

April 2019

## BOARD OF DIRECTORS

### Gary Phillips '22 President:

14800 N SR 167 N  
Albany, IN 47320  
(260) 251-4670  
behere@netdirect.net

### Steve King '22 Vice President:

1155 S. Paoli Unionville Rd  
Paoli, IN 47454  
(812) 797-0059  
kingstephen228@gmail.com

### James Johnston '21

Education Chairman:  
806 Twyckingham Lane  
Kokomo, IN 46901-1885  
(765) 452-8165  
kokomoblacksmith@comcast.net

### John Bennett '21

Secretary:  
741 W Jessup Rd  
Rosedale, IN 47874  
(812) 877-7274  
JohnBennett1959@gmail.com

### Jeff Reinhardt '20

2810 W. Riley  
Floyd's Knobs, IN  
(812) 949-7163  
ptreeforge@aol.com

### Dave Kunkler '20

20749 Lancaster Rd.  
Branchville, IN 47514  
(270) 945-6222  
dwkunkler@yahoo.com

### Bill Corey '23 Vice Pres

3398S CR 225E,  
Danville, IN 46122  
(317) 919-1047  
bc65925@gmail.com

### Aaron Baker '23

#### Librarian:

Larry Rosentrader  
8715 E. 375 N  
Churubusco, IN 46723-9501  
260-693-3267  
lrosentrader@gmail.com

#### Editor:

Bill Kendrick  
1280 N 900 W  
Seymour, IN 47274  
(812) 445-3009  
bill.d.kendrick@cummins.com

#### Treasurer and membership secretary:

Farrel Wells  
8235 E 499 S  
Dunkirk, IN 47336-8807  
(765) 768-6235  
flwells@frontier.com

#### Awards Chairman:

Charlie Helton  
2703 South Water Plant Road  
Westport, IN 47283  
(812) 591-3119  
heltoncs@frontier.com

# 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.

The Indiana Blacksmithing Association, Inc., its staff, officers, directors, members, and hosts and the *Forge Fire*, specifically disclaim any responsibility or liability for damages or injuries as a result of any construction, design, use, manufacture or other activity undertaken as a result of the use, or application of, information contained in any articles in the *Forge Fire*. The Indiana Blacksmithing Association, Inc. And the *Forge Fire* assumes no responsibility or liability for the accuracy, fitness, proper design, safety, or safe use of any information contained in the *Forge Fire*.

*The Forge Fire* is the newsletter of the Indiana Blacksmithing Association Inc. (IBA) IBA is an affiliate of the Artist-Blacksmiths Association of North America Inc. Permission is granted to other similar non-profit organizations to reproduce uncopyrighted articles originally appearing in *The Forge Fire* provided credit is given the original source.

#### 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.

**IBA CONFERENCE AT  
TIPTON COUNTY  
FAIRGROUNDS  
MAY 31—JUNE 2**

**NO HAMMER INS ARE SCHEDULED  
CONTACT GARY PHILLIPS IF YOU WOULD  
LIKE TO HOST A HAMMER IN**



## Editors Message

### The IBA Conference is ready to go for May 31—June 2.

The brochure and registration form should be coming in the mail shortly. For those of you who want to get a jump start, the brochure and registration form are posted on the IBA Facebook page, links are shown below.

IBA Conference Registration (sign up) form:

<https://www.facebook.com/download/preview/276251563322629>

IBA Conference Brochure:

<https://www.facebook.com/download/preview/804100629988658>

Fred Oden is organizing the Iron-in-the-Hat. It will follow last year's concept of high quality items with separate ticket draws for each item. If your ticket is drawn, you have until Sunday to claim your item. You do not need to be present to win. Contact Fred Oden if you have any questions.

We will have the Gallery, so bring items that you have made or acquired.

In addition to the Iron-in-the-Hat we will have our regular Saturday night auction. Items selling for more than \$100 are eligible for a 50/50 split. Please donate items to both Iron-in-the-Hat and to the auction.

Mark Aspery will our primary demonstrator. Steve King and Broadus Thompson are slated to give 1/2 day demonstrations on Saturday. The Friday night demonstration has not been revealed.

Mark will be teaching two **classes at Conner Prairie** before the Conference.

Wednesday May 29: Tool Making.

Thursday May 30: Slitting. Drifting, Punching & Joinery

Classes are \$150/day. Both classes may be full, but contact Jim Johnston for availability/waiting list.

Blue Moon Press will be supporting our Conference again this year. They offer a wide selection of books pertaining to blacksmithing and related subjects. Be sure to visit their booth during the Conference.



<https://bluemoonpress.org>

Call to Order Toll Free 24/7 - 866-627-6922

### INDEX

PGS 3-4  
SATELLITE NEWS

PG4  
IBA BUSINESS  
MEETING NOTES

PGS 5-11  
ABANA  
CHAIN MAKING

### Dates to Remember

April 20 2:00PM  
Memorial Service  
for Charles Gruell  
at Kelley Farm

May 31— June 2  
IBA Conference

IBA website: [www.indianablacksmithing.org](http://www.indianablacksmithing.org) IBA Facebook page:  
[www.facebook.com/groups/IndianaBlacksmithingAssociation/](https://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  
 Dennis Todd (574) 542-4886

### 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 Hoopengartner (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

Meet:  
 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

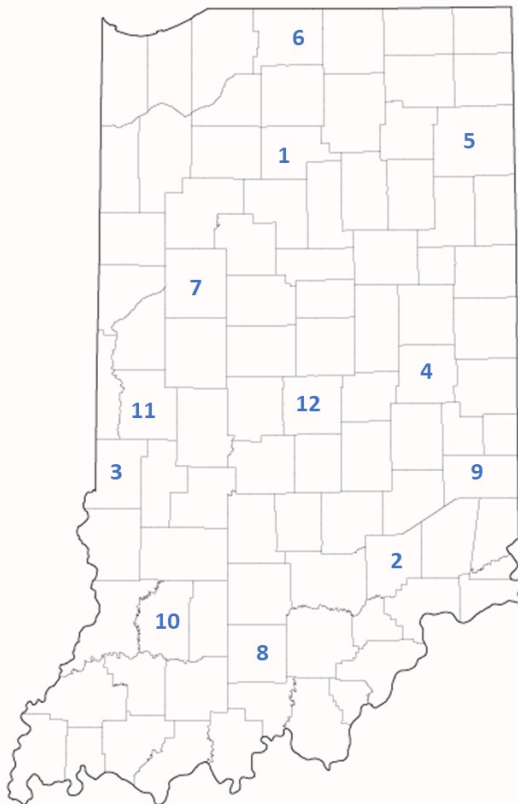
Meet: 1st Saturday  
 Contacts: Jim Malone (812) 725-3311  
 Terry Byers (812) 275-7150  
 Carol Baker (317) 809-0314

### 11) Covered Bridge Blacksmith Guild

Meet: 1st Saturday  
 Contact: John Bennett (812) 877-7274

### 12) Satellite 13

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



### Jennings County Historical Society Blacksmith Shop

The Jennings County Historical Society Blacksmiths met at the forge of Kevin Welsh. After much discussion and a whole bunch of breakfast, Kevin fired up the forge and made a bracket for lighting fixture. Fred Vinup prepped several rods to try out the newly acquired courting candle fixture ( a brainchild of Ray Sease's) which makes an excellent product as Fred found out. Xander Good tried out his skill upsetting a spike. Dave Good took a bearing and proceeded to turn it into a hot cut. Alex Spellman made a latch hook. Brad Weaver, with a little advice from Charlie Helton, made a nice dutch oven lid lifter. We had a record ticket sales for iron in the hat. We left stuffed with a lot of fine food. This was a great hammer in. Our next meeting will be back to the Vernon shop. I hope to see a lot of regular faces who couldn't make it to some of the other meetings. As usual, bring lots of iron in the hat and plenty of cash. Paul Bray



## IBA Satellite Groups and News (continued)

### Meteorite Mashers

This month we met at Dave Kunkler's shop in Branchville. Good attendance on a rainy day. Had both coal and gas forge running. Several folks were forging at the same time just about all day. A billhook, a drawknife and a bowl adz were forged. The next meeting will be at Jeff Reinhardt's shop in Floyds Knobs.

**Our group, the Meteorite Mashers have found that we see a huge spike in new members when we demonstrate at local events. We have a number of demonstration trailers and so forth. We recommend demonstrating as a recruitment tool. If your group does not have an active demonstrator, we may be able to help via coming to a local even and demonstrating with a few of your group so you can see how much fun and many recruits to your group are to be had. We even have a demonstration group The BFH that does big work with team striking and that group is often a paid demonstration group. Team striking really draws a crowd. Try demonstrating and see if it works for you too. You can contact Jeff Reinhardt at [ptreeforge@aol.com](mailto:ptreeforge@aol.com)**

## IBA Business Meeting Notes

New IBA Directors: Bill Corey and Aaron Baker  
Thank you to Bill Newman and Bill Conyers for your service.

IBA Officers: President: Gary Phillips Vice President: Steve King  
Secretary: John Bennett Treasurer: Farrel Wells

Financial Report: I did not get complete information, but IBA did come out about \$2000 ahead over the last year. Farrel Wells plans to send out monthly financial reports to the board of directors.

IBA Conference Update: Summarized on Page 2

MidWest Regional Blacksmith Conference (Pontiac): Will be first weekend in October

Blacksmith of the Year award will be named the Clifton Ralph Blacksmith of the Year.

**Possible new satellite group: If you are interested in forming/joining a satellite group in the Valparaiso area Rod is looking for interested smiths. His shop is located at 38N 600W, Valparaiso, IN 46385. Hammer ins ion 1st Saturday of the month, starting at 9:00 CST. If interested contact: Rod at (219) 241-0628, or email [mechrod@icloud.com](mailto:mechrod@icloud.com).**

Charles Gruell Memorial service: There will be a memorial service for Charles Gruell at Kelley Farm on April 20, starting at 2:00

# The ABANA 2020 Conference.

## The Chain Making Competition: Novice Category



360 Degrees of Blacksmithing



ABANA 2020 June 3-6  
Saratoga New York

Mark Aspery



## Mark Aspery

### ABANA 2020 Conference Competitions #1 Chain Making, Novice Category

Mark Aspery, California.

There will be three evenings of competition during the ABANA 2020 blacksmith conference in Saratoga Springs, NY. Each evening's competition will be divided into three categories - Novice or beginning smith, Intermediate and the Open category.

This article focuses on the first evening's competition, chain making.

The novice category will have 25 minutes to make three links of chain. The links will be examined for quality. The smith having the best three welded links of the group will be declared the winner.



*Three finished links*

It is worth noting that there will be a 30-minute demonstration before each competition starts. This demonstration will be aimed at the Novice project.

If I were thinking about entering this competition, this is what I would do to practice and prepare:

You will be issued with three or four pieces of 6-inch long,  $\frac{3}{8}$ -inch diameter rod - more if you need it. There will be  $\frac{3}{8}$ -inch bolt-jaw tongs supplied by Kayne and Son, some flux with flux spoons and an array of hammers available.

You can start the competition with at least one bar hot, as hot as you like.

You can only use the anvil, tongs and hammer. The vise will be deemed out-of-play in the novice category.

With the middle of the bar hot, bend the bar into a 'U' shape. Strive to get both ends equal with each other and the sides parallel.

If you have practiced, and you know your measurements; you can make the bend in the pritchel hole of the anvil if you prefer.



*Bend the bar either at the bick or in the pritchel hole*



*Get as far as you can working from the top, then turn the link over*



*Keep an eye on the length of the arms, try to keep them of equal length. Stop if they get out-of-whack.*

## The ABANA 2020 conference chain making competition

If the ends don't align, leave the 'U' shape open, and with the bend resting on the anvil, tap the longer leg. This action should shorten the long leg and close the 'U'.

Move another bar close to but not into the fire as you place your 'U' shaped bar, ends first, into the fire.

Heat both ends and pull the bar from the fire, holding the bar at the bottom of the 'U' bend. If one end is cooler than the other, start forging on the cooler end. Hopefully the hotter end will still be at a workable temperature when you have finished with the cooler end.

Place one end on the step of the anvil at a 45-degree angle horizontally, close to the nearside edge. The other leg should be nearly touching the flat face of the anvil.

The edge of the step should bisect the line from the outside corner to a point about  $\frac{3}{8}$ -inch from the end of the bar.

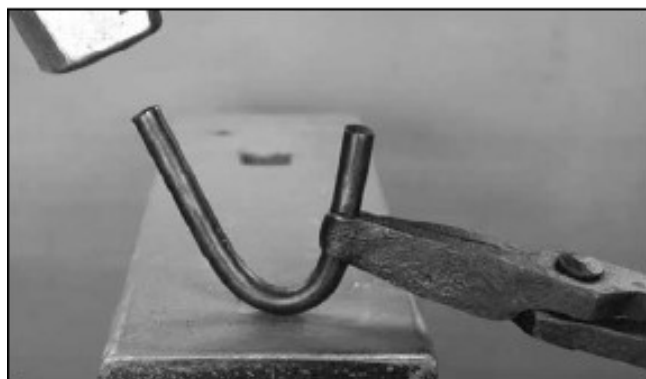
You are now going to make a 'Chain-Step-Scarf'.



*Nothing good ever comes from continuing with a project that has a twist in the stock.*



*If the judge won't let you use the vise, use the pritchel hole to take out the twist*



*Keep the link open if the arms are unequal length*



*This isn't good either. Change the shape from a U to an open V and tap the high side down*



*Hammer on the long arm to shorten and close the link*



*Hold the top corner in line with the step.*



## Mark Aspery

Draw down the end of the bar in such a way that it develops a taper that looks like a flag on the bar.

Strike the end with a moderate blow and create a shallow shoulder. I like to hold my hammer at a slight angle, to match the angle of the proposed scarf taper.

Move the outside corner out  $\frac{1}{16}$  -  $\frac{1}{8}$ -inch, as you pivot around the inside corner of the shoulder and give the end another blow.

Move the outside corner again the same distance and repeat the blow. At no point do you move the inside corner of the shoulder.

Repeat this process until the end of the taper is quite thin and will blend easily into the weld that you are going to undertake soon.

Turn the link over, so that the steps of your scarf are facing up and scarf the second end of the link.

At this stage you are ready to close the link in preparation for forge welding.



*Keep hammering and pivoting to create the slope of the scarf*



*The scarf looks like a flag on the end of the bar*



*Pivot around the bottom contact point*



*Hold your hammer at a slight angle to the anvil face*

As you practice, the aim here is to have enough heat left at the end of forming the two scarves that you can close the link in the same heat.

If that is not the case, then take another heat and close the ends, overlapping them together so that the shoulders of the scarves match up.

Heat to near welding, brush, flux and return to the fire to bring back to welding heat.



*A chain-step-scarf on one end of the bar*



## The ABANA 2020 conference chain making competition



*Turn the bar over and scarf the other end*



*Tap the ends together*



*Note that the original scarf is step side up*



*Keep everything flat in readiness for fore welding*



*Bend the ends so that they overlap each other*



*You might need to level the ends so that the points are aligned*



*Bend the second arm around the bick*



*Weld on the flat face of the anvil first*

## Mark Aspery

It would be nice to finish this weld in one heat, two at max, so take the proposed weld to the upper welding temperatures in order to buy a little extra time at the anvil as you weld.

First weld the two ends together on the flat face of the anvil - working from both sides, then move to the bick to dress the inside and outside seams of the weld.



*Weld the upper and lower seams at the same time*



*Here is my effort, I'm heading to the bick to continue welding*



*Move to the other side of the apex and repeat.*



*Have the apex tilting towards the heel of the anvil as you work*

Working on one side of the apex to the weld, turn the apex of the link slightly towards the heel of the anvil and continue to weld two seams; the one that you can see, and the other resting on the bick.

Turn the link to the other side of the apex and repeat the move, welding both the top and bottom seams of the weld at the same time.

Don't force the weld. If you need another heat to finish the weld, then take it. The judge will be looking for your quality of finish, not just the fact that you got the two ends to stick!



*If your link is a little wonky, dress it on the face of the anvil*

Typically, you will end up with a pointed outside corner at the weld site. I like the look of this result as it speaks to its handmade history. But don't leave the corner and have a bad weld. If the weld needs dressing, use the material stored in the corner to fill the gaps.

The official judge might not like the corner look, so ask and comply.

You will make two single link pieces and then join those two links together with a third link.

## The ABANA 2020 conference chain making competition

With the third link, have the two single links resting on the face of the anvil somewhere near the heel, away from the area that you have been working on.

Bend and scarf the third link. Turn one end in and then move to the other two links resting on the heel of the anvil. With the turned end lowermost, slip the two links onto the open link.



*Turn the second end in and close the gap. Note that the welded links are beneath the tong jaws.*



*After turning one end in, pick up the other two links with the turned end down.*



*The trick now is to weld without letting the other two links get the better of you in the process*



*Keeping the links on the turned side will be an advantage in the next step*



*I try to keep one link either side of the tong jaws as I continue to weld on the bick*

Close the final arm on the third link. Try to keep the fully welded links on the bottom as you close the end of the third link at the bick.

Having one finished link resting above the tongs will lead to the link bouncing and getting in your way as you attempt to close the open end.

Do your best to protect the first two links from the ravishes of the fire, bring the third link up to a welding temperature and weld. You may have to flick the first two links out of the way as you weld the third.

Brush the links while you still have the heat, dipping your brush in the slack tub as you brush can sometimes help pop off stubborn scale pieces, giving you a better looking finished product.

The judge may or may not allow a wax finish on the chain - follow their directions or incur their wrath!

Follow the ABANA 2020 conference on Facebook\*:

**ABANA 2020 Conference**

Register for the conference at:

[www.ABANA.org](http://www.ABANA.org)





## The **FORGE FIRE**

Newsletter of the  
Indiana Blacksmithing Association, Inc.

**Farrel Wells** *Membership Secretary*

8235 E 499 S

Dunkirk, IN 47336-8807

First Class Mail

Address Correction Requested  
If Undeliverable return to  
sender

Indiana  
Blacksmithing  
Association, Inc.



## 39'th ANNUAL CONFERENCE

TIPTON COUNTY FAIRGROUNDS  
TIPTON, INDIANA  
MAY 31—JUNE 2



Featured  
Demonstrator  
**Mark Asperry**

- ◊Exhibit Gallery
- ◊Tailgaters welcome
- ◊Saturday night auction