



# N.J.B.A. Newsletter

Volume 5, issue Number 2

## Summer is almost over!

Ok, now think of all the things that you wanted to do this summer and still have not done....I hope your list isn't as long as mine. This newsletter is running a little late due to a two week vacation in Florida by the editor and trying to get as much member contributions as I can.

So hopefully all the information is here and it's all correct and we can try to get down to finishing all those summer projects when we get done reading the newsletter.

## Upcoming events for 2000;

**September 17**; Sunday, starting at 10 am. The meet will be at **Tim Millers** shop in Bayport, Long Island. See details on this page.

**October 7th**; Saturday 10AM - 5PM. Not an official meeting, but an event that members can take advantage of. Demonstrators are needed for the **Country Fair at Longstreet Farm** in Holmdel Park in Holmdel, N.J. See details on page 2 .

**October 28**; Saturday. Work day at Peter's Valley. John Rais is lining up projects in the blacksmith shop to enhance the function of the shop. Stay tuned for more details.

**November**; No official meet at this time.

**December** ; Our Holiday party, date, time and location to be announced.

## September Meet

### in Bayport, Long Island

September 17, at 10 am. The meet will be at **Tim Millers** shop in Bayport, Long Island, NY. We will be having **Mike Schermerhorn** as a representative of the **Art and Metal Co., Inc.** of Hanson, MA They are the suppliers of a recently

available material called Pure Iron. Many rave reviews have been heard of this material and this will be an opportunity to try it out and to compare it to other materials. The day will also feature a demonstration of tooling Tim has made for the power hammers in his shop. If time allows we may have additional demos by some of our members.

#### Directions:

To Tim Miller's shop in Bayport, L.I., N.Y.: Take the Long Island Expressway to exit 62 - Nicolls Rd, go south to the end and make a right onto Montauk Highway. Go three lights (quick), look for sign on left, Tim Miller Blacksmith. Go to back of driveway and park on the blacktop before the chain link fence, some tailgaters may be able to park near the shop, call first to make arrangements.

Shop: 631-419-1185

## October Meet

**At Peter's Valley Craft Center** October 28,2000, a work day at **Peter's Valley**. John Rais is lining up projects in the blacksmith shop to enhance the function of the shop. Stay tuned for more details.

**Directions:** Peters Valley Craft Education Center is located at 19 Kuhn Road. in Layton (Sussex Co.). NJ 07851. (Phone: 201-948-5200). From Interstate Rt. 80: Take Exit 34B to NJ Rt. 15 North. to US Rt. 206 North. Left onto NJ Rt. 560 West. through the blinking light in the center of Layton. onto NJ Rt. 640: go about 2 miles and turn right onto NJ Rt. 615. Go approximately one mile.

From US Rt. 209 (on the west bank of the Delaware River in Pennsylvania): Take PA Rt. 739 South across the Dingmans Ferry Bridge. Take the first right at sign to Peters Valley. Go two miles.

# New Jersey Blacksmiths Newsletter

## October 7th, Country Fair at Holmdel Park

**Blacksmiths needed** for demonstrations at the Country Fair being sponsored by Longstreet Farm in Holmdel Park, Holmdel NJ.

Longstreet Farm is a restored late 19th century farm. Demonstrations can and will be done both in the farm's blacksmith shop and outside. NJBA has held several meetings at the farm and has demonstrated at the shop before. The shop is fairly well equipped - Champion forge and bellows, two anvils, assorted tongs, assorted hammers. Stock and coal provided. Anyone interested in demonstrating please contact; **David Macauley**,

732-206-1568,  
drmacauley@att.com

Direc-



tions;

To get to Holmdell Park take the Garden State Parkway to exit 114. Go west about 3/4 mile on Red Hill Road to Cranford Corner Everett Road, and make a right turn. On your left will be Bell Laboratories, recognizable from its unique water tower. Either the first left (Roberts Rd.) or the second (Longstreet Rd.) after Bell Labs will take you to Holmdell Park. Find a parking spot and follow signs to Longstreet Farm.

## Business Members

We would like to thank the businesses that joined with the new class of business membership, lets all give them the support that we can:

Ginty's Welding Service, Inc.,  
2 Lee Mack Ave., Danbury, CT, 06810

Timothy Miller, Artist Blacksmith,  
Bayport, Long Island 631-419-1185

## NJBA Board of Directors

**Marshall Bienstock**, June, 2001

663 Casino Dr., Howell, NJ 07731

732-938-6577 732-780-0871

mbienstock@worldnet.att.net

**Larry Brown**, Editor, June, 2001

90 William Ave., Staten Island, NY 10308

718-967-4776

Inbrown@con2.com, brownln@hotmail.com

**Bruce Freeman**, June, 2000

222 Laurel Place, Neptune, NJ 07753

732-922-8408, 609-716-2827

freeman@monmouth.com,

freemab@pt.fda.h.com

**Jon Folk**, Director until June, 2001

P.O.Box 143, Old Bethpage, NY 11804

(516) 625-5667.

**Bill Gerhauser**, Director until June, 2000

415 Hutchinson St., Hamilton, NJ 08610

609-394-1817, bgahow@earthlink.net

**Josh Kavett**, June, 2001

471 Casino Dr., Farmingdale, NJ 07727

732-431-2152, jakavett@aol.com

**Doug Learn**, June, 2001

121 Pebble Woods Drive, Doylestown, PA, 18901

215-489-1742 doug.learn@Primedica.com

**David Macauley**, Director June, 2000

4 Patricia Ct., Howell, NJ 07731

732-206-1568, 732-949-8422

drm@anchor.ho.att.com

**Jeff Morelli**, June 2001

234 Rahilly Road, Wrightstown, NJ 08562

609-723-5990

**Nate Pettengill**, June, 2001

24 Byron Rd., Short Hills, NJ 07078

npetteng@motown.lmco.com

**Steven W. Rhoades**, June, 2001

513 Harding Highway, Vineland, NJ 08360

856-697-4144, hotiron1@juno.com

**Bruce Ringier**, June, 2001

201-652-4526 346 Rt.565 Wantage,NJ 07641

**Tim Suter**, June, 2000

1112 Ladner Ave., Gibbstown, NJ 08027

856-423-4417

**Greg Phillips**, Director untill 2002

(914) 457-5671, Acorn Forge, 937 Route 17k, Montgomery, NY 12549 suresign@frontiernet.net

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## Report on the June meeting

The June meeting was held at Historic Cold Spring Village in Cape May New Jersey. Bill Futer, Dave Macauley, Larry Brown, and Steve Rhoades, from NJBA, brought their portable forges and anvils. The NJBA setup at HCSV's blacksmith shop, run by Jerry Goldman. NJBA members delighted visitors to HCSV with demonstrations, lectures and various examples of ironwork. Buffet lunch was provided to demonstrating NJBA members by NJBA. Thanks to HCSV, Jerry Goldman and demonstrating NJBA members. Thanks to Steve Rhoades for this report.

## A Report on the ABANA Conference in Flagstaff, Arizona

Report by Joshua Kavett

### Flagstaff conference

The 2000 ABANA conference in Flagstaff Arizona was terrific. This is the fifth conference I have attended. They continue to be a wonderful experience. I met many people I knew only as emails on the Internet. A few impressions, in no particular order:

A. The bridge project for the National Ornamental Iron Museum was a monumental piece of work. Balustrades were contributed by many smiths from around the world. They were assembled to the started bridge, then the whole thing was stood upright near the dining hall. ABANA can be proud of this project. I am only sorry that I did not understand the scope of this project and did not complete my balustrade.

B. The tailgate sales were very interesting and very varied. People actually came in from all over the country to sell. Many appeared to do well, however, no one appeared to sell out. Prices definitely have risen, and many smiths seem to have all the stuff they need.

C. The demonstrators put on terrific classes. All were well attended, but the setups allowed for all to see. One of the understated highlights was the demonstrations put on by an elderly Italian smith, (sorry, I forgot his name), that Mike Bondi found during one of

his trips to Italy. He did three sessions, forging a complete project each time. He took small bars of steel, proceeded to hot split and draw out the stock. The results were organic shapes- a stem with three flowers, a reed plant and another flower. They were truly amazing. He also had other examples of his work involving using all the available material in drawing out, then raising it into forms.

D. The auction of demonstrator pieces went quite well. Most pieces brought a decent amount for the ABANA scholarship fund. The biggest disappointment in terms of price were the large gates design by Jerry Hoffman and done by volunteer smiths out west. They were terrific, finished except for final paint. They sold for only \$7000, about 1/3 of what ABANA had hoped for. (If they weren't 2500 miles from home, I would have bought them for that price.)

E. The setup and location of the conference was great. This was the second time they had it at Northern Arizona University. Since the last conference in 1986, a new dining hall/conference center was built near the primary dorm. All of the activities were revolved around the dining hall, making it a quick trip to get to anything, or hop between demos. They had about 1000 smiths here, and about 500 family members. The tone of the conference was more relaxed than at Asheville. There were fewer hills to hike, and the walk to events was minutes. Everything seemed to be organized better, right down to the program/demo listings. They had fewer events scheduled, making choosing events easier.

More on the conference in the next issue. The next conference is planned for June 5-8, 2002 in western Wisconsin.



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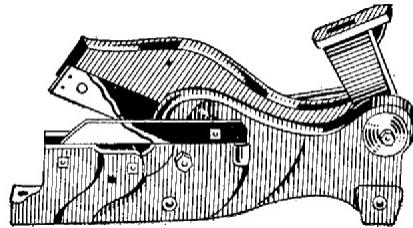
## Flagstaff From a Board Member's Perspective

Report by Doug Learn

Going to an ABANA conference is not the same when you are a Board member. In the past, I attended the St. Louis and Alfred conferences as a civilian, spending time at the demonstrations, slide shows, lectures, galleries and other events pretty much for my own enjoyment and learning interests. No real preparation was needed to attend these conferences, other than to register and make transportation plans, and perhaps to see who was demonstrating. Once at the conference, I made my plans to attend as many of the functions as possible that I had interest in, and then tried to do so.

Seeing all the people I only run into at the conferences is always a benefit, reliving the past and maintaining these friendships and ties to the blacksmithing community. Once the conference was over, like most attendees, I retained as much information as possible, practiced the techniques that I had picked up and worked them into my skill set, but pretty much went about my life as before.

This July I attended as a Board member, and the experience was much different. Having organized the first six Forging on the River conferences for the River Bluff Forge Council, I understood what went into a conference, but not at this level. I was involved with the planning of the event in some way from the time I joined the Board in November of last year, primarily making sure that the Chapter Liaison letters covered the needs of Bill Calloway and the Arizona hosts for the conference. As time grew nearer, all the Board members were involved in many of the details that only the Board handles, and much work went into getting ready to attend the conference. On the day before the opening of the conference, the Board met in a general business meeting, spending over 14 hours discussing the state of ABANA and making decisions on finance, the publications, the forward direction of ABANA, this conference and the next conference. The discussions were frank and open, but with good results that the membership will see in the coming months and years.



On the first day of the conference, we had meetings with the newsletter editors and the presidents, again requiring preparation with the other Board members and attendance at both. At the opening ceremonies, I as the other Board members, was involved. The next day we made sure that the ABANA booth was up and running smoothly (as it was, LeeAnn being the efficient Executive Secretary that she is), and stayed in contact with the Arizona team to help solve any issues that may need Board involvement. I then tried to do what most smiths attend conferences for, namely watch demonstrations, look at the vendor areas, and talk to all my friends in the smithing community and make new ones.

Through all of this however, members sought all the Board members out, including myself, to express their ideas and opinions, and, as a Board member, I always took the time to talk to the members. The conference is the only time that members have all the Board in one spot and easily accessible, and with me, many took the opportunity to talk to me.

Once leaving Flagstaff, the follow-up with Board initiatives continues, with membership requests being followed up, ideas written down and discussed, and in general trying to build on the success of the conference and the input of the membership to make ABANA better.

Bottom line; attending any function as a Board member of that organization, be it NJBA or ABANA, is a whole nother beast, compared to attending just as a member.

**Doug Learn  
ABANA Board Member, Chapter Liaison**

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## Fisher & Norris Museum/Book/Grant Project by Joshua Kavett

I have finally received final approval for \$5000 for research/photography/interviews concerning the Fisher anvil company. The research phase is now in full swing. I am working on interviews with the principles, and have started the photography part. I hope to fulfill the grant requirements, and submit the report to the state this winter. I will then work on the transcript and layout of the book.

I have decided to build a new building to house my "museum." This project will follow the book. I have started preparing the site for the building, and hope to have the shell build next spring. This will give me a permanent place to house the archives and my anvil collection. I have continued to add to the collection, which now numbers around 50 Fisher anvils.

## Auction news: Sent in by **Josh Kavett**

Anvil prices continue to average between \$1 and \$2 per pound for anvils on several auction sites. However, some specialized and small sized anvils bring big bucks. A 24 lb. Hay-Budden recently sold for \$1482 on E\*\*y. This is the smallest HB known to exist. It had the factory engraving, "Knifemakers/Blacksmiths Anvil" and was made about 1920. The anvil was bought by a gentleman who has a Farriers Museum in Oklahoma. He also owns the biggest HB anvil known to exist at around 750 lb..

## Coal

Coal is now available through Alex Parubchenko at his shop in Trenton. Please contact Alex or John Chobrda at the shop, Phone # (609) 396-9583.

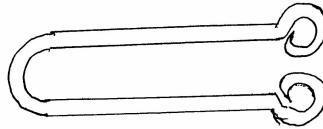
**www.artist-blacksmith.org**

It may be the only address you need.

## Scrap Bin Submitted by **Tim Suter**

### EMBER TONGS

I saw this concept for ember tongs at an antique shop recently. It was made with 1/4" round, about fourteen inches long over all. The ends of the rod were flattened to about 1/2" wide and formed round with a spoon like concave and about a 1/2" center opening. This would be a quick and easy demo piece and could be jazzed up by squaring a section of the reins and twisting.



## Report on July Meet

### Report by **David Macauley**

The meeting at the fair went well. We had several demonstrators including:

**Josh Kavett** - We actually saw him pick up a hammer and strike hot steel -made some knots in 1/4" steel

**Marshall Bienstock** -who made striker for a flint an steel kit and a fork

**Norman Nelson** -who brought a display board with some hooks and candle holders. Norman was also a big help in instructing two young men, Nathan and Mark that had volunteered at the farm. Nathan and Mark had tried blacksmithing before and wanted to get some more instruction. They thanked us often and very politely for all of the help.

**Bruce Freeman** - who was making some forge welded hearts - they looked quite good.

**David Macauley** - who demonstrated courting candles on Friday and baskets on Saturday.

**Jeff Morelli**- who board a display board of his knives that he makes out of files. Jeff also demonstrated making knives.

**Tom ?** - who also brought some knives that were very beautiful.

General comments: We had two forges the larger flat toped, steel forge that Bruce had donated last year and a small pan forge that Andy donated. We also brought two anvils and a vice. We could have used another forge at times - maybe a gas one. Having another forging station would have made things even more tight under the tarp. We really could use a sign to indicate who we are. The brochures helped, but a sign would have given us even more visibility. We seemed to get allot of interest, let's see who shows up at the meetings and the open forges.

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## Open Forges

We want to encourage all to join us at:

### Monday Night Open Forge in N.J.

Marshall Bienstock is hosting an open forge in his shop at 7 pm almost every Monday night ( Please call ahead on holidays to make sure , (732)780-0871 )

### Monday Night Open Forge

#### In Orange County

Greg Phillips will be hosting an open forge in his shop in Orange Co. NY. For more information Contact: Greg Phillips, Acorn Forge, 937 Route 17k, Montgomery, NY 12549, (914) 457-5672, Suresign@frontiernet.net

### Open Forge on L.I.

The open forge on Long Island is temporarily suspended. Jon will probably restart it in mid-October. For information and directions, call (516) 625-5667

## Blacksmithing

### Workshops and Classes:

#### Peters Valley Craft Education Center

19 Kuhn Rd., Layton, NJ 07851 (973)948-5200  
pv@warwick.net Http://www.pvcrafts.org/

#### Academy of Traditional Arts

#### Carrol County Farm Museum

500 South Center St. Westminster, MD 21157  
(410)848-7775 (410)876-2667

#### Touchstone Center for Crafts

R.D.#1, Box 60, Farmington, PA 15437  
(724)329-1370 Fax: (724)329-1371

#### John C Campbell Folk School

One Folk School Rd.  
Brasstown, NC 28902  
1-800-365-5724 www.folkschool.com

## Advertise with us!

Contact: Larry Brown, Editor for current rates.  
(718)9674776, brownln@hotmail.com  
90 William Ave, Staten Island NY 10308  
Ads may be submitted by mail or e mail attachment.

## Art & Metal Co., Inc "YOUR PURE IRON SUPPLIER"

243 Franklin Street (route 27), Hanson, MA 02359

<http://www.artandmetal.com>

CALL (781) 294-4446 FAX (781) 294-4477

Hours are from 8am to 5pm Monday thru Friday

Art & Metal Company will be stocking a full range of round bar, rectangles, square bar and sheet at our Hanson, Massachusetts location starting January 2000.

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We have a **50 lb minimum** per order, this can consist of 2-3 sizes to make 50 lbs.

We also will be accepting American Express, Master Card, or Visa for payments.

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The process for each  
item is shown on page 2 of  
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## NJBA By-laws

### Preamble

The New Jersey Blacksmiths Association (NJBA) is an independent forum and voice for blacksmiths in the State of New Jersey. It was founded by people having interests in diverse aspects of blacksmithing, including the art, the craft, and the history of blacksmiths and blacksmithing and related crafts. Among those interested in the artistic aspect were members of the Artist Blacksmiths' Association of North America (ABANA). Among those interested in the historical aspect were people involved in historical interpretation and in historical research, usually in cooperation with historical sites in New Jersey. Among the founders were blacksmiths of considerable experience, as well as novices. It was the intention of the founders that NJBA bring together and represent the interests of all such people, and to increase their number and skills.

NJBA is structured to be a vital group in which the most active, interested persons rise quickly to positions of responsibility. Accordingly, there are no elected offices, but only elected directors who divide all responsibility between themselves at every board meeting. To rapidly involve new people in the activities of NJBA, the board is authorized to add to its own membership. To keep the board beholden to the membership, directors are reelected annually by the membership. To provide stability and continuity of the board, a board member may serve up to two years between reelection by the membership.

In any case where there is apparent conflict between a statement in this preamble and a statement in an article, below, the Article shall take precedence.

### Article I. Name

The name of this organization is the New Jersey Blacksmiths Association.

### Article II. Purposes and Objectives

The NJBA is organized exclusively for educational purposes including the following:

To actively promote the art, craft and historical significance of blacksmithing.

To increase public awareness and understanding of the history and contributions of blacksmithing and blacksmiths, as well as of the vitality and potential of modern blacksmithing.

To act as the point of contact in the State of New Jersey concerning the art and craft of blacksmithing.

To disseminate information in printed and other media, including public or commercial media.

To sponsor blacksmithing events and exhibits throughout the state of New Jersey.

To support the activities of outside organizations whose objectives or facilities enable promotion of NJBA objectives.

To provide a forum and meeting ground for members.

To sponsor or conduct educational conferences, programs, demonstrations, workshops or training.

To disseminate information concerning sources of blacksmithing related literature, material and equipment to the blacksmithing community.

To advocate the art and craft of blacksmithing.

NJBA is not to act in the capacity of a trade union, commercial guild or business-advocacy group.

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None of these objectives shall be construed to promote lobbying or commercial activity by this organization for its own or its members' financial gain.

## **Article III. Tax-Exempt Status**

The board shall ensure that NJBA achieves and maintains tax-exempt status under state and federal law. The organization and directors shall refrain from any activity which would jeopardize that status:

The directors shall not be compensated for services in that capacity.

NJBA shall not endorse candidates, lobby elected officials or participate in the political process.

NJBA is not and shall not act as a trade union or in any other commercial capacity.

## **Article IV. Membership**

Regular Membership Status. Any person engaged or interested in the art, craft or history of blacksmithing and accepting the purposes and bylaws of NJBA may become a member. A member in good standing shall be current in dues payment, except where the directors decide that a grace period, applicable to all members, is in the interest of the NJBA. In special cases, the board may waive dues for a regular member, but such waivers must be renewed annually. A member in good standing shall have the right to vote and to participate in any NJBA activity, except where excluded by skill level. In no case shall one person be allowed more than one vote in this organization.

Honorary Memberships. The board may bestow honorary memberships of an emeritus or ex-officio nature on a retired or practicing blacksmith. An emeritus membership would be one bestowed upon a person whose life experience and contributions as a blacksmith is considerable and worthy of recognition. An ex-officio membership would be one bestowed upon a blacksmith during his tenure in some office or capacity, such as the blacksmith at an art community or historical site. An ex-officio membership would not be automatically bestowed to each successive office-holder, but each successor has the right to petition the board for ex-officio membership. An honorary membership may be bestowed only when it will serve to enhance the NJBA. Honorary members will not have a vote in the organization. Honorary members may be elected as non-voting members of the board. An honorary member may also hold regular membership, in which capacity he will have a vote as member or director.

Terminating Membership. Any member may withdraw from this association upon written notice of such intention to the secretary. A lack of payment of dues thirty days beyond the annual renewal (plus any grace period) will be considered a request for resignation and the member will be dropped from the organization. An ex-officio honorary membership will be terminated when the person leaves the office which entitled him to that membership.

## **Article V. The Board of Directors**

Authority of the Board. The organization shall be governed in all aspects by the board of directors.

Size of the Board. The board must maintain its size at no fewer than five directors. There is no upper limit to the number of directors. The board of directors may increase its size at any

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time by electing as a director any active, participating member in good standing of NJBA. It must do so if the number of directors ever drops below five.

Quorum. A quorum shall consist of one-third of the board (rounding any fraction up), or five directors, whichever is greater. In the event that the number of directors drops below five, the remaining directors form a quorum; however their first item of business must be to elect additional directors to bring the number to at least five.

Qualifications of Directors. Any member showing leadership in or working on behalf of NJBA shall be considered by the board for election as a director, and may petition the board on his own behalf for such consideration.

Disqualification by Defeat in Election by Membership. A person who was defeated in election to the board at a membership meeting may not be reelected by the board, but only by the membership in a subsequent year's election meeting. (This provision assumes no limit to the number of seats on the board, and would not apply to a person defeated only because of limitations to the number of available seats.)

Election of Directors by the Membership. An annual meeting shall be held for the purpose of electing directors and announced to the membership by mail at least two weeks in advance. Nominations (with second) of candidates will be accepted from the floor. Any director elected by the board since the last election by the membership must be reelected by the membership in order to remain on the board. Since, as stipulated above, no director may serve more than two years without coming up for reelection, any director last elected by the membership two years previously must be reelected by the membership in the current year in order to remain on the board. The directors shall be elected by majority vote of the membership.

Term of Service. A director elected by the board shall come up for reelection by the membership at the next membership meeting that is called for the purpose of reelecting directors. A director may serve no more than two years without coming up for reelection by the membership. There is no limit to the number of terms he may serve.

Termination of Directors. The board of directors shall drop from its membership any director who resigns, who moves out of the area, or who fails to maintain his membership in good standing. In addition, the board may drop from its membership any director who does not participate in NJBA business, by means of the following procedures:

- 1) Any person who has been a director for the twelve-month period up to and including the current board meeting, and who has attended fewer than two board meetings in that period, shall be subject to removal from the board at the current board meeting.
- 2) The removal of a director shall be by a majority vote of the board at any regular board meeting, or at a special meeting called for the purpose.
- 3) At least 21 days prior to this board meeting, the board shall be notified of any directors subject to such removal. Such notification shall be by any appropriate means, but care shall be taken that all affected directors receive the notification.

Frequency of Board Meetings. The board shall meet not fewer than six times per year.

Division of Responsibilities. At each board meeting, the directors shall divide among themselves the responsibilities of the organization in any manner they see fit. The manner of division shall be recorded in the minutes, and will be effective only until the subsequent board meeting, except as mandated by law, contract or business requirements of banks or other institutions. The responsibilities of the directors may be identified by the roles of the traditional of-

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fices such as President, Vice President, Treasurer, Secretary and Editor or the traditional chairmanships such of Ways and Means, Programs, Membership and Hospitality, but other responsibilities or alternative divisions may be defined at any meeting. Any of these responsibilities may be divided among directors.

Continuity of Responsibilities. Certain responsibilities of the board are best held by the same person or persons for extended periods of time. These include the duties of Treasurer, Editor and Membership. The board shall take care that these and similar tasks are not arbitrarily reassigned, and that ample overlap time is provided when responsibilities change.

Delegated Responsibilities. Clerical duties, such as taking minutes or bookkeeping, may be delegated to any member, or to any nonmember approved by the board.

Specific Responsibilities of the Board. The duties will consist of undertaking the daily business of this organization, including the following:

Keeping a permanent record ("minutes") of all the business conducted at both board meetings and membership meetings, including elections, votes and resolutions. The minutes of board meetings shall record the names of all persons attending board meetings. The minutes of membership meetings shall record the names of all board members in attendance, as well as a count of all persons in attendance. (Minutes need not be taken at membership meetings if no business is conducted.)

Issuing a newsletter not less than quarterly, and for appointing the editor of any periodical publication of the group.

Maintaining a membership roster that will include the pertinent information for each member and director.

Establishing and maintaining liaison with other organizations where such liaisons are in the interest of NJBA.

Making the bylaws available to any member upon request.

## Article VI. Dues and Finances

The provisions of this Article are intended to avoid financial errors, mishaps and wrongdoing where large amounts of money are involved. Where transactions of more than one-hundred dollars or a treasury balance of more than two thousand dollars are involved, the provisions of this Article shall be followed explicitly. Where lesser amounts of money are involved, the provisions of this Article should be considered guidelines to be followed to the extent practicable; in this case the directors are responsible for ensuring that the procedures employed are proportionate to the money amounts involved.

Dues. The annual dues shall be set or changed by the board by unanimous consent at a board meeting or by a majority vote at a membership meeting called for the purpose. The board shall have the discretion of setting dues periods, of pro-rating dues, and of creating multiple membership (and dues) categories, and of admitting organizations as non-voting regular members.

Cash. When a large amount of cash is received at meetings and events, at least two directors or other persons designated by the board shall receive and count the money. No such money shall be counted privately. It will be counted at the meeting or event and the amount will be recorded in a timely fashion in the account books. Cash shall not be kept longer than overnight or weekends, other than a petty cash fund as allowed by the board.

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Fiscal Year. The fiscal year shall correspond to the calendar year, unless otherwise defined by the board.

Account Books and Check Book. The board shall keep an account of all monies received and expended for the use of the organization and shall make disbursements only upon approval of the board. The funds, check book and account books shall at all times be under the control of the board and subject to their inspection and control. At the expiration of their terms the directors shall deliver over to their successors all account books, check books and other bank records, monies and other properties of NJBA.

Financial Reports. A financial report shall be presented orally at every board meeting, and shall be recorded in the minutes. A full financial report shall be prepared in writing annually, and shall be filed with the records of the NJBA. More frequent reports may be ordered by the board at any time.

Budgets. NJBA shall develop a budget for all its functions, and no amount over \$25 shall be spent without the approval of the board of directors.

Audits. The board may elect to have an annual audit at the end of each fiscal year, with a report back to the board and the membership. The auditors may go over the books with board members, but the full audit must be done privately.

Banking. The board shall deposit all funds received in a financial institution, approved by the board. Funds may be drawn only upon the signature of one or more directors who have been registered with the financial institution as having signing authority. The financial institution shall be informed that the policy of the NJBA is that no checks may be withdrawn to "cash." Nothing in this provision shall require the NJBA to open an account which, through its fee structure, will unreasonably deplete the NJBA treasury.

## Article VII. Membership Meetings

Frequency and Preferred Arrangements. General membership meetings are to be held at least four times per year, and preferably in conjunction with demonstrations at shops volunteered by the membership.

Compensation to Host. Those members providing their forge for these meetings will be reimbursed for expenses incurred in the production of demonstrations and the meeting. The compensation will be set by majority vote of the board.

Quorum. In deciding NJBA business, a quorum of the membership shall consist of those attending the membership meeting.

## Article VIII. Conduct of Meetings

Rules of Order. Wolfe's Rules of Order (by Joan L. Wolfe, *Making Things Happen*, (Brick House Publishing Co., Andover MA, c. 1981), or (Island Press, Washington, DC, c. 1991) shall be the parliamentary rules employed by NJBA.

Informal Meeting Conduct. Where meetings are amiable and self-directing, and as long as participants have no objection, the traditions of parliamentary procedure will be observed only informally. As much as possible, decisions shall be made by unanimous consent.

Invoking the Rules of Order. If at any time the chairman of a meeting considers it appropriate, he may conduct the meeting according to the rules of order. If at any time any participant at a board or membership meeting feels the need, he may legitimately interrupt the proceedings

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("rise to a point of order") and move to invoke the rules of order. This motion requires a second, but permits no discussion and requires no vote. The chairman continues the meeting under the rules of order.

Meeting Agendas. The board is responsible for writing an agenda for each board and membership business meeting. The agenda shall be distributed or shall be posted in a form readable by attendees. The chairman of a meeting shall have the discretion to depart from the agenda, but participants may legitimately interrupt ("rise to a point of order") to move a return to the agenda. Such a motion, once seconded, is open for discussion and vote.

Committee Meetings. Any committee functioning as part of or on behalf of NJBA shall follow the procedures of this article, but need not keep minutes. Committees need not prepare agendas for their meetings. Committees must report progress and expenditures to the board in person or in writing.

## Article IX. Business Conducted by Polling the Board

Means of Polling. The board may conduct business requiring a vote at any time by polling the directors by telephone, mail, electronic mail, or other such means.

Business Subject to Vote by Polling. Any matter of business may be transacted by polling the board, excepting only amending these bylaws, which must be conducted at a meeting. Directors may be elected by polling the board, but there will be a limit of two directors elected by such means between any two meetings of the board.

Procedure. A motion will be made and recorded in writing by any director, who will then be responsible for polling every board member for their votes, and tallying the votes.

Passing a Motion. A majority of the directors must approve the motion by polling for it to pass. There is no lesser number that can be considered a "quorum" for a vote by polling. The motion becomes effective as soon as a majority of the board votes in favor.

Recording the Vote. The voting must be completed by the time of the subsequent board meeting, and the vote will be tallied in the minutes of that meeting.

## Article X Amendments to these Bylaws

Normal Amendment Process. These bylaws may be amended by a majority vote at any membership meeting, or by a unanimous vote at a board meeting, called for the purpose at least thirty days in advance. The proposed changes shall be mailed to directors (for a board vote) or to the membership (for a membership vote) at least one week in advance of the date of the meeting at which the changes are to be considered. The amended bylaws will not go into effect unless approved by ABANA.

Special Amendments Provision to Maintain ABANA Chapter Status. These bylaws may be amended by a simple majority vote of the board if necessary to maintain ABANA chapter status.

Special Amendment Provision to Maintain Tax-Exempt Status. These bylaws may be amended by a simple majority vote of the board at a meeting called for the purpose at least two weeks in advance, if necessary to achieve or maintain tax-exempt status under state or federal law. The amended bylaws will not go into effect unless approved by ABANA.

# Do the Rebar twist

by Jim McCarty

Hardly a meeting goes by that Doug Hendrickson doesn't come up with something new. His latest was this nifty rebar twist that looks, well, sort of like you put a lot of effort into doing it when all you really do is flatten the ends, heat and twist. I tried this technique on the fork, which was made at the state fair. It was a lot of fun putting the finished piece out on the table and asking those watching to try and guess how it was done. No one caught on. I also tried other types of rebar but they just didn't look as good. Other uses might include candlesticks, railing pickets, handles for drawers and whatever.



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## Rivet header

I recently had a railing job for which I needed to support rivets inside of scrolls for heading. After a couple of tries I came up with a solution that worked great and looks to be quite versatile. It's made of 5 main parts.

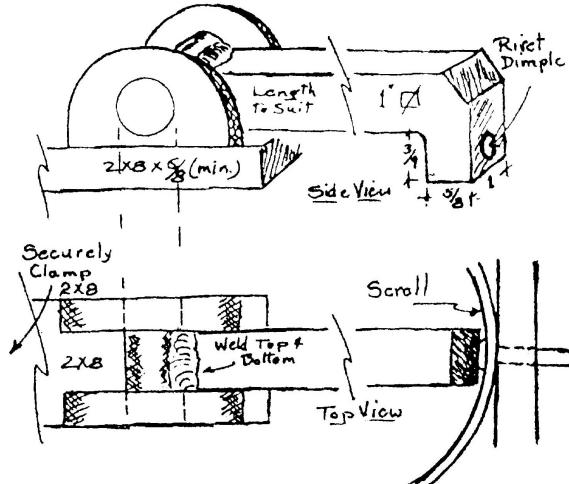
First is an 8" section of 1" square forged to a dog leg 3/4" long when measured to the inside corner, 5/8" thick and 1" wide. A dimple is ground or drilled near the tip on the outside of the dog leg to cradle the rivet head while heading it. This will be welded to along (5 feet or longer) piece of 1" square. The other end is later welded to a hinge.

The hinge is built of a piece of 5/8" or thicker steel 2" wide and 8" long. Two ears 1/2" thick are needed and must be drilled for a 1" pin. The ears are welded onto the 2" wide strip so the 1" square will fit between them easily. A 2-1/2" long 1" pin is inserted into the ear holes, the long 1" bar is slid between the ears up to the pin and welded together making sure the bar is level (off the table by the thickness of the plate the ears are welded to) and the dog leg is pointed down.

To use the contraption it must be clamped to the table, bench or trestle by the hinge end so the arm can be lifted up in order to position the work underneath. When the arm is lowered on top of the work it should be in position to cradle the rivet head as you head the other side. Good clamps are important but the weight of the tool is more important. Should you make this tool, don't skimp on the stock. Make it as long and as heavy as you can.

—David Court

Reprinted from the Newsletter of the New England Blacksmith Association



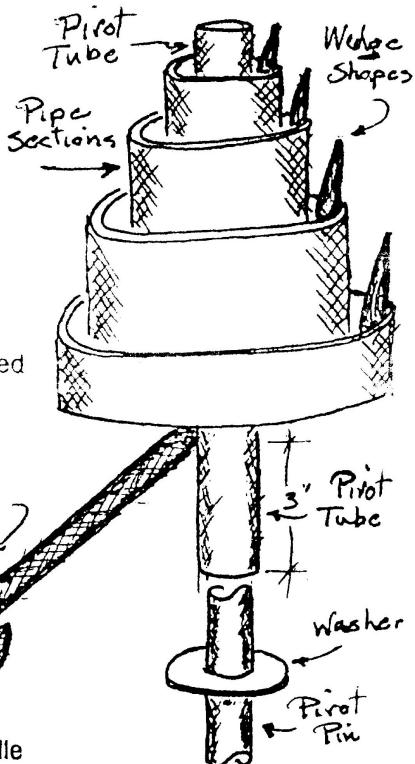
Rivet Header      DavidCourt

## EZ'S Multi-Size Hook Jig

by Eric Ziner

### To Construct:

- Cut pieces of pipe, tube.
- Forge wedge shapes.
- Weld wedges to pipe and pipe to pivot tube.
- Weld washer to pivot pin sized to fit pritchel hole.
- Weld handle under pipe, onto pivot tube. Orient handle so that when the handle is pulled toward self, hook stock is wrapped around pipe mandrel.



### To Operate:

- Draw point.
- Form tip of hook.
- Quench tip.
- Seat between wedge and pipe, and pull handle

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## CHARLIE'S CORNER

*This is your opportunity to contribute to the Newsletter. If I don ~ get any questions then there will not be a Charlie 's Corner just a blank space. It's up to you. Your name does not have to be used unless you request it.*

*Contact me at: 240 Dolphin Court, Oakville, Ontario, L6J 5S8.*

*Phone (905) 842-1599*

*E-mail csurton@sympatico.ca or give me your question at a meeting.*

**Question:-** *Asked many times by various people at meetings. What is the proper height for the anvil?*

**Answer:-** There is no "proper height" A lot depends on the work that is to be done on the anvil. Many of you have heard me say that in the shop where I served my apprenticeship the height of the anvil was designed for the striker and not the blacksmith. I show a picture of Dick Wilkinson and his striker Bob Chariton. You will note that the anvil is less than knee

height. Also note the length of Wilkie's hand hammer. This is so that he can reach the work on the anvil and point to where he wants the work to be hit with the sledge. Remember that when using anvil tools the height where the sledge strikes would be raised the height of the tool about 4 to 5 inches.



Some people prefer their anvil to be at about fist height. This alleviates the need to bend over the anvil and consequently helps to avoid sore backs. Some like their anvils at crotch height. This helps if you want to use two hands to work on the job. These smiths will put the work between their legs and this gives them both hands to work with. You can imagine the disaster if the anvil is too high and the work is not sitting flat on the anvil and you strike it hard with the hammer. Ouch!!

So as far as I am concerned there is no set rule, it's up to the individual to set his anvil to suit his own needs and comfort.

**Question:-** *From George Morrison. I am making a mirror from flat stock bent on edge to a diameter of 18" Do you have any advice.*

**Answer:-** Just finished a similar job George. It is always a little tricky bending flat bar on edge. As you know when bending on edge the outside of the ring has to stretch and the inside compress. This is easy to explain.

Let assume the stock you are using is I  $1\frac{1}{2}$ " X  $1\frac{1}{4}$ ". Let's say the ring is 18 inches inside diameter, which equates to a circumference of 56.52 inches. The outside diameter of the ring (using 1  $1\frac{1}{2}$ ' flat stock) equate to 21" this would mean a circumference of 65.94. Which means that the metal would have to stretch and compress to an equivalent of 9.42 inches.

In order to compensate for this stretching and compression we always add the thickness of

From the Newsletter of the;  
Ontario Artist Blacksmith Association

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the metal to the inside diameter when calculating a ring. However when bending on the flat we add the width, make sense? The formula for the length of stock would be, Inside diameter of finished ring 18" plus the width of the material

$1\frac{1}{2} = 19\frac{1}{2}$ ", multiplied by Pi or 3.14 =  $19\frac{1}{2} \times 3.14 = 61.23$ . Which is the length of stock required to make the ring.

A quick word of advice. I find it difficult to get the ends to bend to the exact curve so I allow for a 2 inch overlap. This way I can cut through the overlap and get a nice clean joint.

Now to the bend itself. First, lay out the inside diameter of the ring on a piece of flat sheet metal (plywood is no good it will bum). Do this with your dividers set at nine inches and describe an 18" circle. As you bend the ring keep checking against your layout. Making sure that you have it right on the mark before taking the next heat. Make yourself a jig to bend the ring on. I will attempt to draw a rough diagram.

The drawing shows a curved section made to the same inside diameter of your finished ring. This is welded to a piece of angle iron with an extra piece welded to it to keep the curved section rigid. A 1/2" hole is drilled at the end, at a distance that will just allow your material to fit snugly, as shown by the dotted line. A pin made from 1/2 round is then dropped into the hole to hold the material while it is being bent. The jig is then held in a vise by the angle iron. The stock is heated, the pin placed and the stock pulled in the direction of the arrow.

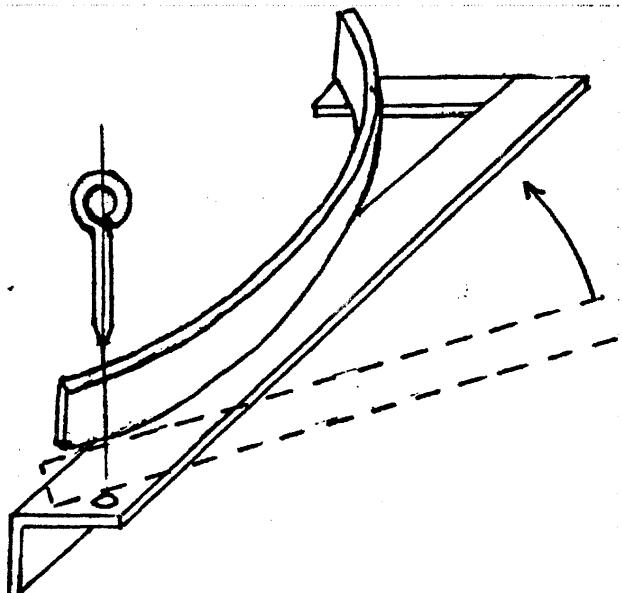
To start the bend, first, bend the end of the stock over the edge of the anvil beck. I like to cool off the corner that I am hitting with the hammer, this stops it from flattening. Check the curve against the layout pattern. When you have about three to four inches curved start using the jig to bend the curve. You will find that the material will buckle. Straighten the stock making sure that you

do not leave hammer marks, using a flatter helps. Check again with your layout pattern and make any adjustments. Keep taking heats and bending the curve (remember keep the heats consistent metal will always bend more where it is hottest)

After you have bent about a quarter of your ring turn it around and bend the other end forming a "C" shape. Now, close up the "C" and you will have formed the ring. You will find that you have better control if you use the "C" and through the overlap and get a nice clean joint.

I hope that I have given some information that you can use and thanks for the question George.

Please keep your questions coming. I may not always be able to give a satisfactory answer and if you realt there has a better answer please come forward. Remember blacksmithing is a art and there are many ways of performing various operations and none of them are wrong.



From the Ontario Artist Blacksmiths Assoc,  
The Iron Trillium, Sept/Oct 1999

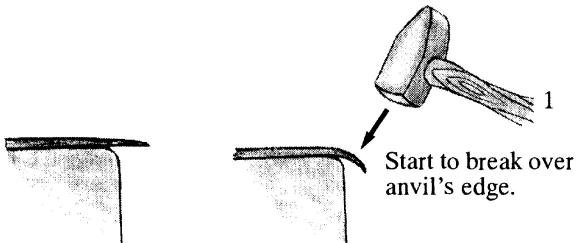


The first step in forming a scroll is to forge the end of the stock into whatever prep shape you want to use. In most cases this includes forging a taper on the bar. The length of the taper has a big impact on how graceful the scroll will appear. The taper and the ever-smaller inward turn of the scroll relate visually. Too little taper and the scroll will appear awkward. So start far enough back to give the taper a long transition.

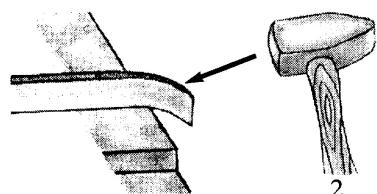


Too little taper.

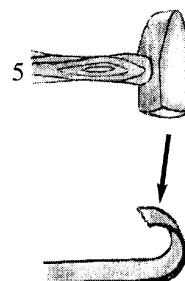
Gradual taper.



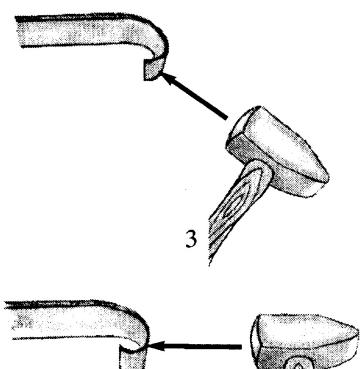
Once the stock is tapered take a forging heat and extend the taper out into space over the anvil's edge by about 1/4". Begin to break the tapered bar in short increments as it is progressively extended past the anvil's edge. Keep the hammer blows light. As the curve of the scroll develops increase the length of each increment to create the ever increasing diameter of the scroll. If the bar kinks or the progression seems awkward, either flatten it slightly or open the kinked area with a bending fork and/or wrench.



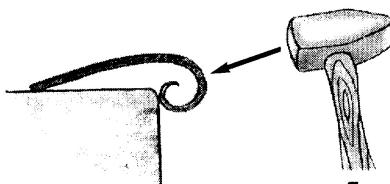
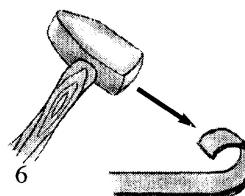
The arrows indicate the direction to strike the scroll in order to develop the effect gradually. Whether the scroll is on its side or back, the direction to strike from is the same.



The angle of the hammer blow controls the curvature and progression of the scroll. No matter how detailed the written explanation, there is no substitute for trial and error and correction when learning a process. Using scroll templates to visually compare the progressing scroll helps.



Working with light, repetitive hammer strokes cannot be over-emphasized. Like drawing a curve with a series of dots, each hammer stroke breaks the flat plane of the bar locally into a continuous curve. To few hammer strokes will give a faceted scroll with each bend appearing as a kink. The same error can be caused by hammer strokes that are too hard.



To tighten or adjust a part of a scroll that is too difficult to reach with a hammer it works well to back-up the part to be adjusted with the anvil while striking the opposite side of the scroll.

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## Scroll Templates

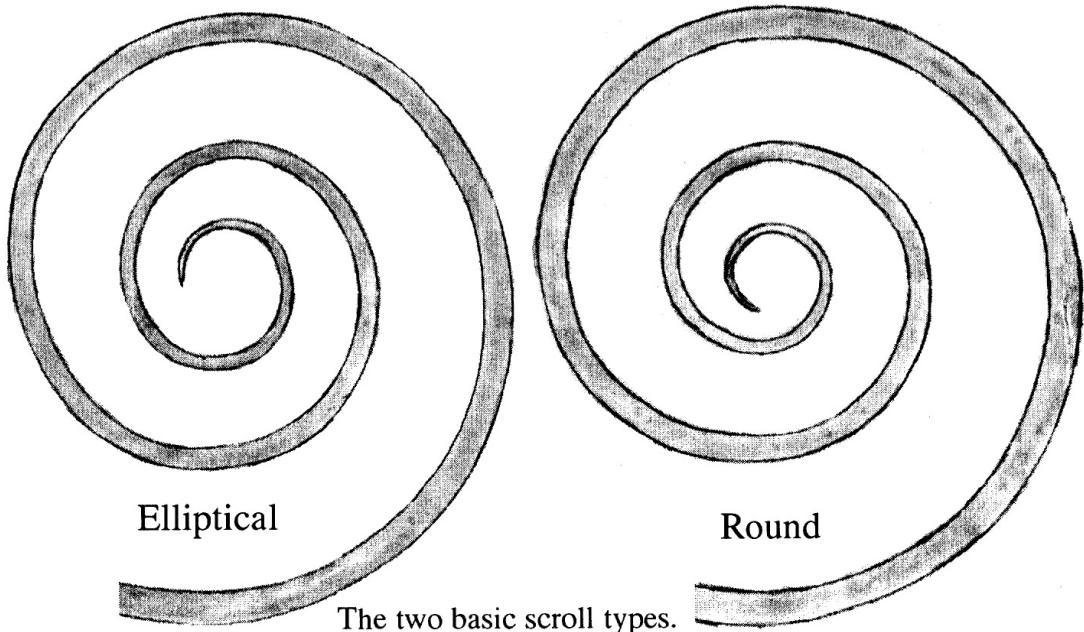
George Dixon, Metalsmith  
[www.traditionalmetalsmith.com](http://www.traditionalmetalsmith.com)

These scroll templates can be traced or photocopied and sized to fit your design requirements. They can also be used to compare a master scroll forging against before it is welded to a plate in making a scroll jig.

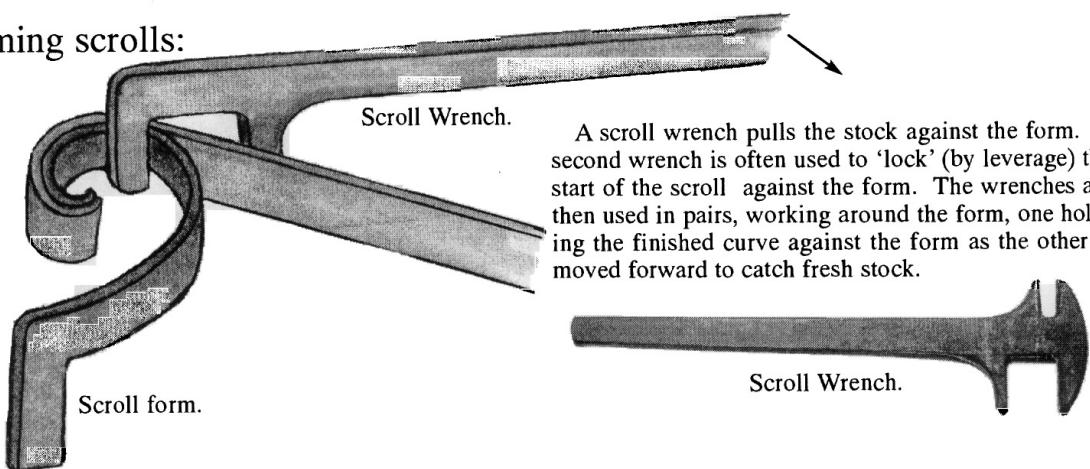
To transfer these patterns onto a sheet of steel, first copy and size. Then rub soft chalk powder onto the back of the scroll pattern paper and lay it face up - chalk side down onto a sheet of steel. If the steel version is to be just a comparative 'chalk jig plate', one that is used to check freehand scrolls against during the forging process, 1/8" to 1/4" thick steel is sufficient. However, if the steel plate is to form the base of a hot-work scroll jig then it should be a minimum of 3/8" thick. This type of scroll jig has the master scroll form welded to it.

Never quench your jig plates or scroll jigs, let them air cool. If they are quenched hot, they will soon warp and become useless.

There are enough situations that require short runs or require scroll-like endings, on leaves for example, that it is important to learn to scroll metal freehand and by eye before you become dependent on jigs. A freehand scroll can also become the comparative 'visual jig' for a subsequent short run just by doing each of the run in sequential stages that are held against the first, or master scroll as they are formed and adjusted. This skill will save a lot of time when a large number of parts is not required and thus a jig would not be cost efficient.



Forming scrolls:



A scroll wrench pulls the stock against the form. A second wrench is often used to 'lock' (by leverage) the start of the scroll against the form. The wrenches are then used in pairs, working around the form, one holding the finished curve against the form as the other is moved forward to catch fresh stock.