



VOICE

JULY

2013

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UP COMING EVENTS

JULY 13, 2013 - RICHARD ROSS - RAY VALLEY, AR
TRADE ITEM - A MOUSE

JULY 20, 2013 - DEAD LINE FOR THE NEWS LETTER

AUGUST 10, 2013 - ROBERT MUESER - MOUNTAIN HOME, AR
TRADE ITEM - ANYTHING MADE FROM A
COMBINATION OF A RAILROAD
SPIKE AND A HORSESHOE

AUGUST 20, 2013 - DEAD LINE FOR THE NEWSLETTER

NEWSLETTER DISCLAIMER:

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Date: Wednesday, June 12, 2013 7:26 AM

From: justin jones <justindunhamjones@gmail.com>

To: Mike <boa-editor@suddenlink.net>, Doster, Joe and Carol <jdoster@windstream.net>, Elaine Enlow <hekenlow@windstream.net>, Alberta Wells <rbwells@eritter.net>

Subject: June Meeting Notes

We had a great meeting this month at Rusty Wheels. The weather was perfect, there was a great turnout, and it seemed like everyone was busy at one of the three forges we had going. The tractor show was also very good this year, featuring several unusual tractors. One that stood out to me was custom built with 10ft diameter wheels, a truck frame, and a small Briggs & Stratton engine powering it. The tractor was made for crossing high water. It was quite a sight to see it towering over lawn tractors at the show.

Guests to this month's meeting included Clyde Foster from Huntsville. Bob Patrick introduced Luke Roberts, who is a knife maker from Mountain Home. We also had Roger Rose from Yellville, and Harold Plumley was visiting as well. We also had a new member on site, Michael Harrellson.

Our July meeting will be on the 13th at Richard Ross' shop. Our August meeting will be at Robert Mueser's home. The trade item he selected is anything made from a combination of a railroad spike and horseshoe.

Hardy is still collecting tools for the toolbox. Tickets are \$1 each, or 6 for \$5. We've currently collected \$282, but likely collected more by the end of the meeting Saturday.

As part of an ongoing discussion about bringing an attorney into our group, Bob Locke proposed that we look into the cost of hiring one. We hope to have more to report back next month.

Ron said he was contacted by a blacksmith who would like to sell his entire shop. He'll be at a future meeting with more details. Ron also completed the installation of electric brakes on the BOA trailer. Ron is still in need of bags for coal. Ron also thanked the group for bringing so many sale items. We even had several nice knives that were donated to the group.

Bob Patrick highly recommended Nathan Robertson's hammer class. I will be contacting Nathan at Jackpine Forge for more details. Bob also told us about the Alex Bealer Award, as he was a previous recipient himself. The Award the winner receives is a hand forged froe that is engraved.

Bob Locke also proposed that BOA purchase a First Aid Kit. He, Greg, and Mike will help find something that will suit our needs.

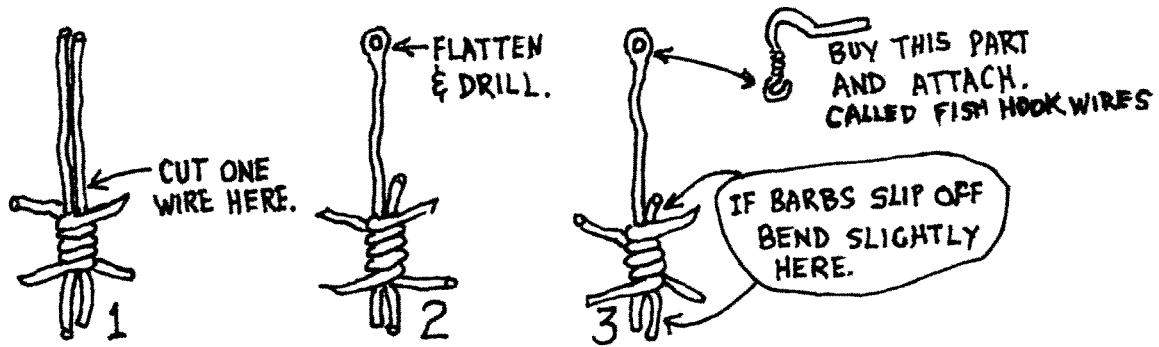
See you next month!

Justin Jones

The NEA chapter will be meeting on the 20th of July at Glenn Owen's shop. Meeting will start at 7 and go till 4, trade item will be a bottle opener. We had two meetings both were very good. The May 25th meeting we had 6 members and 2 visitors present. We had the June meeting on the 1st of June at the H4L ranch in Jonesboro. We had 6 members present and over 100 people came and watched. It was a rainy day but it was nice for forging in the barn.

Thanks, Glenn Owen
Steward NEA chapter of BOA

BARBED WIRE EARRINGS



A few years ago, I saw a lady wearing some earrings made of barbed wire. I asked her if I could look at them for a moment. She was happy that someone had noticed them and let me take a peek. I memorized them quickly and a few minutes later, I sketched them, so I could remember the details. They aren't difficult to make, and just now I'm looking at the set I made for Elaine, as I draw this pattern. They go well with Western attire. You may use old, rusty wire or newer wire with the plating still intact. I don't remember if I heated them before hammering the flat place before drilling the hole for the fish hook wires (available at hobby shops). Plating gives off a poisonous gas when heated, so always use good ventilation, if using this method. You will need to dull all the sharp edges of the barbs before they are worn. Rather than flattening and drilling a hole for the fish hook wires, you may leave a longer piece of barb wire, and bend over to accommodate the fish hook wires!

Enjoy!
Harold

CONGRATULATIONS TO RON AND BERTIE WELLS ON THIER 50th WEDDING ANNIVERSARY IN JUNE (AT OUR MEETING AT RUSTY WHEELS TRACTOR SHOW.).

GUNTER QUENCH

ROB GUNTHER, THE PROPRIETER OF THE FORGERY AT TIJERAS, NEW MEXICO, HAS DEVELOPED AN EXPERIMENTAL QUENCHING SOLUTION TO REPLACE A 10 PERCENT SODIUM HYDROXIDE SOLUTION.

IT CONSISTS OF :

5 GALLONS OF WATER

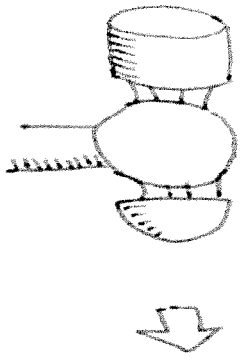
5 POUNDS TABLE SALT

32 OUNCES "DAWN" DISHWASHING LIQUID

8 OUNCES SHAKLEE BASIC I

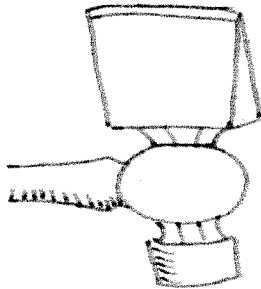
QUENCH AT 1550 DEGREES F. USE CARE WITH ANY QUENCHING MATERIAL. DO IT OUTSIDE OR WITH GOOD VENTILATION TO SAVE YOUR LUNGS. ---- INDIANA FORGE FIRE ---

FROM BALL-PEEN TO TOP SET



Handled top sets have a lot of advantages over chisels and other hand-held tools.

With your hand not in danger of being burned, you can take a little longer to make sure it is positioned correctly, which is easier to do since your hand is not obstructing your view. With your hand not in danger of being struck by your hammer, you tend to strike harder. The shorter overall length and the additional leverage of a handle make the top set much steadier under your strikes.

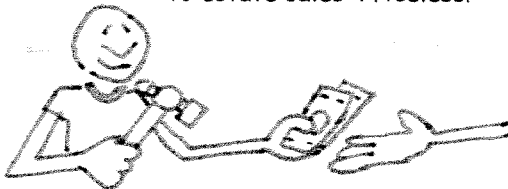


You've seen them. You want one of your own, but you don't have a sitting around, and no one is volunteering to spend a day swinging a sledge as your striker.

Here's how you can make your own top sets, by yourself, on the cheap, without thousands of dollars of equipment.

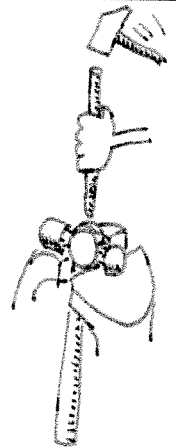
1 Large ball-peen hammer: \$2.00

Telling your wife you "want" to go with her to estate sales: Priceless!



2 Knock the handle out, saving any metal wedges. True, we are blacksmiths, but, hey, waste not want not!

If the handle isn't in good condition, you can get a replacement for about \$5 at most hardware stores. Look for a "ball-peen" or "Engineering" hammer handle about 14 -16 inches long. The handle can be quite thin. You aren't using it to swing, just to hold the tool in position.

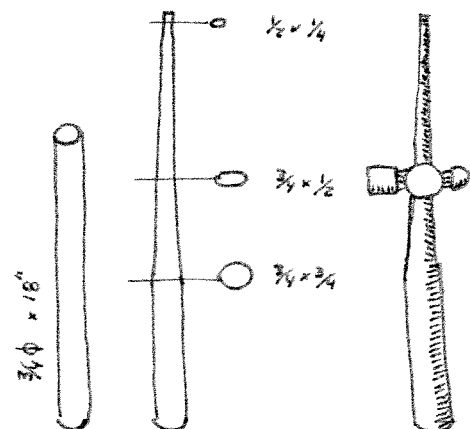


3 As with most blacksmith projects, first you have to make a tool so that you can make a tool, so that you can...

In this case, you need to make a mandrel— a pointed metal rod tapered down on one end so that it easily slides into the eye. It looks like an oversized drift, except that the hammer only slides down about a third of the way, where it fits snugly.

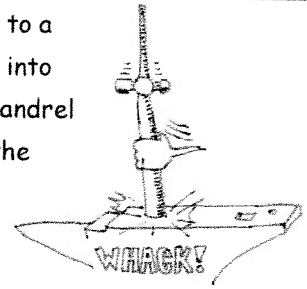
Most large ball peens have an eye something close to 1/2" by 3/4". I started with a 3/4" round, mild-steel rod about 16-18" long. You want to taper one end down, not to a point, but to something easy to thread into the eye of your hammer—mine ends in an oval about 1/4" x 1/2".

The taper only runs about half the length of the rod, shaped so that the head fits fairly snugly about 1/3 of the way down. It doesn't have to be exact, but it needs to make contact will enough to keep the head from flying off while you work on it.

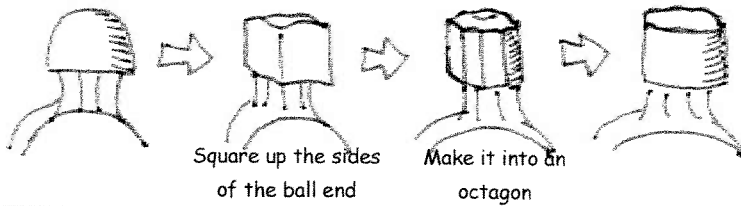


4 NOW you can heat the hammer head. I have a gas forge, which is ideal for this because you can let the tool steel soak the heat in deep without any danger of burning the steel. Only heat the hammer head, not the mandrel.

5 When the hammer head is up to a yellow heat, poke the mandrel into the eye and fish it out. Tap the mandrel down on your anvil lightly to snug the hammer head up. Don't try to drive it on tight—you will make the eye larger.

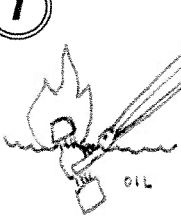


6 Most of the mass in a ball-peen is in the hammer end, not the ball end. You will need that mass to make your tooling, so the first thing you need to do is to convert the ball end into a shape you can strike with another hammer. This should only take 2-3 heats at most.

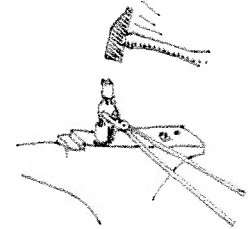


If your octagon looks as poor as mine did, you can continue shaping it to round, and tell everyone you prefer it that way.

7 Flattening the striking surface is the step that's most likely to mess up the eye of your hammer.

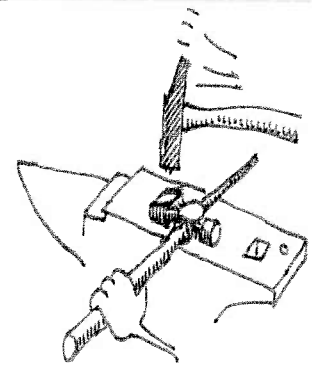


Take a deep heat, pick out the head with tongs this time, and oil-quench all but the striking surface you are working on. It should take only one heat to flatten that surface

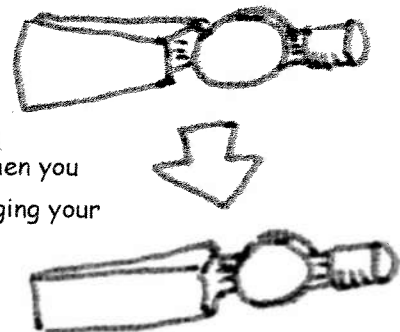
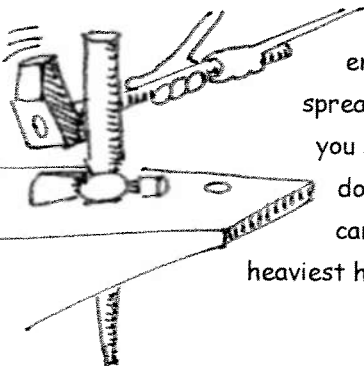


8 Now the hard part begins. The previous steps will make a striking surface suited for many different top tools. From this point on in the demo, we will be making a hot-set.

So-heat the hammer head back up, fish it out on the mandrel, and started forming the wedge. This will take a BUNCH of heats—tools steel is TOUGH. Switch the mandrel to the other end of the eye after each heat so that you work the surface evenly. Each time the hammer head is heating, quench the mandrel in water. You should be able to hold onto it with a gloved hand.

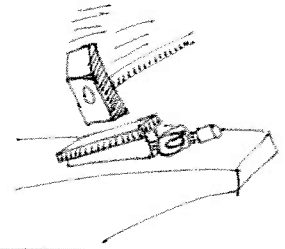


9 When you are tapering the working end of the tool, the wedge will want to spread out into a fishtail. To prevent this, you should be able to put the mandrel point down in the hardy hole and let go of it. Then you can smack the wedge back into shape swinging your heaviest hammer with both hands.



10 When the edge approaches about 1/8", don't try to take it any further. As the saying goes, "He who would a good edge win must forge thick and grind thin."

Take a heat or two to make sure the tool is straight, pretty up the profile, and add your maker's mark. If you don't have a flatter (yet), a flat piece of heavy gauge steel will help take out the bulk of your hammer marks.



11 All this reshaping of the hammer head has put a lot of stress into the metal. You can take it out through a process called annealing. Heat the hammer up to orange all over, and let it cool slowly—don't quench. I just turn off the gas in my forge and leave the hammer in there. Take a break, go rest, drink something, come back in an hour (or more) when the hammer is cool enough to hold in your hand.

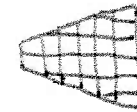
I've heard people say to repeat this process a couple of times. That may be good advice—but I didn't follow it, and everything has worked out Ok so far. I've heard other people say to anneal metal by burying it in a bucket of vermiculite—a non-flammable product available by the bag at most lawn-care stores as a soil additive used to hold water like a sponge. Apparently it holds heat also.



Iron crystal structure before shaping

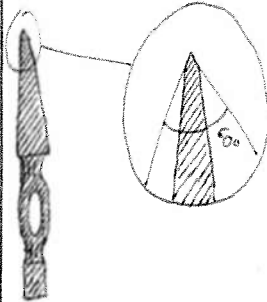


Crystal structure after shaping



Crystal structure rebuilt through annealing

12 This is as soft as your tool is going to get. This is the time to take a grinder/file/flap-disk and make it look nice. Use a wire brush/wheel to clean of any remaining scale. Go ahead and grind/file the cutting edge. For a hot-set, aim for about a 60 degree angle.



I like a little bow in the edge so I can "rock" it along a line.

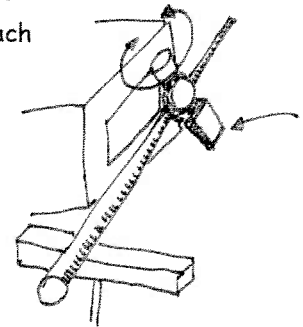


13 Now is the time to harden your tool. Heat the whole head up to cherry-red and quench it quickly in oil.

Note: I have found a military surplus 50 caliber ammo case to be perfect for an oil quench tank. It is metal, not plastic, and welded, not soldered. It has a gasket to keep water out (or oil in), is a perfect size, has a locking clasp and a handle. \$15 at Bennet's in Little Rock. They have a stack of them the size of a car.

14 The tool is now very hard, but very brittle. If you struck it, it would probably shatter. You need to temper it. First, use a flap-disk sander to polish both the struck end and the working end. This has the pleasant side effect of making your mark stand out, as it will still be covered with black oxide.

The struck end needs to be tempered all the way to a blue color (about 600° F), while the cutting edge needs to go only to a pale straw (about 430° F). The most thorough approach would be to first pop it into the oven at 430° for an hour, then take it out and use a torch to bring the struck end and the eye up to blue. I was not so thorough. I just popped the hammer head back on the mandrel and used a tool rest to help hold in front of the door to my gas forge. I went slow to let the metal heat evenly, alternating heating both sides, while keeping the cutting edge below the door, so it did not heat as quickly. Then I quenched it quickly in oil to stop the tempering process.

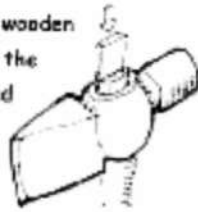


15 Last step—put the handle on your new tap set.

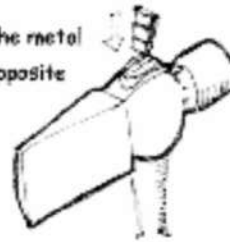
Drive the handle on by whacking the end on your anvil



Hammer in the wooden wedge, saw off the excess wood and sand flush









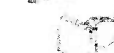
Hammer in the metal wedge the opposite direction of the wooden wedge



The wedges hold the handle on tightly because the cross-section of the hammer eye is shaped like an hourglass—unless you've messed it up!



Here's some ideas for other handled tools you might want to make using this same process:

-  This hot set
-  Top fuller
-  Butcher
-  Slit
-  Slot punch
-  Round punch
-  Flatter



BOA BLACKSMITH TOOLBOX RAFFLE LIST

CONTENTS ARE:

PICKUP TONGS

LONG HANDLED SCROLL TONGS WITH A ROUND TENDON ON ONE REIN

5/16 FERRIER TONGS, 1/2" SQ/RND TONGS, 3/8 SQ/RND TONGS

LARGE SIZE SCROLLING TONGS/PLIERS

6" CALIPER, HANDLED SLITTER

ADJUSTABLE BENDING FORK

BENDING FORK

SMALL SIZE SCROLLING PLIERS

3/4" HANDLED ROUND TOP FULLER

MONKEY WRENCH WITH A WELDED HANDLE TWISTING TOOL

ROUNDING HAMMER WITH A STAINED HANDLE

HAND MADE PUNCHES -- EYE AND CENTER

MEDIUM BALL PEEN

WIDE CHISEL OR NARROW SLOT MAKER -- EDGE IS FLAT NOT SHARP

HAND MADE COAL FORGE RAKE

TALL CUTOFF FOR HARDY HOLE

Central Arkansas Chapter of the Blacksmith Organization of Arkansas

05/18/2013 Meeting Minutes

Attendees:

Dale Custer (Steward)
Robert Fox (Acting Secretary)
Larry & Scooter Layne
Matt & Dave Hawn
Stephan Howaniez (Guest)
Andrea & Julia Hughes (Guests)
Diane & Jonah Rose (Guest)

1. Meeting was called to order by Dale Custer on May 18th at 12:26 p.m..
2. Robert Fox bought six raffle tickets (\$5)
3. The raffle has collected \$320 with a \$500 goal.
4. The State Bar had no suggestions on free legal services for 501(c)(3).
5. Eight bags of coal were purchased by Matt Hawn.
6. A discussion of the BOA website was held.
7. Business cards were handed out.
8. T-shirts are in. Matt Hawn paid and picked up his.
9. Sources of anvils were discussed.
10. Trade Item for the next meeting is a hardy tool (1 inch post), top set tool or spring fuller.
11. Next meeting is set for June 15th at UALR Applied Arts Studio in Little Rock, AR. Demo of twist made with Fly Press.
12. Robert Fox made a motion to adjourn. It was seconded by Dave Hawn.

Respectfully submitted,
Dale Custer,
CACBOA Steward
06/05/2013

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.

SOWRDS, KNIVES, AND DAGGERS IN STORAGE

FIRE FOR SALE 19 PIECES IN ALL.

1 - 36" SINGLE EDGE AND METAL SCABERED

2 - 28" SINGLE EDGE SWORDS

16.5", 12.5", 11", 10", 9.5", 7" SINGLE

9" AND 8.5" DOUBLE EDGE SWORDS

1 - 8" STAINLESS KNIFE

1 - 6" DAGGER

2 - 4" GUT HOOK KNIVES

1 - 3" KNIFE

2 - 6" KNIVES

5.5" FOLDING FROST CUTLERY KNIFE

CALL OR WRITE

ASHLEY CHERI

267 MAYFIELD LN

FLIPPIN, AR 72634

1 - 870 - 736 - 0429

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 it you didn't order one. First come, first serve.

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.

Directions to 116 Crawford Dr. (Meuser's Forge)

If you are coming from the West going East on hwy 62, do the following:

Go East past Wal-Mart on 62. Continue going east. Look for Old Chi Mill (a tavern) which is on your left. Our road is the second left after you pass Old Chi Mill, which is Crawford Drive. You will see a Dollar General Store on your right. Turn left right across from the store onto Crawford Dr. and go about 400 feet and you will see a green house with white trim on your left. That is our house, and you have arrived at 116 Crawford Dr. which is our house.

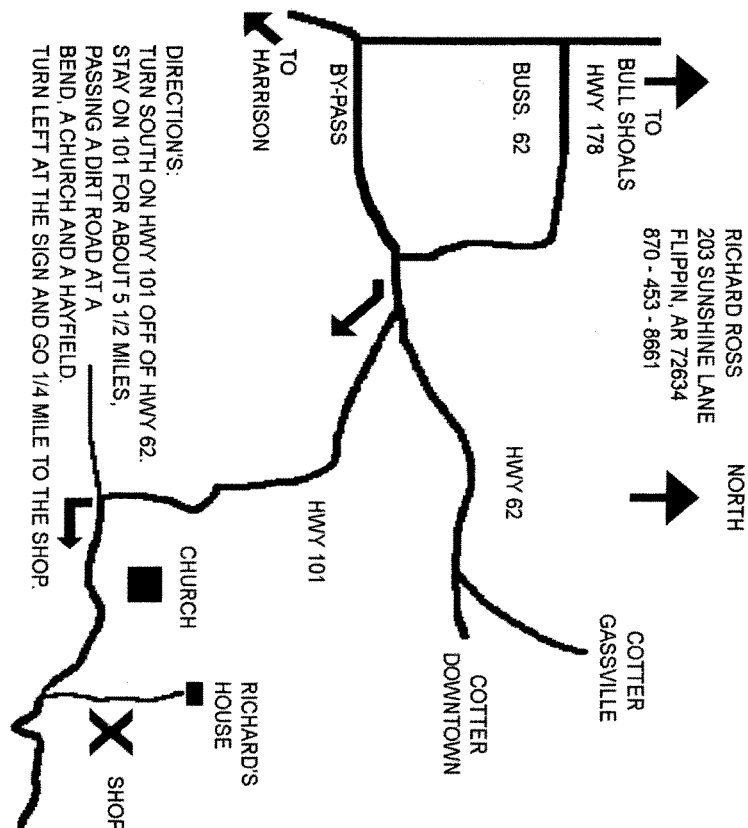
If you are coming from the East going West on hwy.62, do the following:

From the Norfolk Bridge going west on 62, do the following. Continue on 62 until you come to the sign saying Denali (fishing equip.) on your right which is on the corner of Crawford Dr. and 62. There is also a Dollar General Store on your left a few feet *past* your right hand turn. Go the same 400 feet or so and there you will be. Green house/white trim.

If there are any questions call us at 615-1165 (my cell)
or 404-2696 (Jean's cell)

Parking is on the grass in front of the park's fenced in area.

There is bench seating for 20 people available, but if you want to bring a lawn chair feel free to do so.



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

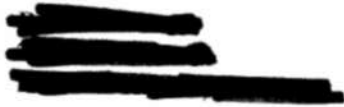
RON WELLS
HCR 32 BOX 141
MOUNT ADEA, AR 72655

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



722223#66000 RC45

