.N.A. bear any responsibility for any adverse results which may occur on these or other items in this newsletter. Use at own risk.

- ANVIL CARE: 1. Never force a tangled tool in the hardy hole as you may break off the heel. 2. Never cut on the anvil face - use the step or a cutting plate. 3. Never use a cutting torch near your anvil. 4. Never strike cold steel on the anvil. 5. Never "blow" an anvil you care about. 6. Never treat someone else's anvil with disrespect - you may lose a friend. (By Hugh Eddy from the newsletter of the Northwest Blacksmiths Ass'n).

- DRESSING ANVIL CORNERS: In a newsletter of the Northwest Blacksmiths Ass'n, Hugh Eddy noted, "When welding anvil edges, it is essential to preheat wrought iron body anvils to about 150°F. first or you may crack the face. One may use one of the many high-impact facing rods or simply use a low hydrogen rod, the latter being softer but much easier to grind down. Go slowly being careful not to overheat the face". To preheat anvils, Steve Wooldridge over in Indiana simply waits to a hot day and sets the anvil in direct sunshine for several hours. It absorbs enough heat to weld properly.

- KAO-WOOL WARNING: With the use of gas forges and Kao-wool, there are some things everyone should know about Kao-wool. On each box from Manville and Babcock & Wilcos the following warnings are printed. Know what you are using and use it with care. "Possible cancer hazard. Overexposure to after service dust may cause lung disease (silicosis). When handling: Use a respirator during installation or tear-out; Wear long sleeve, loose fitting clothing, gloves and eye protection; Wash after handling and Wash clothes separately from other clothing - rinse in washing machine thoroughly after use." (By Thomas Richards from the newsletter of the Northwest Blacksmiths Ass'n).

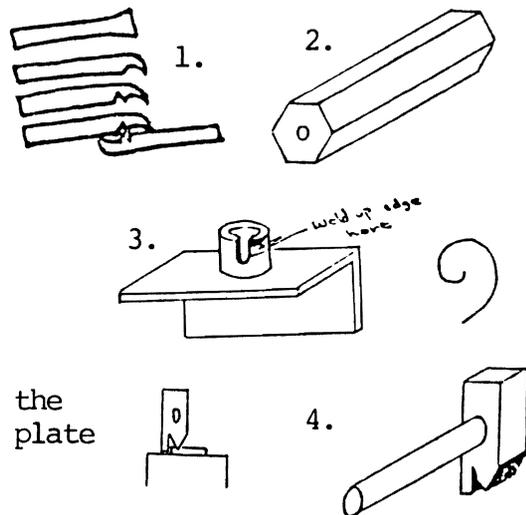
- Tips from a workshop by Bill Fiorine as reported by Hugh Eddy in the newsletter of the Inland Northwest Blacksmith Ass'n:

1. To make a cleat scarf weld, upset end, form scarf over anvil's edge, notch on hardy and weld.

2. Monkey tools are used to shoulder tenons. Use quarry rock bits which have pre-drilled holes. Anneal, drill hole to tenon size desired and harden and temper working end.

3. A scroll tool can be made by using black pipe of the proper diameter. Notch, build up one edge, and weld on plate or angle iron.

4. This edging tool makes parallel grooves. Tool design determines depth and location of groove. Work each side at the same heat to minimize distortion. (And quench tool often to avoid dulling or deforming tool - ks).



- PATTERN WELDED STEEL TECHNIQUES: By using two colors of modeling clay, you can experiment with various patterns. Fewer layers give a more distinctive pattern while many layers give greater strength. Patterns may be random or developed by twisting or by surface manipulation such as fullering or milling grooves. (From a workshop by Bill Fiorini in the newsletter of the Inland Northwest Blacksmith Ass'n).

- SHOP TIPS by Brad Silberberg (from the newsletter of the Blacksmith Guild of the Potomac):

- When straightening cold work on the anvil, use your hardie hole to allow the stock to flex far enough to stay bent. Steel, being extremely elastic, must be bent past the straight position so when it snaps back it will end up straight. It is very hard to straighten bent stock on a flat anvil face as it affords little deflection. Hold a bar over your hardie hole and hit the bar directly over the hole as you pull it to you. The gibber your hardie hole, the more bending will occur. Now try the same thing on the anvil face.

- To answer several recent inquiries about hardening spring steel - ALWAYS HARDEN SPRING STEEL IN OIL! Water quenching is too stressful for springs, which are formulated to be flexible. Water quenching can cause cracks to form along the length of a rod or bar of spring steel. Always temper springs before trying to flex them. Double tempering is even better. If a spring turns out to be too soft, anneal it before rehardening it. Spring steel is pretty good for making woodworking tools, which need to be flexible, but remember a piece of steel which has been wrapped into a coil and flexed in the front end of someone's pickup truck for five or ten years is bound to exhibit some metal fatigue when straightened out and made into a drawknife. When making struck tools, like metal chisels, use too steel. Springs are not made to be hit!

- A recent project involved the use of some cast brass rosettes of a floral design which had to be drilled and tapped on the back for mounting. A way had to be found to hold the castings face down, centered, and flat without having them 'helicopter' in the drill press. I temporarily glued one rosette face up to a steel plate, greased it, and surrounded it with a loose fitting frame of a 1½" long section of 4" square tubing. The frame was clamped to the plate and filled with molten lead. When cool, the clamps were removed and the pattern picked out of the lead leaving a perfect impression of the casting. This mold was then relieved so the rosettes would sit in it properly, but not stick. A plate was then welded to the back of the mold so it could be centered and clamped under the drill press. This system was used to drill 180 castings with only hand pressure needed to keep them in place. This method could also be used to support odd shaped work or work at an odd angle for machining by holding it in a box in the proper orientation and casting lead around it. After machining, the lead can be melted out, freeing the object. ALWAYS BE CAREFUL WHEN HANDLING AND MELTING LEAD...WEAR A FACE SHIELD AND HAVE GOOD VENTILATION! LEAD IS VERY TOXIC!

- To anneal brass when cold working, heat the brass to a low red heat (not a glowing red) and let it soak at that temperature a few seconds. Allow the brass to cool to black and then quench it in water. This will render the brass as soft as possible. Be careful not to overheat the brass or it will crack when hammered later. Bear in mind that brass melts at orange heat!

- BEGINNER'S TIP: When forging a point or taper, always start from the end of the bar. Get the tip as thin or as pointed as it needs to be first, then work up the bar. Use the anvil horn like a giant bottom fuller to draw the stock faster. When you gear is forged out as far as necessary, smooth it up at a lower heat on the anvil face. When making a round point, always forge a square point first, then break the corners to form an octagon. Finally, round the work up by turning it quickly while tapping with a light hammer as you work up the taper. Alternating turning directions often will give a rounder taper.

- WORKING WITH HIGH CARBON STEEL: Do not work high carbon steel below 1600°F. If a magnet will stick to the steel, it is too cold to work. (By Ollie Juairé from the newsletter of the Guild of Metalsmiths).

- WELDING TIP FROM WILLIANSBURG: When welding steel to wrought iron or mild steel (as for a chisel blade), heat the steel, apply borax, and allow to cool. Heat the iron, apply E-Z Weld, and return to the fire. When orange hot, remove, place the cold steel on top, and return to the fire with the steel uppermost until welding heat is reached. Borax is used for additional finishing heats. Since the steel is colder than the iron, the change in temperature necessary to bring each piece to its respective welding heat is approximately equal, lessening the chance of burning the steel. This technique can also be used in cases where differing-sized pieces of the same alloy are being welded, with the thinner piece being the one applied cold. (By Jan Kochansky from the newsletter of the Blacksmiths' Guild of the Potomac).

- THREADING TAPS: I have recently tried a different kind of threading tap, the spiral point or "gun" tap. The end has a twisted point much like a drill bit. I used these taps with a tapping attachment to my milling machine, but they work very well by hand with a tap wrench. The drill bit-like tip does most of the cutting and seems to move the chips away from the tap faster. I used a 3/8" x 16 thread tap to tap 18 holes 1 1/2" deep in 15 minutes with the mill. These taps are easier to start straight by hand, and they do not have to be backed off until the bottom of the hole has been reached. As always, use plenty of threading oil when using any tap. (By Brad Silberberg from the newsletter of the Blacksmiths' Guild of the Potomac).

- DESCALING COPPER AND BRASS: To clean fire scale off of copper or brass, use a pickeling mixture of 10% sulphuric acid and 5% potassium dichromate crystals. Carefully dip the metal into the cold solution for 5-10 seconds with plastic or wooden tongs. Then rinse and scrub with soap and a brass-bristled brush. Brass will come out looking golden yellow and copper will be rosey pink. The metal can then be buffed or left as is. These chemicals may be hard to obtain, as chemical supply houses have rules about who they will deal with. Ask a chemist friend! ALWAYS USE CAUTION WHEN HANDLING ACIDS...WEAR EYE PROTECTION AND WORK IN A WELL VENTILATED AREA!!! (By Brad Silberberg from the newsletter of the Blacksmiths' Guild of the Potomac).

- REFRESHER READING: Take the time to go back through those old newsletters and Anvil's Ring magazines (and blacksmithing books - ed.). You are certain to find some tidbit which didn't seem worth reading then, but is directly related to that project you are working on now! (By Brad Silberberg from the newsletter of the Blacksmiths' Guild of the Potomac).

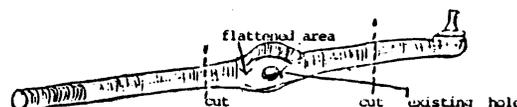
- INSIDE FINISH MIXTURE: To make a mixture to finish interior ironwork, buy a square metal gallon can of turpentine, two quarts of boiled linseed oil and enough beeswax to make about a 3" diameter ball. Pour the turpentine into another safe container and cut the lid out of the can. Make a tight-fitting snuffer lid by cutting one piece of wood which will just fit inside the can and nailing it to a piece which is cut 1" bigger all around then the opening. Now pour the oil into the can, add the beeswax and heat this flammable mix carefully (use a double boiler) until the wax is completely melted. Remove the can from the heat and carefully add the turpentine until the liquid is within 1 1/2" or so from the top. Allow the mix to cool. It should look like butterscotch pudding. When using the mix, the workpiece should be just barely too hot to hold. The mix should be applied with a rag, the piece allowed to cool for a few minutes, and then the excess oil must be wiped off of the iron will be sticky for days. Small or intricate pieces can be dipped into the mix (only at a very low heat!). Keep your snuffer/lid handy in case you set this volatile mix on fire. (By Brad Silberberg from the newsletter of the Blacksmiths' Guild of the Potomac).

- PACKED FIRE: For years, the railroad blacksmiths have used the packed fire. This fire is concentrated as well as controllable. But, the best thing is, IT MAKES VERY HARD COKE!!! It's worth looking into. First, clean everything out of your firepot, EVERYTHING! Next, put a piece of wood about the size of the airhole over the airhole. Next put DAMP, WASHED, FINES COAL, around the wood and pack it down until it is at the top of your firepot. Pack it tight!! Now open the ashgate to let the water drain. As soon as the water drains, remove the piece of wood. You should have a hole the size of the airhole surrounded by tightly packed coal. NOW start your fire in the hole with newspaper and some kindling. Keep adding COKE to the fire until you have it built up past the top. (By Ryan Johnson in the newsletter of the Appalachian Area Chapter - ABANA).

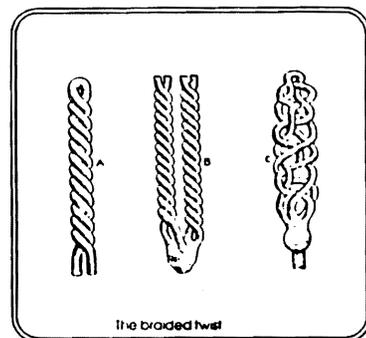
- ANVIL MAGNETS: A magnet on the anvil cuts down on the noise. However, the magnet also has another good purpose - a holdfast!!! A large magnet on the side of the heel can hold small bars, rulers, even those punches which always roll off the anvil when you need them the most. (By Ryan Johnson in the newsletter of the Appalachian Area Chapter - Ryan is a 14-year old smith, with two years experience. He writes a Beginning Blacksmithing column for this newsletter).

- BASKET HANDLES: For producing runs of fireplace tools with a basket handle, instead of forge welding for round rods or square bars to the shaft, weld them to it using oxygen/acetylene welding. Put in more weld than needed and forge it to fit the shaft. If done properly, the weld will be invisible. (From a demonstration by Jay Reakirt at the 1988 ABANA Conference).

- FORGE TOOLS FROM JUNK TIE RODS: Tie rods from cars and light trucks make good set tools for your forge work. The reasons for using tie rods are: a number of sizes to choose from, a swelled area with a hole in it (eliminating the need for a primary punching operation) and a decent carbon content for reasonable workability. Cut off the length you need for the tool and save the rest for straight tools. For the blade, etc. on the longer end. Punch hole both ways to enlarge. Flatten hole sides to make oval shaped. Upset striking end and forge thicker if desired. To harden, heat the metal to its critical temperature - the minimum temperature at which a magnet will not stick. Quench and buff until shiny. To temper, slowly heat the metal back from the edge so colors will run to the edge. We prefer a dark bronze (about 500°F) for cold chisels, and a blue-red (about 575°F) for hot chisels. If unsure of forging or heat treatment, anneal metal in wood ashes for a few hours, heat to critical temperature again, and quench. (By Joe Jay and Pat Cheatham from the newsletter of the Texas Artist-Blacksmith Ass'n).



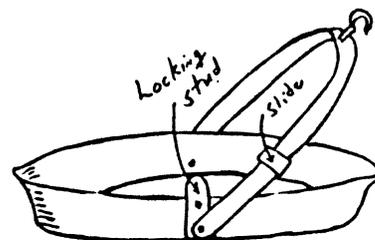
- THE BRAIDED TWIST: Four pieces of round soft steel twisted together can be used as a handle for a poker or shovel. To do this a piece of 3/16" round is cut 12" long, heated in the center and bent so that the ends meet. After hammering the two rods together, the piece is again heated, catching one end in a vise and twisting to the right with a pair of tongs. The piece is shown in Figure A. Another is made in the same manner, and the two are welded together at one end, as shown in B. If the handle is intended for a poker, a piece of 3/8" round may be welded to it, and a small collar welded at base of the tists to give it a finish. The top part may also be welded and an eye turned at the end. The entire handle is now heated and twisted to the right. It should be twisted considerably, and it must be kept straight and not allowed to get out of shape. Then the handle is heated again, and is twisted to the left until it appears as shown at C, forming a braided effect. (From the newsletter of the Rocky Mountain Smiths).



- RESTORING ANTLERS: To restore the luster to dried-out antlers (e.g., for a knife handle), soak the pieces in dissolved Potassium Permanganate crystals. Soak antlers until desired darkness. Let dry thoroughly. Then buff with white rough at 2750 rpm (or so) until high spots are buffed white. (By Larry Wood).

- KEEPING LONG TWISTS STRAIGHT: When twisting bars, if you can't use a second man to support the free end of the side you're turning, use a short length of pipe. Clamp the iron in the vise, slip the pipe over the free end up to where it is comfortable to hold it. Saves a lot of straightening. (By Carol Sakowski from the newsletter of the Upper Mid-West Blacksmiths Ass'n).

- TRI-POD SKILLET: When I was in Australia, I went to a museum and saw one of these. It had been made by a local smith to use in conjunction with a fireplace crane in a restored colonial home. Might be something for Buckskinners and campers. Cut and grind handle off a 10" or 12" cast iron skillet (available in junk shops everywhere). Use 1/8" x 3/4" strap for the bail handle which folds flat. Rivet loosely to skillet on one side only. On other side of skillet has a projecting stud with 1/8" x 3/4" slide to hold bail in upright position, or let it fold flat for storage. 1/4" round used for swivel hook at top center of handle. (From the newsletter of the Upper Mid-West Blacksmiths Ass'n). (It appears the position of the rivets need to be reversed (i.e., loose rivet at the top edge of skillet) or liquids are likely to drip out of the loose rivets - ed).



- TIPS FROM TOM SHEETS (From the newsletter of the Tullie Smith House Blacksmith Guild):

-- Avoid unnecessary cooling of your work in water because this will tend to introduce internal and external cracks in the work itself.

-- Don't wash your hands in the slack tub with soap because soap changes the ability of water to cool the work.

-- Keep your work under the powerhammer aligned with the dies because initially, when the work is hot IT will bend, but after it starts to cool, the work won't bend - YOUR ARM WILL!

-- Use tong rings on tongs made to fit the work under the hammer, DON'T TRY TO MAKE DO!

- COLD TWISTING: On occasion I've had calls for railings with twisted pickets, usually between 32" and 40" long. Since pickets this long tend to flex while being twisted lengthwise manually, I not use a piece of pipe the diameter of the picket, but two inches shorter in length. I then clamp the first inch of the picket in the vise (with copper padded jaws), clip the pipe over the picket, and use the last inch of picket for my twisting wrench. Works great, and the pickets don't end up looking like pretzels! (By Sam Jacobs from the newsletter of the Tullie Smith House Blacksmith Guild).

NOTES FROM THE 1988 I.B.A. CONFERENCE, 7-8 May, Tipton, IN:

Scott Lankton demonstrated making a Damascus-pattern billet. He started with three layers (mild, high carbon, mild) with the bottom layer serving as the handle. He forge welded the layers, drew them out and cut the billet into three pieces. He said he prefers three layers instead of the normal two here since it increases the layers faster, a seam would not be in the exact middle of the final billet and the welding heat penetrated better as the layers were thinner. During two folds (the second and fourth I think) he inserted thin

pieces of nickel. When cleaning off the scale for forge welding, he put water on the anvil top and used a hammer from a bucket of water. This, in effect, steam blasted off more scale than could be removed with a brush.

Clifton Ralph provided the set-up used by Nol Putnam to demonstrate. As a portable leg vise, he welded a plate to a piece of stock to fit the hardy hole and then attached the leg vise through its normal mounting holes to this plate. The bottom of his anvil stand had a pipe for the bottom leg of the vise to fit into. When he needed the vise, he merely dropped it into the hardy hole and the bottom piece of pipe. He had a heavy anvil stand, but, even then, the ability to hit sideways was somewhat limited. Interesting idea though for demonstrating purposes where sinking a post is not practical. Plate had a channel effect to it.

Clifton had also made adjustable bending forks by attaching hardy hole stock to the back of a monkey wrench head to fit into the hardy hole. The inside jaws (smooth - no teeth) were rounded to avoid scoring the material being bent.

Nol was using the standing twisting wrench made from one piece of leaf spring. Clifton suggested the handle be put in the middle of the inside leg to help avoid distorting while twisting. Nol agreed but pointed out it could be difficult to work inside a tight pattern if you had to go over another piece with this method.

I forgot to note his name, but one displayer had made a fireplace poker by using a railroad spike with a pineapple twist as the handle. It was forge welded to 3/8" square stock. Another use for those spikes. Looked nice.

Nol said he was considering using blind rivets (the head on only one side of the stock) by drilling the holes, dropping in a short piece of copper brazing rod, inserting the rivet and then heating the area up to braze the rivet into the hole. There would not be stress on the rivets, he merely needed to secure them in the holes.

Kurt Fehrenback, from the I.B.A. group, was demonstrating hands-on blade making from files. He made a nifty clamp for the leg vise by cutting a C-clamp in half and then welding the top half to a piece of stock about 1" x 1 1/2" x 6". This piece was put into the vise and the stock (e.g., blade to be filed) secured by tightening down the normal C-clamp screw. No marks were left on the stock being filed but someone pointed out that leather could be put on the screw pad and bottom plate if doing really soft work.

Nol demonstrated brass inlay work by putting a chisel mark in hot stock and then undercutting the cut to both sides at about a 45° angle slightly. This put a key-way effect to the groove. He then tapped in a length of brass electrical wire and filed the top smooth.

Nol recommended putting a short length (e.g., 1") of garden hose on both sides of the leg vise handle. This prevented pinching fingers and rounding out the hole in the screw end.

For a knife blade sander, Scott merely puts his powered hand-held belt sander in the leg vise.

For those using five gallon plastic buckets as water tubs (and have burned through the bottom of them), Clifton solves this problem by cutting a metal plate to fit the bottom. He used about 1/4" steel but sheet metal could also be used.

* * * * *

HEAR YE! HEAR YE! HEAR YE! (Continued)

While your Editor doesn't claim to be much of a welder, I do have a welding machine and disk grinder. If your anvil needs its edges dressed, call and see what we can work out.

FOR SALE: Many sizes and types of tongs, anvils, tools, etc. Also have post drill, forge blower, hot shear. Send large SASE for list. Tom Rutkowski, 18062 Hamburg, Detroit, MI 48205 - 303-526-7201 after 7:30 PM.

POSITION AVAILABLE: Master blacksmith at Ohio Historical Society's Ohio Village near Columbus. \$7.18 - \$7.57 plus excellent benefits and incentive pay. Contact Steven Henthorne, 1985 Velma Av., Columbus, OH 43211 - 614-297-2300 for more info.

Special thanks goes to John Baker and Owen Vance for bringing ice tea and lemonaid to the July meeting. Due to the temperature, it was greatly appreciated by all.

Final reminder to please, pretty please, register for Quad-State in advance as it makes the registration process go much smoother.

MEMBERSHIP APPLICATION

ARTIST-BLACKSMITHS' ASSOCIATION OF NORTH AMERICA

Membership in ABANA includes a subscription to The Anvil's Ring.

New Member _____
Renewal _____

Name: _____

Address: _____

City: _____ STATE _____

Phone: () _____ ZIP: _____

Practicing Smith _____ Artist _____ Teacher _____

Student _____ Amateur _____

- Full-time Student...\$25.00 per year
- Regular Member.....\$35.00 per year
- Family Member.....\$40.00 per year
- Senior Citizen.....\$25.00 per year
- Overseas Member.....\$45.00 per year
- Contributory.....\$50.00 per year
- Library Sub.....\$25.00 per year

(Please remit in U.S. currency)

CHECK MUST ACCOMPANY APPLICATION

Mail to: A.B.A.N.A.
P.O. Box 1181
Nashville, TN 47448

Comments:

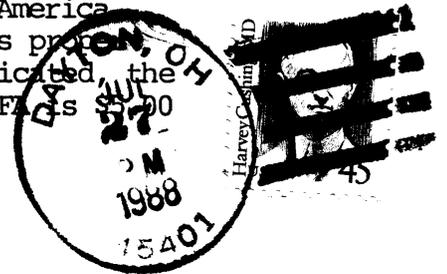
SOFA SOUNDS is the bi-monthly newsletter of the Southern Ohio Forge and Anvil (SOFA) Chapter of the Artist-Blacksmith Ass'n of North America (ABANA). Non-copyrighted material may be reprinted as long as proper credit is given to the original source. Unless otherwise indicated, the material herein was provided by the Editor. Membership in SOFA is \$5.00 per year payable to S.O.F.A. in care of the Editor.

SOFA SOUNDS
c/o Ken Scharabok, Editor
P.O. Box 33399
Dayton, OH 45433-0399

Dick Franklin
7158 Klyemore Dr.
Dayton, OH 45424

6/89

NOTE: Your SOFA membership expires with the date on your label.



FIRST CLASS

