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January 2019

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.

**Jan 19
2019**

BILL CONYERS' SHOP

**Feb 16
2019**

**KEN DETTMER'S SHOP
COLUMBUS**

**Mar 16
2019**

BUSINESS MEETING

**Apr 20
2019**

TBD

INDEX

PG 3

CLIFTON RALPH
PHOTOSPGS 4-6
SATELLITE NEWSPGS 7-10
FILING VISEPG 11
DECEMBER
HAMMER IN**Dates to Remember**March 9
Celebration of Life
of Clifton RalphMarch 16
Annual Business
Meeting at Kelley
Farms**Editors Message****Celebration of Life of Clifton E Ralph**

March 9 12:00—4:00 CST

Location: Knights of Columbus Hall, 1400 S Broad St, Griffith IN

A luncheon will be served. Please RSVP number of attendees to conz@comcast.net or text to 219-929-5488 or directly respond in the Facebook link: <https://www.facebook.com/events/2211150895874105/>

Note the celebration begins at 12:00 Central time.

Many of you have already heard that Clifton Ralph passed away. His family is planning a service on March 9, which would have been Clifton's 88'th birthday. Clifton has been a great inspiration to many of us.

He was an icon in the blacksmithing community with skill and knowledge that few could match. His style was direct and to the point.

May he rest in peace and know that he will be missed.



We have hammer ins set for January and February. This month, the St Joe Valley Forgers will be hosting at Bill Conyers' shop in South Bend. February will be at Ken Dettmer's shop in Columbus. Directions are posted on the back page.

March will be the IBA annual business meeting at Kelley Farms just off US31 between Tipton and Kokomo. The annual business meeting includes election of new board members. This year Bill Newman and Bill Conyers terms are expiring. Anyone interested in running for one of these positions should contact Gary Phillips (ph: 260-251-4670). Nominations are needed immediately so the ballot can be included in the February Forge Fire.

Charlie Helton is seeking nominations for rookie of the year and blacksmith of the year candidates. Nomination forms and guidelines are posted on the IBA web shown below (go to "membership" tab and scroll down to "awards"). Nominations are due by April 1. Charlie is encouraging each satellite group to submit nominations for both.

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

Clifton Ralph

Photos courtesy of Dominick Andrisani



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

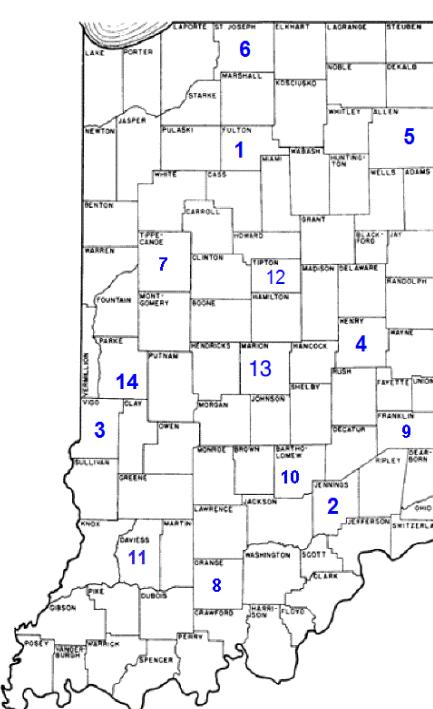
Meet: 1st Saturday
 Contact: Tim Metz (812) 447-2606

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 December hammer in for the Jennings County Historical Society Blacksmiths was held at John Cummins forge. This is a great shop that anyone would be proud to own. Add a bed and bath and you could live here. Broadus and Angus Thompson worked very diligently on a log roller(cant hook). Nicely done! Nathan Pelvor drew out material for a set of tongs from leaf springs. Broadus then worked on a knife blank. There was more food than all of us could eat in two days! There were two door prizes and a couple of bonus prizes. Lots of iron-in-the-Stetson to be had.

The next meeting is at Paul Brays(mine) 139 South Park Drive, Seymour.

February-Kenny Dettmer's ,15721 250W Columbus,IN. NOTE; State meeting same place on the following week.

March is at Kevin Welch's,25619 Gill Rd., Nabb,IN. Hope to see ya in January!

Paul Bray

IBA Satellite Groups and News (continued)

Meteorite Mashers

This month the Meteorite Mashers met at Dave Kunkler's shop in Branchville. We had a number of new folks to come visit. Aaron Baker demonstrated several knives, with Eduardo Sol helping. One was a RR spike knife with a 1084 inserted and welded for a good cutting edge. The crowd was good, the shop was warm and the food excellent. I do believe that a good time was had by all. The next meeting will be at Jeff Reinhardt's shop in Floyds Knobs.

Fall Creek Blacksmith Shop

8 smiths showed up. the furnace wasn't working. Lesley Hale made dogs, Tom White did crosses, Jamie worked on hooks for his shop to be. Gary had a rr spike (I don't know what he was making ?) I tried a new idea making a snow flake from sheet metal (not good) and forged a blank letter opener for inserting a marble later. The stock was from a refrigerator my grand son scrapped. At first I thought it was stainless, but ended up plated. I made sure no toxic fumes came when heating but the material was tougher than plain mild (probably the plating) making it tougher.. This was a shelf bracket originally.-----Rural Smiths had a demonstrator from Missouri a few years back that used metal sheet from appliances and he made flowers and crosses from salvaged material

reported by Dave Wells



IBA Satellite Groups and News (continued)

Bunkum Valley Metalsmiths

The Bunkum Valley Metalsmiths met Saturday the 5th. The weather really cooperated with us. Around 30 were in attendance with 4 newcomers. Lots of forging, teaching, a good iron in the hat and some great food. We welcome anyone who is interested in observing or learning about metalsmithing. We meet the first Saturday of each month beginning about 9am in Odon Indiana. Happy New Year!

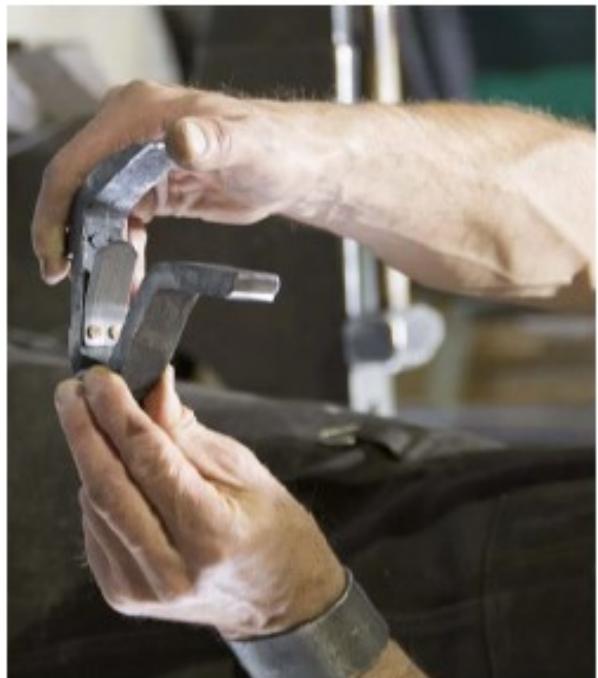


On May 18, 2018 James Makely demonstrated the making of a filing vise based on the vise in Mark Aspery's book: The Skills of a Blacksmith Volume II.

This is a general description of the process. The details are in Mark Aspery's book Volume II. RMS offers Volumes 1, 2 and 3 for sale for \$60 each.

Article and photographs by Mike Otis

A filing vise fits into a post or machinist vise—it has smaller jaws that are bent so that the piece to be filed is held at an angle. The tool is made up of two jaws, a spring (as seen in the picture at right) that pushes the jaws open slightly, a stop (below) that keeps the vise from sliding down in the post vise and a rivet that holds the jaws together and provides a hinge. The vise can be left open in the post vise by virtue of the spring and the stop. A few other parts will be listed as we go.



James started with 2 pieces of 1/2" X 1" X 7" bars noting that the lower jaw would end up being about 1" shorter than the top jaw.

Start by upsetting one end of each bar on the anvil (right) The upset should be about 3/4" thick and will become the boss. Chamfer the edges of the upset then move to a round swage.



Editor's Note: This article reprinted from the Summer 2018 edition of Forge Facts, a publication of the Rocky Mountain Smiths

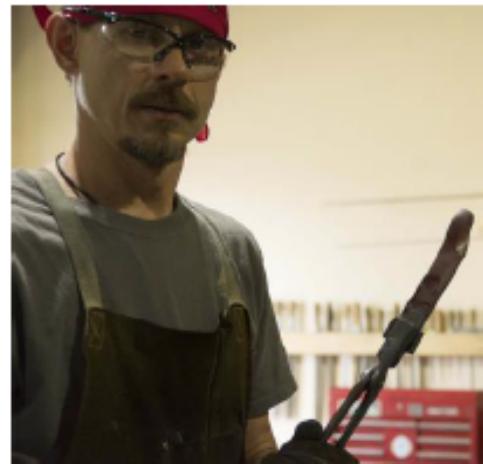
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Round the upset end both in a swage block or an anvil bottom swage and at the anvil. File to clean up as necessary.



Once the end is nicely rounded, move the rounded end over the edge of the anvil and knock the boss down so that one edge is in line with the jaw as in the photo at left.



Using half-faced blows on the boss, offset it as in the photos at left, and right above. Lay the diameter of the boss plus 1/8" of the bar on the anvil with the bar at 45 degrees to the edge of the anvil for the half-faced blows. Form a disk about 1/2" thick.

Punch and drift 5/16" holes in the bosses for the hinge pin. The rivet will be 5/16" (or 3/8" if the punched holes end up slightly bigger) by 1-1/2" long.

Mark Aspery says the distance between the center of the punched hole on the boss and the bend on the lower jaw should be about 3-1/2", but check the fit in your post-vise to be sure the boss doesn't bottom out on the screw casing of the post-vise. If the 3-1/2" dimension works, the lower jaw should be marked 3-1/4" up from the center of the punched hole in the boss so that you can see the mark when the jaw is heated. Heat the jaw and clamp in the post-vise with the mark right on the top of the post-vise jaw.

To see which way to bend the jaws, look at the picture at right: The top jaw that has the spring riveted to it is bent in the same direction that the boss/hinge plate protrudes. The bottom jaw on the left of the picture is bent away from boss/hinge plate. The picture below (of the lower jaw being bent with the flatter) shows the direction of bend in relation to the boss.

Bend the lower jaw using a flatter. (Below)



The top jaw is longer than the bottom jaw as seen in the picture at right. (even though the bottom of the bosses are not dead-even you can see the top jaw is longer) Measure up 4 inches from the center of the boss rivet hole and center punch, as long as the measurements given so far work with your post-vise. The center punch can be seen in the photo above on both jaws. Clamp in the vise as with the bottom jaw and bend slightly more than the bottom jaw.



With both jaws bent - now is the time to fit them together with a bolt in place of the rivet for the hinge. Tweaking and filing (more or less depending on how the forging went) will be needed to achieve a good fit. Filing the high spots where the filing vise jaws contact the material being held will increase the holding power. Some chamfering and filing on the tips of the jaws should be done for the look in the picture at right.



Lay out the stop by loosely clamping the upper jaw in the post-vise 2" or so below where the bend in the jaw is. Scribe a line at the top of the post-vise— this marks the bottom of the stop. The stop will be a piece of 1/2" X 1" bar lay out the tenon hole 1/4" above the scribed line centered on the jaw. The tenon will be 3/8" so drill a 3/8" hole on your layout mark.

Continued on next page

The stop is 1/2" thick so lay out lines 1/4" above and 1/4" below the center of the drilled hole. Use a hacksaw to cut a slot to fit the 1/2" bar. Be careful which side of the line you saw on—you don't want too much slop in the slot. Cut 1/16" to 1/8" deep with the hacksaw so your layout lines just disappear. Make more cuts between the two outside saw cuts and chisel out the slot as the picture on the previous page shows.

Better to have the slot slightly tight and file both sides to fit.



Counter-sink the hole on the inside of the jaw so the tenon will be flush (left).

For the tenon James necked down the end of a 1/2" X 1" bar and worked it down to size under the power hammer with a 3/8" thickness stop bar. He cut the tenon off with a hardy hot-cut, cleaned up the end

of the tenon at the anvil, set the heated tenon-end of the bar into the slot over the pritchel hole with the tenon in the punched hole and lightly hammered it home. (This also served to monkey the tenon.) Then he set the tenon from the other side into the counter-sunk hole (not pictured). He used two 1/8" rivets for the spring. James used a piece of band-saw blade for the spring. Rivet the jaws together with a 5/16" rivet—you're done.

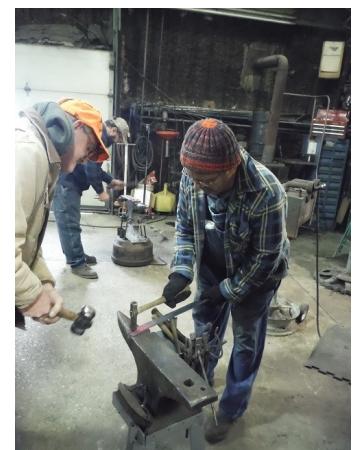


December IBA Hammer In Hosted by Don Reitzel

Eric Shotwell started out demonstrating, bending scrolls .
(cold.) Kurt Fehrenbach demonstrated scrolling fixtures, (a scroll on each end of one bar. then forming a double scroll on it. Gary Leeman forged a scrolling fork. Kurt made another scroll by splitting the end , spreading some then forming the scroll end. Unusual reminding me of looking similar to a rams head. Then Eric made a Ginkgo leaf by first plasma cutting out the blank from 3/16 sheet stock the heating and forging the shape. He used a piece of wood stump for forming the irregular shapes. After lunch we had a open forge. IBA board met in Dons Log cabin. It was cold but once forges got burning things warmed up.



Reported by Dave Wells





The **FORGE FIRE**

Newsletter of the
Indiana Blacksmithing Association, Inc.

Farrel Wells *Membership Secretary*
8235 E 499 S
Dunkirk, IN 47336-8807

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February 16 Hammer In Kenny Dettmer's Shop

15721 S 250W Columbus, IN

From the North: take I 65 S to Ogilville / Walesboro (exit 64) turn. right. Go to the 1st cross-roads (300 W). Turn left. Approx 1 mile to the "T" . Turn left (600s). Go to 250W. Approx. 4 miles to a brick house on your left.

From the South: I 65N to Jonesville exit 55 turn. right, go to road 950 (in Jonesville). Turn left. Go to 250W turn. right. Kenny's house is approx 1/2 mile on your right .

Please bring a dish to share.

January 19 Hammer In Bill Conyers' Shop: 50964 Lilac Rd, South Bend, IN

From the south: Go through South Bend on US 933 to Auten Rd. Turn left or west, cross the riv-er, the first road is Lilac turn right (north), look for yellow house on right

From the toll road: Get off at exit # 77 this will put you on US 933. Go north to Auten Rd. Turn left or west, cross the river, the first road is Lilac turn right (north), look for yellow house on right