



VOICE

APRIL

2013

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UP COMING EVENTS

APRIL 20, 2013 - TIRED IRON TRACTOR SHOW GENTRY, AR { SHOW RUNS }
TRADE ITEM - A CRITTER OF YOUR CHOICE { APRIL 19 - 21 }

APRIL 24, 2013 - DEADLINE FOR THE NEWSLETTER

MAY 11, 2013 - RON WELLS MOUNT JUDEA, AR
TRADE ITEM - NUT CRACKER

MAY 26, 2013 - DEADLINE FOR THE NEWSLETTER

MAY 27, 2013 - GLEEN OWENS, JONESBORO, AR
TRADE ITEM - ANYTHING FOR THE GARDEN

NEWSLETTER DISCLAIMER:

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BOA Minutes for March 9, 2013

The regular monthly meeting was held at the shop of Hardy Todd at Marble.

The February minutes were approved as printed in the Newsletter.

Old Business:

Website development: Dale Custer, with a friend hosting the site, has set up a BOA test webpage. The trial nature of the site is reflected in the following web address: <http://anvil.impactyourweb.com>

Please access the site and send suggestions to Dale, Justin Jones, or myself. Look at other sites (my personal favorite is BAM webpage) and tell us what you think.

Non-Profit: Dale Custer has also been inquiring about non-profit and LLC status and contacted the Arkansas Sec. of State Office. Bob Lock (from experience) suggested that contracts drawn up by persons not in the legal profession are suspect and often dismissed within the legal community and the courts. Discussion raised the need for legal advice, so if you have a lawyer friend, get them involved in Blacksmithing. We need that skillset in our membership.

New Business:

Ron Wells reported that the club does not have sufficient inventory of "for sale" items for the Tired Iron of the Ozarks show in April. All members need to make items; key rings, steak turners, crosses, hearts, etc. and get them to the meeting where we have a buying public.

Ron also reminded us of the upcoming BAM Conference and suggested it is a great event to learn and network with other blacksmiths from all around the country.

Hardy Todd donated a 3 foot section of heavy gauge railroad rail to be raffled off. Joe Doster spent 3 hours at Hardy's band saw cutting it in two sections. His hard work paid off as he won the raffle, netting \$16.00 for the organization. Hardy would like the second section to go to a starting Blacksmith. Ron Wells has a similar rail intended for the same purpose. If you are new to blacksmithing, and don't yet have an anvil, talk to Ron, Hardy, or myself.

There 27 to 30 people present, hard to count as folks came and went.

Former member Ron Sheirey came and brought a guest – Ed Osoris who jumped right in a made a couple of items from horseshoes.

Trade item for April is a "Critter". May meeting at Ron Wells will be a Nut Cracker.

Respectfully Submitted,

Joe Doster for Harold Enlow

NEWS AROUND BOA

Hello fellow blacksmiths,

We have received some sad news. Our member Bryan Griffin's father passed away early Tuesday morning. He was 56 years old. Visitation for Wayland Griffin will be from 6:00-8:00 PM on Wednesday, March 13th at Roller Coffman Funeral Home 923 Hwy 65 N in Marshall, AR. The funeral services will take place at McMahan Cemetery Hwy 74 W just North of Snowball at 10:00 AM on Thursday, March 14th.

The family has set up a memorial fund in Wayland's name at Simmons First Bank of Marshall. BOA has sent flowers: With deepest sympathy to the family of Wayland Griffin from his friends of the Blacksmith Organization of Arkansas.

The obituary is at www.rollerfuneralhomes.com/obit

Ron

Blacksmithing courses at Bob Patrick's shop

Here is another opportunity to learn from the best. Bob Patrick asked me to share this with you. Bob Patrick will be teaching 2 beginning and intermediate level blacksmithing courses in 2013 at his shop through the Arkansas Craft School. One is April 26 – 28, 2013, the other short course is November 1 – 3, 2013.

Please contact the Arkansas Craft School for more information -

Web site- <http://arkansascraftschool.org>

Email - arkcraftschool@gmail.com

Phone - (870) 269-8397.

World renown bladesmith, Jim Crowell, will be teaching Damascus steel and blade smithing courses as well, and there are many other courses taught by other Arkansas craftspeople, such as Bob's wife, Mary. Bob also instructs in virtually all other areas of blacksmithing at any level by private arrangement in his shop. The Craft School classes are very small and less expensive than individual instruction and are a great chance to learn at a reasonable price. Bob and Mary have limited housing, but they have tent or RV camping with no hookups. There is an outhouse and outside water available.

There is lodging available at nearby towns.

Mary is teaching classes at the same time that a spouse may be interested in.

BOA members who have taken Bob's courses include:

Dale Custer, Chad Wagner. Bill Angle. Frank Wallace. Justin Jones. Si Compton.

There may be others, but I'm sure that any of these guys would be happy to share their experience with you.

Again, this is a great opportunity to learn from the best.

Your friend,

Ron Wells, Treasurer of BOA

Sharpening

(Plain and Simple)

I understand tool sharpening as a two stage process--grinding and honing. (Any honing compound will work.) Grinding is accomplished by a number of ways using a grinding wheel, a belt grinder, sandpaper, or various stones so that the edge is shaped by removing larger amounts of metal. Honing is accomplished by the use of the buffing wheel, leather, or paper so that the cutting edge is applied to the shaped edge by removing very small amounts of metal.

I am of the opinion that it is necessary to grind tools from time to time. As a tool dulls metal breaks away right at the very edge. Buffing or honing will replace that keen edge by removing very small amounts of metal right at the very edge thus the bevel with repeated dulling and honing becomes shorter and therefore blunter. The tool may indeed be sharp but the edge is at a steeper angle and will not cut through the wood with the same original ease. This is especially true when carving softer woods such as basswood where a thinner edge is used. So from time to time the edge needs to be thinned down by grinding.

Having said this, I want to acknowledge that many carvers do over-grind while others over-buff. Also, there are probably as many theories on sharpening as there are woodcarvers.

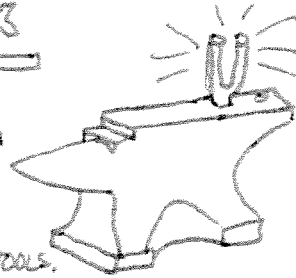
I don't have any secret method for sharpening tools. Sharpening is a two step process and it is very simple. Grinding and honing. Both can be done with power or by hand. I would recommend a diamond stone for the grinding process and a leather strop for the honing process. Grinding is the process of shaping the blade. Honing is the process of putting the final cutting edge on. Keep the knife flat while grinding so that you maintain a low bevel. When honing, also keep the blade flat on the leather. The leather compresses and as it comes back up at the edge of the blade it creates the honed cutting edge and secondary bevel. How much to grind or hone? Honing leaves a shiny surface. Grind until the shiny is gone then put the shiny back on. It's as simple as that, but like most things, takes lots and lots of practice.

I am glad you like the knife. Just sharpen it the same way you sharpen any other quality knife. It might just take more time is all. Sharpening is a two step process, grinding and honing. I use a 1" sanding belt to do the grinding and a floppy wheel (cloth buffing wheel) to do the honing. You can do it with a stone and leather strop. I recommend a diamond stone. The knife has a shiny area right at the edge. Keep the blade flat and grind until the shiny is gone then hone to put the shiny back on. Simple as that.

Having trouble keeping the knife sharp? I find that a newly sharpened tool, especially if the edge is very thin will need breaking in. The term "breaking in" means that a small portion of the material is worn away and then renewed as in the breaking in of an engine when the metal parts wear together and then mesh more smoothly. The next time you go through the sharpening process try rehoning. Try not to let the edge get too bad before rehoning. A couple of times and the problem may be eliminated. Thanks.

Ron Wells

WELD-LESS BENDING FORK



ONE PROBLEM WITH GETTING STARTED IN BLACKSMITHING IS THE NUMBER OF TOOLS YOU NEED. YOU CAN MAKE MOST OF THESE TOOLS, BUT IN MANY CASES, YOU NEED TOOLS TO MAKE TOOLS. HERE'S HOW TO MAKE A VERY USEFUL TOOL FROM NOTHING BUT A SHORT PIECE OF SQUARE STOCK

① START WITH A SHORT PIECE OF SQUARE STOCK ABOUT EIGHT INCHES LONG. MILD STEEL IS FINE. THE BAR SHOULD BE SLIGHTLY LARGER THAN YOUR HARDY HOLE. MY ANVIL HAS A $\frac{3}{8}$ " HARDY, AND ONE INCH STOCK WORKED PERFECT.

THREE INCHES FROM ONE END, MARK EACH FACE VERY LIGHTY WITH A COLD CHISEL. THIS WILL BE THE TANG END OF THE FORK THAT GOES INTO THE HARDY HOLE.

② HEAT TANG END OF THE STOCK AND PUT A SHORT CHAMFER IN IT.

THEN TAKE A PIECE OF SOAPSTONE AND MARK ONE FACE. FROM NOW ON, WHEN DRIVING STOCK INTO HARDY HOLE, KEEP THE SOAPSTONE MARK FACING THE HORN OF THE ANVIL.

③ DRIVE THE STOCK INTO THE HARDY ENOUGH TO LEAVE AN IMPRESSION ON ALL FOUR FACES. YOU SHOULD BE ABLE TO DO THIS ON THE SAME HEAT AS THE CHAMFER IN STEP TWO.

④ REHEAT THE TANG END OF THE STOCK AND TAPER FROM THE SCORE MARKS AT 3" DOWN TO THE HARDY HOLE MARKS. THIS IS VERY LITTLE TAPER.

BEFORE: TANG LENGTH 5" HARDY HOLE IMPRESSION

AFTER: TAPER

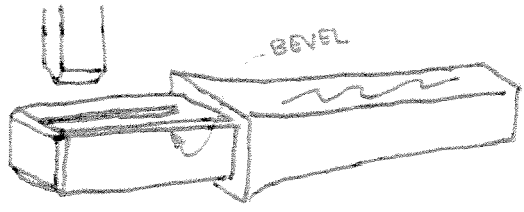
⑤ REHEAT TANG END OF STOCK AND DRIVE IT INTO HARDY. IF ATAP ON THE SIDE DOES NOT FREE IT, YOU CAN QUENCH IT WHICH WILL CAUSE IT TO SHRINK. THIS TANG FORMING PROCESS SHOULD NOT AFFECT ANVIL TEMPER, BUT DON'T LEAVE IT IN LONGER THAN NEEDED.

⑥ REPEAT HEATING AND TAPERING UNTIL THE STOCK IS DRIVEN INTO THE HARDY UP TO THE TANG LENGTH MARKS.

YOU CAN THIN THIS PART WITH HAMMER TO SPEED PROCESS. NEVER HAMMER ON PART THAT IS ALREADY SIZED.


BAR WILL BE SLIGHTLY UPSET ABOVE TANG.

7 HEAT THE TANG ONE MORE TIME. USE A CHISEL TO NOTCH THE TANG ON THE SIDE WHERE THE SOAPSTONE MARKS WERE, SO YOU ALWAYS KNOW WHICH SIDE FACES THE HORN. ALSO, SLIGHTLY BEVEL THE EDGES OF THE TANG.



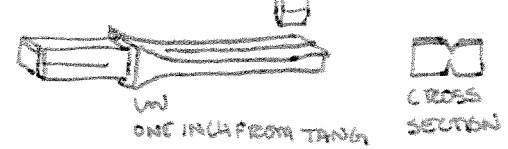
A COLD CHISEL WITH A WIDER POINT ACTUALLY MAKES A BETTER NOTCH THAN A NARROW HOT-CUT CHISEL. THE POINT IS TO MAKE IT EASY TO SEE - NOT TO CUT.

8 HEAT THE OTHER END OF THE STOCK, THEN TURN THE NOTCH TO THE SIDE, AND THIN THE FORK UNTIL IT IS TWICE AS WIDE AS IT IS TALL. WORK FROM BOTH SIDES, BUT MAKE SURE THE TANG NOTCH STAYS ON THE NARROW SIDE, SO THAT THE FINAL FORK FACES YOU, NOT THE ANVIL HORN.



ABOUT ONE INCH TRANSITION TWICE AS WIDE AS HIGH IN CROSS-SECTION

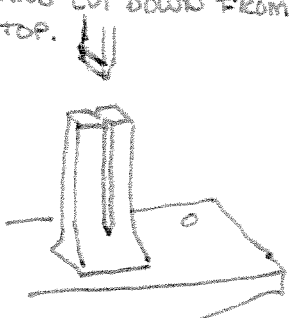
9 GET A DEEP HEAT ON THE FORK, AND, USING A HOT-CUT CHISEL, CUT ALMOST TO THE CENTER FROM TOP AND BOTTOM OF FORK FROM TIP TO ABOUT ONE INCH FROM START OF TANG.



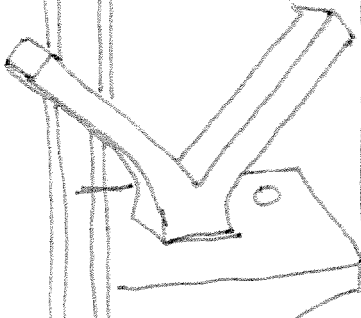
ONE INCH FROM TANG CROSS SECTION

THIS WILL TAKE SEVERAL HEATS

10 TO FINISH THE CUT, HEAT THE FORK, PLACE IT IN THE HARDY, AND CUT DOWN FROM TOP.



11 BEND EACH LEG OUT 45°



WHY?

WHY NOT CUT ALL THE WAY THROUGH FROM ONE SIDE?

EVEN A HOT-CUT CHISEL DEFORMS STOCK, PUSHING METAL IN THE DIRECTION OF THE CUT.



WHY NOT CUT HALFWAY THROUGH, AND FINISH FROM OTHER SIDE?

BECAUSE THE CHISEL IS MOVING METAL, YOUR NICE POINTY BOTTOM OF YOUR FIRST CUT IS FLATTENED BY THE SECOND, RESULTING IN FLAPS ("RAGS") THAT MUST BE FILED OR GRIND OFF



SHARP FIRST CUT IS DEFORMED BY SECOND.



WHY CUT ALMOST HALFWAY FROM BOTH SIDES AND FINISH FROM THE END?

- LESS DEFORMATION OF CROSS-SECTION.
- NO RAGGING
- THIS LETS YOU USE THE HARDY, WHICH PREVENTS THE PIECE FROM MOVING AROUND
- THIS LETS YOU "CORRECT" IF YOUR CUTS ARE NOT PERFECTLY ALLIGNED
- THIS KEEPS YOU FROM CUTTING INTO THE FACE OF YOUR ANVIL

FOR MORE INFO: SEE MARK ASPERRY'S ARTICLE "PUNCHED AND DRIFTED HOLES" IN THE WINTER 2013 HAMMER'S BLOW ABANA PUBLICATION

12 ROUND THE TWO FORKS ON THE FACE OF THE ANVIL. DON'T DRAW THE FORKS ANY LONGER OR THINNER - JUST KNOCK THE CORNERS OFF.

CROSS SECTION!
 SQUARE → OCTAGON → ROUND

13 VERY IMPORTANT!
 USING A BLUNT EDGE, FULLER THE CRACK AT THE BASE OF THE FORK UNTIL ROUND, TO PREVENT FUTURE SPLITTING

THIS CRACK WILL EVENTUALLY SPREAD
 THIS WON'T.

14 USING A COLD PIECE OF ROUND STOCK ROUGHLY THE SAME SIZE AS YOUR FORKS, HAMMER IT DOWN INTO THE FORK, AND BEND THE FORKS UP AROUND IT. WITHOUT USING THIS SPACER, THE GAP BETWEEN THE FORKS WILL TAPER

THIS IS ALSO A GOOD TIME TO MAKE SURE THE FORKS ARE IN LINE WITH THE HORN, SQUARE, AND STRAIGHT.

15 CLEAN UP WITH WIRE BRUSH AND FILE. USE GRINDER OR FILE TO PUT SLIGHT CHAMFER ON TOP OF FORKS

CHAMFER

16 THE MOST IMPORTANT STEP - PUT ON THE MAKER'S MARK!

THIS IS A FOX

THANKS!
 HOPE YOU GIVE IT A SHOT.

Robert

Our March meeting was a good one we dodged the rain and had pretty good weather overall. I finally got my shop enclosed all the way which made for a little better meeting cutting the wind out. We had 11 members present and got quite a few things made during the day. We forged a bearded axe, a knife, tongs, forge rake, strap hinges, 2 hooks, a door handle, and a Japanese Sai. Overall everyone got to learn a few new things and saw several things that they had not seen before. I want to thank everyone for participating and helping each other to do there projects, it is allot easier when you have help, along with someone that can share in what you made. It was not raining so we grilled up some hotdogs, am looking forward to spring and nicer weather. We had a short business meeting and will have or next meeting at my shop in Jonesboro on the 27th from 8 till 4 the trade item will be anything for a garden. I would like to welcome Eddie Mullins from Marmaduke who just joined our chapter. I would like to thank everyone for making the meetings enjoyable and educational, keep up the good work.

Thanks, Glenn Owen
Steward NEA Chapter BOA

| Degrees F. | Color | Tools |
|------------|-------------------------|---|
| 200 | | |
| 375 | | Gauges |
| | Very pale yellow | |
| 430 | | Light turning |
| 440 | Lemon yellow | Lathe, scrapers |
| 460 | Straw yellow | Drills, milling cutters |
| 480 | Dark straw | Punches, rock drills, shears |
| 500 | Brown | Woodworking, reamers, stone mason's |
| 510 | Brown with red spots | Wood chisels |
| 520 | Brown with purple spots | Sledge hammers |
| 530 | Light purple | Axes, adzes, hot sets, augers, blacksmith hammers |
| 540 | Full purple | |
| 550 | Dark purple | Cold chisels |
| 560 | Light blue | Screwdrivers, saws |
| 570 | Blue | |
| 580 | Dark blue | Wagon springs |
| 610 | | |
| 630 | Blue tinged with green | |

| MELTING POINTS OF METALS | |
|--------------------------|--------------------|
| METALS | DEGREES FAHRENHEIT |
| SOLDER, 50-50 | 400 |
| PEWTER | 420 |
| TIN | 449 |
| BABBITT | 462 |
| LEAD | 621 |
| ZINC | 787 |
| MAGNESIUM | 1204 |
| ALUMINUM | 1218 |
| BRONZE | 1675 |
| BRASS | 1700 |
| SILVER | 1761 |
| GOLD | 1945 |
| COPPER | 1981 |
| IRON, CAST | 2200 |
| STEEL | 2500 |
| NICKEL | 2646 |
| IRON, WROUGHT | 2700 |
| TUNGSTEN | 6150 |

Gunter quench

Rob Gunter, the proprietor of the RForgerly at Tijeras, New Mexico, has developed an experimental quenching solution to replace a 10 percent Sodium Hydroxide solution. It consists of:

- 5 gallons water
 - 5 pounds table salt
 - 32 ounces "Dawn" dishwashing liquid
 - 8 ounces Shaklee Basic I
- Quench at 1550 degrees F. Use care with any quenching material. Do it outside or with good ventilation to save your lungs.

—Indiana Forge Fire

| Heat Colors of Mild Steel | Temperature(F) |
|--------------------------------|----------------|
| Red Heat | 975 |
| Black Red | 990 |
| Dark Blood Red | 1050 |
| Red Heat (visible in sunlight) | 1080 |
| Dark Cherry Red | 1175 |
| Medium Cherry Red | 1250 |
| Full Cherry Red | 1375 |
| Light Cherry Red | 1550 |
| Salmon | 1650 |
| Light salmon | 1725 |
| Yellow | 1825 |
| Light Yellow | 1975 |
| White | 2220 |
| White Welding Heat | 2550 |

TAILGATE CORNER BUY SELL AND TRADE

FOR SALE OR TRADE; FORGES, FIRE POTS, BLOWERS, ANVILS, HARDY TOOLS, TONGS, HAMMERS, VISES, AND ETC. CALL FOR A CURRENT LISTING & PRICES.

Bob Lock - 417 847 6708.

PS. I also have a 2000HD Sportster 1200cc \$4500.

Chris Padelford has a 25pound Little Giant new style in great working condition for \$2800 obo, a work table 4x4 x 1 3/8 inch thick on casters for \$400 obo, a 4in post vice on stand \$125 obo, gas forge \$100 obo. I am leaving the business after 25 years due to shoulder problems, all equipment is in great shape and has lots of use left. Plus miscellaneous blacksmithing tools, too many to list all reasonably priced. I can be reached through email brandynchrispadelford@yahoo.com or at 870-291-0366, please leave a message if I miss your call.

Si Compton has a fire pot for sale for \$ 50.00

Contact him at;

Phone - 501-701-7880

e-mail - hybiscus67@hotmail.com

We are still selling tickets for the toolbox containing all those tools. The box is getting heavy. The tickets are one dollar each or six for five dollars. Hardy Todd is taking care of that.

News Flash

The BOA t-shirts and caps have arrived. Come to the April meeting to pick up yours. T-shirts are \$10 each. Caps are \$8 each. We have a few extra caps, so you can still get a cap even if you didn't order one. First come, first serve.

**DIRECTIONS TO
TIRED IRON OF THE OZARKS**

TIRED IRON IS LOCATED AT 13344
TAYLOR ORCHARD RD. GENTRY, AR
DIRECTIONS FROM HWY 412 AND
MOUNT OLIVE ST. IN SILOAM SPRINGS, AR
GO NORTH ABOUT 1.7 MILES ON MOUNT
OLIVE ST.

TURN RIGHT ON DAWN HILL RD. TO TAYLOR
ORCHARD RD { NOTICE SIGN IN THE "Y" }.

TURN LEFT ON TAYLOR ORCHARD RD.
GO ABOUT 2 MILES { STAY ON PAVEMENT }
ON TAYLOR ORCHARD RD TO SHOW GROUNDS.

DIRECTIONS FROM HWY. 59 IN GENTRY, AR
FROM THE TRAFFIC LIGHT AT HWY. 59, GO WEST
ON HWY. 12 { THIRD ST. } FOR ABOUT 1/2 MILE.

JUST PAST THE CITY PARK, TURN LEFT { SOUTH }
ON PIONEER LANE { FOLLOW SIGNS FROM THIS POINT }.
GO SOUTH ON PIONEER LANE FOR ABOUT 1/4 MILE TO
THE CORNER OF THE HIGH SCHOOL PRACTICE FIELD.

TURN RIGHT { WEST } ON SWEPCO RD.
FOLLOW SWEPCO RD THROUGH THE CURVES FOR
ABOUT 1 MILE.

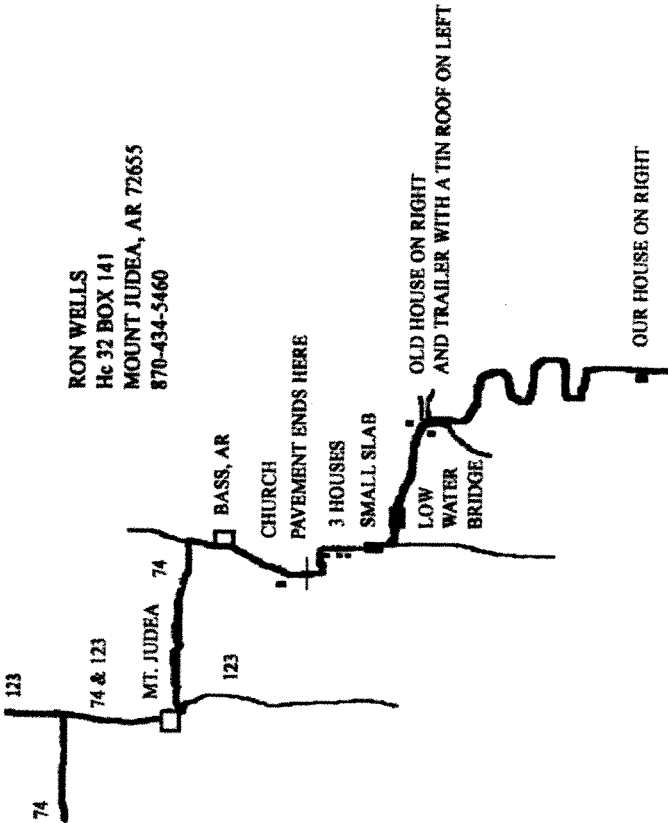
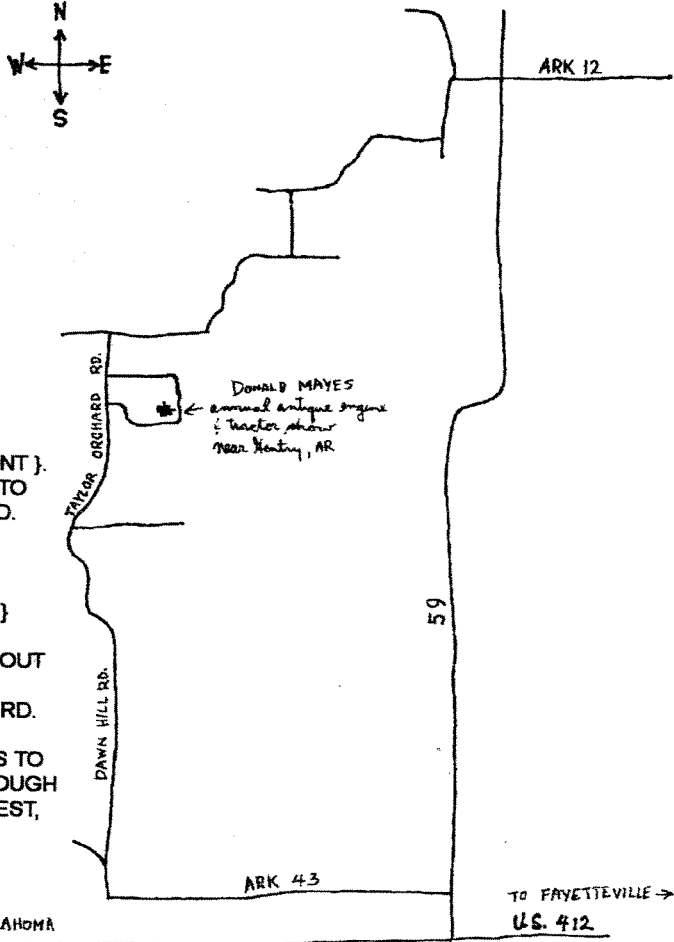
TAKE TAYLOR ORCHARD RD TO THE LEFT { SOUTH }
FOR ABOUT 1/2 MILE.

TURN RIGHT { WEST } ON MARION LEE RD. FOR ABOUT
1/4 MILE.

TURN BACK LEFT { SOUTH } ON TAYLOR ORCHARD RD.

STAY ON TAYLOR ORCHARD RD. FOR ABOUT 2 MILES TO
13344 TAYLOR ORCHARD RD. THE ROAD GOES THROUGH
CURVES, AND AFTER IT STAIGHTENS OUT TO THE WEST,
GO ABOUT 1 MILE.

TAYLOR ORCHARD RD. WILL TURN BACK TO LEFT
{ SOUTH } ABOUT 1/8 MILE TO THE SHOW GROUND
ENTRANCE.



FROM HARRISON AND POINTS FURTHER EAST, TAKE 123 AT WESTERN GROVE TO MT. JUDEA.
FROM MARBLE AND POINTS FURTHER WEST, TAKE 412 TO 21 TO 43 TO 47 TO MT. JUDEA.
AT MT. JUDEA TAKE 74 TO BASS. IT IS ABOUT 7 MILES FROM MT. JUDEA TO THE END OF THE
PAVEMENT AT BASS. YOU ARE NOW ABOUT 3 MILES FROM OUR HOUSE. THIS ROAD, IN
PLACES, IS ROUGH, NARROW, CROOKED, AND STEEP, SO REDUCE SPEED AND COUNT ON
ABOUT 10 MINUTES FOR THE 3 MILES. WATCH FOR 3 HOUSES WITH THE FADED WHITE BOARD
FENCES. JUST PAST THIS POINT YOU WILL CROSS A SMALL CONCRETE SLAB. VERY SHORTLY
TURN LEFT (MARKED BY THE ANVIL SIGN) OVER A LOW WATER BRIDGE. CONTINUE UNTIL
YOU COME TO AN OLD HOUSE ON THE RIGHT AND A MOBILE HOME WITH A TIN ROOF BUILT
OVER IT ON THE LEFT. STAY ON THE MAIN ROAD (MARKED BY AN ANVIL SIGN), WHICH BEARS
RIGHT AND STARTS UP THE MOUNTAIN. AFTER SOME SHARP CURVES YOU COME TO OUR
HOUSE ON THE RIGHT. (DIRECTIONS FROM RON).

BOA

Blacksmith's Organization of Arkansas Membership Application

Are you an ABANA { Artist Blacksmith's Association of North America } member? _____

NAME _____
Membership Dues: \$25.00
per year DUE in January *

ADDRESS _____

PRIMARY PHONE # _____
{ CELL OR LAND LINE }

E-MAIL _____

Are you interested in blacksmithing for a LIVING? _____
HOBBY? _____

- Special areas of interest
- KNIFE MAKING _____
 - GUNSMITHING _____
 - ARCHITECTURAL _____
 - RESTORATION _____
 - BUCK SKINNING _____
 - MEDIEVAL _____

BLACKSMITH ORGANIZATION OF ARKANSAS

RON WELLS
HCR 32 BOX 141
MOUNT JUDEA, AR 72655

Or bring to the next meeting and give to

BOA membership is a family membership. For the payment of one membership dues all the members of a family would be afforded all the benefits and privileges of a full membership.

* If the dues are paid in the last three months { October, November, or December } of the year, membership is paid up for the following year.
If dues are not paid within the first three months { January, February, or March } of the year, the member is removed from the membership.

BLACKSMITH of ARKANSAS
124 BLUE CEDAR DR
BULL SHOALS, AR 72619

