

October 2015

BOARD OF DIRECTORS

Gary Phillips '18 President:

14800 N SR 167 N
Albany, IN 47320
(765) 789-8316
behere@netdirect.net

Steve King '18

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

Bill Conyers '19 Vice Pres

50964 Lilac Rd,
South Bend, IN
(574) 277-8729
billconyerssr@yahoo.com

Bill Newman '19

4655 Williams Rd
Martinsville, IN 46151
(317) 690-2455
ruralsmiths1@yahoo.com

Dominick Andrisani '16

3608 Capilano Drive
West Lafayette, IN 47906-8869
(765) 463-4975
andrisan@purdue.edu

Ted Stout '16

8525 W 700 S
West Point, IN 47992-9258
(765) 572-2467
stout8525@tds.net

James Johnston '17

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

Keith Hicks '17 Secretary:

5184 State Road 252
Brookville, IN 47012
(765) 914-6584
keithhicks2011@gmail.com

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.

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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.

Oct 17 2015	OPEN
Nov 21 2015	TBD
Dec 12 2015	DON REITZEL SHOP STILESVILLE
Jan 16 2016	TBD



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Dates to Remember

Dec 12
Hammer In at Don
Reitzel's Shop

Editors Message

I suspect that some emails are not reaching me. This month I only received two satellite news updates, and one only had the subject line with no content. If you have sent me something to include in the Forge Fire and do not see it, please let me know. If there is a problem, I will switch to a different email account.

We had a good board of directors meeting last month. Here are a few highlights:

- ♦ The IBA financial report looks strong with year to date income exceeding expenses by about \$1000. The IBA will invest in some additional equipment for the annual conference.
- ♦ Steve King and Dominick Andrisani accepted an assignment to investigate transferring the conference demonstration videos onto DVD format for inclusion in the library.
- ♦ The board wants to initiate a financial audit. The last audit was conducted a number of years ago, and the board would like to ensure complete financial compliance. Along with the cash accounts, an inventory of IBA assets is planned.
- ♦ Jim Johnston has the 2016 and 2017 conference demonstrators lined up. For 2016 we will have Kim Thomas and Nathan Allen. Charlie Helton and Brad Weaver will also be demonstrating. For 2017 we will have Robert Taylor and Gordon William.
- ♦ A request was made to have a professional photographer at future conferences. The intent is for individuals to be able to purchase prints of their displayed work for inclusion in their personal portfolios.
- ♦ The board reiterated the desire to avoid satellite group meetings on the 3rd Saturday of each month as well as during the annual conference.

After the board meeting, we had an open forge. Bill Newman demonstrated a two piece hanging candle holder. Charlie Helton and Brad Weaver dialed in a set of tongs for working railroad spikes. The adjusted tongs do a great job keeping the spikes secure for forging.

You may have noticed a shortage of IBA monthly hammer ins. We have 13 satellite groups as well as some excellent individual shops. Right now I am aware of only two scheduled hammer ins: Dec 12 at Don Reitzel and Feb 20 at Ken Dettmer shop. If you are willing to host a hammer in, please contact Gary Phillips. Gary's contact information is on the front page.

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: 2nd and 4th Saturday
 Contact: Clint Casey (260) 627-6270
 John Schamber (260) 579-7303

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: Jim Malone (812) 725-3311
 Terry Byers (812) 275-7150
 Kathy Malone (812) 725-3310

Satellite 13

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

Bunkum Valley Metalsmiths

Bunkum Valley Metalsmiths met on September 10, 2015 through September 13th. We all met at Elnora . We had a wonderful time.

Jennings County Historical Society Blacksmith Shop

The Jennings County Historical Society Blacksmith Shop started with Charlie Helton making a sleeve for a cant hook, using a single tree end for a pattern. Bill Newman was mentoring Daniel and Melie Orellang on some of the basics. Phil Schoffenhorst was working on "J" hooks. Alex Spellman and Russel Dean worked on tongs. Cainen McCrory made "S" hook. Eli Neakam worked on a leaf, with Jack Neakam also made a leaf while mentoring Eli. Alex Spellman was mentored by Charlie Helton and Brad Weaver in the final stages. This was a great day to get a lot of newcomers working the forges. Great iron-in-the-hat and 18 in attendance. Paul Bray

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) 344-1730

The Southern Indiana Meteorite Mashers

Contacts: Billy Merritt (812) 338-2876
 Steve King (812) 797-0059
 Jeff Reinhardt 812-949-7163

One-Armed Blacksmith's Shop

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

"Doc" Ramseyer Blacksmith Shop

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

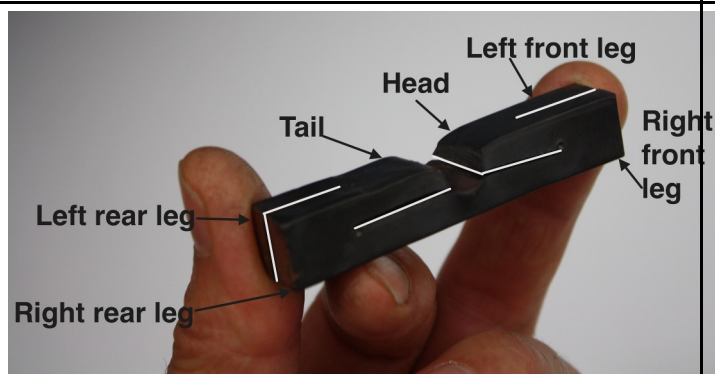
Making a Dog Using Two Split Crosses by Dominick Andrisani



The square stock used was $\frac{1}{2}$ " square and 3.5 inches long. The material was silicon bronze 655, although any square stock will do. The first step is to make the two band saw cuts that separate the legs.



Second step is to forge a $\frac{1}{4}$ " indentation in the middle of the $\frac{1}{2}$ " square stock so that the $\frac{1}{4}$ " wide band saw blade will fit in. This allows the saw to make the two cuts (visible above) that separate the head and tail from the stock. These last two cuts overlap the first two cuts by half the width of the square stock ($\frac{1}{4}$ ").



In this illustration the band saw cuts have been accentuated with white lines. The next step is to heat up the material in the forge. Silicon bronze should be heated up to a dull red color. When hot the head and tail material can be lifted and bent forward and aft respectively. Then the legs can be bent and forged to project downward.



The two split crosses have allowed the blacksmith to get the metal is approximately the right place. At this point the smith can forge the four-legged critter to look like anything (dog, cat, etc.). The resulting dog was about 5 inches long. Feel free to experiment with the dimensions.

Recent Work by Dominick Andrisani



Forged Silicon Bronze Flower Candle Holder



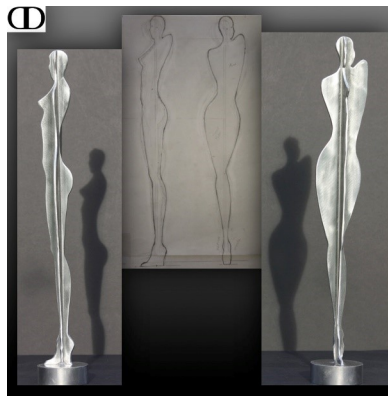
Forged Bronze Nut Bowl



Forged Copper Venetian Gondola Vase Made From Bus Bar



Forged Bronze Split Crosses



A Milled Solid Stainless Sculpture



Forged Copper Rose Bowl



Forged Mild Steel Door Knocker



The Steele Family



The Bronze Family

The photographs above depict many of the pieces recently made by Dominick Andrisani. They were display and sold on September 20 in West Lafayette at Art on the Wabash, a juried art show. Dominick is a big fan of forging with silicon bronze. His warning, however, is to make sure you don't get the bronze too hot. If it's bright red or yellow wait until the metal cools to a dull red before hitting it. Sometimes it will fall apart in the fire at a yellow temperature. Bronze can be forged right down to room temperature and does not appear to work harden like copper would. Also, be sure to use silicon bronze. Other bronze alloys are more likely to crack, split or otherwise fall apart, thereby ruining your work.

The 2015 Indiana State Fair Queen with Bill Newman



This 1/2 page article reprinted from The Prairie Blacksmith Association December 2000

Upsetting Bolster

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 in figure 1. 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 chamfered 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 hole, see figure 2.

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.

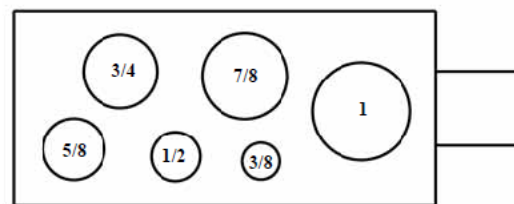


Fig 1

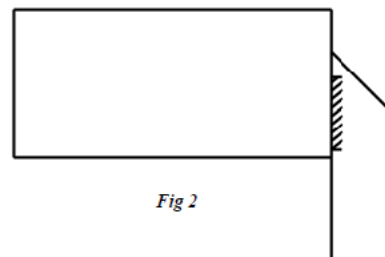


Fig 2

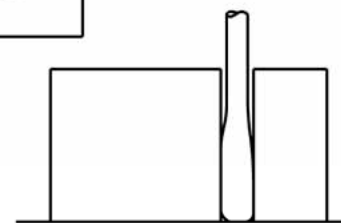


Fig 3

Blacksmith Week Demonstrator Gary Eagle Non-Traditional Scrolls



A fairly simple yet versatile scroll, one of Gary's favorites.

Draw a taper in flat stock, down to approx. 1/4" tip, about 8" taper.

Using a 3/8" fuller in hardy, make 2 divets in one edge of the taper, beginning at the tip.

Continue, using a 1/2" fuller, for the rest of the divets, making them gradually larger and farther apart. Straighten the full length.

To scroll over the horn, bend at 90°, then start at the tip, bending a tight curve over the horn, gently curving the length of scroll as desired.

It will want to kink at the fullers, and the resultant scroll is a series of straight lines approximating a curve.

Straighten out the scroll so it lies flat.



Hot Iron News

A Facetted Scroll

Knock over 1/4" of flat bar as sharp a bend as possible on edge of anvil.

Always hitting on the flat, continue folding over, 6 turns minimum for the effect. The scroll at the left has 14 turns.

The scroll can tolerate a little bit of gap and still maintain the effect.

To open up the scroll, heat and put in vise, using channel locks to unwind from the outside. Use a fine chisel to pry open the inside.





Variation on the Faceted Scroll

Fold over a length of bar stock and fold as with the simple Faceted Scroll to create a Double Faceted Scroll.



Gary giving the 'okay wise guy' look to a verbose heckler from Bend, Oregon.

Blacksmith Week Demonstrator Gary Eagle Non-Traditional Scrolls



Another Scroll

Flat bar stock, approx. 1 1/4" x 3/16".

Taper 10-12". Swedge the length of the taper, the length of the scroll. The part of the swaged taper that goes to the inside of the scroll is narrower than the outside, so it will scroll into a gentle curve more easily.



The examples at far left are gently fullered on both sides. Fuller one edge at a time, beginning at the tip and continuing down the length of the curve. Use a small hammer and gentle blows to avoid distortion.

Left and Below: A scroll used by Edgar Brandt, an Art Deco artist blacksmith (1880-1960).

Fuller only one side, leaving a regular edge on the inside, convenient for binding to other pieces.



Thank you Gary for all the versatile design ideas and techniques. Your blacksmithing style is smooth, conservation of movement and precision. Wow!



Above: Previously made scroll sample, incorporating a combination of scrolls similar to these, with additional decorative details.

Coal Dust

Albin Drzewianowski

The topic of coal dust came up recently. Some beginners do not realize that you can forge using coal dust or coal that has a lot of coal dust in it. On more than one occasion, I have come across someone at the Guild's forge who was sifting out the dust. I explained to him that he was throwing away money. Coal dust is still coal and you can burn it in the forge.

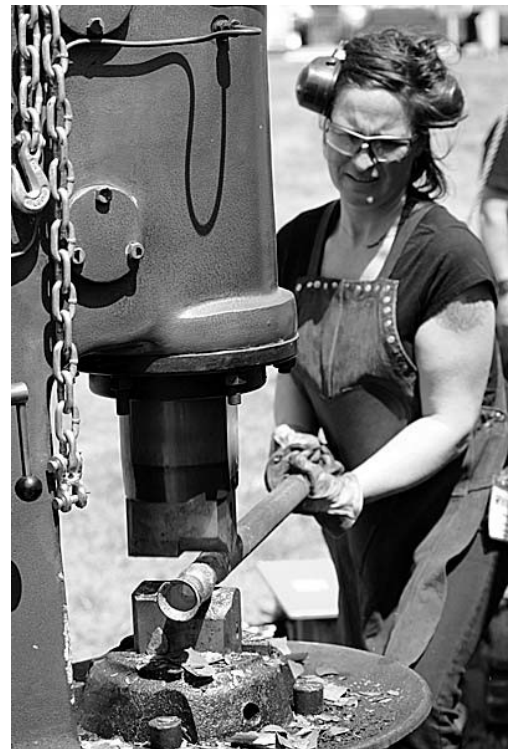
It is a little more work to forge with coal dust but it can be done. You need to moisten the coal dust before you add it to the fire. If you have coal that includes lots of coal dust, then first put it a bucket and add enough water to get the consistency of loose mortar (as if you were going to lay bricks).

Blacksmith Guild of Central Maryland Sep/Oct 2015 HAMMER & TONG 9

Pipe Forging Tips from California Blacksmith Newsletter

From Megan Crowley

When forging pipe down, it does not lengthen.
Instead, the walls compress and get thicker.



From Frank Trousil

When forging pipe in the center, cool the ends.

This will help maintain a round reference section.

Tong Clips- By Doug Merkel

Article courtesy of the North Carolina ABANA Hot Iron Sparkle - Editor

Francis Whitaker once told me that he wished that he had started using clips to hold his tongs together sooner than he did. He said that it would have kept his left arm, wrist and hand from developing such bad arthritis. Sounded like good advice, so I have been using tong clips for the past 15 years.

Why should you use some type of clip to hold the tong handles together and not just your handgrip???? For the same reason that you use a light grip on your forging hammer, to reduce the transfer of vibrations from the tool to your body. Holding, swinging and striking with the hand hammer is an article in itself, but all the different techniques have one thing in common. They all try to reduce the amount of vibration transferred to your body. The less vibration transferred to your body through either/both arms then the longer you can work that day and for years to come.

One way to reduce vibration transfer is to use a very light grip. If you do not use a death grip to keep the tongs closed then you can use a very light grip just to control the piece on the anvil or under the power hammer. Let the tong clip hold the item to forge, that way you only have to concentrate on the forging part of the operation.

Enough talk, tong clips are made in many shapes and sizes. Just like shoes, tongs and hammers, you can never have enough. Some are an open design to be slipped on the tongs from the side and others are closed ended to be put on from the handle end.

This clip is made from stainless steel, because I had some in the scrap pile, but can be made from what ever you have around the shop. This started with some 11-gauge steel (1/8 inch, .125 inch) that was 2 1/2 inches by 3 1/2 inches. Any thinner and you end up with too massive a clip. If the clip gets too large it just ends up vibrating off of the tong handles during use.

Sketch out your design right on the steel. This one has one large hole and three smaller holes, each at a different distance from the one large hole. That way you get three clips in one. Center punch each of the four holes, drill them out, hack saw, band saw or cold cut most of the excess metal away. File/grind/belt sand the edges to shape. Stamp with your touch mark and use. The large hole on this one is 3/4 inch with 7/16-inch small holes. Make them to fit yo

You are blacksmithing, so you can hot punch the holes if you want, or hot cut the excess material. Use your skills and design your own clips. You will find as you use clips that it is much easier to concentrate on what you are doing with the hammer and not worry about holding onto the material. Your tongs and clip are doing that for you. As Francis told me "If you cannot hold it, then you cannot hit it!"

GET IT HOT, HIT IT HARD, QUIT WHEN IT'S DONE



11-gauge 1/8" x 2 1/2" x 3 1/2"

Finished Tong Clip



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Farrel Wells *Membership Secretary*
8235 E 499 S
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