June 2020

THE FORGE FIRE

The Newsletter of the Indiana Blacksmithing Association, Inc.

An Affiliate Of The Artists-Blacksmiths' Association of North America, Inc.

IBA is a Not For Profit Indiana Corporation recognized by the IRS under section 501(c)(3)

9:30 AM is the regular meeting time for IBA Hammer-Ins
with beginner training available at 9:00 AM.
PLEASE MAKE SURE TO ASK FOR HELP!

If you would like an IBA membership application form, please contact Farrel Wells, Membership Secretary (765) 768-6235.

BULK LOTS ARE AVAILABLE TO DEMONSTRATORS,
SHOPS, SHOWS AND OTHERS WILLING TO MAKE THEM AVAILABLE.
WE APPRECIATE YOUR HELP.

More nearby resources and organizations for blacksmiths:

Rural Smiths of Mid-America:
Meetings are on the first Saturday of each month
Call Ron Gill
317-374-8323 for details

IBA MEETING SCHEDULE

Check the latest *Forge Fire* for monthly **IBA** revisions.

No June Hammer In

Check IBA Facebook site for up to date news about hammer ins

Editors Message

Article credit: The article on page 11 is reprinted from the May-June 2020 edition of The Upsetter, the newsletter of the Michigan Artist Blacksmith Association. There was insufficient space to include the credit on that page.

At this time I do not have any updates relative to IBA state hammer ins or events. SOFA is gathering information relative to holding or canceling Quad State in September. I do know that many satellite groups are beginning hold hammer ins. Please exercise caution and maintain social distancing as well as possible.

Ray Sease Awarded 2020 Paul Moffett Service Award

Brad Weaver—IBA Awards Chairman

I just presented the first award for 2020.

The winner of the 2020 Paul Moffett Service Award is Raymond Sease! For those of you who don't know, Ray founded the Vernon Blacksmith Group and has kept it together all of these years. He has helped countless blacksmiths along the way. This was long overdue! Thank you Ray and **Congratulations**!

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Dates to Remember

tbd

IBA website: www.indianablacksmithing.org IBA Facebook page: www.facebook.com/groups/IndianaBlacksmithingAssociation/

IBA Satellite Groups and News

1) Sutton-Terock Memorial Blacksmith Shop
Meet: 2nd Saturday at 9 AM
Contacts: Fred Oden (574) 223-3508
Tim Pearson (574) 298-8595

2) Jennings County Historical Society Blacksmith Shop
Meet: 2nd Saturday at 9 AM
Contact: Ray Sease (812) 522-7722

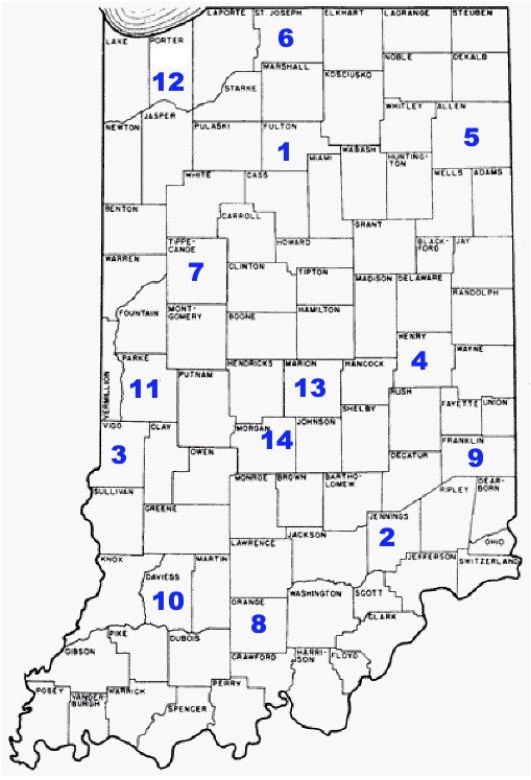
3) Wabash Valley Blacksmith Shop
Meet: 2nd Saturday at 9 AM
Contacts: Doug Moreland (217) 284-3457
Max Hoopengarner (812) 249-8303

4) Fall Creek Blacksmith Shop
Meet: 4th Saturday at 9 AM
Contacts: Gary Phillips (260) 251-4670

5) Maumee Valley Blacksmiths
Meet: 2nd Saturday
Contacts: Clint Casey (260) 627-6270
Mark Thomas (260) 758 2332

6) St. Joe Valley Forgers
Meet: 4th Saturday at 9 AM
Contacts: Bill Conyers (574) 277-8729
John Latowski (574) 344-1730

7) Rocky Forge Blacksmith Guild
Meet: 2nd Saturday at 9 AM
Contacts: Ted Stout (765) 572-2467



8) Meteorite Mashers
Contacts: Mike Mills (812) 633-4273
Steve King (812) 797-0059
Jeff Reinhardt 812-949-7163

9) Whitewater Valley Blacksmiths
Meet: 2nd Saturday
Contact: Keith Hicks (765) 914-6584

10) Bunkum Valley Metalsmiths
Meet: 1st Saturday
Contacts: Jim Malone (812) 725-3311
Terry Byers (812) 275-7150
Carol Baker (317) 809-0314

11) Covered Bridge Blacksmith Guild
Meet: 1st Saturday
Contact: John Bennett (812) 877-7274

12) Snake Road Forge
Meet: 1st Saturday
Contact: Rod Marvel (219) 241-0628

13) Satellite 13
Meet: 4th Saturday
Contact: Darrin Burch (317) 607-3170
Doug Wilson (317) 439-7684

14) Old Town Waverly Blacksmiths
Meet: 2nd Saturday
Contacts: Mike Lyvers (317-728-5771),
Kenny Hale (765-318-3390),
Mike Jackson (317-509-9115).

Jim McClure passed away May 14. Jimmy requested to be cremated. There will be a celebration of life later. Prayers for Jimmy will be appreciated. Jimmy led a good life and influenced many in our lives, both personal and blacksmithing. He would have celebrated his 99th birthday July 4th.-----Jimmy always joked about the Nation celebrating his birthday every year. RIP Jim McClure

https://www.indianafuneralcare.com/obituaries/James-Warren-McClure?obId=13492440

Editor's Note: This article was written by IBA member Ray Phelps and was published by the Rural Smiths of Mid-America newsletter in 1994. It has since been reprinted by the Alabama Forge Council and by the Philip Simmons Artist Blacksmith Guild before coming to us.

Ray's Coat Hook

The coat hook shown here is one made by Ray Phelps at his forge as a demonstration piece for our R S M A meeting of Jan. 1994. The basic design for the hook is one shown in "The Hammer's Blow", p. 8; Fall, 1993

Ray made modifications in the original plans that most of us felt were improvements.

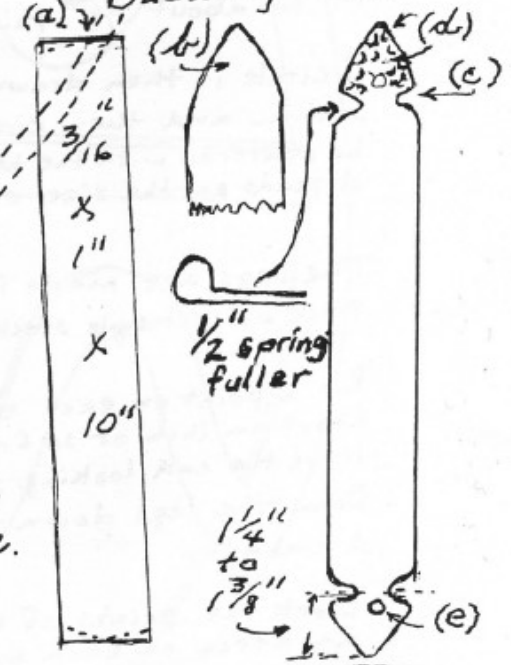
1.(a) He began by rounding the ends of the backing plate with a file (a) to prevent cold shuts.

(b) The ends were then shaped for arrowhead finials.

(c) Notches were made as shown at (c) about 1¼" to 1⅜" from the ends

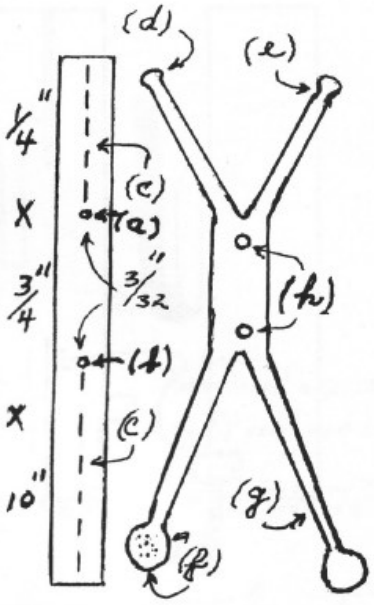
(d) The edges of the arrowheads were chamfered with a hammer and rounded up toward the centerline. Hammer marks were left in to simulate the chipping marks seen in a real arrowhead.

(e) Holes were drilled in the arrowheads (¼") (as shown at (e)) for wall mounting.



1 Demo by Ray P. Write-up by Jim Mc.

Coat Hook (cont.)



2. (a & b) To make the hooks, Ray used the flat stock shown, first drilling holes at (a) and (b) 3" and 4" from their respective ends. Holes were 3/32".

(c) He then split each end up to the holes.

(d) All the arms were spread and each was upset on the end.

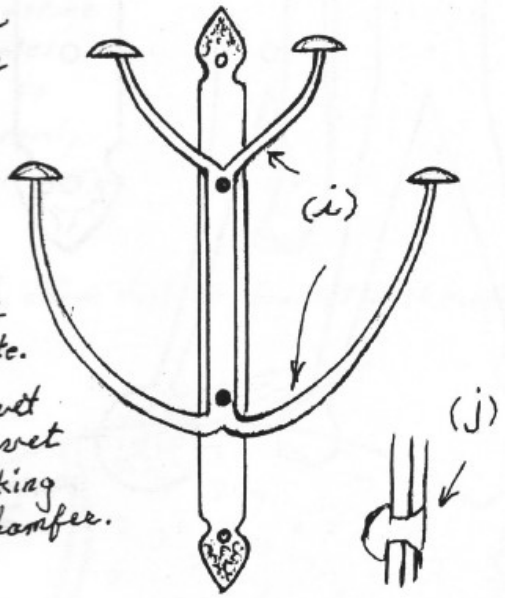
(e) Each end was notched about 3/8" in from the end (but moderately).

(f) Ray forged a 3/4" to 1" penny-foot on each end, cupping each one according to its final position. (See below before cupping.)

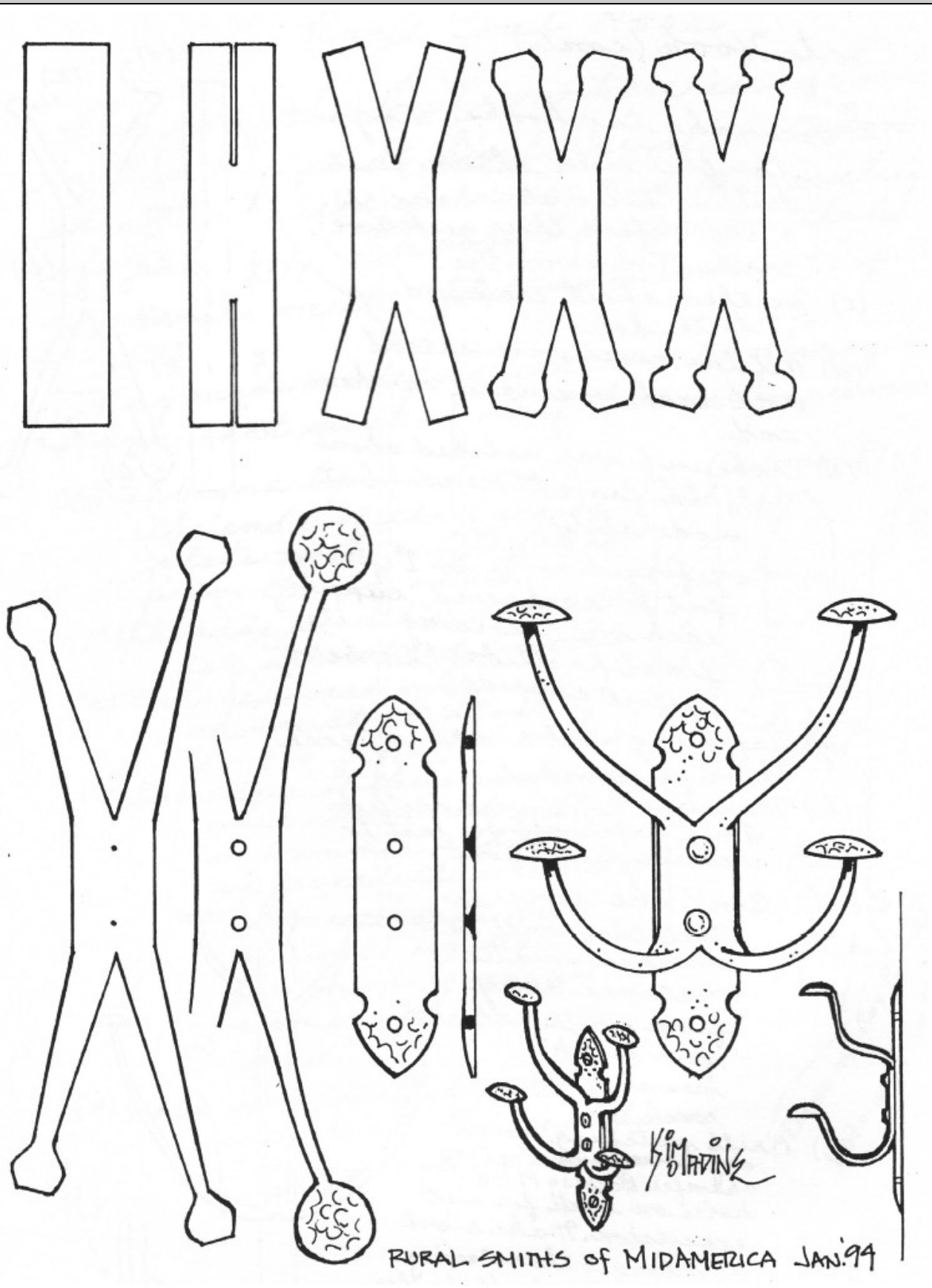
(g) Tapering and rounding each arm came next.

(h) Mounting holes were drilled. This step could be last to reduce distortion.

(i) Bend the arms so that they will be an appropriate distance away from any wall you might mount your rack on.



(j) Drill matching mounting holes in Backing Plate. Chamfer Backing Plate holes on back for rivet expansion. Make rivet 36% longer than Backing Plate thickness for 1/3 chamfer.


KIM D MADDING
RURAL SMITHS of MIDAMERICA JAN.'94

Shop Made Centering Head

Text and Photos by Jim Carothers

The idea for this centering head is not original to me; I think I saw something similar on a woodworking site several years ago. Today I needed a centering head and decided to take these photos:

This article reprinted from the June 2020 edition of the Saltfork Craftsmen Artist-Blacksmith Association newsletter.

My Favorite Tongs

This article is reprinted courtesy of the Michigan Artist Blacksmith Association "The Upsetter" newsletter May-Jun 2020

By Steve Anderson, a MABA member

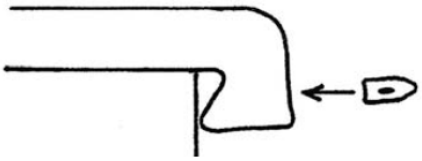
My Favorite Tongs are a unique design which allows forging a larger bit with less work to draw out the reins. They are extremely versatile and their light weight makes them feel like an extension of your hand.

Stock Size	Stock Length (2X*)	Rivet Size Bit	Drill Size
3/8" round	11" (22")	3/16"	3/16" or 1/4"
7/16" round	12" (24")	1/4"	3/8"
1/2" round	13" (26")	1/4"	7/16" or 1/2"

**cut the stock twice as long and forge bits on both ends, then cut in center to avoid having to use tongs.*

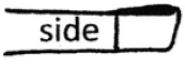
Bend the stock up 90 degrees. Bending 3/4" of an inch for 3/8" stock and 1 inch for other dimensions.

Upset.

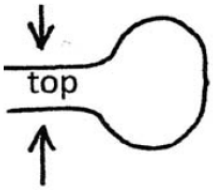


Square up bit ends.

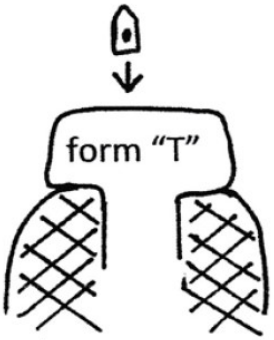
Repeat upset and square steps to drive bit end further down to almost as thick as stock, keeping it square.



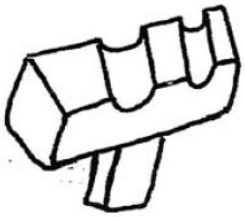
Forge upset down to stock thickness at welding heat.



Slightly flatten sides.

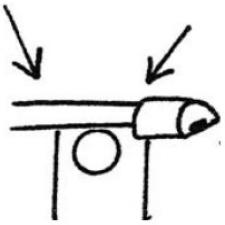


Form "T" in post vise, then square ends on anvil.

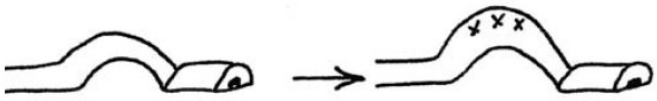


Round the bits in a swage.

Drive a 1/4" rod into the ends to form a groove.



Form an arch by hitting alternately on both sides of the horn **NOT on top**.



Spread pivot point with ball pein, and then re-flatten.

Draw out reins to length and align as shown above.

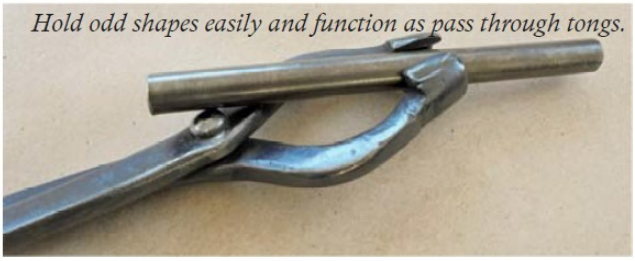
Slit and drift rivet holes and drill to size.

Assemble with a temporary bolt and set bits, offsetting them as shown.

Grind bits to match, and then hold in vise just behind the pivot with a thin spacer. Hold bits together with vise grips and drill hole for bit size from chart.

File grove in bits to taper back and soften edges.

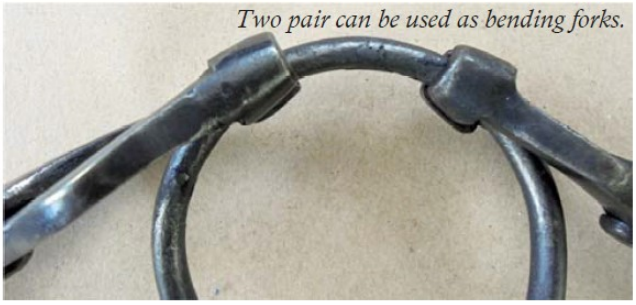
Reset bits if necessary, finish with a file, and rivet.


Hold odd shapes easily and function as pass through tongs.


Hold any shape of stock firmly.


Works well as bolt tongs.


Excellent for forging rings and chain making.


Two pair can be used as bending forks.

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 damag-ing 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!

This article reprinted from the June 2020 edition of the Pittsburgh Area Artist—Blacksmith Association newsletter

Railing Picket- work in progress

By Darla Selander, a MABA member

I started with 1/4x1/2” stock 12” long. I used a large diameter pipe for a jig to keep the element symmetrical. Make both elements the same (the same leg overlapped on the other) so when you assemble it one leg lays on top of the other. Tack with mig and then lightly forge weld each lapped end together. From there, forge weld onto the upright.

The *FORGE FIRE*
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Indiana Blacksmithing Association, Inc.

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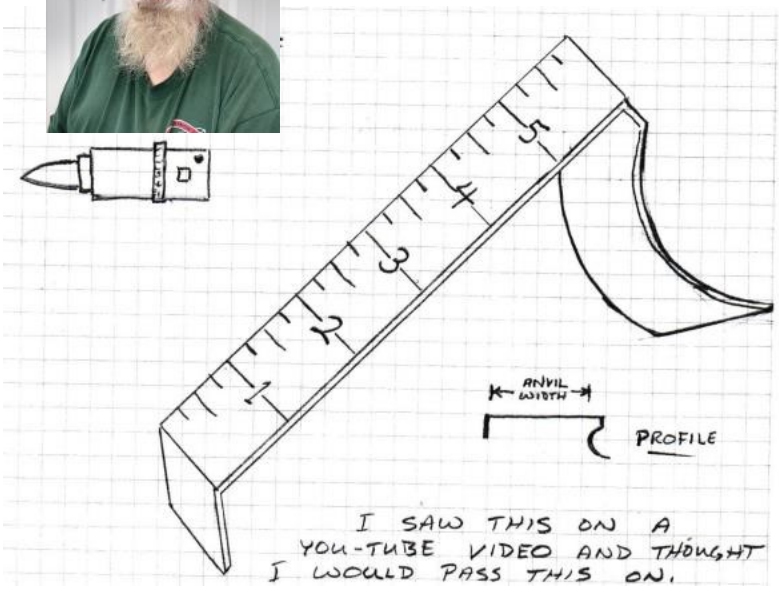

Anvils Rule!

By Phil Travis

This rule will snap in place across your anvil and is held in place by spring ten-sion. I made mine from a scrap of 1" mild steel 1/16" thick. The numbers are stamped in increments of 1/4",1/2" and 1 inch marks and are made with sharp cold chisels of appropriate width. The spring tension keeps it from vibrating loose or moving and allows you to place it where needed. This is not my original idea, I happened to see it on a you-tube video and thought I would pass this on. *Phil credits Dennis Frescett, "DF in the Shop", a series of You-Tube demonstra-tions for this idea.*

Article reprinted from the June 2020 Pittsburgh Area Artist-Blacksmith Association newsletter