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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.

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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.

Sept 16 2017	BARTHOLOMEW COUNTY 4-H FAIR GROUND
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Oct 21 2017	TBD
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Nov 18 2017	TBD
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Dec 9 2017	TBD (2ND SATURDAY)
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TRAIL OF COURAGE

Dates to Remember
Sept 22-24 Quad State SOFA
Oct 13-14 UMRBC

Editors Message

It is short notice, but we will have a state hammer in on Sept 16 at the Bartholomew County 4-H fairgrounds. The smithy has four demonstration forges, so we should have plenty of hammering going on. The hammer in is hosted by the One-Armed Blacksmith Shop. The IBA board will also convene for a regular business meeting. Directions are posted on the back page.

Check the IBA web site and/or Facebook page for up coming hammer ins.

We have two major blacksmithing events coming up in the region.

- ◆ SOFA will be hosting their annual Quad State hammer in September 22-24. Details are posted on page 11 or check the web site:
<https://sofablacksmiths.org/event/quadstate-2017/>
- ◆ Upper Midwest Regional Blacksmith Conference will be held October 13-14 at the Threshermen's Park in Pontiac, IL. Pep Gomez and Mark Asberry are the feature demonstrators. Mark will also be conducting classes October 9-11. Full details and registration forms are available at the following web site: <http://umrbc.org/>

As the cooler weather settles in we have an uptick in local festivals. The annual Trail of Courage festival will be held Sept 16 & 17 at the Fulton County Historical Society grounds just off US-31 by Rochester. If you find yourself in Northern Indiana will some free time, I encourage you to stop in. They are looking for demonstrators in the blacksmith shop. If you are interested contact: fchs@rtcol.com.

This month I have included a single article on chasing solid material. The article was written by Tom Latane and was originally published in the ABANA Hammers Blow. I hope you find it as interesting as I did.



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
 Dennis Todd (574) 542-4886

3) Wabash Valley Blacksmith Shop

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

5) Maumee Valley Blacksmiths

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

7) Rocky Forge Blacksmith Guild

Meet: 2nd Saturday at 9 AM
 Contacts: Ted Stout (765) 572-2467

9) Whitewater Valley Blacksmiths

Meet: 2nd Saturday
 Contact: Keith Hicks (765) 914-6584

11) Bunkum Valley Metalsmiths

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

13) Satellite 13

Meet: 4th Saturday
 Contact: Bill Newman (317) 690-2455

2) Jennings County Historical Society Blacksmith shop

Meet: 2nd Saturday at 9 AM
 Contact: Ray Sease (812) 522-7722

4) Fall Creek Blacksmith Shop

Meet: 4th Saturday at 9 AM
 Contacts: Gary Phillips (260) 251-4670
 Dave Kline (765) 620-9351

6) St. Joe Valley Forgers

Meet: 4th Saturday at 9 AM
 Contacts: Bill Conyers (574) 277-8729
 John Latowski (574) 344-1730

8) Meteorite Mashers

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

10) One-Armed Blacksmith Shop

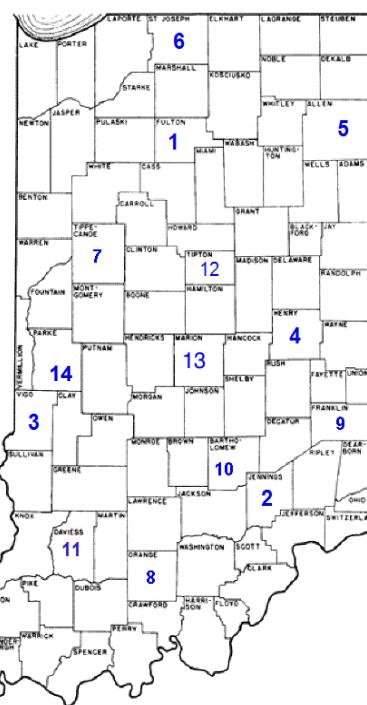
Meet: 1st Saturday
 Contact: Tim Metz (812) 447-2606

12) "Doc" Ramseyer Blacksmith Shop

Location: 6032W 550N, Sharpsville, IN 46060
 Meet: 3rd Sunday at 2 PM
 Contact: Charles Gruell (765) 513-5390

14) Covered Bridge Blacksmith Guild

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


Jennings County Historical Society Blacksmith shop

The Vernon Blacksmith group hammer in was a very great meeting. Bill Kendrick and Charlie Helton upgraded and fine tuned our new power hammer. The hammer hits very hard. A safety and how to use demo was given . Three members then used the hammer for the first time. Kenny Dettmer reshaped the dies. A new member, Paul Honey, forged for the first time ever! He was assisted by Kevin Welsh and Ray Sease. The first time hammer users were Jack Neukam ,Alex S. and Dave McNulty.

Labor Day week end will be split between Hayden blacksmith shop, Vernon shop, and Friendship. We are hoping for a good turnout so which ever you go to will be appreciated. The Vernon blacksmith shop will be open on the regular stated meeting on the 9th . hope to see you there.

Submitted by Ray Sease and Paul Bray.

IBA Satellite Groups and News (continued)



Bunkum Valley Metalsmiths

The Bunkum Valley Metalsmiths met with over 30 in attendance. We loaded up for the annual White River Valley Antique show which starts this Thursday and runs thru Sunday. We also had plenty of smithing and learning going on. And of course some tall tales on the porch. It was a great day, lots of good food and fun! Come and see us this week at the show as we operate the blacksmith shop and demonstrations for all the visitors!



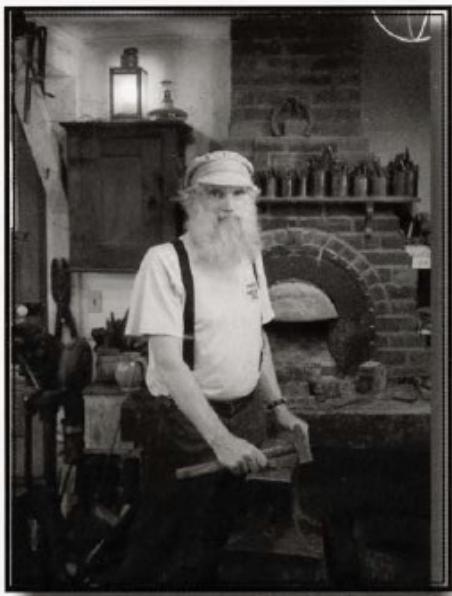
Rocky Forge Blacksmith Guild

The beautiful August weather made for a good turnout at Ted Stout's shop. There were 22 people in attendance. Several people worked on their knives from the June meeting, while others worked on candlestick holders. There was an excellent lunch of chicken and noodles. The Iron in the Hat brought a number of interesting items such as a large sawmill blade, a snowblower, and several different materials for making knife handles.



This 6 page article reprinted from ABANA's The Hammer's Blow, Winter 2017

Chasing Solid Material



by Tom Latané
HB Staff Writer
Photos by Catherine Hillman Latané



Image #1: Finished chasing

Chasing solid material employs the same tools and is similar to chasing sheet, except that there is no downward displacement, nor embossing from the back. With solid stock the basic surface contour is forged and any major depressions are made while the material is hot. Pieces not flat on the back can be supported by a depression carved or burned in a dampened wood block to avoid deforming the forging. (Steam from the wet wood is annoying, but does not sting the eyes like smoke.) The rest of the detail is achieved with the metal cold. Because of the mass of solid stock, deformation is limited to the surface. Displaced metal is forced to either side as each tool presses into the material. As resistance builds on the sides, metal is forced out from the surface. This action adds dimension and can be used to upset material well above the original ground.

I have chosen a stylized acanthus leaf as an example because it employs many of the different types of chasing tools I use.



Image #2: Planisher (left), and four various butchers

These are the terms I use for my tools:

Planishers are flat or slightly domed on the end and have most or all of the edges rounded. On some I leave one edge square for working up to corners. The planishers smooth and shape flat or convex surfaces.

Butchers are what I call any tools with offset leading edges and ends at a variety of angles. They are used to produce steps in surfaces and come in several sub-types. I will call the angled part that contacts the surface of the workpiece the "end" and the side adjacent to the leading corner the "face."

This 6 page article reprinted from ABANA's The Hammer's Blow, Winter 2017

Straight butchers have flat ends and flat faces meeting at various angles, in straight leading edges. They are used to create straight steps and those with convex curves.

Curved face butchers have flat ends at a variety of angles, and faces with a variety of curves. They are used to produce steps with concave curves and, in making this leaf, to reach into the valley to upset the center vein.

Curved end butchers have ends of various curves at assorted angles to flat faces. They are used to chase straight steps through concave areas. In making the leaf they will also be used to give the leaf edge curved indentations.

I have a few butchers of other configurations (concave curves and curves on both face and end), but I rarely use them. I did not use them to make this leaf.



Image #3: (L to R) Center punch and liners

Center punches produce inverted conical depressions of various sizes.

Liners are chisels that produce lines of different widths depending on the angle to which they are sharpened, and the depth to which they are driven. They can be sharper than liners used on sheet because there is no danger of tearing through thick material. I make them straight and in different curves. I chamfer the corners on the sides of many of them to prevent corner nicks, but do not crown the center. I leave square corners on some for use where there is an abrupt stop. You can round the side corners of one end and always trail with that end while saving the square-edged end for working up to a step.

Rounds are dome-ended punches that produce rounded dimples in assorted sizes.



Image #4: (L to R) Round tool, fullers, and teardrop tool.

Fullers are like chisels with the ends ground to various radii to produce rounded grooves. I make them straight and in assorted curves. They can have one edge ground square for ending a groove at a step and the other ground rounded to planish the groove when trailing.

Teardrop tools produce teardrop indentations of different sizes. Those with longer teardrop shapes can be used to create tapered grooves by rocking them toward the narrow or wide end while chasing the groove.

Note: My tools are tapered toward both ends, leaving the greatest resistance to flex in the center where it is most needed. When I started forging in the 1970's, a stone carver told me that the taper keeps the force centered down the length of the tool. I also like the way it looks.

I harden both ends of my chasing tools and temper the struck end a bit more (business end brown, struck end blue). When struck with a soft-face hammer, the ends of the tools mushroom very slowly. I keep them in cans according to type. Storing them business end up, I survey the selection and can pull one out without lifting others by a burr on the end of the first. I dress the soft-face hammer by re-forging once a year. Not only is it safer to avoid striking hard steel with hard steel, but the soft-face hammer is less likely to send tools flying across the room (though it is not absolute insurance).

A leaf will be chased on the jaw of a 3" bench vise. After forging, any filing to be done must be completed before the chasing. I do not want to remove the material that is left standing above the original surface (by chasing) because it adds to the design.

This 6 page article reprinted from ABANA's The Hammer's Blow, Winter 2017



Image #5: Basic leaf design applied with a Sharpie™ marker.

I draw the basic leaf design (without any sub-lobes or edge detail) in the space it will occupy with permanent ink using a Sharpie™ Fine Point pen. In drawing and chasing this type of design, I am dividing and subdividing the spaces. I draw the pointed end of the leaf, then divide the width of the leaf in half with the center vein. On each side of the vein I draw a dot in the center of the crown of the convex curve. I then connect this with a gentle arc to the spot where the curved tip of the leaf meets the straight side of the stock. This drawing is enough to establish the leaf. I have clamped the piece to a short block of steel held in the vise, because it has no parallel sides to fit in the vise, and it is not flat across the bottom,



Image #6: Beginning with a curved-face butcher.

I start chasing the center vein at its base with a curved face butcher placed so the angled end will push material away from the vein.



Image #7

Note: I once had a class in which half the students, perceiving that a triangular ridge was the goal, turned the butcher the wrong way and achieved a ridged vein after the first step. However, the vein did not end up taller than the surrounding surface, and they had trouble forcing the unwanted material away from either side of the vein.



Image #8

The straight butcher is used over the convex surface.

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Image #9

The curved end butcher is used through the valley. The two sides of the vein should meet before reaching the tip of the leaf. When developing the shape, cracks are likely to form if the lines of the vein and those of the leaf edges meet in the same place.



Image #10

A straight butcher can be used to form the leaf tip with a slight convex curve. Before I accidentally rub away any more of the ink lines, I designate the bottom of the cleft between the major leaf lobes with a center punch. Sometimes it is necessary to remove ink lines with abrasive paper or a wire brush, so that the true shadow can be seen without the distraction of the dark ink.

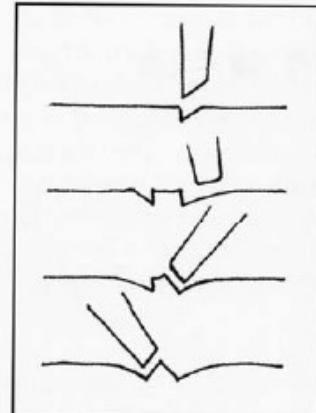


Image #11

A pass with the butcher leaves a dramatic step and a more subtle line where the angled facet meets the surface. In many cases the more subtle angle and the dramatic edge can be pleasing. In this case, I planished away the more subtle line to create a gentle curve from the original surface to the bottom of the steps forming both sides of the vein and the leaf tip.

Material pushed to the sides of the bar when chasing the leaf tip and base of the center vein is filed away before any desired protrusions are created.

I use a butcher with very little angle (leading edge against the base of the vein) to planish the sides of the vein to a ridge, upsetting material above the original surface level. Where the edges are concave, a curved-end butcher is used. A straight butcher is used where edges are straight, and in the valley a curved-face butcher is employed.



Image #12

This 6 page article reprinted from ABANA's The Hammer's Blow, Winter 2017

A curved liner is used to chase a gradual arc from the center punch mark on either side of the main vein, to the junction of the leaf tip with the straight side of the bar. I use a small teardrop tool to transition the bottom of each crease into the center punch depression. The liner is tipped toward the outside and driven deeper to widen the crease at the edge of the leaf. The upper lobes formed by the crease are then sub-divided by chasing a minor crease in the middle of each. These are opened at the leaf edge by driving the liner deeply, at an angle.

The leaf tip can be set off by slightly undercutting with an acutely angled straight butcher. To give the perimeter of the leaf some vitality, the edge can be broken by driving curved-end butchers and liners with square edges in from the outside. Try to achieve an interesting form by contrasting sharp indents with rounded convex curves and pointed tips with concave indents.



Image #13



Image #14

Variations

The smallest of the chisels in image #14 was used to chase the rope segments on the bead below the leaf in image #16. A bead can be created in a flat area by chasing a ridge like the leaf vein and rounding the top. This bead was filed across the bar. The hollow chisel must be wider than the bead to reach diagonally across it. If twisted until both points catch on the bead, the chisel will make indentations of uniform angle as long as the width of the bead is consistent. Spacing is left to the eye. I make the concave arc in the chisels flatter than the round of the bead, so the crown of the bead will be satisfactorily indented before the points of the tool dig as deeply into the recesses on either side.

As a simpler exercise, the leaf in image #15 was chased on a flat bar 3/16" thick.



Image #15



Image #16

The leaf in image #16 was created with the ground above the leaf tip stepped back to a flat plane so the leaf stands out more. During the forging stage the bar was butchered, then leveled with a flatter. The material which was pushed to the sides by this process was then cut away with a chisel.

The bolster on this hacksaw frame (Image #17) was chased in the round. The circular impressions and the spaces between the leaf tips were chased hot while a helper held the piece over a wood block. The cold chasing was done while the piece was still on the end of the bar, which could be held over the wood block by the vise. A teardrop tool was used to create the flutes in the lobes.

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Image #17



Image #18



This baluster form (Image #18) was held by wood blocks in the vise for the cold chasing. A pair of hardwood pieces, wide enough to reach the top of the jaws when resting on the tube of the screw box and as long as the baluster section, was loosely bolted at the bottom to a spacer, narrower than the forged piece. When forging was completed, the hot baluster was placed between the wood pieces so that a cavity, conforming to the curves of the metal, was burned near the top of each piece of wood. As a result, the cold baluster could be securely clamped between the wood jaws in the vise and rotated as needed. ■

Blacksmiths, Artist –Blacksmiths – you are invited to the 42nd Trail of Courage Living History Festival

Sept. 16-17, 2017, Rochester, Indiana.

Fulton County Historical Society grounds, 4 miles north of Rochester on US 31 and Tippecanoe River. Address 37 E 375 N, Rochester IN 46975.

Earn free admission by demonstrating at the Sutton – Terock Blacksmith Shop in the Living History Village called Loyal, Indiana beside the Round Barn. Or at Fred Oden's Tiosa Forge at the south end in the woods.

Pre-registration is encouraged. Registration form is on www.fultoncountyhistory.org.

Hours are Sat. 10-6, Sun. 10-4, rain or shine. Bring the whole family to join the fun. Wear your historic work clothes. Swap ideas. Enjoy foods cooked over wood fires, canoe rides, two stages with music and dance, historic camps, traditional crafts and trading, muzzleloading shooting & tomahawk throwing contests, mountain man tug of war, more. If you want a booth or camp to sell your crafts or wares, register early. Fees may apply.

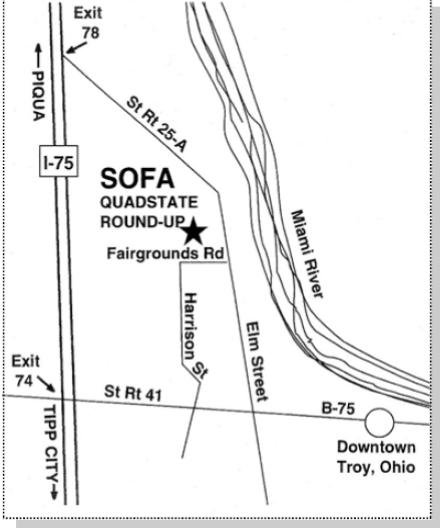
For more information, contact Fulton County Historical Society at 574-223-4436. fchs@rtcol.com.

Special this year: Sharon Hoogstraten, Citizen Potawatomi Nation, will exhibit "Dancing for My Tribe" photos and program Sept. 15 at 7:30 pm in the museum Friday evening before the Trail of Courage. Have you ever seen a Transparent Image 12 feet long by 8 feet tall? It shows a giant oak tree west of Jacksonville, Ill., which is so old it was there when the Potawatomi went through on the Trail of Death in 1838.



SOUTHERN OHIO FORGE & ANVIL

Registration on line at: sofablacksmith.org
or request a copy by mail: SOFA, P.O. Box 727, Troy OH 45373



A great learning experience!

Friday, Saturday and Sunday
September 22-24

- 2 days of demonstrations.
- Ironwork gallery.
- Large & small tools found at the huge tailgate sales.
- Meet smiths from all over the world.
- Blacksmithing books for sale.
- Learning forge stations.
- Forging competition.
- Camping on the fairgrounds available.

Demonstrators-
 Michael Bendle, Delphos, Ohio - Repoussé
 Joe Bonifas, Spencerville, Ohio - Contemporary
Emmert Studebaker Commemorative Project
 Richard Sullivan, Columbiana, Ohio - Forge Rifle Barrel Colonial Williamsburg
 Kevin Cashn, Hubbardston, Michigan - Blade Smithing
 Nathan Allan, Conner Prairie, Indiana - Traditional
 Benjamin Lockhart & Danielle Russell, Logan, Ohio - Basic Blacksmithing

◆ Friday Night Forging Demonstration by Pete Braspenning
 ◆ *Gallery Judged Category "Lighting Fixtures"*

Display your work at SOFA!
 Exhibition: One of the highlights of Quadstate is the Gallery Area, and everyone is encouraged to bring samples of their work to display. Beginning smiths are especially encouraged to show their works; as well as spouse and family member's crafts.



The FORGE FIRE
Newsletter of the
Indiana Blacksmithing Association, Inc.

Farrel Wells *Membership Secretary*
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Dunkirk, IN 47336-8807

First Class Mail

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**September 16 Hammer In
Bartholomew County 4-H Fairground
Hosted by One-Armed Blacksmith Shop**

750 W 200 S, Columbus, IN 47201

Directions: I-65 Exit 68 east on SR 46. Turn south on SR 11. First traffic light is CR 200S, turn right at the light. Blacksmith shop is in last building facing CR200 S.

Lunch will be carry-in. The Sept. Business will be held onsite.