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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)

10:00 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 Moe Handy
(317) 862-5647 for details.

IBA MEETING SCHEDULE

Check the latest *Forge Fire* for monthly IBA revisions.
Contact **Michael Wollowski** (812) 232-2591 if you are willing to host or demonstrate for IBA

**Nov 19
2011**

ST JOE VALLEY FORGERS

**Dec 10
2011**

**CHAZ KAISER'S
(BOARD MEETING)**

**Jan 21
2012**

**FALL CREEK BLACKSMITH SHOP
MIDDLE TOWN**

**Feb 18
2012**

**KEN DETTMER SHOP
COLUMBUS**



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JIM JOHNSTON

Dates to Remember

Oct 29
Special Hammer
In for Ron Tincher
(see page 10 for
details)

Dec 10
Board Mtg

Editors Message

I am running late again in getting the Forge Fire to print. Consequently the October hammer in has already occurred. We had a beautiful day at Wabash Valley with a big turn out, lots to eat and a fascinating demonstration. John Bennett put on a demonstration on how to create life like deer antlers. John's work is top notch. Look for a full article in an upcoming issue.

The September hammer in was sparsely attended, but we did have a quorum for the board of directors meeting and the vote on by-laws revisions. The proposed by-laws changes were approved unanimously. The significance is that board decisions can be managed electronically to speed up the process. One key benefit is that meeting minutes can be read, approved and published before the next board meeting.

The board also discussed having expanded issues of the Forge Fire to include special articles on techniques and projects. The intent to provide information that individual members can use to improve their forging skills. Obviously this will require articles of interest. If you have something that would be of interest to others, please send that to me. If you are not comfortable writing a long article consider photographs or sketches with some simple descriptions.

Start thinking about nominations for the board of directors. Ted Stout and Dominick Andrisani are at the end of their current terms. At this time have not heard if either or both will seek re-election. We have a lot of qualified members who would make excellent candidates.

On page 11 you will find a conference update letter from Jim Johnston. This year we had two very successful conferences at Tipton and at Pontiac, IL. The conferences were successful both in terms of attendance and profitability. Please give Jim a word of thanks for all of his efforts. More importantly tell Jim what you can do to assist on future conferences. Satellite groups are encouraged to manage a particular conference function such as managing the auction or scheduling people to work the registration desk.

The theme for next years conference exhibit is a garden arch or arbor. The work can be mixed materials, but must have some original metal work. Now is a good time to begin pulling ideas together on the motif and general designs.

Visit the IBA website at: www.indianablacksmithing.org

IBA Satellite Groups and News

Sutton-Terock Memorial Blacksmith Shop

Meet: 2nd Saturday at 9 AM
 Contacts: Fred Oden (574) 223-3508
 Dennis Todd (574) 542-4886

Wabash Valley Blacksmith Shop

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

Maumee Valley Blacksmiths

Meet: 1st Saturday
 Contact: Clint Casey (260) 627-6270

Rocky Forge Blacksmith Guild

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

Whitewater Valley Blacksmiths

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

Bunkum Valley Metalsmiths

Meet: 1st Saturday
 Contacts: Doug Neukam (812) 259-4430
 Steve Stoll (812) 486-9668
 Kathy Malone (812) 725-3310

Jennings County Historical Society Blacksmith Shop

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

Fall Creek Blacksmith Shop

Meet: 4th Saturday at 9 AM
 Contacts: John Zile: (765) 533-4153
 Larry Singer (765) 643-5953
 Farrel Wells (765) 768-6235

St. Joe Valley Forgers

Meet: 4th Saturday at 9 AM
 Contacts: Bill Conyers (574) 277-8729
 John Latowski (574) 255-6209

The Southern Indiana Meteorite Mashers

Contacts: Billy Merritt (812) 338-2876
 Steve King (812) 797-0059
 Shawn Gilley (812) 486-9113

One Armed Blacksmith's Shop

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

"Doc" Ramseyer Blacksmith Shop

Meet: 3rd Sunday at 2 PM
 Contacts: Mike Kelley
 Charles Gruel (765) 513-5390

Sutton-Terock Memorial Blacksmith Shop

Sorry I did not get this in last month. These minutes are by Tim Pearson for Aug.20 meeting Thanks Tim for all your hard work.

The shop opened at 9 a.m. by Tim. Fred was at the State Fair demonstrating.

We had a new visitor, Larry Uceny from Plymouth, he made a "S" hook, a ring & started a leaf. Paul Fleischmann started a new project, his cigar holder & ashtray on top of an old soda & acid fire extinguisher was given to his neighbor friend. Robin Flitterling installed the motor mount for our Little Giant power hammer that he modified he also wired it at the motor we still need to wire in at the breaker panel and get padlocks for it. Jim Johnston paid us a visit. Tim Pearson made 4 skewers out of 1/8" square stock. The shop was closed at 3 p.m.

Sept. 10 2011 shop open 9 a.m. 8 people here to have fun. Larry Uceny finished his leaf and made a set of tongs with my help. Allyson Bender made a double hart. Tim and Denny Setnor made a flag stand. Norm Berkshire brought his son that I met at the the State Fair he made 2 S hooks. Wayne Hollenbaugh finished his leaf and put it on our tree of friendship. Shop closed at 3 p.m.

Hammered in Friendship

Fred Oden

IBA Satellite Groups and News (continued)

Jennings County Historical Society Blacksmith Shop

The Vernon Blacksmiths got off to a good start by Kenny Dettmer made a nice leaf key chain for a visitor. Bill Newman (on the back side of the forge) began working on a Russian rose on a heart. Ray Sease and Jed McCrory each made a drive-in squirrel feeder. Kenny Dettmer began heating a large pry bar brought into the shop to be straightened. It certainly didn't take him long to make short work of that job. Kenny and Bill Newman , working together, each made half a tong, except for the reins, which will be added later. They seemed to fit rather nicely. Bill Newman then decided to make a second "rose heart". Audrey Schulte, a newcomer, spent some time working on some basic skills. Ray and Kevin Walsh each made more squirrel feeders. Ray Sease made a fire poker for a visitor. Kenny then began to make a humming bird, (after repeated efforts to get Jim Watts to do it,)from square stock . Jim Jessie demonstrated it at a hammer-in at his house. If you made one of these as nice as the one he made, your wife wouldn't let you rest until you made several. Kenny's turned out very well also. both sides of the forge were going most of the day and it worked very well. No one burned up anyone else's work. We are anxious to see how it works with a power hammer?? We had a good turn out and iron-in-the-hat. Thanks to all who made today enjoyable. Paul Bray

Maumee Valley Blacksmiths

Maum

Greetings:

The October meeting of the Machinist Group is this coming Tuesday, October 11th at 7:00 PM in the Auditorium of Ivy Tech, Fort Wayne. Hope that you can make the meeting. Paul Lageman, a regional director for Senator Dan Coates will be speaking about the concerns that were expressed at the last two meeting. Thanks to Ken Jacobson for lining him up as a speaker. He will be talking about vocational programs. There may be one or two others who can also give input present.

This Saturday, October 8th is the annual Fall "Toy" Show at the Jefferson township Park. The show will run from about 8:00 AM to 4:00 PM. You are invited to show your hobby interests. We are trying to make this show grow so your displays are needed. There will also be swap meet materials and we invite you to bring those items that are getting underfoot and seemed to be a good idea, but are now in the way. If nothing else, you can rotate your stock by selling the old stuff and replacing it with new "STUFF." There is no charge for admission, display or selling swap items. The sawmill will be running, the blacksmiths will be demonstrating, the new LARGE steam whistle that was purchased will be demonstrated on the now functioning steam boiler. I hope that you can come and participate and tell neighbors and family. Should be a beautiful day. Refreshments will be available.

John Schamber

260-579-7303

Maumee Valley Blacksmiths:

I am sending you the same reminder that I sent to the Machinist Group in the interest of saving time and energy. (important to an old guy like me.) Reminder that we will be demonstrating in the blacksmith shop all day so I hope that some of you can be present.

Rocky Forge Blacksmith Guild

Our regular Rocky Forge meeting will be at Fowler Park which is about 5 miles south of Terre Haute. This is an IBA meeting hosted by the Wabash Valley satellite group. The meeting will start at 10:00, but I would suggest getting there around 9:00. Be sure to take items for iron in the hat and a lawn chair to watch the demonstration. I do not know what the lunch provisions will be so check the October edition to see what to do for lunch.

I encourage you all to attend this meeting because I know most of you have never been to an IBA meeting and the Fowler Park shop is really special. Be safe and enjoy the show.
Ted

Bunkum Valley Metalsmiths

We met at the Elnora Antique show this month. We got quite the turn out for the week end. Many smiths showed up to further the trade. To list it all would take more than we have space for in the letter.

To say it was a success is an understatement. We need to say a very big thank you to Forge&Anvil for having us there at the show. So thank you Doug, thank you Jim.

While some were sick, some were sore and some good to go it was an effort made by all that made it work. Thank you to all of the blacksmiths who came and pitched in. See you all next time @ the normal meeting place. 1st weekend of month. Til then keep your fires burning.

Our October meeting was held on the 1st of October and it was a beautiful, cool day. We had around 15 people in attendance, I say around because some just stopped by for awhile and others stayed the day. It was a good day of smithing with several projects in the works. We had 2 forges going and kept them both busy. We also shared a meal together and alot of enjoyable conversation and story telling. It was a good day. It was decided in the business session that our November meeting will be combined with the Ron Tincher Hammer In at Jerry Robinette's on October 29. New officers were nominated, since we won't meet here in November, and they will be voted on in our December meeting for year 2012. Until next time remember, even if you have too many irons in the fire, don't lose your temper :)



Traditional Tool Shapes & Applications

Article submitted by Ernie Dorrill

Most of the tools listed and discussed in this document have over 1000 years of history behind them and until relatively recent (the last 300 years) a striker was used, in concert with the blacksmith, for the applied work. This note is intended to cover major tool shapes that can be divided into 'families' such as straight chisels, curved chisels, butchers, flatters, ball tools, fullers, tear drop tools, etc.

All tool shapes are generic and can be used in the widest range of applications from something the size of a quarter to the size of a 2'x 2' or 2'x 4' panel.

Generic tools should have incremental sizes (1/8", 3/16", 1/4", 3/8" and 1/2"). Note: 1/4" diameter tools will not hold up under a treadle hammer, therefore, never use less than 3/8" to 1/2" tool steel and make all tools approximately 4 1/2" in length. Generally, S7 has been a good tool steel and is water and/or air hardening steel designed for impact forces while at the same time, maintaining a cutting edge. W-1 can also be used for specific applications. When hardening this steel, quench all but the last 1/2" striking end to maintain a soft surface. This steel can be used for both hot and cold work and will provide years of service. Occasional dressing and buffing may be required.

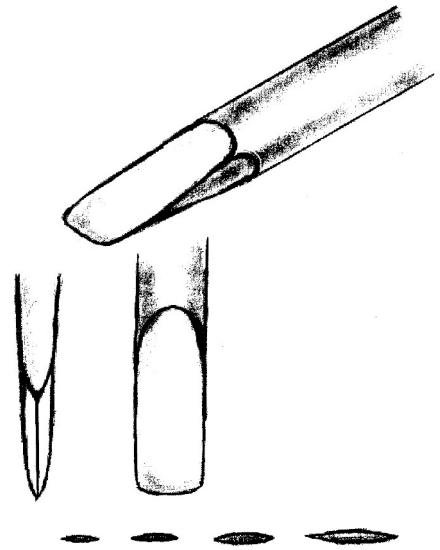
Slitting Chisels –

A slitting chisel should have the same thickness but incremental widths. This common cutting edge thickness produces incised lines that have the same visual line-weight. They will all leave the same width line if struck to the same depth. For example, 3/16" wide, 3/8" wide and 1/2" wide chisels that are all similar in thickness would allow switching between them as the pattern requires, and still maintain the same visual effect in incising as if a single tool was used.

Why switch between various straight chisels? The 1/2" wide chisel will cut a straight line, as will the 3/8" wide and the 3/16" wide chisel. But the 3/8" wide and 3/16" wide straight chisels will cut or incise progressively tighter curves. Having the same line-weight as they cut ever tighter curves allows one to cut a near infinite range of curves as well as various length straight lines while maintaining the visual width of the cut as a decorative constant (calligraphy with a chisel). This line weight in incising can be seen in pierced work as a constant bevel along the cut edge that you will not get if the chisels have varying thicknesses when switching between them to accommodate the pattern. Visualize a set of chisels with a common wedge in vertical section compared to a set with varied vertical wedge sections.

Also, in cutting or incising intricate patterns, there may be need for varied length - straight and curved cutting capacity. In some cases, the curve is so tight that only a curved chisel will suffice in which instance, make one in the configuration the pattern demands. (All chisels should be symmetrical. Test in lead or clay before heat treatment by rotating it as it is struck. A symmetrical curved chisel will cut a core-shaped plug, where as an asymmetrical curved chisel will ride out of its track and give a choppy cut when rotated.) Otherwise, there is difficulty in moving from a straight cut into a range of broad curves using just the three sizes of straight chisels. This is true whether incising into or cutting completely through metal. Intricate repousse' and pierced patterns with areas cut out completely (negative spaces) often have various length short straight lines to be cut as well.

The cutting edge should be slightly crowned along the straight chisel blade length, so the center just makes contact first with both ends of the blade rounded so the cutting edge continues up the side of the chisel for a distance. Chisels intended for deep slitting should have a cutting edge that extends up the side for about half the thickness of the metal to be slit. The ideal cross section for a slitting or incising chisel is elliptical, like a canoe. The cross section of a properly formed chisel should be a progressively narrower canoe shape when approaching the blade. As a line is incised or cut, the chisel should be moved forward about one half the blade length per stroke. The cutting edge that runs from center of the blade up the side of the chisel leads the cut cleanly. The radius on the corner makes a leading cut that is a diagonal to the plane of the metal being cut. This provides a visually clean effect (a tapered cut rising through the metal) at the end of a slit and, because there is a diagonal through the metal instead of a vertical line, flexing is less likely to result in a crack. A saw cut split often cracks during flexing since it is vertical through the metal. The canoe or elliptical cross section has the effect of planishing the lead cut mark as the thicker center is moved forward a half-chisel length per cut. (Do not get the center too thick or the wedge action will cause drag as well as wedging open the cut and tearing the metal). A lead cut followed by planishing action at the middle of the chisel is produced as the chisel moves forward. Each cutting process is a series of passes; do not force the tool through material if a smooth result is desired.



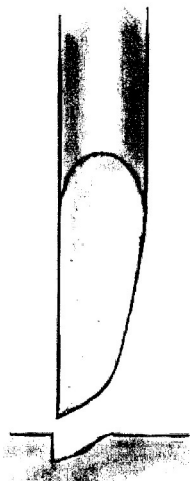
Curved Chisels –

Development of curved chisels requires perfect tracking, in many cases, and therefore requires precision in curved chisel development. Using annealed tool steel, place in vice at a comfortable angle (25 to 35 degrees) and nick the edge with a triangular file to provide a tracking groove for the round file. File down to at least ½ of the files diameter, then grind a canoe shape on the convex side of the chisel which will meet at the cutting edge.

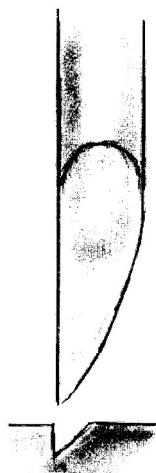


Butchers –

Butchers are made in pairs (first and second pass). First pass butchers are steeper in angle back from the vertical face, and second pass butchers about half as steep, about 45 degrees and 30 degrees respectively.



First Pass



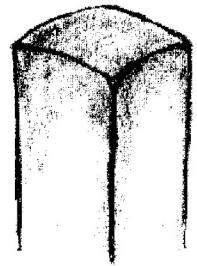
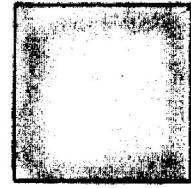
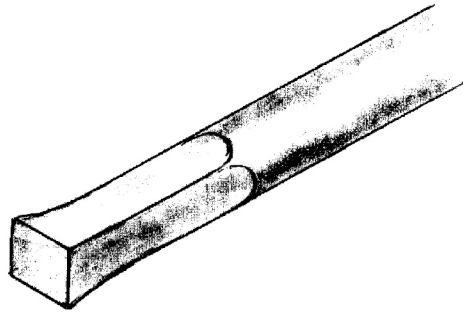
Second Pass



Front View Butcher

Flatters –

Flatters are produced in the same size range as all other tools and all have a slightly crowned face and less than sharp edges. Shapes can be square, triangular, rectangular, round or oval. Make flatters in special shapes as needed for particular projects.



Elliptical face



Half-round face

Ball Tools -

Ball tools can be in sets, one half-round and one elliptical face per size in every size of tool steel stock from 1/8" in increments up to 1". Convex end shapes can range from shallow to deep.

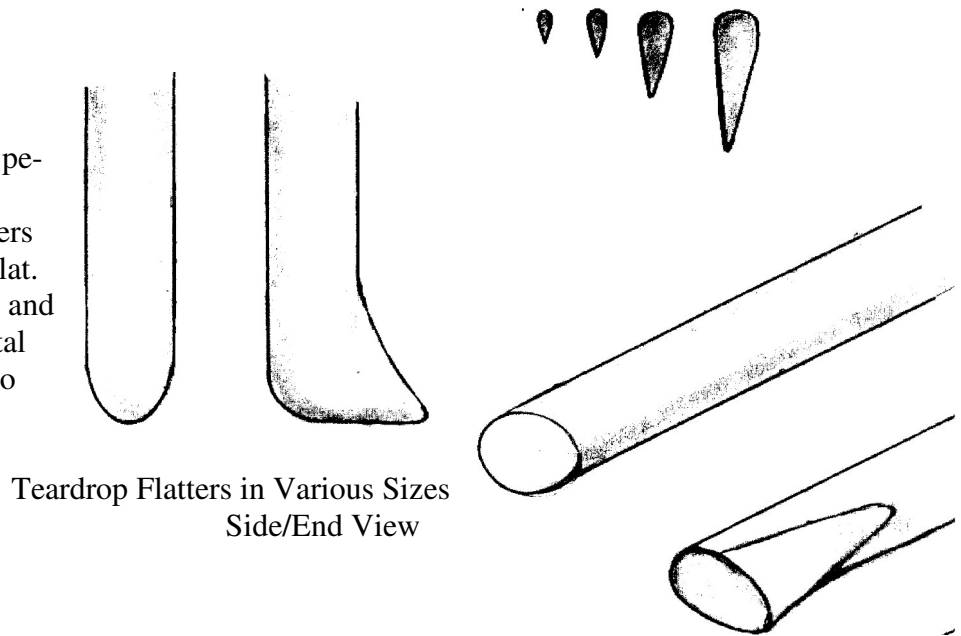


Chasing Tools -

Chasing tools have work faces that can range all over the map. Begin with oval and rectangular faces, slightly crowned in sizes similar to those cited above. Ball end tools are also used in chasing.

Teardrop Flatters or 'Shoes' -

These tools have a teardrop shaped perimeter to the working face that is slightly crowned in some while others with the same 'footprint' are dead flat. There are also those that are curved and should be made in pairs. Incremental widths at the heel range from 1/8" to 3/8".



Teardrop Flatters in Various Sizes
Side/End View

Fullers –

The most common fuller shape is a tapered wedge that ends in various half-rounds or elliptical working faces. Sides are somewhat squared off. This configuration is intended to span the material to be fullered. For repousse' and chasing, a fuller that has the ends tapered and rounded with a slight crown along the work face is better. This blunt version of a chisel, with less of a canoe-like section, allows conventional fullering, set and strike ... but also allows the tool to be slid a half-tool length per strike to leave a fullered line that has no tool marks. Conventional fuller shapes can dig in at the ends if they are not held perfectly vertical.

All tools should be heat treated except the last 1/2" striking end in order to prevent spalling when struck. Full length heat treatment allows a 1/4" W-1 (water hardening drill rod) too, for example, to survive treadle hammer work all day long. 3/8" to 1/2" round S1 is more commonly used, because of heat resistant properties needed for thin bladed tools (hot or cold work). All work is laid out then marked cold with the tool to be used in the subsequent process, either hot or cold, many chasing (repousse') tools can be 1/4", 5/16" or 3/8" round W-1. Because of the mass of blunt working ends (small flatters, ball shapes which are crowned work surfaces), W-1 is acceptable for chasing tools smaller than 1/2" diameter.

Although tools described may seem somewhat small, the scale of work ranges from very small to large. A small tool is more versatile, it fits into more spaces and a small tool transfers more energy from the hammer (hand or treadle) to the work face due to its small footprint. This makes a marked difference in deep cold chasing. Shapes are more generic than specific in that there are very few that give a single effect. This allows more versatility of work. Period European motifs have a huge range of patterns and shapes. The generic, small tool approach allows a smaller set of tools to do a wider range of work in a wider range of sizes than any other approach.

Use of tools relates to specific action in applying the tool to metal. Although there are plenty of times that a tool is set and struck as a single operation, most application of tooling to metal (hot or cold) involves setting the tool and maintaining continuous contact (as opposed to set and strike, set and strike) while striking and dragging the working end along the layout. Crowned faces of tools makes dragging the tool easier; move one-half tool width per strike without lifting and setting tool. This dragging or continuous contact approach gives a much smoother effect to whatever tool process one is applying. Cutting, chasing, piercing, incising, etc.,

are all made much cleaner with this approach. There is also less of a miss-strike. When one lifts the tool and sets it anew with every strike it is easy to set the tool off and strike it anyway due to the rhythm that develops. Therefore, set the tool on the layout or previous pass, and with a rocking and dragging motion ...drag and strike. This applies to either hand or treadle hammer driven tooling.

When making tools, give close attention to details of form, edge, radius and finish (polish the working end like a mirror – less friction as it moves across or through the metal).

This attention to the tool will aid in refinement if it does not work as intended. The difference between a tool that works VERY WELL and one that does not is often very subtle. Those subtleties will not be apparent without trial and error and close attention given to the result of every nuance of modification.

Most of this information was provided by George Dixon, A Review of Tool Shapes and Applications, 1997 and supplemented by Ernie Dorrill (2009) based on actual trial and error experience.

State Fair Update

Bill,
In The Forge Fire
you asked for photos from the State Fair. No one from the group saw this I suppose, but waiting for John Cummins to pick me up and our tools I met Miss Indiana State Fair. Some times it pays to be the last man out.

Gary E. Johnson



Special Hammer In October 29

A Hammer In will be held on October 29, 2011 to honor Ron Tincher for his many years in blacksmithing. A pitch-in lunch will be served so please bring a full covered dish. All are welcome friend or foe. Plan on having a good time and fellowship with good food.

The address is 16139 North 500 East, Elnora, Ind. From the map I was given you take highway 57 out of Elnora toward Newberry then you can take 1500 South and the shop is located at the above address. Any questions please call Jerry Robinette at 1-812-692-5146. So mark your calendars now.

Note: If you have difficulty reaching Jerry, try his cell phone at 812-787-2047.

Conference Updates:

Well people I have put this off as long as possible. It seems I can talk till my jaws lock up but freeze at the keyboard. Sorry. I have been part of two outstanding conferences this summer and there are some people I need to thank. Our conference in June had two of the very best demonstrators in the country in Peter Ross and Ernie Dorrill. Both are artisans of the first rank and I can't say enough about them. Ray Sease and Harry Williams both did an excellent demo on Saturday. Kevin Walsh and Matt Jones assisted Ray and did a fine job. I expect someday they will do their own demos for us. Dick Fisher provided the Friday night demo and did an outstanding job. Jan Ryan did the spouses program and was well attended. The beginner's class was conducted by Keith Hicks and his helpers and was excellent. Alvin Cave conducted our auction which I should add was highly successful

Our set up and tear down crew as always do so much I can't even begin to tell you how much I owe them. Unfortunately I lost my notes and can't recall everyone that helped. All I can say is thanks you guys make me look good.

The second conference was at Pontiac Illinois in July. Nathan Robertson did a bang up job for us especially when Lyle Winn struck for him. Nate's demo not only showed you how he works but why he used the tooling he did and how through trial and error he came up with it. Thanks Nathan. I also should mention Bob Bergman who allowed us to use a brand new Kick Ass power hammer and even supplied the compressor to run it. Thanks Bob. Also Bill Kendrick who transported the sound equipment and set it up, Thanks.

Indiana was well represented at Pontiac Bill Conyers group built a beautiful gate that realized \$3000 in the auction. Once again I am unable to remember names but thanks to all who helped.

I just finalized the line up for our next mini-conference in December. Mark Thomas has agreed to demo and perhaps talk of his experiences in Africa. Should be enlightening.

The conference in June 2012 will feature Elmer Roush at one end and Clay Spencer at the other. Jim Perkins will do the Friday night demo and Jennifer Hayden and her father Bill Conyers will do a Saturday demo. Bob Cruickshank (the working mans friend) will round Saturday out.

We have went ahead and rented the show barn for next year and plan to have a Gallery set up by Ted and Dominick so bring your best work. The auction will be held their also and food service too.

I need to enlist satellite groups to take care of video, the auction, the contest and possibly registration. I really need people to step up for this as I can't be everywhere at once (I know, I know most of you don't want to see me at all).

This year has been exceptional; we made money, had fun, met new people and renewed old friendships. I couldn't be more proud to be associated with any group of people anywhere thanks for a great year and here is to another coming up.

With fraternal best wishes

Jim Johnston



The *FORGE FIRE*

Newsletter of the
Indiana Blacksmithing Association,
Inc.

Bill Kendrick *Newsletter Editor*

1280 N CR 900 W
Seymour, IN 47274

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November 19 Hammer In: St. Joe Valley Blacksmiths

Bill Conyer's 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 river, 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

December 10 Hammer In & Board Meeting Chaz Kaiser's

16 Indiana Avenue, Batesville, IN 47006

It's a pitch-in lunch, please bring a dish to share.

Coming from central Indiana, take I 74 east towards Batesville. Exit at SR229 and turn South towards Batesville. Turn left onto IN 46 / Broadway St. and follow for about 1 mile. Turn right onto Pearl St. (by Batesville Casket) then follow Pearl St. to Indiana Ave. Chaz is located at 16 Indiana Ave.