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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 **John Wendel** (812) 343-1969 if you are willing to host or demonstrate for IBA

Mar 19 2011	JENNINGS COUNTY HAYDEN, BUSINESS MEETING
Apr 16 2011	SUTTON-TEROCK FULTON COUNTY
May 21 2011	WHITE WATER VALLEY BLACKSMITHS
June 3-5 2011	IBA CONFERENCE TIPTON FAIR GROUNDS



Editors Message

I am about a week late getting this edition to print. Hopefully it arrives in time to remind you to vote for our two board of directors positions. The ballot was included in the February Forge Fire. We have three strong candidates in Bill Conyers, David Childress and Kenny Dettmer. Be sure to make your vote count.

We had a really big turn out for the February hammer in at Ken Dettmer's. Jack Brubaker demonstrated on the Williams White hammer. Jack also gave us a lot of information about blacksmithing history relating to tool making for the local Indiana limestone industry. Michael Wollowski was under the weather, so the hammer/ergonomic evaluation did not happen. Hopefully we can reschedule in the near future.

I would like to apologize to the members of the Bunkum Valley and Southern Indiana Meteorite Mashers. Apparently I have been mixing up their satellite news. I ask all satellite groups to look at their listings and make sure I have their information correct including hammer in locations, dates, times and contacts.

As already mentioned the our new board of directors election is coming up. The votes will be counted at the annual business meeting on March 19 at Hayden. Please attend. If there things you would like to change, or things you would like to stay the same; this is a great way to get your desires heard. It appears the weather is finally breaking, so the Sullivan Blacksmith Shop will be open. I am planning to have a brief demonstration on several joinery techniques, specifically collaring. Perhaps that will be helpful in some of the gate/grille projects.

Speaking of the gate/grille projects, be sure to get your items ready for our June Conference. Last years Conference was a big hit and this year looks to be just as good. We have some outstanding demonstrators who will be covering a wide variety of topics. Be sure to come and support the IBA while you have a great time. Look for the IBA Conference Brochure some time in March.

Don Neuenschwander sent me a reminder about a copper working class coming up in April. If you are interested in learning about copper work, check out the notice on page 6.

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Hammer In at
Sutton-Terock

April 16-17
Copper Class
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June 3-5
IBA Conference

July 15-17
UMRBC

Visit the IBA website at: www.indianablacksmithing.org

Bunkum Valley Metalsmiths**Southwest Region****Daviess Co.**

The Bunkum Valley Metal Workers meet the first Saturday of the month. Forgemaster Doug Neukam (812) 259-4430. Treasurer Steve Stoll (812)486-9668. Secretary Shawn Gilley (812) 486-9113.

We had a great turn out, 15 approx. And lots of work being done in the shop. Doug made a diagonal peen hammer on the press. That turned out really nice. Shawn made some blade style tongs. CJ made a large tri-pod. and much more work was done than can be recalled.

Throughout the day there was always 4-5 people working on the forge. Lots of instruction given to all who were there. Got some new members to the group and some who will be back now that they have the itch!

On a sad note, the group also suffered a loss Saturday. George Kutch lost his wife. We were all saddened for him and his family and send them our condolences. Many may know George and his son Dennis. They have been involved in many things to help further the Blacksmithing tinsmithing work. Please remember them in their time of loss.

We will meet again on 4-2-11. Encourage all to attend and bring items for iron-in-the-hat. And a dish. Our lunch of beaver stew was delicious and all enjoyed the fellowship we share.

The Southern Indiana Meteorite Mashers**Southern Region****Orange County**

Forgemaster Billy Merritt (812)338-2876, Treasurer Steve King (812)797-0059, Secretary Shawn Gilley(812)-486-9113

We met and had a good morning. Many had to work and yet still had a good turn out. 9 people made it for the day. Lots was discussed as all can imagine, and we still manage to forge a good bit too. Jerry B. made an anvil bick. Shawn made set of off-set tongs. Billy forged out a large billet of damascus.

Lunch did us well w/ chicken and noodles provided by Jerry R. Which should remind us all to thank the ones who help us in ways others don't see..the wives! They support us and feed us and are not thanked enough. So thanks to Bobbi!

We will be meeting at the shop of Jason Hardin, (2872 S. Becks Mill Rd, Salem, IN 47167) 3-11-11. So please all remember to bring dish and items for Iron-N-Hat. Til then, keep the fires burning.

St. Joe Valley Forgers**North Central Region****St. Joseph County**

Meetings of the St. Joe Valley Forgers are held on the 4th Saturday of the month starting at 9 a.m. at the residence of Bill Conyers in South Bend. For more information contact John Latowski at (574) 255-6209 or Bill Conyers at (574) 277-8729.

St. Joseph valley forgers, February meeting Saturday 26, 2011. Shop opened at 9:00, with a very good attendance, 15 people. At the start Bill Conyers had a meeting with everyone there with the importance of being an IBA member, and the reasons why. Four new beginners learned how the hammering and forge works by making s-hooks with John Latowski instruction. While the rest of us worked on the gate for the conference. We assembled the posts for the gate to hang on, looking very good. with Bill Conyers welding them together. One thing is happening we are running out of room in the shop. Bill is hoping to pour the slab for the new shop in the spring. We had a very good lunch with people bringing dishes to pass, Linda, Bill's wife made salads, and beef and noodles, which was very good. After lunch we went all went back out to the shop, to work on the projects. Closing about 3.00 P.M

Jennings County Historical Society Blacksmith Shop Southeast Region Jennings County

Meetings of the Jennings County Historical Society Blacksmith Shop are held on the second Saturday of the month starting at 9 am in downtown Vernon. For more information contact Ray Sease at (812) 522-7722.

Our February meeting was at "Doghouse Forge" owned and operated by John Cummins at Moores Hill. John shared a lot of information with us, some of his own experience and some learned from others, including reading material, CD/DVD etc. about the heat treating process for knife blades in particular. Bob Bynam brought a long knife blade, a hunting knife blade, and a patch knife blade to be used in the demonstration. John was gracious enough to share the knowledge used in making some 300 or so knives, many of which were made from pattern steel, or Damascus as many may call. He began by warming his quench oil with a piece of hot steel. John then heated the knife blanks one at a time to non-magnetic then put them in the oil. After they cooled sufficiently, they were then put in an electric oven, brought up to temperature (which varies with the materials used) in this case we were using spring steel from a leaf spring. After reaching temperature, they were allowed to cool and were reheated to the same temperature to better allow the molecules to realign themselves. We know that at least one person left John's a very happy camper. John then heated a roller bearing (approx. 1 1/2" X4") and by using a hydraulic press and his 100lb Little Giant, formed a knife blank. He made it look so easy. Do try this at home. After a brief history on anvils, Frank Clifton began forming a ladle, and a fork. John and his family fed all of us a great meal and stuffed us with dessert. I do think Charlie Helton was partial to the Blueberry Cheese Cake, although no one noticed. HA! We had 12 in attendance (down from usual mostly from illness) and a nice "Steel-in-the-Setson. Thanks John for a great hammer-in. Next month's Hammer-in will be at the home of Jim Watts. This will be his first, so let's show our appreciation. Bring someone with you and--oh yes, Iron-in-the-hat! Pitch-in meal or brown bag. No place close to eat

Maumee Valley Blacksmiths Northeast Region Allen County

The Maumee Valley Blacksmiths and Blue River Blacksmith Guild are a merger of two of our satellite groups. They meet on the first Saturday of the month at the Maumee Valley Steam Association Grounds in New Haven, Indiana. Call Clint Casey at 1-260-627-6270 for more information.

Rocky Forge Blacksmith Guild Northwest Region Tippecanoe County

Meetings of the Rocky Forge Blacksmith Guild are held on the second Saturday of the month starting at 9 a.m. Meetings are held at the home of Ted and Carol Stout, approximately 8 miles south of Lafayette. For more information contact Ted Stout at (765) 572-2467.

The March 12th meeting will be held at Ted's shop and based on our last month's discussion it appears what the membership wants most is to have forging time. So this month will be forge time. If weather permits we will setup outside and forge junk iron into useable products. Some of the junk iron will probably still be junk iron, but we can work on that aspect. That is why we come to learn.

Bring your tools and metal for iron-in-the-hat. For lunch we will order Pizza from Arnie's in Shadeland and split the cost between us. Bring your own pop or drink free water. If you would rather not have Pizza, then bring a brown bag lunch. (((Note: if you happen to choose fried chicken for your brown bag, then you better bring enough for everyone. That is just a friendly warning.)))

See you all on Saturday, March 12th, the coffee and doughnuts should be ready by 8:30.

Ted

Sutton-Terock Memorial Blacksmith Shop**North Central Region****Fulton County**

Meetings of the Sutton-Terock Memorial Blacksmith Shop are held on the second Saturday of the month starting at 9 a.m. at the Fulton County Historical Society Museum. The museum is located four miles north of Rochester on US 31. For information, call Fred Oden, Forgemaster & Treasurer, at (574) 223-3508, or Dennis Todd Secretary/Reporter at (574) 542-4886.

Ten people came to forge but first we had to shovel a path of about two hundred yards to get to the shop. Sure will be glad when winter is over. We got the shop open about 9:30 and started the fires.

Kestrel Little started to work on a tripod and his friend Travis Houehin worked on stakes for their teepee.

Dave Nickels worked on making a cup type coat hook under my instructions as I keep him in the dark about what he was making. But when he finished it and seen what it was he made another one. Then he started on a trammel hook. Jeff Sullivan punched holes in some brackets and made a ceiling hook with a dragon head we are not sure just what he is going to hang on it. Bob Riley made a leaf for his key ring. Then Bob and his friend Frank Ciccalolla both worked together on making trammel hooks these fellows can be fun just to watch. Dan Nedig made a holder for a glass that was after I got the fire going. I think that Dan is going to have to start over as a blacksmith and learn how to start the fire. Paul Fleischman is still working on the ash tray for his friend. I think that his friend maybe wondering if Paul will ever get it done. Paul Atkinson a farrier that use to come, came to visit us and is thinking about rejoining us.

Tim Pearson helped me do the instructing Thanks Tim.

Shop closed about 3:30 PM.

Hammered In Friendship

Fred Oden

Fall Creek Blacksmith Shop**East Central Region****Henry County**

Meetings of the Fall Creek Blacksmith Shop are held on the fourth Saturday of the month starting at 10 a.m., with open forge at 9 a.m. at the residence of John Zile in Middletown. For more information contact John at (765) 533-4153 or Larry Singer at (765) 643-5953. Or Farrel Wells at 765-768-6235, flwells@verizon.net

The meeting started 9:30, Feb 26, with each of the 13 present giving a shop tip. Joe Gobel Brought a Walleye Sculpture, and Tom White brought a tropical fish, and vase of roses. We discussed having more demos, but many thought we needed to devote more meeting time to projects for conference auctions, and fill in with an occasional demo. About 11 am we called James Johnston to find out what the contest item was for 2011. He was still in bed. We called later and were told it was a wall hanging, and a garden item is to be made for the regional conference. Thanks Jim. Tom White made a rose bud. Kim Soladine made a horse head key fob, Do Kern drew out a damascus billet on the power hammer. Charles Gruell made a back scratchier. Dave Kline used a nail header he won in the iron in the hat at Kenny Dettmers, to make some nails. Dave Wells and Eric Shotwell made several chain links. The others watched, ate all the donuts and drank all the coffee. We had Iron In The Hat. Retired to the Iron Kettle Restaurant for lunch, then returned to the shop to play some more. We do want to remind everyone that Roy Wescott' auction will be March 19. The time has not been chosen, so continue to check on line at " Auction Zip". Come and see us. We like company

Wabash Valley Blacksmith Shop**West Central Region****Vigo County**

Meetings of the Wabash Valley Blacksmith Shop are held on the second Saturday of the month starting at 9 a.m. Meetings are held at the blacksmith shop in Fowler Park, approximately 7 miles south of Terre Haute. For detailed information, contact our forgemaster, Doug Moreland (217)284-3457 or our librarian, Max Hoopengartner (812)249-8303.

One Armed Blacksmith's Shop**South Central Region****Johnson Co.**

Meetings of the One Armed Blacksmith's Shop are held on the 1st Saturday of the month starting at 9am. For more information contact Tim Metz at (812)447-2606 or tim.metz@cummins.com.

Tim Metz and Jeff Park just finished a side by side build of two identical power hammers. This is Tim's second hammer. His first one was the result of seeing Paul Bray's hammer combined with ideas from other power hammers he saw online. The first hammer worked great. But, the more he used it the more ideas he came up with for tweaks and refinements. So, the first hammer was sold to make room for the next one. These most recent two hammers took approximately six weeks to build working a couple of days a week. They were finished just in time for the February meeting of the One Armed Blacksmiths. At the meeting, Kenny Dettmer started the fire and Ray Sease was the first one to pound hot metal and break these new hammers in. After using his new hammer, Tim said he would never be without a power hammer again and has already started making the next one just in case. Tim's hammer can be seen at his shop at the March 5th meeting of the One Armed Black Smiths and Jeff's hammer can be seen at his shop at the April One Armed Blacksmiths meeting. Thanks to Paul, Ray and Kenny for their help and advice along the way.

**Whitewater Valley Blacksmiths****Southeast Region****Franklin Co.**

Meetings of the Whitewater Valley Blacksmiths are held on the second Saturday of the month starting at 4:00 p.m. They meet at the home of Jimmy Dean. The address is 3104 Seeley Road Cedar Grove Indiana 47016. For more info call Keith Hicks at 765-647-0019.

COPPER CLASS

vases, plates and other forms
April 16-17 @ Bellflower, IL

contact Roger or Janet Lorange @ 309 475 9012

Don R Neuenschwander

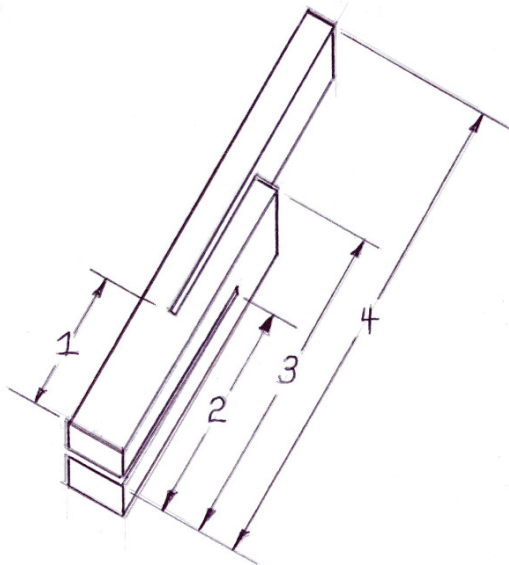
Split-Cross from a Pipe

By Dominick Andrisani

Many blacksmiths have created beautiful split crosses (a.k.a. Friedrich Cross) using solid square stock cut as shown in the sketch below. It is also fun to use the same technique to make split crosses out of pipe. When you are done the cross appears to be made out of pipe of half the original diameter. Typical dimensions are given in the table below.

Length#	Diameter of Pipe (inch)				
	1/4	3/8	1/2	5/8	3/4
1	9/16	7/8	1+5/32	1+7/16	1+23/32
2	29/32	1+3/8	1+13/16	2+9/32	2+23/32
3	1+7/16	2+5/32	2+7/8	3+19/32	4+5/16
4	2+5/16	3+15/32	4+19/32	5+3/4	6+29/32

Dimensions for lengths shown below.

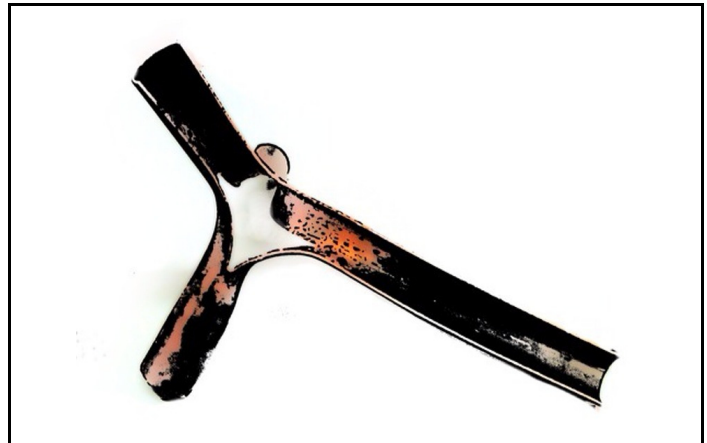


Split-cross lengths defined here for a square bar also work well for pipe (sketch and dimensions by Jeff Reinhardt)

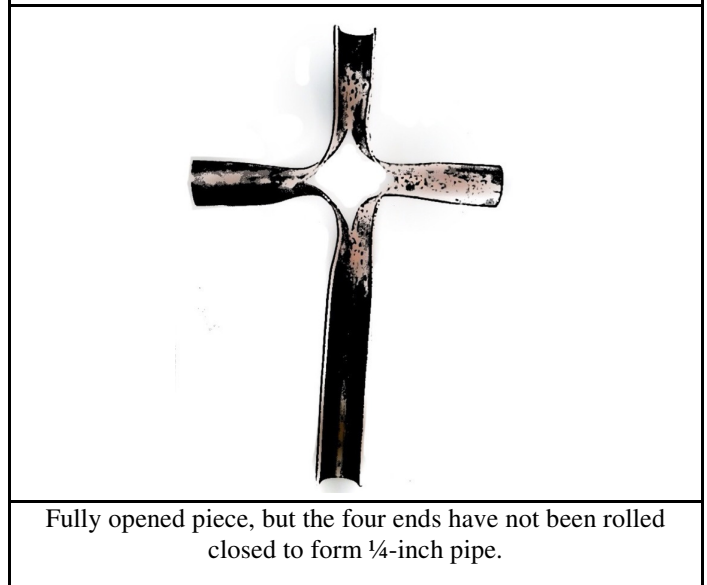
If making your cross out of stiff copper pipe, make the three cuts shown in the sketch above. Cut the metal before annealing or the pipe may become so soft as to collapse while being cut. The second step of annealing the copper (getting it red in the fire) is very important to prevent the copper from tearing in the center where the four arms meet. You should anneal copper only in a space where there is good ventilation as some nasty fumes may be given off. If

skipped, as the copper is already soft and flexible. Allow the copper to cool or quench it in water. The copper should be worked cold.

Opening the cut-annealed-cooled pipe should be done slowly and carefully. Considerable stretching of the material in the center where the arms meet will occur. The opening should be done equally on each arm with an eye for symmetry. You can use any flat tool to help you open the cross. I used a wide chisel to get it slightly opened and gloved fingers to open it the rest of the way.



Partially opened 1/2-inch copper pipe. Take care that the opening in the middle remains symmetrical.



Fully opened piece, but the four ends have not been rolled closed to form 1/4-inch pipe.

In the photographs above the vertical arms are concave up and the horizontal arms are concave down. After fully opening the cross (as shown in the lower photo above) each arm will need to be rolled closed

using soft copper tubing, the annealing step can be so that the original 1/2 inch pipe closes into a 1/4 inch pipe. This can be done with a hammer on the anvil. I prefer to use a copper hammer on copper. The vertical arms will close on the top as illustrated, thereby producing a seam in the front, while the horizontal arms will close at the back producing seams on the backside. I find that laying a 1/4 inch diameter steel rod on the cross helps me to align the top and bottom arms and to form a uniform 1/4 inch pipe around the rod. The rod can be slid out with a little elbow grease. The rod can then be used to align and form the horizontal arms. Take care in forming the copper near the center of the cross to get smoothly varying edges connecting the horizontal to the vertical arms.

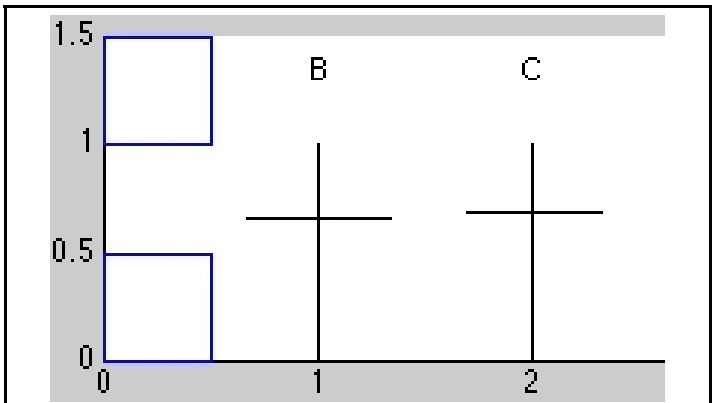
Illustrated below is a finished split-cross made from half-inch copper pipe. The finished dimensions are 6 inches tall by 4 1/4 inches wide and the arms are a 1/4 inch in diameter.

To complete the cross, the copper was cleaned in a mild acid pickle (like pH Down available at your favorite pool store), rinsed in water, darkened by dunking in a solution of liver of sulfur (available at www.delphiglass.com) for several minutes, rinsed again in water, scratched with a hack saw blade to make the copper sparkle, and polished with paste wax. Note in the picture above that there are seams on the vertical arms. These can be filled in with braze or left as shown. On the backside of the cross the horizontal arms also have the seams.

A final word about the overall proportions for a cross. Throughout history you can find examples of many different cross proportions (ratio of height to width and ratio of the length of the top arm to the height), and you can still see all manner of cross proportions in use today. The one for you to use is the one you think looks better. Several examples of overall cross proportions that I think look good are given in the illustration below.



Split-cross made from 1/2-inch copper pipe showing seams along the vertical arms. Arms are 1/4 inch in diameter. The top arm is a little shorter than the right and left arms.



Two cross proportions drawn to scale. The two blue squares should look perfectly square.

Method	Top Arm/Height	Height/Width
B	0.333	1.500
C	0.301	1.618
Copper Cross	0.333	1.412

Proportions for the two cross designs and for the copper cross pictured at left. The top arm is the vertical portion above the crosspiece. Method C uses the Golden Ratio (ratio of height to width is 1.618) while method B uses round numbers like 1/3 and 3/2. The top, left, and right arms are the same length in methods B and C.



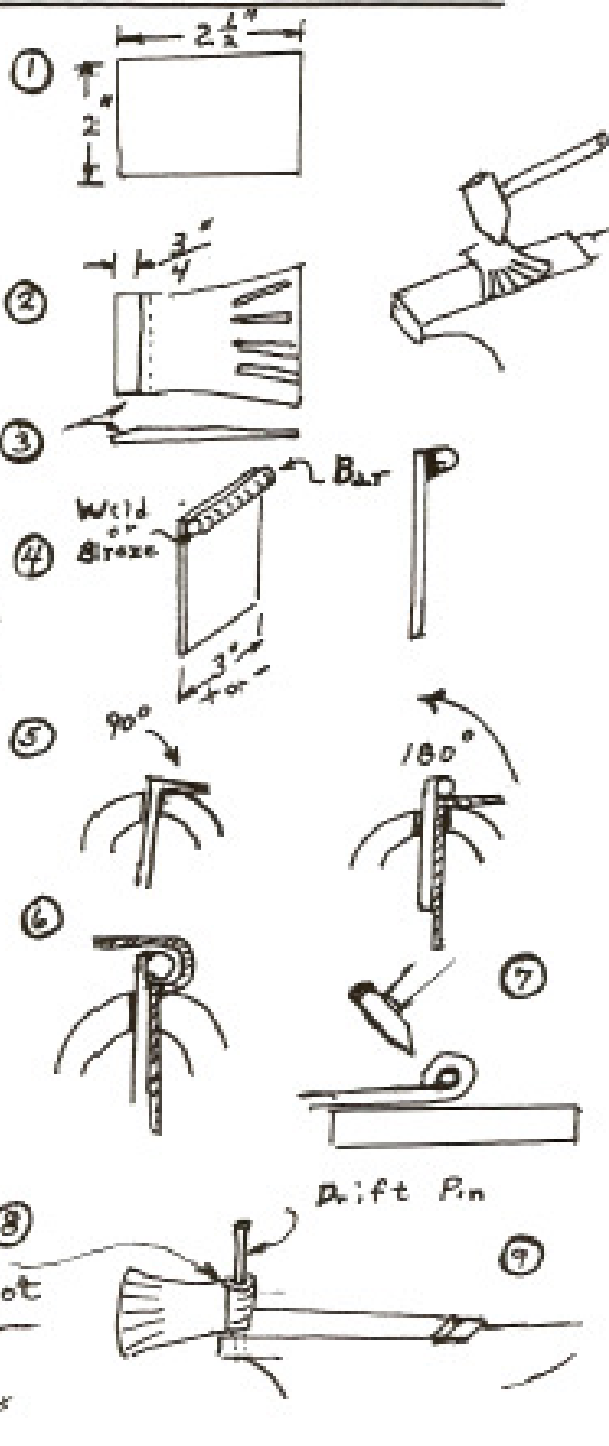
BUTTERFLY HINGE

Raymond G. Phelps

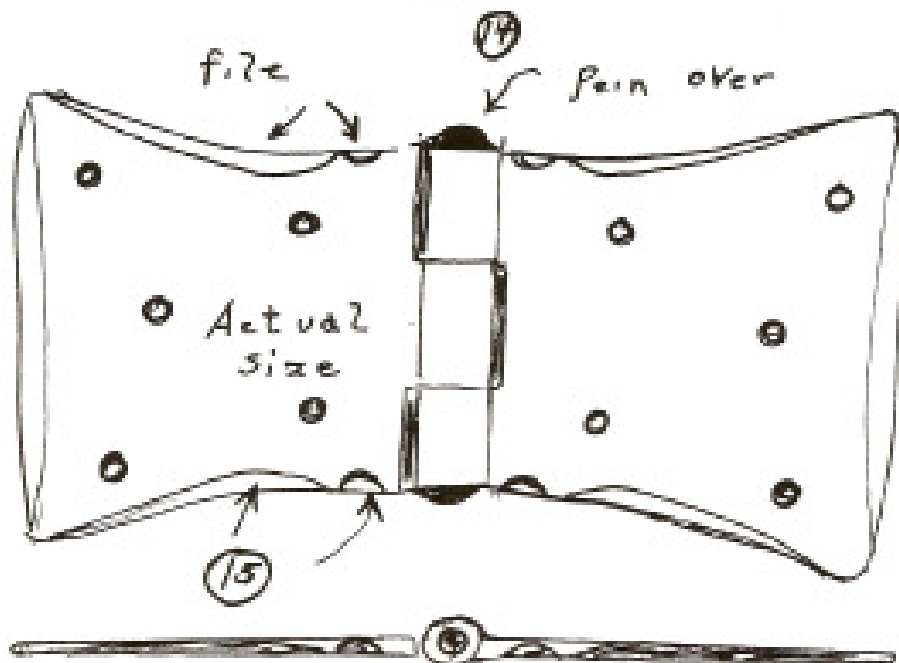
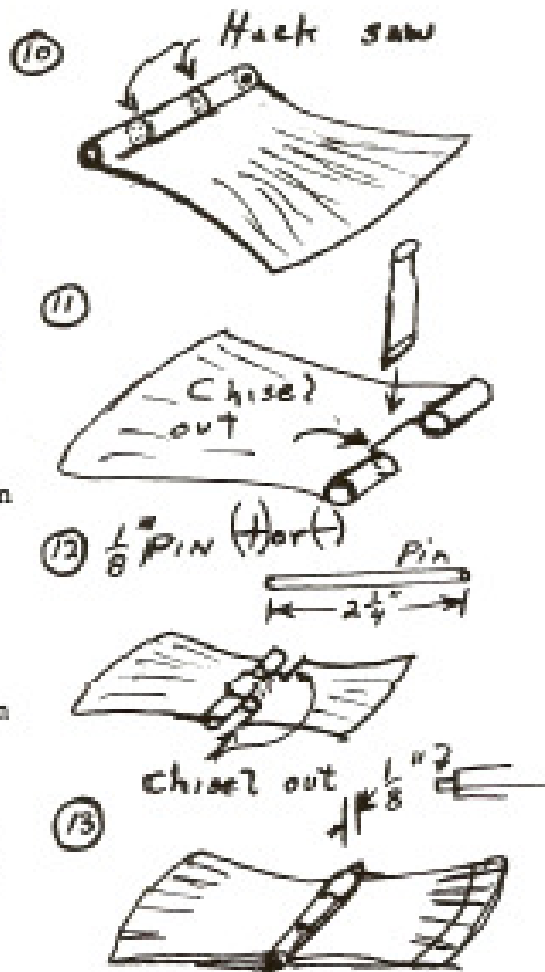


Stock: 1/8" X 2" X 5" Long

1. Cut two pieces, one for each half of the hinge. (2" X 2 1/2" long)
2. The shape is formed by flaring out one end.
3. The other end is tapered back 3/4".
4. Make a bar the size of the pin and weld or braze to one end of a piece of 3" flat stock. This will make a jig to bend the hinge parts over.
5. Heat, place in vise and make sharp right angle bend on tapered hinge half.
6. Next, place jig behind the hinge and bend 180 degrees.
7. Remove jig and continue to close up eye of hinge.
8. Install drift pin the same size, so as to shape round, then remove pin. Heat to red, then put Borax flux on and weld.
9. Heat again after welding and drift out the eye to the size of permanent pin.



10. Once both sides are completed, layout and mark where cuts are to be made.
11. Hacksaw the center out of one side, then use chisel to cut across.
12. Lay other half next to it and mark where to cut out each end opposite the other half.
13. Assemble by using 1/8" pin sticking out on the ends in order to pin over.
14. Lay out screw holes and punch or drill.
15. To add a little decoration you can file with a half round file on an angle.
16. Finish by blackening with paint or heat and apply a mixture of linseed oil, turpentine and beeswax.



Miscellaneous Items

Roy Westcott Auction

You may or may not know that Roy Westcott passed away recently. Some of his shop equipment will be auctioned off on March 19 starting at 12:00. The location is 2686 W 400 S, Greenfield, IN. Some of the auction items can be viewed at www.auctionzip.com. The items listed include both machine tools and blacksmith tools.

Anvil Carry

Ted Stout passed along the following link: <http://www.youtube.com/watch?v=CnxwJm0z-gU>
The video shows a contest where the object is to lift and carry an anvil with one hand. The contest requires tremendous physical strength, especially grip strength. This might be a fun contest at our Conference or other function.

Touchmarks/Stamps

Columbia Marking Tools (CMT) www.columbiaamt.com (phone 586-949-8400) is the manufacturer of the stamps many of us blacksmiths are ordering and using today. My stamp 1/8" letters reading "T. Stout" and cost about \$70 a year ago. They last very well (many years) on both cold and hot applications. The CMT folks will work with you to design what you need, whether it is your logo or letters. If you send them your signature they can even make a die for it. Several of us have bought from them and have been very happy with the results. They are about one half the cost from some of the blacksmithing supply houses.

Ted Stout

Blacksmith Pat Lyon (supplied by Jim Johnston)

This painting has always been a favorite of mine. The subject is Philadelphia blacksmith Pat Lyon. He lived from 1779 to 1829. The painting itself was painted by John Neagle around 1826. In 1798 after losing both his wife and daughter to yellow fever wrote this for his grave marker:

My sledge and hammer's both declin'd,
My bellows too have lost their wind;
My fire's extinct; my forge decay'd,
And in the dust my vice is laid;
My coal is spent, my iron's gone,
My nails are drove, my work is done

Instead of dying he lived till 1829 becoming one of the more prosperous Philadelphia blacksmiths.

Much more info is available at:

http://www.engr.psu.edu/mtah/articles/pat_lyon.htm





The FORGE FIRE

Newsletter of the
Indiana Blacksmithing Association,
Inc.

Bill Kendrick *Newsletter Editor*

1280 N CR 900 W
Seymour, IN 47274

First Class Mail

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Annual Business Meeting

March 19

Hayden Historical Museum

Hayden is located in Jennings County about midway between Seymour and North Vernon, just north of US50. From US50, turn north on CR675W. Turn right at the first cross road (Base Rd). The Museum is the third building on the right. A gravel parking lot is located behind the museum.

Please bring a dish to share.

Sutton-Terock Blacksmith Shop

April 16

Located at the Fulton County Historical Society

Located off US-31 about 4 miles North of Rochester