



SOFA SOUNDS

SOFA
SOUTHERN OHIO FORGE & ANVIL

AUGUST/SEPTEMBER 1986

Artist-Blacksmiths Association of North America

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Ken Scharabok (513-252-3001)

MARK YOUR CALENDAR: Unless otherwise indicated, all meetings will be held at the Studebaker Homestead on Rt. 202, four miles north of I-70. Guests and the public are welcome. Bring items and tools you have made for display. Donation of items for the newsletter support raffle are always welcome. Please don't park on the grass, there is ample parking around the production buildings, but please don't block driveways or interfere with plant operations.

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| August 2nd, 1 PM | BUSINESS MEETING followed by a workshop lead by Ron Thompson on making an old-fashion beaver trap. Teams will be picked at random to work on the various pieces with final assembly. |
| August 13th - 17th | 1986 ABANA NATIONAL CONFERENCE at Flagstaff, AZ. This one should be well worth the trip. Plan your summer vacation around this event. Flagstaff is about an hours drive to the Grand Canyon. |
| September 6th, 1 PM | BUSINESS MEETING followed by a demonstration on making tenons by Hans Peot. Among others, Hans will show how to make square tenons at an angle such as were used in the Homestead Gate. |
| September 27th & 28th | 1986 QUAD-STATE BLACKSMITHING ROUND-UP. |
| October 4th, 1 PM | No meeting this month due to Round-Up. |
| November 1st, 1 PM | BUSINESS MEETING followed by a demonstration to be announced. Call Ken Scharabok if you would like to volunteer as the demonstrator. |

MEETING NOTES:

The June 14th meeting was sparcely attended, probably due to the wonderful weather that day and one week delay.

Item covered during the brief business meeting were:

The Treasurer gave a report on the operating year financial condition. The group essentially broke even, not considering the investment placed in the building fund from the last Round-Up. A copy of the fiscal year report can be obtained by sending a 22¢ stamp to the Treasurer.

Creative & Friendly

The Brukner Nature Center needs a blacksmith demonstrator for the weekend of July 12th.

Demonstrators are needed for the Studebaker Family Reunion to be held at the homestead on July 19th and 20th.

Photos from the Whitaker Gate Workshop were passed around. The group broke even on the workshop cost.

Your editor managed to mislay the notes on who won items during the newsletter support raffle. It did bring in \$28.50 for this purpose. From memory, Rushsylvania member Ralph Van Buskirk won a beautiful Clayton Knot firepot poker donated by Lima member Bud Rolston. Wapakoneta member Scott Murray sent in \$5.00 for the raffle and won two items, one of which was a wrench donated by Spring Valley member Bill Fleckenstein. Emmert Studebaker donated a chisel. Several others won small items, most of which were donated by Bill Fleckenstein. Thanks to all who donated items even if I cannot specifically identify you.

Neither of the scheduled demonstrators were able to attend. Dick Franklin did a brief demonstration on various twists while one section of the gate was used to describe how the twists in it were made.

* * * * *

A small group of members met on June 14th to work on the gate. We finished the collars and riveted the bars to the frame on one gate section. When the gate is finished, before those who didn't help on the gate critique it, I would like to relay the story of how the angel got to be placed on the Christmas Tree:

It seems they were having a Christman Party in Heaven and many of the Heavenly hosts were decorating a tree. However, there was this one little angel who nothing anyone did pleased her. "Don't hang that bulb on that branch, it would look better on the next one", "Don't hang the lights there, go in the other direction". This went on and on until the tree was finished. The little angel then said, "Well, now that you finally have it finished, were are you going to put it?".

We essentially completed and test hung the two gate halves on July 10th. Still to be finished are the scrolls on top of the gate halves, a closing latch and putting in textured relief to the cut-out figures in the ovals. Our goal was to have the gate halves hung for the Studebaker Family reunion on July 19th & 20th. To achieve this Hans Peot, Ham Hammond, Dick Franklin, Larry Gindlesberger and your Editor worked Tuesday and Thursday evenings and some Saturdays for about two months on the gate. I can't speak for the others, but I learned more about blacksmithing while helping on the gate than in the books I've read or demonstrations I've seen to date. It was an excellent educational experience.

* * * * *

At the June 12th Board of Directors/Officers meeting, the primary item discussed was group liability insurance. Due to a combination of low renewal rates and the insurance situation in general, ABANA has had to drop liability insurance coverage for the Chapters. The group officials directed the Secretary/Treasurer to obtain a formal liability insurance quote to cover the monthly meetings and the Quad-State Round-Up. The other major item discussed was the Quad-State. Everything is more or less in place except for a formal list of volunteers to assist during the event (particular set-up on Friday morning and clean-up on Monday morning). Volunteers will again receive a break in the registration fee. All of the primary demonstrators are expected to be on hand for the Friday evening informal session. Tongs competition challenges have been sent out to the blacksmithing groups in KY, IN & MI. If you are interested in being on the SOFA team (two people), contact Ken Scharabok. First

rough fourth place prizes are \$50/\$25/\$15/\$10 for the team. The competition will be making a pair to tongs to hold 3/8" flat stock and round stock judged on speed of completion and quality. Should be a rather interesting event on Saturday evening.

The raffle brought in an additional \$38.00 to support the newsletter. Dayton member Art Holz won a 24" metal rule donated by Findlay member Dave MacDonald. Mt. Blanchard member Ed Hulihan won a large meat fork donated by Rushsylvania member Ralph Van Biskirk. Emmert Studebaker donated three boxes of cut-off metal lengths from his bandsaw. These were won by New Carlisle member Richard Knopp, Spring Valley member Dave Buehrle and Dave MacDonald. New Carlisle member Hans Peot won a soapstone marker donated by Kettering member Ham Hammond. Waynesville member Dennis Hoffer won a bag of miscellaneous nuts and bolts donated by Spring Valley member Bill Fleckenstein. Dave MacDonald won a pair of large tongs. Dayton member Joe Abele won two old files, Dayton member Ken Scharabok won a cold drink plastic can holder donated by Dayton member Owen Vance and Huber Heights member Dick Franklin won a can of iron filings for making his own E-Z Weld-type flux.

Dave MacDonald gave an excellent horseshoeing demonstration. Dave is a farrier rapidly turning into a full-time blacksmith, as he now limits his farrier work to race houses. I had never seen a horse shod before, which was apparently the case with many of the others attending. Judging from the comments afterwards, this was one of our best demonstrations this year. Dave has a way with horses (he apparently calls all of them Wilbur) and is an excellent demonstrating instructor. I'm not about to run out and enroll in farrier school, since it looked like a lot of work, but it sure was nice to finally see how it is done.

Several observations on Dave's demonstration:

- Dave recently purchased a small LP gas forge from Mankels Blacksmithing Supply (7836 Cannonsburg Road, Cannonsburg, MI 49317 - catalog \$1.00). He said he really loved the forge for working with small pieces of metal such as horseshoes and hooks, as you can leave in the pieces without worrying about their being burned. He highly recommends this type of forge for small item production work. His small anvil is also from Mankels.

- Dave used 1/4" x 3/4" x 12" stock to make the demonstration shoes. To make the first bend he put the far end on the anvil horn and bent it in a downward shaped bow before putting it over the horn bow down to complete the shape. This is opposite from bending metal downward over the horn. On the second and third bends to complete the horseshoe shape, Dave moved the metal and hit the same area of the horn rather than trying to follow the metal around the horn.

- To mark the hot metal for punching, Dave used a silver pencil. He commented that often the mark could be seen even on the reheated metal and that it worked much better than soapstone.

Again, it sure was an interesting demonstration. I would like to thank Emmert Studebaker for arranging for borrowing a horse from his niece, Pam Erisman of New Carlisle. The horse (an Arabian) behaved well except for the one time Dave had to "speak" to it to show it who was boss. We noticed that horse readily cooperated thereafter. You may have seen a picture of this horse in the Dayton paper. Remember a picture of a horse with "4-sale" painted on the hind quarters - well, this is that one. A beautiful horse.

ADMINISTRATIVE ANNOUNCEMENT:

Ye Editor will be on vacation from August 7th through September 14th. Am going to the national conference and then out to the West Coast from there. Thus, if your membership is up for renewal, please make payment before I depart if possible.

NOTES FROM THE KENTUCKY BLACKSMITHS ASS'N CONFERENCE, May 10, 1986:

- Damascus Pattern-welding (Guy Vinson, Louisville, KY):

-- A good flux for forge welding blanks is the glass flux used by glass workers.

-- An interesting pattern can be made by cutting a completed billet in half lengthwise, twisting each side tight in the opposite direction (accepting an uneven twist pattern), rewelding it to the rod handle and then forge welding the two halves back together.

-- It is better to acid etch with a weak solution longer. He usually uses sulfuric acid ratio of five parts water to one part acid with at least an overnight soaking.

-- You can start with three layers (mild/tool/mild) as easy as five or more. You just have to forge weld more often to get the desired number of layers.

-- Bold patterns (few layers) can be just as attractive as many layers.

- Tool Making (Jim Batson, Huntsville, AL):

-- Jim described himself as a "Thermo-mechanical manipulator of ferrous material".

-- The three most important pieces of equipment in a blacksmith shop are the forge, anvil and postvise. Get the best available you can afford.

-- To keep postvise jaws in alignment when working with a piece at one side only, he uses "top hats" which are "T" shaped pieces of various thicknesses.

-- When working on a piece, heat it past the area to be worked to keep heat in the metal longer.

-- There are two things a good blacksmith can't forge weld - the crack of dawn and a broken heart.

-- Don't avoid cold rolled metal just on the name. Some (e.g., 1012 or 1016) is very close to the old wrought iron in carbon content and working ability. Due to the low carbon content, you can forge weld it at a higher temperature. As long as it doesn't contain sulfur or some other additive for machining qualities, give it a try.

-- Two of the things which will send a blacksmith to hell are hitting cold metal and not charging enough for their work.

-- Truck axils make good hammer heads (probably 4140) but need to be oil quenched.

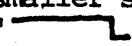
-- For the hammer head demonstrated, he used a bar called "flute-a-gon" since the four corners of the square bar (1 1/2" x 1 1/2") were fluted. Apparently it is a German-manufactured metal with a carbon content under 1%.

-- There are three basic ways to make tongs:

--- The classic method uses square bars (e.g., 5/8" x 5/8" or 3/4" x 3/4"). The CORCIA book on basic blacksmithing has a good section on this method.

--- You can use rectangular stock such as 3/8" x 3/4". Fuller on one side about one inch from the end and on the opposite side about two inches from the end. On the first fullered area, round off the sharp edges and twist it 90° in one direction. At

the second fullered area draw it down for the rein. The area between the two fullered areas is the pivot/rivet area. When making the second one, be sure to twist the jaw area in the same direction as the first half.

--- To make tongs out of smaller stock, you have to upset the pivot area. Form the end of the bar into a "  " shape with the middle part about 2" long. Heat the middle area to a high heat and upset it for about half the length. This area can then be flattened for the pivot area.

-- Francis Whitaker says that tongs should be made out of smaller stock than the material to be handled (i.e., out of 5/8" to handle 3/4").

-- For holed tools out of smaller stock, the hole sides should be as fat as possible. This usually means slitting and spreading rather than punching.

(NOTE: The Louisville folks present said that 1/4" to 1/2" square bars (cold rolled, 1012 or 1016) are readily available in that area from new/used metal dealers).

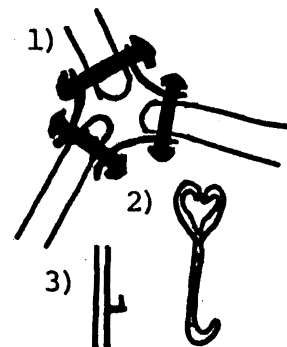
REPORT ON THE NORTHWEST OHIO BLACKSMITHS ASS'N MEETING:

The first meeting of the Northwest Ohio Blacksmiths (NOB) Ass'n occurred on June 17th, at the Seven Eagles Lodge south of Grand Rapids (near Akron). Many of those attending are also interested in blackpowder shooting/buckskinning so several brought along teepees and other primitive sleeping quarters.

This meeting was intentionally unstructured in that they had several open forges and participants were invited to step up and demonstrate something for the other folks. Don Witzler made several cable knives, making it look easy. He said the secret is in heating the cable for a while first to remove impurities between the strands (grease, etc.), not overheating the metal (its a fairly high carbon steel), liberally fluxing with borax and to do the forge welds on a small anvil on the forge top. Another participant (I believe Bill Hans), did a basket twist inside of a basket twist - in the opposite direction. I didn't see this demonstration but I understand he started with four strands, forge welded the two ends, and then twisted it tight in one direction. When straightened, it was surrounded by other strands and these were forge welded to the first piece and each other. The second group of strands were then twisted in the opposite direction and opened up. Tightening the second strand bundle opened up the first bundle. Anyone want to demonstrate this at one of the SOFA meetings?

Sunday NOB was officially organized with Don Witzler as the initial President. In order to support this organization and blacksmithing in the northwest Ohio area, SOFA and NOB will be having joint meetings on the third Saturday of every other month, starting in July. This is in addition to our regular monthly SOFA meeting. It is hoped that this will give SOFA members in the Lima/Findlay/Akron area access to blacksmithing events.

One of the campers had the nicest fire tri-pods I have seen. The legs were made out of 1/2" stock about 40" long. The tops were drawn out and bent over into the typical goose-neck shape with a short, protruding lip. What made the tri-pod unique was the manner in which the tops were put together. He had made clips about 2 1/2" long slightly bent at both ends. These were attached to the top loops using rivets. This way the legs fold into a compact bundle and set up easily.- see Illustration 1. To hold a coffee pot or kettle over the fire a hook fit down through the opening at the top (I-2). About 8" from the bottoms of the legs he had added a clip (I-3) to hold a grill made out of strap material (about 1/8" x 1") with rods inserted through and riveted over (I-4). The grill



appeared to be about 18" on a side, large enough for a coffee pot and large skillet. When the grill was put up on the clips on the legs, the entire stand was fairly stable. I believe he used a length of chain with a hook on one end to adjust the height of the vessel while hanging on the center hook.

Don Witzler had another clever idea for a fireplace grill which he said dates back to the Revolutionary War. A piece of banding about 3/16" x 1" had been woven back and forth to form a grill area. To attach it to the post one end was worked around the post like a ribbon. The grill could be adjusted to any height since, as soon as it was let go, the post would bind in the ribbon area holding it at that height. He said that soldiers used to make these out of old barrel hoops.

MANUFACTURE OF DAMASCUS-PATTERN BARRELS:

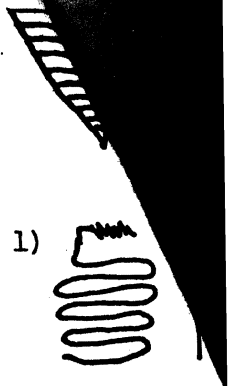
The following article was submitted by Dayton member Al Holz. He noted in the cover note, "I have become a collector of Damascus blade folders (pocket knives). I was showing them to a friend when he asked me why I suddenly became interested in Damascus? I went to my file and pulled out this article from the April 1949 issue of The American Rifleman. I thought it might be of interest to some of our members."

"The Damascus and laminated steel barrels which became popular in the last half of the eighteenth century were made in a unique manner. The entire process for two- and three-iron Damascus barrels is pictured above (to the right). The stages in manufacture are illustrated on the opposite page (also to the right) and described in W.W. Greener's The Breachloader and How to Use It (London, 1892) as follows:

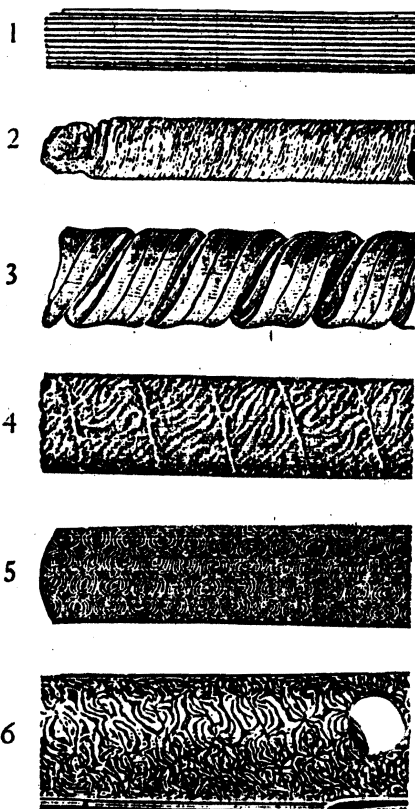
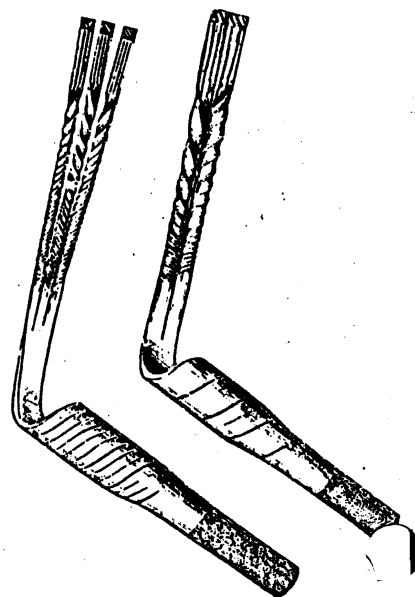
The iron for the manufacture of gun barrels was formerly made from scrap and old horseshoe nail stubs. The modern way of preparing the metal for gun barrels is to make the whole from new metal, as follows: Bars of prepared steel and superior gun iron are placed together in fagots alternatively, then heated to welding heat in a furnace, and placed under a tilt hammer, and welded into one bar (Fig. 1), which is passed through rolls and cut into pieces; then go through the same process of hammering and welding again. The best metals made by this process are laminated steel and fine Damascus, the former containing a larger proportion of steel. The Damascus and laminated barrels differ only in the way that the iron and steel are put together in the first process.

For the cheaper or single-iron Damascus, a square rod is taken about four feet long and five-eighths inch thick, and placed in a forge fire until about eighteen inches of the rod is brought to a red heat, when one end is thrust into a square hole in a block made fast to a frame, and the other end fixed into a moveable head at the other end of the frame. A rotating motion is then given to the movable head by means of a winch handle and cogwheels. The rod, being square, cannot turn round with the head, so is twisted on itself (Fig. 2).

4)



1)



The cheaper quality laminated steel, which is also known in the trade as single-iron Damascus, is made by drawing out this one rod into a riband, which is afterwards coiled on a mandril and welded together (Fig. 3 shows three-iron Damascus after twisting on mandril ready to be welded). The illustration (Fig. 4) shows the figure of the barrel when finished. The next quality is two-iron Damascus or laminated steel, made from two twisted rods, each three-eighths square, and welded together and rolled into a riband, with the twisted spirals in opposite directions, as shown (Fig. 5).

Three rods are used, and welded in the same way for the best barrels (Fig. 6). This is the favorite number for English barrels. Sometimes, but rarely, four rods are used. Three rods made a very much finer figure than either one or two rods.

In Belgian barrels as many as six rods are sometimes used (Fig. 7), but the over-twisting rends apart the fibers of the iron and the rods are weakened thereby."

Another article on these pages addressed the risks incurred in using modern loads (smokeless powder) in Damascus and laminated shotgun barrels. Apparently this was quite a problem around this time.

A.B.A.N.A. NEWS! (From the April 30, 1986 PRESIDENT'S MESSAGE by Stan Strickland):

"April has been very busy for the Board and the Financial Advisory Committee. I do hate to bring negative news to you, but A.B.A.N.A. is your organization and you should know what is happening. A.B.A.N.A. is having a rough time financially. We continue to see a drop in membership and rising cost of everything we do for the membership. Membership stands at the same number it was two years ago and continues to shrink with each dues billing. A.B.A.N.A.'s income is 99% derived from membership dues and non-renewal means we will be forced to cut some services now offered. This is no longer just a possibility that we will have to cut back. It is my duty as President to advise you that you will see some drastic cuts in the very near future. As an example of our plight, we can count on only \$22.00 per member average, due to the different classes of membership. The rising cost of producing and printing of The Anvil's Ring alone now accounts for \$26.24 per member. You don't need a calculator to figure we cannot operate long at this rate."

"It was evident a year ago that A.B.A.N.A. needed to increase its base of dues paying members and an extensive program of increasing the membership was placed in operation. I am sorry to report that after a year of increased mailings, additional items for sale, and personal attendance at blacksmith meetings to promote A.B.A.N.A., the net financial return was negative. At this writing, all efforts are towards increasing the membership and relieving the financial problem."

"Aside from money matters, we are also having problems with the insurance companies (twelve to be exact). It seems that A.B.A.N.A. will no longer be able to insure the Chapters. The insurance companies will not insure a risk they cannot define and A.B.A.N.A. is having difficulty getting insurance at any cost."

If you would like to contact Stan on any A.B.A.N.A.-related matter, his address is 1147 Dantel Court, Stone Mountain, GA 30083. Stan recently left industry to devote his efforts full-time to A.B.A.N.A. and blacksmithing.

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Who has the demonstration tapes? Please return them so they can be passed on to the next person on the viewing list. These are VHS tapes of demonstrations at some of the SOFA meetings.

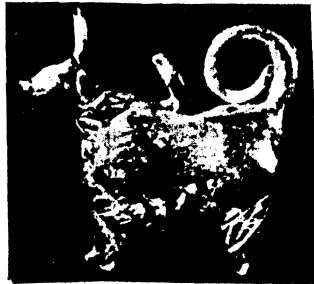


HEAR YE! HEAR YE! HEAR YE!

In the "It's worth whatever someone will pay for it department", your Editor recently spent a couple days down at Gamburg. In one knife/gun shop, there was a post vise with 3" jaws and no mounting bracket or spring. The price tag attached read "\$300.00". No kidding! I went back to double check! Shop operator wasn't there so I couldn't ask if it was made from platinum or some other exotic metal. Other blacksmithing-related items in some of the antique stores were a bit high, but not that high. Only Damascus pattern-welded blade noted, at a different shop, was \$650 (without finished handle) - marked down from \$1,000. Blade wasn't even that nice.

Owen Vance sent me a copy of his company's (Aerobrazo) newsletter with an article noted.

This pendant was found in an Iranian grave and dated to about 4,000 BC. Measuring only .6" long, the dog and holding ring attached to its back are made of basically the same material, .95% to .97% gold, 1% to 2% silver and .2% to .4% copper. However, the point where they are joined has substantially more silver (20%) and copper (5%). Evidently, the ancient artisan who created this piece understood that alloying metals reduced melting temperature and made brazing (soldering) a reality.



The national office announced the death of two long time ABANA members. Dr. Calvin T. Smith passed away on June 9th. He had served ABANA as President during the early days and was responsible for the highly successful ABANA national conference in Greenville, SC. Joe Hansberry of Murfreesboro, TN passed away on May 27th after a long illness. Mr. Hansberry, 84, was a life long blacksmith and for years Resident Blacksmith at Cannonsburg Pioneer Village in Murfreesboro. He was a long time member of ABANA and the Appalachian Area Chapter.

The Illinois Valley Blacksmith Ass'n is planning a group travel package to the Flagstaff Conference via AMTRAK. Roundtrip fare is \$239 per person. Departure is August 11th from Chillicothe, IL. Return is Tuesday, August 19th. For further info. contact: Bill Kaufmann, RR #2, Danvers, IL 61732 - 309-963-4906 or Rich Smith, 103 Green Leaf, Bloomington, IL 61701 - 309-662-4587.

BLACKSMITH WANTED: The John Deere Historic Site, Grande de Tour, IL needs a blacksmith to work in their blacksmith shop during the summer of 1987. Would like someone with good blacksmithing skills who is able to relate to the public - about 40,000 - 50,000 visitors annually. Would prefer someone in their 20's or 30's. Salary and expenses are negotiable. For further info. contact John F. Coy, John Deere Foundation, Moline, IL 61265.

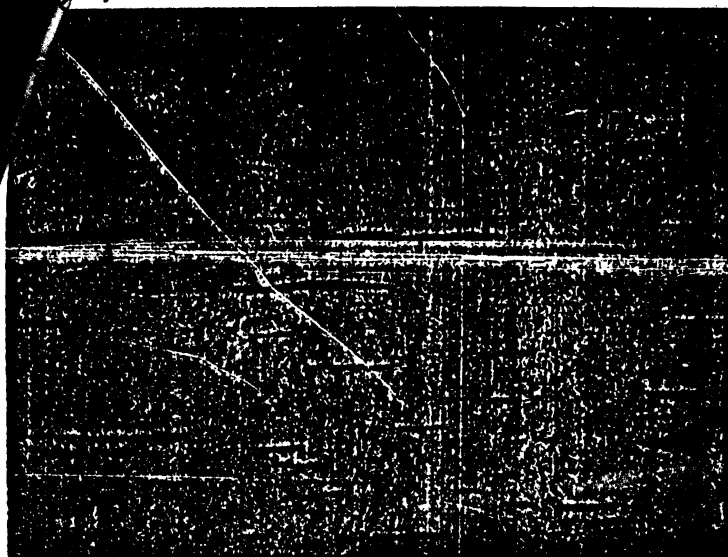
DEMONSTRATORS WANTED at the South Park Summerfest '86 on Park Drive Blvd. off of Wayne Avenue, August 17 from noon to 7PM. \$15.00 booth space fee. For an application contact Summerfest '86 Committee, 424 Hickory St., Dayton, OH 45410 - 513-461-7102.

BLACKSMITH WANTED to produce a line of early American decorative wrought iron accessories at the Cambridge Village Forge, c/o Rowe Pottery Works, 404 England St., Cambridge, WI 53523. Full-time position. Benefits and salary depend on experience.

BLACKSMITH WANTED to run a completely equipped shop. Write to Art Barber, Charleston Forge, Rt. 6, Box 41-A, Boone, NC 28607 - 1-800-331-7025. Applicant should be a good, steady, artistically capable blacksmith able to organize and train apprentices for production work. Compensation based on experience and ability.

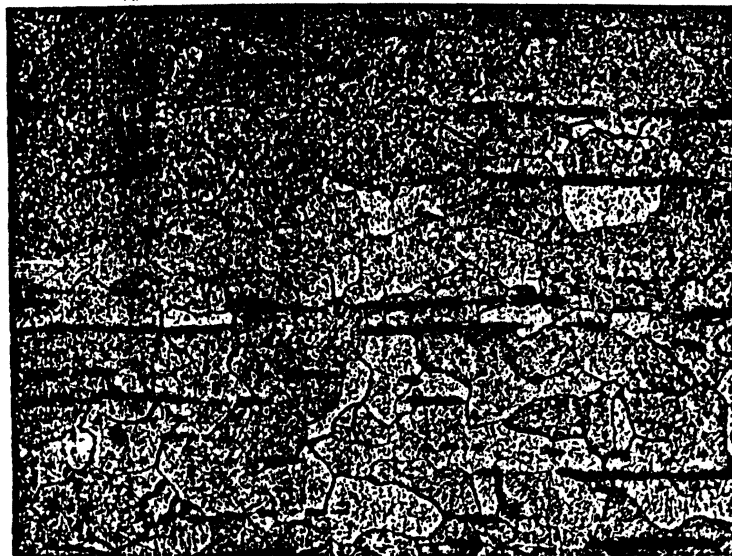
FREE: About 40' of 1/2" wire cable. You remove from fill dirt. Jane - 426-1903.

Wrought Iron



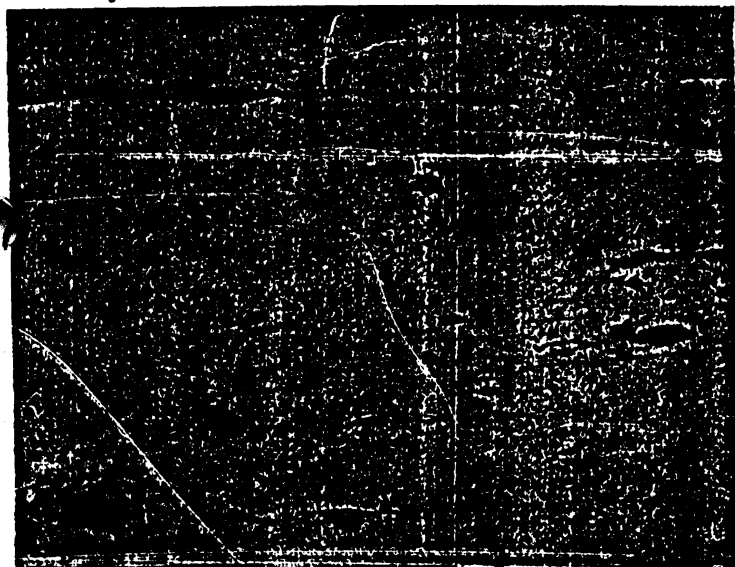
50 X - unetched

Wrought Iron



100X - etched

Wrought Iron Wrench



50X - unetched

Wrought Iron Wrench



100X - etched

AN ANALYSIS OF WROUGHT IRON:

As a follow-up to the metallographic analysis he did in the 4/86 newsletter, I asked Ron Thompson to look at two pieces of wrought iron. The first (upper photos) is a piece of the wrought iron used at the Conners Prairie Workshop. The second (lower photos) is an old wrench clearly showing the distinctive layering of wrought iron.

Ron commented that wrought iron is a commercial iron consisting of slag (iron silicate) fibers entrained in a ferrite matrix. It was made by mixing together slag and relatively pure iron. In the hot worked condition, the slag becomes elongated, thus promoting considerable anisotropy. The toughness of wrought iron is very good if the crack is perpendicular to the fiber axis but very poor if it is parallel to the fiber areas. He also noted that the grains of ferrite showing orientation streaks of SiO_2 (slag) could be seen in the right hand photos. Cuttings from the wrench tested out at 0.095% carbon, less than half that of today's mild steel.

Dave MacDonald (3515 Springlake Dr., Findlay, OH 45840) has additional 24" metal rulers for sale at \$20.00 each plus \$2.00 for S&H. If you have priced this quality of ruler, this is an excellent price. Dave will have them for sale at the Round-Up while his limited supply lasts.

Roger Krass (53 Laura Ave., Centerville, OH 45459 - 433-7221) is organizing the blacksmithing demonstration portion of the Ohio State Fair (1-17 August). He needs a couple of more demonstrators to complete the schedule, particularly on August 13th. Also, if you have items you would like to send over on consignment (consignment fee negotiable), also contact him.

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 me a 22¢ stamp.

The next meeting of the Kentucky Blacksmith Ass'n will be September 6th in Morehead, KY. The K.B.A. has decided to hold semi-annual gatherings with probably several demonstrators. For further information, contact James Clay, P.O. Box 545, Morehead, KY 40351 or Craig Koviari, 147 Stevenson Ave., Louisville, KY 40206.

Norman Larson (5426 Hwy. 246, Lompoc, CO 93436) has issued a new brochure on the out-of-print blacksmithing books he has available. For a copy send him a 22¢ stamp.

THE STURDY BLACKSMITH: (The following was recited by Mrs. Craig Kaviar at the last K.B.A. meeting. I believe she said it was from a work of Mozart.)

Oh, the Blacksmith's a fine sturdy fellow. Hard his hand, but his heart's true and mellow. See him stand there, his huge bellows blowing, with his strong brawny arms free and bare. See the fire in the furnace aglowing, bright its sparkle and flash, loud its roar.

Blow the fire, stir the coals, heaping more on; till the iron's all aglow, let it roar on! While the smith high his hammer's a-swinging, fiery sparks fall in showers all around. And the sledge on the anvil is ringing; fills the air with its loud clanging sound.

Let the blows, strong and sure, quickly falling; hast the work, for the iron fast is cooling. Oh, the smith he's a fine sturdy fellow! Bravely working from morning til night; hard his hand, but his heart's true and mellow. Like his anvil, he stands for the right.

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SOFA SOUNDS
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1135-6 Spinning Rd.
Dayton, OH 45432-1641
513-252-3001

Dick Franklin

NOTE: Your SOFA membership
expires 6/87.

*Ye Olde Village Blacksmith
A Mighty Man Is He*

*Beneath The Sprawling Chestnut Tree
An Artist In Ironcraft Is He*

24 July 1986

To: SOFA Board of Directors/Officers

Subj: Attached ABANA Correspondence

I received a phone call from Jim English last evening. He pointed out that we apparently misunderstood his letter in that it was not selling calendar space and asking for how many of the calendars we wanted delivered to sell. Rather it was an offer to front end finance the calendar printing with the opportunity to recoup the \$200 cost by receiving 50 free copies of the calendar for resale with further copies available at \$2.00 each for chapter sales. Thus, if we sell 50 copies of the calendar (as we have the last two years at \$4.00 each), we would breakeven on this transaction.

I recommend we reconsider this offer and sponsor a month (September preferred). The photo for the month can be the Studebaker Gate.*

We need to discuss this at the next Board/Officer meeting at 12:00 AM before the next meeting on August 2nd. We are also trying to have the Quad-State registration brochure ready for assembly before the next meeting. If it is ready, we will put it together at 10:00 AM, also on August 2nd.

Respectfully,



Ken Scharabok
SOFA Secretary/Treasurer

*Jim would need a B&W 8½" x 11" photo and negative. We would need to include this cost in our consideration also.



July 14, 1986

Mr. Jim English
c/o Cedar Creek Forge
N70 W6340 Bridge Road
Cedarburg, WI 53012

Dear Mr. English:

On your recent mailing concerning the 1987 ABANA Calendars, please send only a consignment of 50 of them to our group. This seems to be about all we can sell locally, based on sales the last two years.

They can be sent either to the Chapter President or myself at the below address.

Respectfully,

Ken Scharabok
SOFA Secretary/Treasure
1135-6 Spinning Rd.
Dayton, OH 45432-1641

Creative & Friendly

ABANA CALANDAR--1987

"BLACKSMITHING IN NORTH AMERICA" is the title of the official 1987 ABANA CALANDAR. Devoted exclusively to the North American Blacksmith, the calandar will promote blacksmithing activities and events.

The front cover and twelve monthly pages will feature pictures of blacksmithing activities. Each 8 1/2 x 11" feature picture space will be sold to advertisers on a first come first serve basis at the rate of \$200.00 per single Calandar month. The ad sponsor of the monthly feature picture may list up to ten insertions through out the year to promote any blacksmithing event or function in North America. Each subscriber will receive 50 copies of the calandar which can be sold at the suggested retail price of \$4.00. each and thereby recoup the \$200.00 investment.



INDIVIDUAL LISTINGS: Chapters, clubs, schools, groups or individuals may advertise any blacksmithing event or function in North America at the rate of \$10.00 per event.

PUBLICATION: Publication and delivery will be the last week in November in time for Christmas gift giving.

All photos, logos, ad copy, and payments must be received no later than **September 30, 1986**. Make checks payable to ABANA CALANDAR. Plan your events now and promote them ABANA wide in "BLACKSMITHING IN NORTH AMERICA".

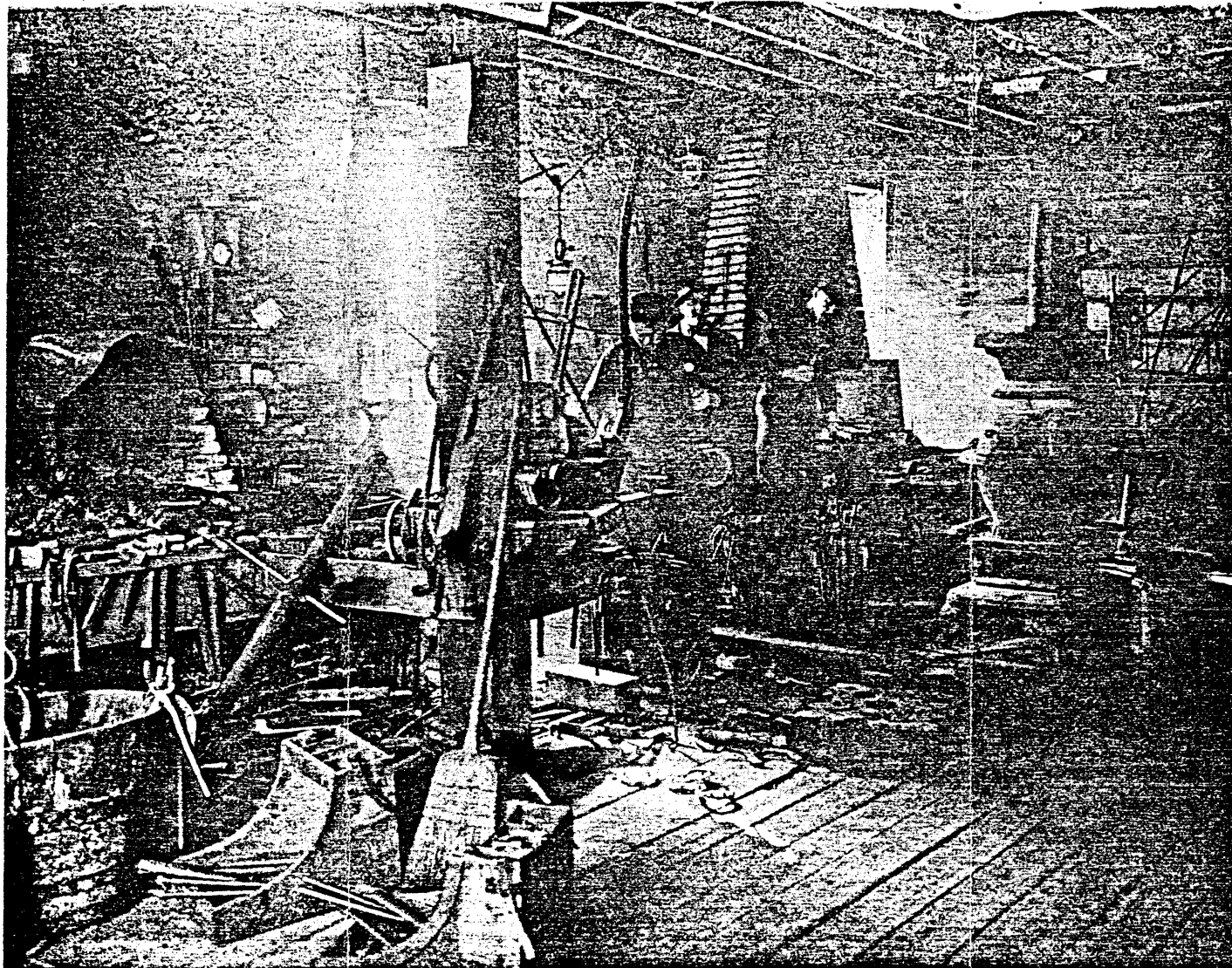
Direct further inquiries to Jim English, c/o Cedar Creek Forge, N70 W6340 Bridge Road, Cedarburg, WI. 53012. #414-375-2201.

Sincerely,

Jim English
ABANA CALANDAR
Chairman-1987

CHAPTER RATES: For Chapters the same rates apply. However, a Chapter subscriber will receive 100 copies which can be sold to your membership at \$4.00 each, thereby making a profit of \$200.00 for the Chapter. All individual sales will be through Chapters or subscribers.

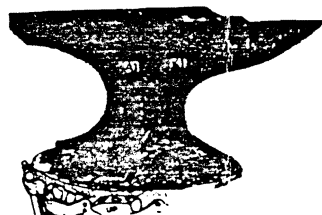
Chapters or subscribers may order additional copies from ABANA at \$2.00 per copy. Minimum order 10 copies.



Scenes of old Cedarburg, Wisconsin
Courtesy of Edw. Rappold Collection

Early 1900's Cedarburg
Blacksmith Shop

THIS MONTH COURTESY OF:



CEDAR CREEK FORGE

N70 W6340 Bridge Road
Cedarburg, Wisconsin 53012
414 - 375-2201

LEON PIWONI, BLACKSMITH
JIM ENGLISH, DIRECTOR

PLEASE NOTE: The ad copy on this mock up does not necessarily correspond with the indicated dates.



Each entry marked with an * would cost the advertiser \$10.00. The Francis Whitaker workshop on the 23-24th would be free with 9 other ads anywhere in the Calandar as it is a promotion by the sponsor of the month in this case, Cedar Creek Forge.

WATCH THE LOCAL PAPERS FOR DETAILS

SUN	MON	TUE	WED	THU	FRI	SAT
				1	2 *	3
					"The Hand Forged Tool" with William D. Young, Jr. at Peters Valley Crafts Center, Layton, NJ 07851. (201) 948-5202.	
4	5 * Three week course in blacksmithing at Turley Forge, Rt. 10, Box 88C, Santa Fe, NM 87501.	6	7	8	9	10
11	12	13	14	15	16 *	17
					Workshop with Bill Senseney at Guilford Handcrafts, Inc., P.O. Box 221, 411 Church St., Guilford, CT 06437. (203) 453-5947.	
18	19	20	21	22	23	24
					Francis Whitaker 5TH ANNUAL BLACKSMITHING SEMINAR Cedar Creek Forge FALL BEGINS	
25	26	27	28	29	30	