

May 2020

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# 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*.

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**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 May Hammer In**

**IBA June Conference has  
been canceled**



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TBD

## Editors Message

As noted on the front cover the May hammer in and the June IBA Conference have been canceled. Continued restrictions on group gatherings as well as the potential risks to our make this a sound decision. Jim Johnston is considering an event late in the year. Look for more details in future Forge Fire editions.

Although the cancelations are disappointing, the IBA is solid financially. Many, many years ago Paul Moffett expressed a need for the IBA to be capable of withstanding situations like we have now. That prudent planning means the IBA will continue to plan and host events.

## ABANA Raffle

(see page 4 for web links)

Due to COVID-19 we were unable to have our ABANA 2020 Conference but we still have our raffle items. Help us rise from the ashes by purchasing raffle tickets for these great prizes.

**First prize:**

**BAM box filled with tools made by prominent smiths**

**Second prize:**

**Re-built 100 lb Big Blu air hammer**

**Third prize:**

**240 lb Peter Wright anvil**

Drawing @ The Village Blacksmith Shop 221 North St. Goshen CT August 1,  
2020 @ 7:00 pm

Tickets will be mailed USPS. Winner need not be present.

**All prizes will be shipped FOB Goshen, CT. Winners will be responsible for shipping costs and any applicable tax.**

**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  
 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 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

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

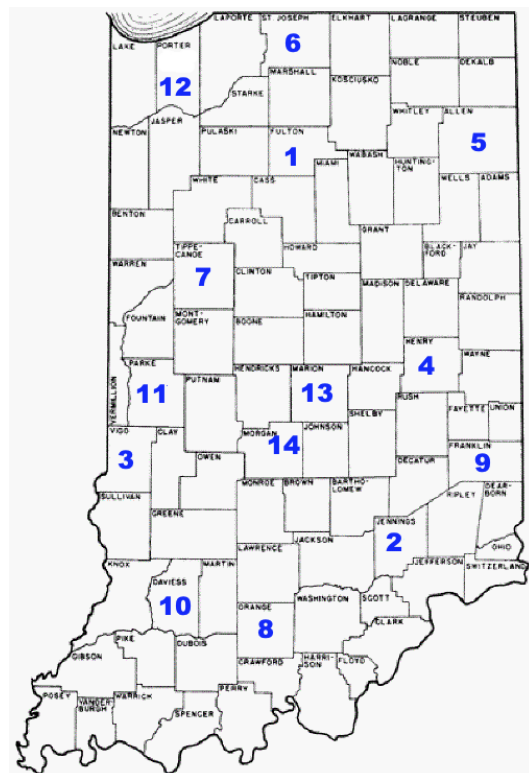
Meet: 1st Saturday  
 Contact: Rod Marvel (219) 241-0628

### 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).



## From the President's Anvil

Greetings to all of you. We have three topics to discuss today:

First, we have been experiencing technical difficulties with the ABANA Server that hosts our website. This occurred late Monday night when our server compacity reached its limits. Our website has been growing exponentially by posting our on-line publications. Frank, our Web Admin, has been working hard to upgrade our system and get back online in a timely manner. This is taking a little longer than expected because our host company has fewer people on staff which in turn is limiting our progress for the upgrade. We should have this back up in a very short period of time, so please bear with us during this process.

Second, you may have seen in our Facebook postings: the 2020 Raffle is about to go live! This event will officially start on May 1<sup>st</sup> 2020. You can go to [www.abanaraffle.com](http://www.abanaraffle.com) or [www.abanaraffle.org](http://www.abanaraffle.org) which will take you to EventSquid. Those of you that have registered for the Conference and already have passwords to log in, simply log in to purchase your tickets. If you have not registered for the 2020 Conference, it will ask you to register in order for us to mail the ticket stubs back to you. Tickets are \$10 each and you can purchase as many as you like and your stubs will be mail to you. Thank you for your support.

Lastly, our new <https://shopabana.myshopify.com/> has now been officially launched. On that website you will find memorabilia for the 2020 Conference, Mini-Anvil's for both the 2020 Conference and non-conference, along with new ABANA specific merchandise. This site is now live and you can purchase items from there at any time.

Thank you very much for your time. Stay safe and have a glorious day.

Leigh Morrell  
ABANA President



## 50 lb Little Giant for Sale

Contact Pete Rogers, 859-552-6502

Location: Central Kentucky

Price \$6000



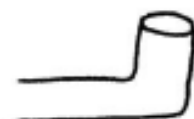
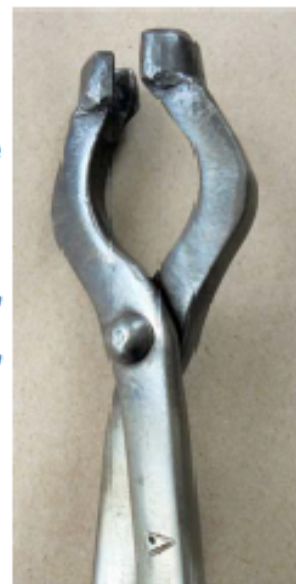
## My Favorite Tongs

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"

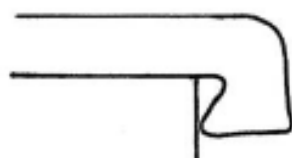
\*cut the stock twice as long and forge bits on both ends, then cut in center to avoid having to use tongs.



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

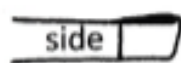


Upset.

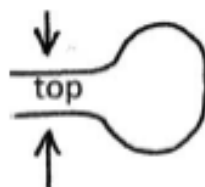


Square up bit ends.

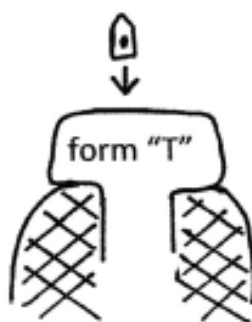
Repeat upset and square steps to drive bit end further down to almost as thick as stock, keeping it square.



Forge upset down to stock thickness at welding heat.



Slightly flatten sides.



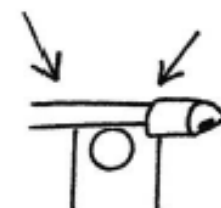
form "T"

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 groove 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.*



## The Harpist's Music Stand

By Bruce Manson

I made the music stand for a lovely and accomplished harp player friend.

The inspiration for the piece is pretty well summed up in the photo. On the occasions I have enjoyed her concerts and seen her play her harp, I have been struck with one thought..... Beautiful lady, gorgeous instrument, wonderful music, ..... and, prominently positioned between those and the audience, a cheap pressed metal music stand that looks like it belongs in a grade school band class. I thought, "We can do better than that!".

Some "technical" data – It weighs 19.2 pounds. Made of hand forged and fabricated steel. Finish is satin black powder coating. About 75-80 hours to make. I found it to be a fun and interesting metalworking project. I learned some new tricks & techniques and stretched my skillset a little:



Colleen performing with the "grade school" music stand.



The die used to form the flutes on the feet. Far left is the clay model used to create the die.

- I made a die for the hydraulic press with tapered & fluted grooves to press the feet, then scrolled the tapered tip and bent the legs to shape.



Fluting die in place in the hydraulic press





Careful layout for the feet, and a sketch for the bottom assembly



The assembled feet



The feet, bottom plate and scrolls are all rivetted together

- I used the fly press with a chisel and guide to groove  $\frac{1}{4}$ " x 1" and  $\frac{1}{2}$ " x  $\frac{1}{8}$ " flat bar for the collars. Made an "out front" bending tool for the fly press in order to form the collars 360 degrees. Formed the collars cold.





Collars in place

- The harp design on the platen was rough cut from 1/8" plate and shaped with belt grinder and files. The "strings" are 1/8" diameter rod welded into the harp frame. The upright sound tube of the harp is raised from the back and slightly curved to provide some 3-dimensional effect. The bass & treble clef symbols are hand forged from 3/8" square bar & textured.
- The finish is satin black powder coat.



*To see the finished music stand in all its glory, see our Gallery, page 10, or visit St. Paul's Episcopal Church in Petersburg, VA when Colleen is performing.*

## Blue Heron

The heron is instantly recognizable to anyone who lives on or near the water. They're pretty easy to recreate in steel. We'll focus on a few distinct features that sets the heron apart from other shorebirds.

These instructions assume that you're using 3/8" square mild steel stock. If you decide to make your heron out of larger or smaller stock, adjust measurements accordingly.

Start by drawing out to a point. Make the taper about 1/2" long.



If you're smart\*, you'll go ahead and neck down the stock about 1 1/2" - 2" from the ridge of the taper. Neck it down to about 1/4", maybe a touch less. This will become the neck of the heron. Go ahead and round the part of the neck stock where it meets the head.



\*I'm usually not smart, and wait to do this until *after* the next step, which is a pain in the neck.

Bend the head stock in half, so that the taper you drew out in step one hangs over the neck stock. Forge weld the head stock into one mass.

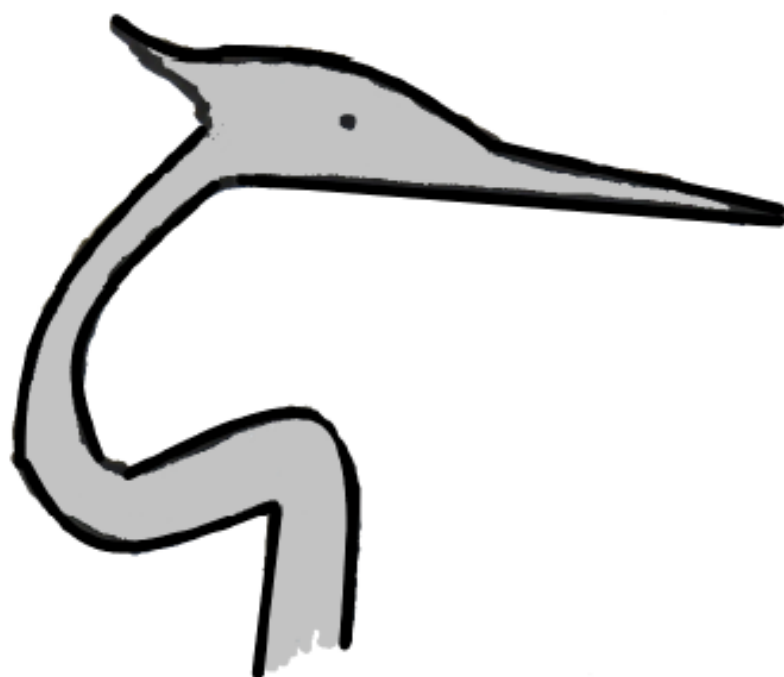


Forge a slight shoulder on the head stock, about 1/3 back from the edge. Then draw out a long taper that will become the heron's beak. Round up the beak and the head—you want no square edges.



Draw out and round the neck. Bend the neck and head into the S-curve that defines the heron. Let cool, then further refine the shape with a file as needed. Use a center punch to add an eye.

I mostly use heron heads on fireplace tools. They've proven pretty popular in coastal markets.







## 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

From PBA Newsletter September-October 2000

## Upsetting

by Jr. Strasil

Upsetting can be a time consuming and frustrating task to perform. With a simple bolster or upsetting bar it can be quick and easy.

Start with a piece of 2" square hot rolled bar about 5" long and drill 6 holes in it as per drawing. Hole sizes are 1" - 7/8" - 3/4" - 5/8" - 1/2" - 3/8". All holes should be 1/64 to 1/32" oversize and very lightly camphered on both sides. Remove burrs from the cut ends and weld on a square shank to fit your hardy hole at the end with the 1" hole.

To use, take a yellow heat on 1 1/2 to 2" of the end of the piece to be upset and taper slightly as in figure 3. Stick the end in the upsetting bar, using a hole about 1/8" larger than the material. Hammer the end of the material. Remove from the block and realign the upset end of the rod with light blows, so you don't undo the upsetting. If a longer or larger upset is needed, taper the end before heating and repeat the procedure.

Upset only 1/8" at a time to control cold shuts and bending of the end. If it sticks in the hole, wait a little while and it will cool and shrink and then slip out easily.

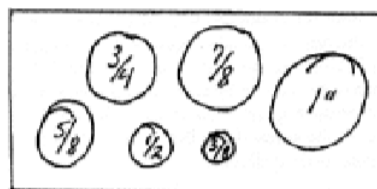


Fig 1

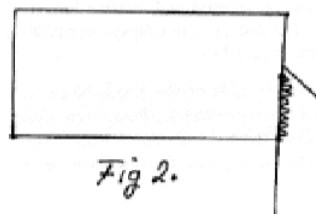


Fig 2.



Fig 3.