

# N.J.B.A. Newsletter

---

NJBA Volume 24, Issue 1 July, 2020

## Chairman's Note

As you may have heard, the NJBA board has decided to continue to keep our doors closed. This was not a decision we took lightly. We do not want to lose our members to this often deadly virus, and we do not want to spread the virus. That said, the NJBA is a community too, and community is important in these challenging times — we hope you'll join us in our online effort to maintain our community. If you have any thoughts on how we can improve our outreach or you want to help, please contact me or any of the board — we're very open to suggestions. - Ryan Amos



## Please Help Your Editor Compile a List of On-Line Videos and Other Resources.

One thing NJBA may be able to do is to help its members find information of value to them as blacksmiths. But your editor cannot do this without your help. If you come across on-line information of any sort that you'd like to make available to other members -- websites, tables, videos, or whatever -- please send me a link at my email address. (See p. 2.) I've been wanting to put together a list like that to publish in the Newsletter and perhaps to post on our website, but I just never seem to find the time to get it together. Please help. - Bruce Freeman, editor.

## Don't Procrastinate -- Please Vote NOW!

The NJBA election has been ongoing for three months already  
and we have received *very few* votes.  
Please Vote NOW using the ballot on the last page of this Newsletter.  
Results will be tallied in early September.

### Reminder:

This Newsletter is now sent by email only, so please be sure that we have your correct email address!  
You can receive printed copies by US Mail if you subscribe for \$10/year.  
See Subscription form on last page.

**Subscribers of the Printed Version of this Newsletter may Renew using the same form as the ballot.**

NJBA must continue to charge \$10 per year for your printed subscription to cover the printing and mailing costs.

# New Jersey Blacksmiths Newsletter

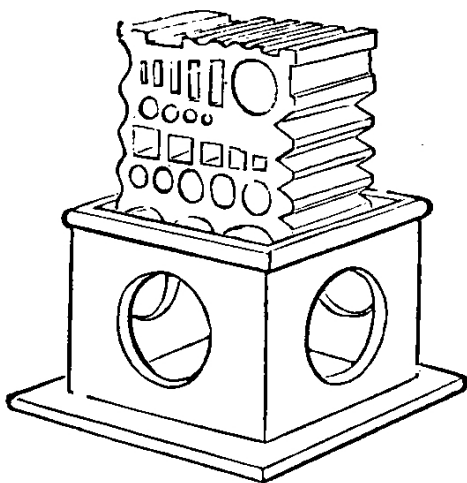
## NJBA Board of Directors

Directors list not published in on-line edition.

## All Upcoming Events Have Now Been Cancelled

**Annual Picnic and Tailgate Sale at EJOT,  
CANCELLED**

Like all events scheduled for 2020 so far, this one has been cancelled due to the pandemic. EJOT has been closed to the public for now and will not reopen in time for this event to be rescheduled in 2020.



We like to thank those who joined  
NJBA as Business Members:  
**Marshall Bienstock**

### **NJBA's Official Address**

NJBA, P.O. Box 224  
Farmingdale, NJ 07727-9998

### **NJBA's Website:**

<http://www.njblacksmiths.org>

### **NJBA Newsletter:**

Will be found on our website (above). Look for  
"Current Newsletter" and/or "Newsletter Archive."

### **NJBA's Facebook Page:**

<https://www.facebook.com/njblacksmiths/>

### **NJBA's IForgeIron subforum:**

Scroll down at <https://www.iforgeiron.com/>.

### **NJBA's subreddit:**

[Reddit.com/r/NJBA](https://www.reddit.com/r/NJBA)

You can get a free Reddit account and post  
questions, links, pictures or whatever here.

***New!***

# New Jersey Blacksmiths Newsletter

## Open Forge Meets

All NJBA-sponsored open forge meets are suspended until further notice due to the pandemic.

### Monday Night Open Forge, Howell, NJ CLOSED UNTIL FURTHER NOTICE

In normal times, NJBA Director Marshall Bienstock hosts an open forge meet at 7 PM every Monday evening except major holidays. (Please call ahead on holidays to make sure the forge will be open.)

### Sunday Open Forge, Smithtown, LI, NY. CLOSED UNTIL NOVEMBER, AT THE SOONEST.

In normal times, from the beginning of November through the end of April, Ron Grabowski will open his forge in Smithtown, LI, NY, to NJBA members. Please call ahead to confirm and get directions: 631-265-1564. Ronsforge@aol.com

### Sunday Open Forge, Holcombe-Jimison Museum, Lambertville, NJ. REPORTEDLY CLOSED.

In normal times, the Holcombe-Jimison Farmstead and Museum and Blacksmith Shop is open on Sunday afternoons from 1:00 PM to 4:00 PM starting on the first Sunday in May until the last Sunday in October. (NJBA does not determine when this museum and blacksmith shop will open or reopen.) The shop is located at 1605 Daniel Bray Highway (Rt. 29) just north of Lambertville, NJ. (holcombe-jimison.org, 609-397-2752) Anyone, blacksmith, novice, beginner or anyone wishing to try smithing for the first time is welcome. (Note: The Museum is not subject to NJBA's age restriction.) There is an annual fee of \$25.00 due on the first day of your arrival. This is for insurance purposes only. You are welcome to come and work on any Sunday we are open, the only Sunday we are closed is to attend the annual meeting and picnic.



## Rules for Participation in NJBA Hands-On Events

These rules apply to workshops, open forge meets, demonstrations with hands-on components, etc.

**The current overweening rule is that there will be no NJBA meetings of any kind until the pandemic emergency is lifted.**

1. Participation in NJBA-sponsored hands-on events is limited to adults (i.e., 18 years or older). This rule was effected as of December 4, 2016. (Note: This policy *does not apply* to open forge meets and similar events *that are sponsored or co-sponsored* by youth-oriented organizations such as scouts, 4H groups, schools or other venues, including the Holcombe-Jimison Blacksmith Shop.)
2. Workshops are open only to NJBA members, but nonmembers may join by paying dues when they register.
3. All workshop fees are due upon registering. Any materials fee is not refundable. A workshop fee is refundable only if your place in the workshop is filled by another person.
4. If you only want to watch the workshop, the fee is half the listed workshop fee.
5. Workshops are intended for the purpose of teaching certain skills and/or completing certain projects, and are subject to the authority of the workshop leader or instructor. Accordingly (as per a vote of the NJBA Board on Jan. 28, 2018.):
  - ♦ The participant shall work *only* on the project at hand and not on any other projects, *without exception*. (Note: Any NJBA member may attend an NJBA open forge meeting to work on his own project.)
  - ♦ Every participant will be required to follow the instructions of the workshop leader, especially any instructions pertaining to safety, or he may be ejected.
  - ♦ A person who has a history of failure to follow instructions may be refused admission to any workshop, at the sole discretion of the workshop leader.



# New Jersey Blacksmiths Newsletter

## **Report on the July 13 NJBA Virtual Board Meeting**

In attendance, by telephone, were Dave Ennis, Larry Brown, Marshall Bienstock, Ryan Amos, Tom Santomauro, Mark Morrow, Dan Yale and Bruce Freeman.

Lightweight Forging Stations. Bruce Freeman recently tallied the hammers and tongs, by type and weight, currently in each of the six color-coded toolboxes. To remediate the deficiencies, he fabricated four additional horseshoer's tongs, and began fabrication of one (of two planned) additional bolt tongs [*which I have since completed - ed.*]. He concluded that, in addition to these, we need 2 straight-pein hammers and one cross-pein hammers, at least one of medium weight, one more wire brush, one more steel rule, and a replacement for one missing chisel (handle still in box) Bruce will review his tool collection and see what he can donate. [*I have done so and have donated the ruler, the wire brush and two of the three hammers. Tom reports he can donate the other hammer. There has been no action on the chisel as yet. - ed.*] Larry suggested fabricating wolf-jaw tongs and flat-jaw tongs. BF will consider this suggestion. [*I have modified the two bolt tongs with cross-V-grooves which will allow them some of the functionality of wolf-jaw tongs. - ed.*]

Bruce also fabricated two more air ducts (to connect blowers to firepots) and a replacement for the broken wheels for the yellow vise. He also found (once again) that the blue toolbox was simply too small for all the tools, so repaired a disused toolbox and painted it blue.

Crane Rail Anvils. Larry has rough-cut some of the heavy crane rail donated by Dan O'Sullivan into anvil shape and sent photos. Some grinding will be needed to make these ready to use. Larry will rough-cut additional pieces of this rail as time permits. The consensus of the Board was sell these rough-cut "anvils" as is rather than to hold a workshop to finish them. The prices will be set, probably by weight, at some future time.

Gas Forge Workshop. Mark has fabricated a prototype gas forge from a Freon bottle. Bruce will draw up plans of this forge after Tom and Mark send him photographs of Marks' prototype. NJBA will hold a workshop for construction of a number of these at some future date. (Jan London has generously

donated a number of Freon bottles for this workshop.)

NJBA Web Presence. Ryan reported that no changes have yet been made to our web presence. NJBA desperately needs an increased web presence given the current situation. Bruce reminded the Board that we now have a Subreddit ([Reddit.com/r/NJBA](https://www.reddit.com/r/NJBA)) that allows postings, and hence communication between participants. However, as yet there has been no traffic there and we need to advertise it further for use for communication amongst the NJBA Membership. Links are needed from our website to our social media may consider deleting the NJBA Facebook page

Our website has an index for the newsletter posted, enabling one to find most any article ever printed in the NJBA Newsletter. However, It's a little inconspicuous right now and needs to be made more obvious.

Swage Block Stand. The Board approved the motion by Mark to allocate funds for the purchase of steel to construct a swage block stand for Marshall's shop. This stand will have wheels off one side so it can be moved when tipped. Any of the swage blocks in the shop will fit on top, flat or upright, with room beneath for the other blocks.

Steel Bloom Smelt. Mark remains interested in conducting a steel smelt but hasn't located a source of softwood charcoal, and he doesn't have a kiln to make it. The Board expressed interest, so we may go ahead with this. We'll need to cut some pine to make charcoal and fabricated a kiln. Mark says we need 800-1000 lb pine wood, but that it has to be cut late in the season after the sap is out of it. Therefore we'll take this topic up again at the next Board meeting.

Reopening NJBA after the Pandemic. Ryan believes that we may now be legally permitted to reopen NJBA events under the Governor's orders if we (1) mandate masks; (2) limit use to one person per forge; (3) limit the number of people indoors; and (4) limit time slots. In the ensuing discussion it was suggested that we allow members to book reservations on-line. Tom proposed having participants sign a liability waiver. It was also suggested that we use the lightweight forging stations and/or propane forges to increase the available work stations. However, some of the Directors indicated that they would not be attending meetings until the pandemic was under control, and others supported this opinion, so reopening was deferred until October.

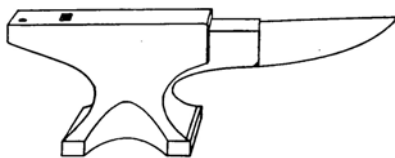
# New Jersey Blacksmiths Newsletter

## **New Jersey Blacksmiths on the Internet** by Ryan Amos

As you may be aware, the NJBA has had a website for a number of years now. However, with an ongoing pandemic and the internet being 30ish years old, we are looking to increase our internet presence. Here is our plan:

1. We've had a Facebook page for some time now, but after feedback that it was too hard to facilitate discussion, we've created a Facebook group. You'll need to ask to join, and then you'll be able to post directly to other members.
2. We've introduced our own subreddit on Reddit where you can chat with other members. Reddit is easy to navigate and post to. We expect this to be our best option.
3. We've had an ongoing project of updating our website to a more modern design. You can take a peek at <https://experimental.njblacksmiths.org/>. Keep in mind that this site is not kept up-to-date and is liable to change at any time.

You can find the links to 1,2 on our homepage at <https://njblacksmiths.org>. Please come chat with us — ask questions, show off your work, or say hi! As a side note, if anyone is interested in filming themselves doing a demonstration or instructional video, please let us know. We'd like to have some video content for our membership.



Anvil, Showing Horn, Tail, Hardie Hole and Spud Hole

## **What Did You Do During the “PAABA-demic”?**

*(from the newsletter of the Pittsburgh Area Artist Blacksmith Association)*

The question was posed, “What did you accomplish during the time you had at home?” *[Below are some responses, those pertaining to blacksmithing. -ed.]*

**Glenn Horr**— Full time blacksmith- Installed an air tension cylinder on his 2 X 72 belt grinder, it works nicely because you can adjust the belt tension you want, also adding a glass platen for it .

Glenn has a water cooled side blast forge and flue that has been in the shop for over 35 years, he said “It is time”! Also finished up a small fab stand and made a flare nut wrench for his regulators.

**Jim Thureau**-Venango County— Jim reported, the President of OVBA (Oil Valley Blacksmiths Association) Dan Riddles, put together a workshop to make twelve, two burner propane forges. This was quite the accomplishment!

**Bob Elliott**— Blacksmith from Fairmont WV— Completed a detailed window grill that has been on his bench for a while. It is 34” by 46 “, made of 1/2” square material and a floral motif in center!

**Anthony Cisco**— New PAABA Member!- Has been getting off to a great start with only one meeting in January under his belt! He is making bottle openers, “S” hooks and other small decorative items and selling them!

**Ed Appleby**— Blacksmith from Laughlintown—Ed confronted a project that was deemed a loss. A lovely knife he made some time ago unfortunately sat in vinegar and over etched by mistake. It was set aside and considered a loss. With the extra time on his hands, Ed gave the blade another chance and to his surprise recovered nicely! Don’t give up can be applied to giving a project a second look!

**Mike Ciuca**-Active PAABA Member— Beside re-flashing and repointing a chimney in preparations for a new roof, Mike made a decorative iris panel, swage block stand, and new tong rack.

**Bob Pickens**— Fabricator/Blacksmith- Being busy is nothing new to Bob. He is making progress on rebuilding his 1921 Runabout/Roadster from the frame up. One weekend he assembled a Clay Spencer Treadle Hammer from parts he had been collecting and acquiring. His 80# Treadle hammer is ready for painting, and that will be done soon! He has also completed many small projects.

**John Steel**— Blacksmith/Fabricator- After 38 years of not having a railing in his home, it was installed recently! John made the commitment that 2020 was the year to design and complete this safety asset to his abode. PAABA Members, Dave Simmons and Mike Ballew helped install 35 feet of custom designed railing. John also organized the Community Project making 10 kits for our members.

## **So, NJBA Members, what blacksmithing-related projects have you been working on during this pandemic?**

Feel free to post your comments to our subreddit: [www.reddit.com/r/NJBA](http://www.reddit.com/r/NJBA) *[You can read about what I’ve been doing on p. 4 in the Report on the Board Meeting.]*

# New Jersey Blacksmiths Newsletter

## Obituary

Long-time NJBA member Arthur M. Monsen, died on March 30th, 2020. Those of you who attended the NJBA picnics and tailgate sales at the Red Mill may remember him by his red suspenders with black anvils. The following obituary is from <https://barlowzimmer.com/book-of-memories/4146619/Monsen-Arthur/index.php>

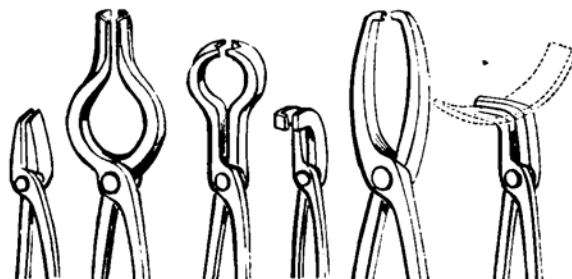
“For those of you growing up in East Windsor, NJ during the 70s and 80s, do you remember listening for the fire sirens letting us know that the fire truck was coming around with Santa? And hopefully all that you remember about the local volunteer fire company was the really great Christmas party they put on for the kids- and never had need of the volunteer heroes who manned it or the heroes who founded it. Maybe some of those Brooktree Residents remember the family with the motorcycles- and the big guy who rode them. Or that man who dragged a 100 year old six foot long bellows around with him to do blacksmith demonstrations at the Lakewood Renaissance Fair. Columbus Flea Market saw him as a regular walker buying his pumpernickel bagel and scratch offs once a week, every week, for 50 years. Some knew him from the Sons of Norway Lodge in Marlboro, NJ where he was a member for many years. Some from the Thursday suppers at the German American Club in Hamilton. And some just knew him by his iconic red suspenders.

“Arthur Monsen was a gentle man, an artist, an engineer, an inventor. He lived a full life, leaving us too early at the age of 82. Arthur grew up in Staten Island/ Brooklyn, moved to Hightstown during his high school years, on to East Windsor where he raised his family, and then retired in Hamilton, NJ. He is survived by his wife- Beverly Keating, three children, grand daughter, great grand daughter, sister and nephew.”



### **Blacksmith Coal and Coke Available to NJBA Members**

NJBA purchased ten tons of “nut” coal of good analysis. In addition to our using it for our demonstrations, this coal will be available for purchase by NJBA members at 20¢ per pound, on a bring-your-own-bag and bag-it-yourself, honor-system basis. The coal is located across the drive from the larger door to Marshall’s pole barn, formerly the site of the coke pile. We still have some coke available at the same price, *behind* this same bin. (Walk around by the path to the left of the bin, but watch for poison ivy.) Plastic bags of at least 3-mil thickness are recommended. (A spring balance, *not legal for trade*, has been mounted beside the bin for your convenience in *estimating only*.) Please inquire of Marshall Bienstock for more information and to make payment.



### **Another Patina Tip**

*This tip reprinted from the May-June 2020 edition of Bituminous Bits, The Journal of the Alabama Forge*  
A couple notes from John Guenther about the “Better Projects Through Chemistry” article in the November/December 2019 issue:

You can turn copper a nice deep red by first heating to a wet orange color and immediately plunging the piece into a super saturated solution of borax in water. The key is to heat the piece from the back side with a torch while watching the surface. Just as soon as the surface starts to look wet, get it into the borax solution. [Editor’s note: when we did this in Bob Taylor’s copper rose class we had our roses right above the solution while heating them!] Rinse in clean water and apply clear lacquer or wax finish when dry.

# New Jersey Blacksmiths Newsletter

## **Excerpts from Newsletters of Other ABANA Affiliates** *An Explanation of the Odd Banners and Page Numbers on the Next Few Pages of this Issue*

In the past, your editor excerpted articles from the newsletters from other groups for inclusion in this Newsletter. This was a laborious because I was doing it without the software needed for excerpting pdf files, using an onerous, roundabout process. As I reported in the last issue, due to my own time limitations, I cannot continue to do this. With the last issue, I emailed all members some complete newsletters from other ABANA Affiliates, a less-than-ideal solution, especially for our subscribers to the hardcopy version.

Fortunately, I have since acquired software that enables me to cut and merge pdf files, which will allow me to add just those pages of interest from other newsletters to the NJBA Newsletter. Unfortunately, this procedure precludes my using the NJBA banner and also prevents sequential numbering of pages. That's life! Please bear with it. -ed.

### **From the President's Anvil**

Today, June 5th, we would have been in the middle of our 2020 conference. I am sure most of you grieve the loss as I do. However, we must go on. Several announcements follow:

1. The summer edition of the Anvil's Ring was posted on Monday and you should be receiving it shortly. A small piece of the 2020 conference is printed in this issue. As well, the candidates for the board positions are included and the voting is open as of June 1, so you can cast your vote here: <https://abana.org/abana-elections-2020/> or call central office with your vote at 423-913-1022.

2. The large item raffle kicked off on May 1 and at 7:56pm on May 29th all raffle tickets were sold. The drawing will be live-streamed from Bob Valentine's shop in Goshen, CT on August 1. At that time, I will also announce the winning candidates for **the board election which will finalize on July 31.** ( [abana.org/abana-elections-2020](https://abana.org/abana-elections-2020) )

3. In the early part of the year, the board voted to have 10 teaching forges made by New England Blacksmiths for the organization, to be included in our event trailer and replacing several of the heavy footprint forges currently owned. Those are complete and ready for use.

4. Our initiative in Johnstown, PA are ongoing. We have, however, some great news – **April 22-24, 2021 Johnstown Gala** – A premier opening in Johnstown with several of the 2020 demonstrators, teaching area, public demos, gallery opening, competition, ribbon cutting, auction, and other fun activities. Look for

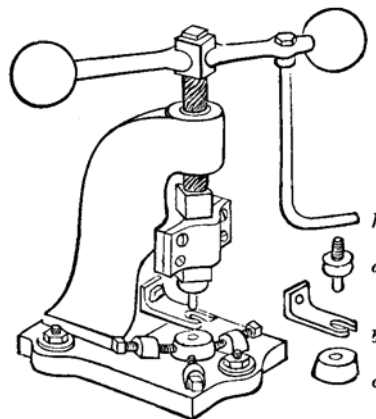
upcoming details as plans unfold. We will be asking for volunteers to help with this venture. Work has started on the Facebook group and can be found here: <https://www.facebook.com/groups/656456954888491/>.

5. The ABANA board received and approved a proposal for the ABANA 2022 Conference by North Texas Blacksmiths Association, along with local affiliates, Balcones Forge, Houston Area Blacksmiths, Louisiana Metalsmiths, and Saltfork Craftsmen. This event will take place in Dallas, TX at the Dallas Motor Speedway in the early spring of 2022. Work has started and the Facebook group and can be found here: <https://www.facebook.com/groups/2442933625949472/>.

Look for information on all of these in upcoming weeks and months – also our postings on the official ABANA website, [www.abana.org](http://www.abana.org).

Be safe, forge hard,

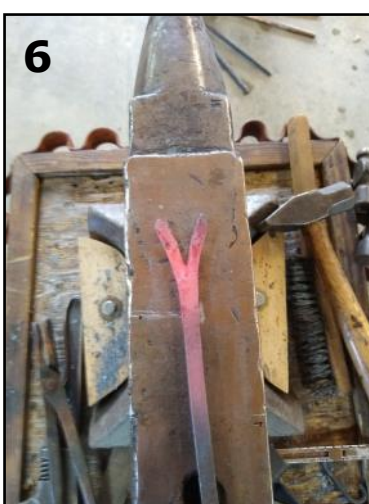
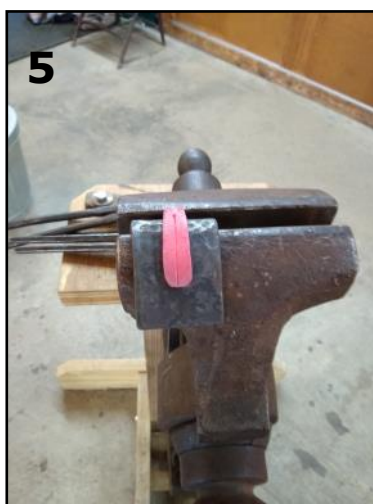
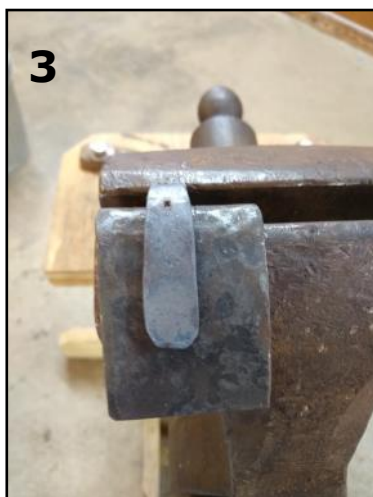
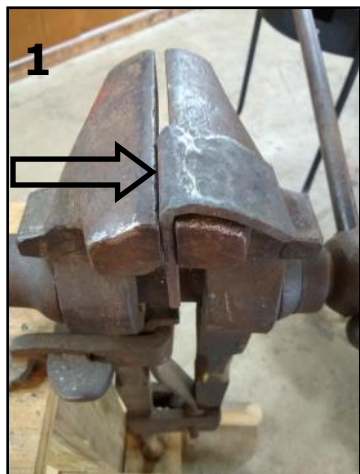
-Leigh Morrell,  
ABANA President





## Splitting Stock on a Post Vise

### By Tom Rohosky



When splitting stock with a chisel, I've found that using my post vise can be easier and more accurate than doing it on my anvil. The height and angle of my vise gives me better visibility and control, and I don't have to worry about holding the work. This means less fiddling and helps me keep the cut where I want it.

My basic setup is shown in (figure 1). I use a mild steel cutting plate; this one is about 1/4 inch thick and about 6 inches long by 2 inches wide. To demonstrate, I'll be splitting 3/8 inch square stock for fork tines. I prepped the stock by flattening the end a bit and bending it to fit the cutting plate, then I clamped it vertically in the vise as shown in (figure 2). I then marked the end of cut with a center punch (figure 3) and did an initial scoring cut (figure 4); both were done cold. This is where using the vise really shines. I find it much easier to keep things centered this way rather than hunched over an anvil. *One important side note:* Start the cut at the punch mark rather than at the end of the stock. If you do creep a little off center, it's a lot easier to fix this at the end of the tine than at the base. From here, simply heat the stock up and continue the cut (figure 5).

Once the cut is complete, straighten it back out on the anvil (figure 6), and you should have a nice even split with well-balanced tines. This cut could have been done on the vise alone, but the plate helps in several ways. First, vise jaws typically have sharper edges, which can unnecessarily mar your work. Second, the plate can support your stock better- especially if your vise is smaller than this one. Third, the plate can be easily preheated so that you don't have a massive heat sink (i.e., the vise) cooling your work too quickly. Finally, this will avoid damaging your vise or your chisel should you cut too far. Fixtures like this can also be used for other projects as sculpting heads, dragon faces, etc. It's good to keep in mind that not all forging tasks need to be done on an anvil.



A good vise is an extremely valuable tool and with a little thought, you can do a lot more with them than you may think. So, if you're having trouble doing this type of work on an anvil, give your vise a try!





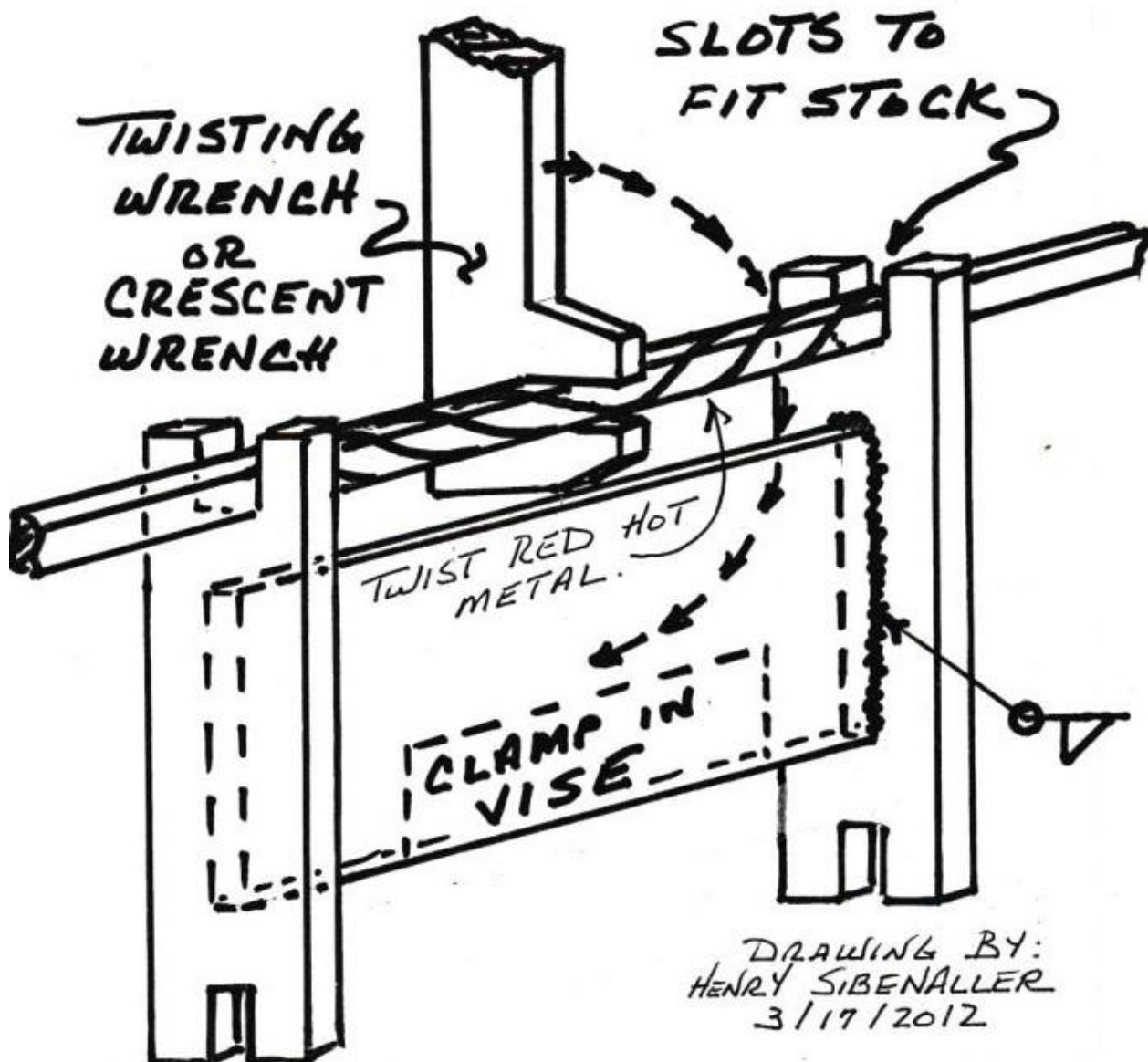
## Have You Been in a Twist?

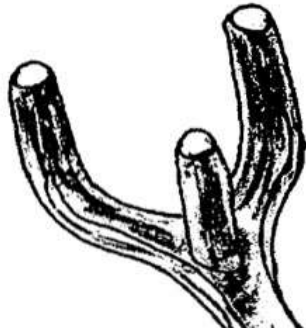
Project by Jim Brown, Drawing by Henry Sibenaller

This spring, we all had a little extra time on our hands. Going through some paperwork, a drawing by Henry Sibenaller surfaced on a nifty twisting fixture. The design was created by the late Jim Brown, a talented farrier with a great gift of demonstrating with style, humor, and talent.

Henry is a long time PAABA member who has contributed to our newsletter for many years. This perfect drawing gives you all the information you need, "read" the drawing and you can add a real asset in your shop.

### JIM BROWN'S TWISTING FIXTURE





## For your Tool Box

### Paul Garrett's Three Fingered Bending Fork

by Dave Smucker

Bending forks have been around forever and there are many ways to make them, but I think that Paul's idea is something new or at least it is a design that I have never seen. I even said to Paul "It makes me mad, because I didn't think of it myself."

What makes a 3-fingered special is the way you can easily use it to bend stock both toward you and away from you.

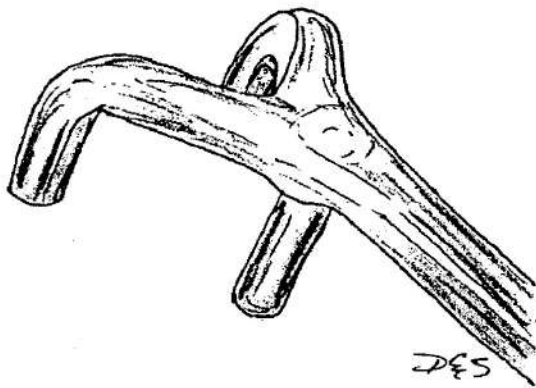
The sketch on this page is of a fork that Paul made that is 24 inches long so the drawing is about 1/3 actual size.

This fork is made from a racecar axle of Hy-Tuf steel. For more on this steel see the article in this issue on "Two Interesting Steels." Paul has this type of material for sale from time to time.

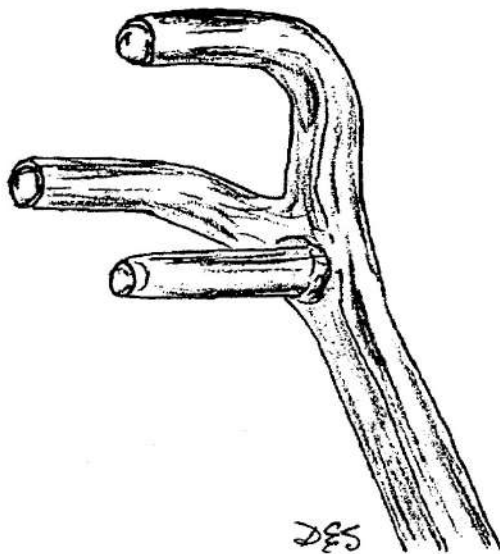
For those that may not know Paul, he is the resident blacksmith at the John C. Campbell Folk School. Make a point of coming to the November meeting of the AACB at the Folk School and meet Paul.

On the following page are some sketches of the 3-fingered head and one way to use this bending fork.

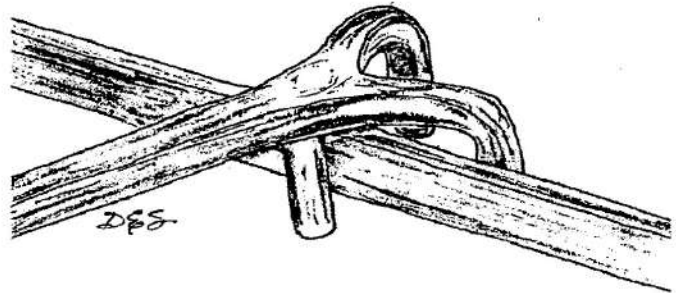
# Projects



To make the fork Paul first drew out the axle and then flattened the bending end. He then split this end and forged the two fingers and bend them 90 degrees. He then hot punched a hole in the base of the wye for the third finger. This finger he drew out of additional axle material fitted in place and arc welded top and bottom.

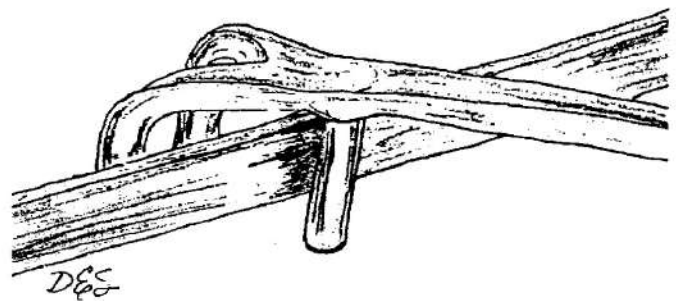


Here is a view from the other side.



This view shows one way of using the fork. In this position, the blacksmith is bending the material towards themselves. In other words, towards the bottom of the drawing.

(There are many positions you can use the fork because of the many ways you can place stock between the three fingers.)



In this view, the smith is bending away from himself or herself, towards the top of the picture.

The really neat thing here is to make a correction to an over bend one does not have to reposition the fork, only shift from one pin (finger) to the other. This requires a handle movement of only about 90 degrees, much much less than in a 2 pin or fingered bending fork.

Making this tool out of a 220,000 psi (pounds per square inch) steel makes this a supper tough tool you can really lay into.

Make some of these forks in different sizes and you will really like them.



# Multi-Position Bending Fork

Text and Photos by Jim Carothers

For quite some time I've been noticing that many farriers are also really good blacksmiths and that some of their tools are special or different for their work. In particular, some of the farriers' anvils have two really handy bending pins (like a bending fork on its side) sticking out from a side of the anvil.

At the 2005 Saltfork Craftsmen ABA Annual Conference (<http://www.saltforkcraftsmen.org>), I also noticed that professional demonstrator Peter Happny repeatedly used a heavy bending fork mounted in the anvil hardie hole. However, Peter's bending tool was not pinned solidly to the borrowed demo anvil; each time he hit or pulled on a piece of metal the bending fork would move.

**Photo 01:** From these observations came the idea for the Multi-Fork you see presented here in these notes. This is simply a combination of the farriers' horizontal bending pins and traditional anvil mounted vertical bending fork. I turned the legs of the vertical fork 45 degrees to the anvil center line; it seems to be handy for me in that orientation. My cut-off hardie is also rotated the same way as this bender.

As old as the blacksmith's craft is and as new as I am at this craft, I expect that I am not the first person



Photo 01: Multi-Bending Fork

to think of making a bending tool like this. The pins are spring steel; the inside spacing between the legs of both forks is 1". The pins are not heat treated – only annealed after forging to shape. The parts were preheated before welding.

Notice also in Photo 01 the tapered pin lying on the anvil. This was made from 1/2 of a horseshoe (my favorite piece of scrap steel).

**Photo 02** shows the Multi-Fork firmly pinned to the anvil. With only a light hammer tap on the tapered pin the tool is locked in the hardie hole. You can turn the anvil stand over before moving the tool.



Photo 02: The Multi-Fork Secured in the Hardie Hole with Tapered Pin

**Photo 03** shows how the pin is used with a hardie stem or peg made from U-bending basic flat bar stock. For my tools that I want firmly mounted to the anvil (anvil cone for example), I have been making the hardie stems in this manner. A second benefit is that the tools are lighter than if the hardie stem was solid bar.

**Photo 04** shows the end of the U-shaped hardie stem and the tapered pin as seen from the underneath side of the anvil heel. I really like this old Trenton anvil, but the factory did not do any finishing work to the under sides of the heel or the horn.





Photo 03: The Hardie Stem and Tapered Pin



Photo 04: The Hardie Stem with Tapered Pin in Place



# OUR FRIEND'S FORGE

Newsletters from other blacksmith associations

Reprinted from Northern Minnesota Metalsmiths Newsletter - June 2020

This article is re-printed courtesy of the California Blacksmith Association Newsletter, Jan-Feb 2017



**Stock.** 1" x 1" x 2½".

1. Upset the end to about 1⅝ to 1¾ square. This end will be the ears and back of the head.
2. Taper the opposite end down. This end will become the trunk and tusks. Go to ¾" to 1" square at first, and then take the taper down to about ⅝" square. Knock the corners off.

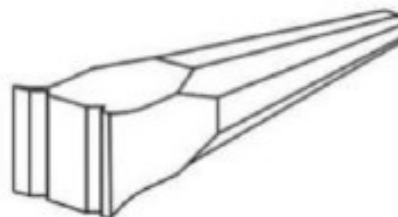
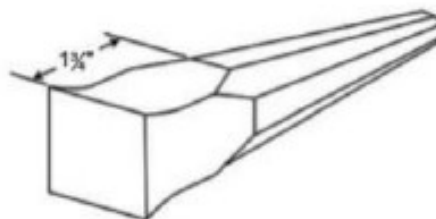
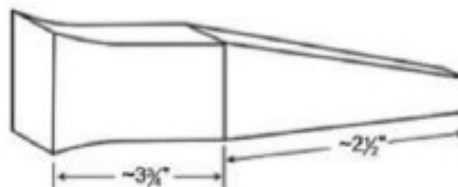
*For clarity, the drawings do not show the corners taken off; however, that will be needed throughout the process.*

3. Make the tapered section octagonal. This starts to form the elephant's nose.
4. Switch ends. Groove the ends in about ⅝" to ¼". These grooves will become the ears.

## FREDDY'S ELEPHANT

### OKTOBERFEST 2013

FREDDY RODRIGUEZ TOOK US THROUGH THE STEPS TO CREATE HIS MARVELOUS ELEPHANT'S HEAD. THIS PROVIDES A GUIDE FOR YOU TO MODIFY AND SIZE TO SUIT YOUR INTERESTS.



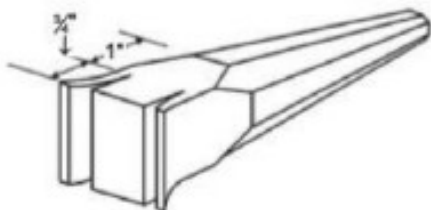
## OUR FRIEND'S FORGE

Newsletters from other blacksmith associations

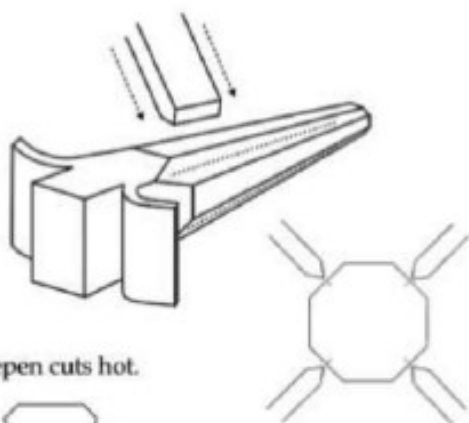
## Freddy's Elephant - continued

**ELEPHANT**

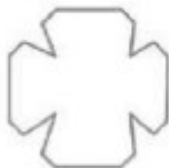
5. Continue the split, about  $\frac{3}{4}$ " down. Split away on each side. Bend out with fuller or side set if needed.



6. Mark for tusks. Go onto the octagonal flats, and mark four sides with cold chisel. Marks go all way back to the parent dimension and down about two-thirds the length of the taper.



7. Deepen cuts hot.



8. Mark for mouth with a cold chisel.

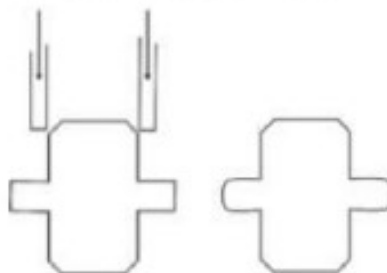
Marks also go back to the parent dimension.



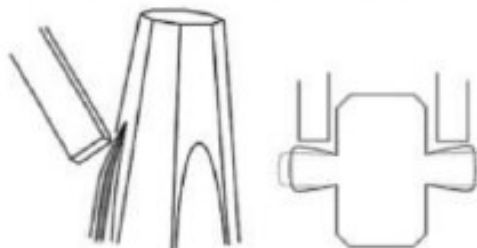
9. Chisel into sort of a Maltese cross.



10. Push the two tusk sections out with a flat chisel. Round the outer corners a bit.



11. Deepen the cuts. Work chisel at 45° from vertical. Flatten the sides with a flat-ended chisel.



12. Cut the mouth. Chisel, and then bend out.



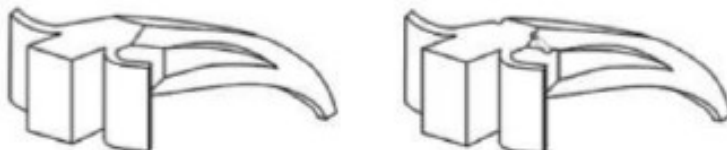
# OUR FRIEND'S FORGE

Newsletters from other blacksmith associations

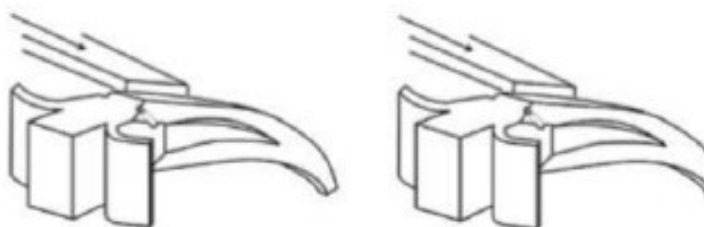
## Freddy's Elephant - continued

### ELEPHANT

13. Bend the nose section over, and then fuller and punch for eyes.



14. Move nose material over and up to create a bit of a swelled-up section. This will take several heats.

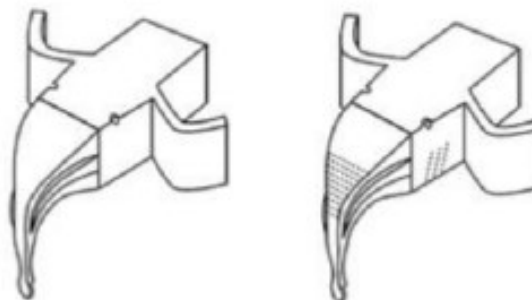


15. Continue to work the nose with a fullering chisel. Add definition with a flat chisel. Isolate (fuller) the end of the nose section to form the nostril area. Bend the nose section past 90°.



16. Make wrinkles on nose. Use a fuller chisel to define nose and cheeks behind tusks.

17. Cut tusks, starting at the tip end. Taper the tusks to a point. Curve out.

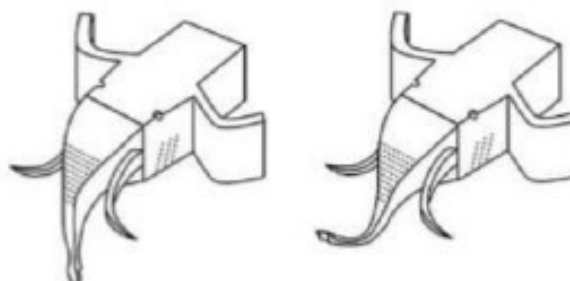


18. Round the ears by drawing out with a rounding hammer or rounding punch. Add character.

19. Clean up and enjoy! ♣



THIS ELEPHANT  
WAS COMPLETED  
BY FREDDY IN HIS  
OKTOBERFEST  
DEMONSTRATION.



# **Combined Form**

## **Subscription Renewal (\$10/year)**

## **Membership (\$20/year for New Members Only\*),**

## **Ballot (*Please vote*), and**

## **Volunteering**

Mail completed form, along with check for any amount due, to the above address.

Name \_\_\_\_\_

Address \_\_\_\_\_

City, State, Zip \_\_\_\_\_

Phone Number(s): \_\_\_\_\_

Email address \_\_\_\_\_

Your correct Email address is *essential* if you don't care to pay \$10 extra for a mailed Newsletter! Please Print Clearly!

**\*Note: Current members owe no dues for the 2020-2021 dues year.**

**My check is enclosed:**      ☐ \$20 (*new* regular membership dues), or  
   ☐ \$40 (*new* business membership dues)

**For printed Newsletters:**      ☐ **\$10 subscription fee** (for paper copies of Newsletter)

## **Ballot for the Election of the NJBA Board of Directors**

Please check the boxes by all nominees you wish to vote for.

<b>Nominee</b>	<b>Nominee</b>	<b>Nominee</b>
<input type="checkbox"/> Ryan Amos	<input type="checkbox"/> Eric Cuper	<input type="checkbox"/> Bruce Ringier
<input type="checkbox"/> Billy Barrett	<input type="checkbox"/> Dave Ennis	<input type="checkbox"/> Tom Santomauro
<input type="checkbox"/> Marshall Bienstock	<input type="checkbox"/> Bruce Freeman	<input type="checkbox"/> Ben Suhaka
<input type="checkbox"/> Larry Brown	<input type="checkbox"/> Mark Morrow	<input type="checkbox"/> Dan Yale

## **NJBA Volunteers List**

"Please put my name on the list of potential volunteers:" (Circle all that apply.)

**Availability:**      Saturdays      Sundays      Weekdays  
**Interests:**      Demonstrating      Coaching Novices      Assisting at Workshops  
**Blacksmithing Experience:**      Novice      Intermediate      Experienced      Professional  
**Other Experience:**      Welder      Fabricator      Other Metalwork      Writer      Editor      Photographer      Videographer  
                                 Facebook Contributor\*      IForgeIron Contributor\*      Website Manager\*