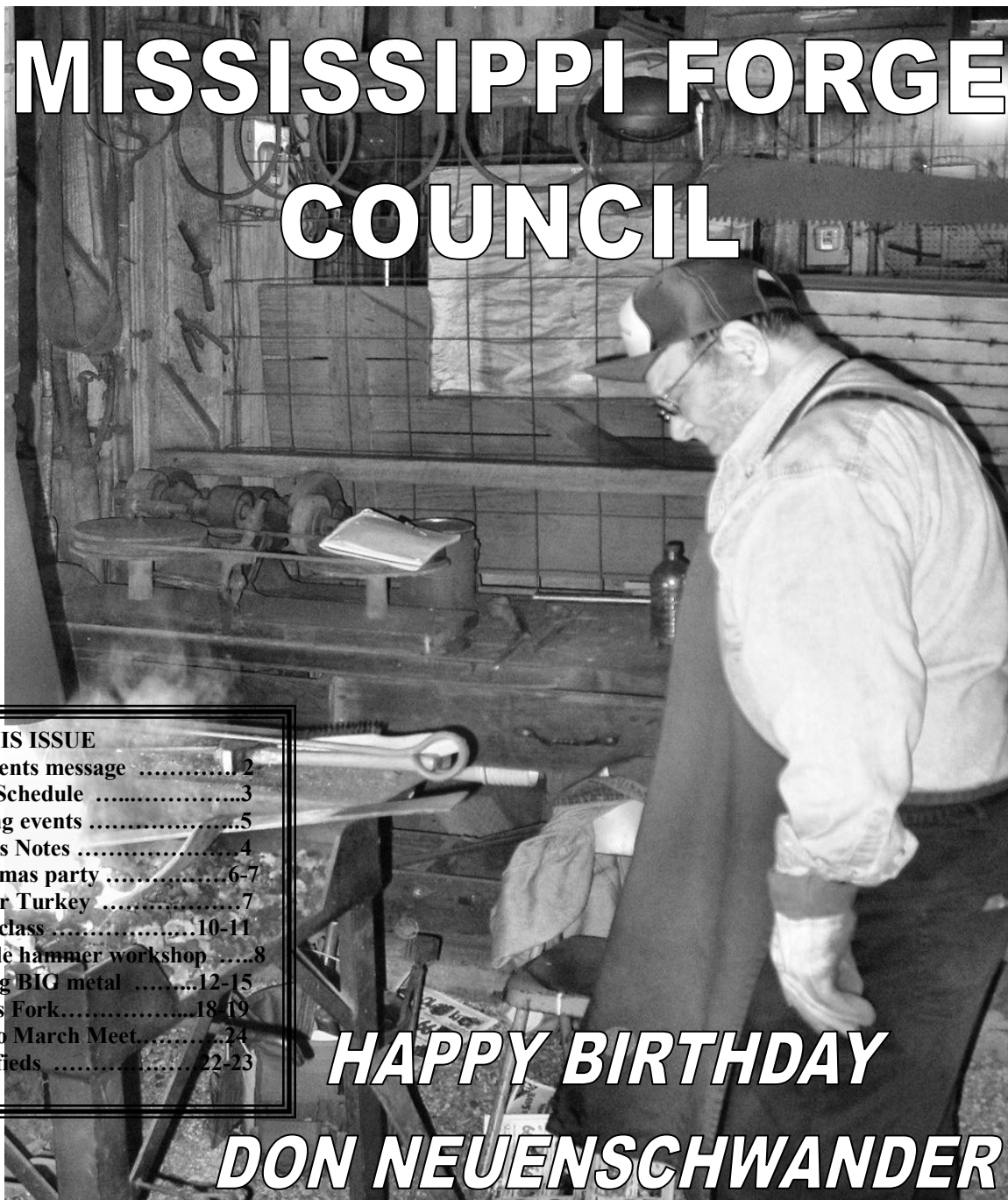


MARCH 2003

The Upset

THE OFFICIAL PUBLICATION OF
THE

MISSISSIPPI FORGE COUNCIL



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HAPPY BIRTHDAY

DON NEUENSCHWANDER

Officers and Board of MFC

President

Bill Pevey
1021 Pevey Lane
Crystal Springs, MS 39059
601-892-1867

Vice-President

Steve Norquist
3433 Lanell Lane
Pearl, MS 39208
601-939-5227
mivde3dejr8@aol.com

Secretary

Steve Paulson
2007 Pleasant Gift Rd.
Canton, MS 39046
601-859-3855
tpaulson@netdoor.com

Treasurer

David Williams
P.O. Box 13515
Jackson, MS 39236
Ph- 601-957-2455
davidw629@aol.com

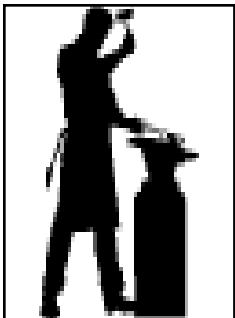
At Large Board Members

Benny Crevitt
1573 Marion Russell Rd.
Meridian, MS 39301
601-483-7025
crevtrad@bellsouth.net

Max Goodman
404 Parkway Rd.
Brandon, MS 39042
601-992-0383
ogremaxg@aol.com

Editor

Jim Pigott
136 Munich Dr.
Madison, MS 39110
ph- 601-540-6030
jpigott@jam.rr.com



Presidents Message Bill Pevey

As I look forward to the coming events for 2003 I can not help but be excited. If the success of the events of the last year is any indication, we are in for another great year of interesting learning experiences and good fellowship.

First of all, on behalf of our entire membership, I would like to say "Thank you" to Jim Pigott for his tireless efforts in leading our council for the past five years. Because of his persistence, dedication and determination we have enjoyed classes and demonstrations that are second to none. Let us keep in mind what he has done for us. Secondly, I want to thank him on a personal level for inviting me to join the MFC on my first visit. If he had not asked me I may have never come to another meeting. I think there is an example here we would all do well to emulate.

Looking at the list of our members, I am amazed at the vast array of talent that is represented. Although I know only about 1/3 of the membership, I see not only blacksmiths but expert knife makers, master electricians, engineers, coppersmiths, computer wizards, book authors, firearms experts, woodworkers, historians, salesmen, a herpetologist, an airplane pilot and various mechanical experts. What other talents are lurking in the remainder of our group? It is my hope that each of you will join in and take full advantage of the great opportunities that we have available to us.

Let's all keep in mind our annual conference scheduled for May 23, 24 & 25. Friday night, the 23rd, we will have a wine and cheese party at the Ag Museum. We would like to showcase items that you have made. We will be inviting architects and interior designers to come and see what can be available to them and their clients. You can bring anything you have created and let our guests have a look. Hopefully we will have a good variety of items to display.

Anthony Goodrum, who did such a good job for us, last year, as our auctioneer, will be back again. The auction is always a vital part of our conference and each of us should make it a priority to bring some items so that Anthony has a lot to work with.

If you are like me, I'm sure you are looking forward to seeing and meeting our demonstrator, Mr. Jack Brubaker. I hope that each of you will personally welcome him and thank him for taking his time to come share his knowledge with us.

After seeing James Monday's turkey gobbler in December, I can't wait to see his demo on making templates for copper sculptures. Also, of great interest to all of us will be Robert Pyrons demo on hammer making. This is only one of Robert's talents and should make for a very informative event.

I look forward to working with each of you in the coming year. Please share with me any ideas that you have that can help our organization move forward in a positive and productive manner.

**

Bill

Committees / Members

Event Scheduling

Ardell Hinton
326 Longmeadow Dr.
Ridgeland, MS 39157
601-8556-2314

Robert Pyron
513 Robinson Thompson
Winona, MS 38967
662-283-3719

Shop Committee

Dale Jones
French Camp Academy
French, Camp, MS 39745
662-547-5318

Ricky Wynn
117 Sumac Dr.
Madison, MS 39110
601-856-2493

Conference Committee



It is time to help. We need volunteers to arrange the Friday party, plan dinner, set up the demo area, get shirts, etc. Call Bill Pevey to make arrangements.
601-892-1867

ON THE COVER

Don Neuenschwander is keeping a watchful eye on his forge. Don, a longtime friend and supporter of the MFC, participated in the table making class with Allan Kress. He is a very well known figure in blacksmithing circles across the country. I am sure that all that know Don would join us in wishing him a
HAPPY 80th BIRTHDAY

MFC Calendar of Events

March 8th— James Monday will share the secrets of working with copper. James has a unique eye for the whimsical and the talent to make the copper work for him. **This meeting will be held in Canton, MS at James's shop. See page 24 for directions.**

April 12th— Work day at the shop. We will have the material and tools to make some repairs and clean the shop and take inventory. We will be running some new lights and plugs, making a cover to lock the coal bin, re-placing some hoods and stacks and patching some holes in the roof. We need help to get this done. Contact Bill Pevey or Jim Pigott to see what tools we need to bring.

April 24, 25, 26— Antique Engine Show in Houston, MS We demonstrate to almost 20,000 attendees at this show. This is a great place to try out your new demonstration techniques and to sell your items. These are friendly people, and a good place to get some demonstration experience. Let Bill Pevey know you will help on Friday and/or Saturday.

May 10th— Tommy Ward will demonstrate brazing techniques, bring your torches if you have them. We can get some practice time in. This will be fun.

May 23rd— 7:00-8:30 pm Wine and Cheese party. Jack Brubaker will present a slide show of his work. We are inviting architects and interior designers from all over the state to meet the MFC. You could call this our coming out party. This will be held in the conference room at the Ag Museum. This should be a fun way to start the conference.

May 24th-25th— The annual conference features Jack Brubaker on this Saturday and Sunday. The auction will be held the afternoon of the 24th. Anthony Goodrum will again be our auctioneer.

June 8th— 5:00 pm to 8:00 pm- **Need demonstrators to help with a Special Request from Dr. Spell. They are having a party and would like to see blacksmithing.**

June 14-15-**Buddy Holmes** is willing to teach a 2 day class on working with copper at his shop, in Louisiana. The dates are tentative . Contact Jim Pigott, 601-540-6030 if you are interested, we will have to work out the details.. We can have as many as 10 people in the class.

July 12th— Robert Pyron will give a demonstration on making hammers. Robert is especially skilled in this area, this is one show I don't want to miss.

Request

We need a volunteer to be responsible for checking out the audio-visual equipment at the Ag Museum, to be certain that we have what we need for Jack Brubaker's slide show. It would be a shame not to be prepared for the wine and cheese party. We will find out what equipment Mr. Brubaker will need. Contact Ardell Hinton 601-856-2314

EDITORS NOTES

Now that I don't have the presidents page to rant on I had to make a new spot for making myself heard. I hope you don't mind too much, besides, editors get to do this sort of thing.

We have a lot to do in the next few weeks, with the conference coming up and a work day at the shop. We are going to have to pull together as much as possible for this next conference to reflect well on us. We are sponsoring a wine and cheese party Friday May 23rd, 6:30-8:00 pm, at the Ag Museum conference room. Jack Brubaker, our demonstrator will present a slide show to our members and invited guests. Did I mention we are inviting a large list of architects and interior designers to the party? The idea is to let our guests see what the MFC is all about and let them meet the blacksmiths that can make those one of a kind items that can really set off a building or room. Jack Brubaker's credentials are impressive, check out his web site at www.jackbrubaker.com. He has presented a slide lecture on his work at the First World Congress of Artist Blacksmiths in Aachen, Germany. His kinetic sculpture was included in the Friedrichshafen Exhibition of Forged Sculpture in Germany. Mr. Brubaker is skilled in making jigs for special designs and will demonstrate bending schedule 40 pipe for use in contemporary design. This should prove to be an entertaining way to meet the folks that represent those well-to-do clients.

This brings me to the picture that I have been saving since our last conference. Do you see this as just an empty table or do you feel a little discomfort when you recognize this as our AUCTION TABLE!! How Anthony Goodrum was able to cajole \$2,700 from these few items is astounding. I know that my own mantra is "this is fun and we are friends" and that will continue to ring true, but it is important to the survival of the MFC that we try just a little harder to support the conference and the auction.

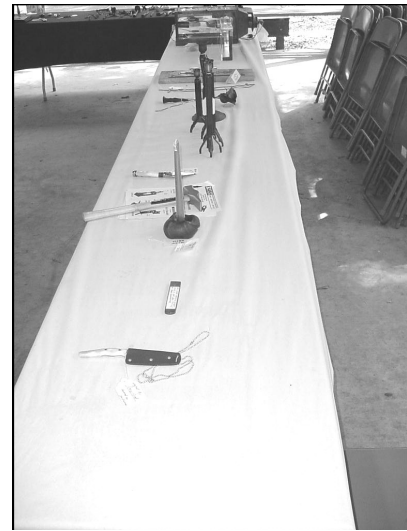
This year we should have a unique chance to display our ability to some people that can create opportunities for those interested. I know that there are just a few members blacksmithing full time or for extra income and these should see this as a golden opportunity, the rest of us hobbyists will still benefit from the recognition the MFC should receive. Our organization could use more support from the community and what better way do we have than by taking advantage of this opportunity. 'Nuff said.

How about our friend, Don Neuenschwander, on the cover. Don lives in Brazil, Indiana and travels frequently to Mississippi in support of the MFC. By the time you receive this newsletter Don will have celebrated his 80th birthday. I can only pray that God will bless all of us with the kind of health and stamina that Don enjoys and which allows him continue to participate in some demanding work.

Happy Birthday to you Don, from the MFC.

Now, back to the conference. Tommy Ward is making a tool box and donating it to the MFC as a raffle item. Our goal is to fill the box with enough tools, tongs, chisels, hammers etc. to make a blacksmith happy. These don't have to be hand made items, store bought will work, just as long as we fill it up with the kind of items that a blacksmith needs for their shop. Call Tommy to find out what is needed for the toolbox, 601-992-4374. Remember "this is fun and we are friends", but the MFC still needs your help to keep things running as they are.

Hope you enjoy the newsletter, contributions are appreciated here too, Jim



NOTICE

THE MARCH 8TH MEETING WILL BE HELD AT JAMES MONDAYS SHOP IN CANTON, MS. SEE PAGE 24 FOR DIRECTIONS AND PHONE NUMBERS

Events of Interest

March 8th, Saturday- 9TH ANNUAL BANGING ON THE BAYOU, Blacksmithing conference of the Louisiana Metalsmiths Association (LAMA), featuring Jeff Mohr demonstrating forging of fireplace tools. There will be demonstrations on forging copper and aluminum, broom tying and a green coal school. LAMA members have made a great tool box filled with handmade blacksmithing tools to be raffled. For more information contact Jerry Baker 337-232-7958, John Perilloux 985-542-4346 or visit their web site at www.lametalsmiths.org.

River Bluff Forge Council– **FORGING ON THE RIVER** March 28th-30th. Featured demonstrators will be Chad Gunter, Corky Storer and Doug Henderson. Location: National Ornamental Metals Museum, 374 Metal Museum Dr. Memphis, TN 38106. For additional information contact Richard Carr 901-872-4009 or Ray Tanner 901-682-9771 or visit their web site www.rbfcmemphis.com.

15th Annual **BATSON BLADESMITHING SYMPOSIUM & KNIFE SHOW**. April 4-6 at Tannehill Historical State Park, McCalla Alabama. The demonstrators are too many to list but the demonstrations will include forging a Medieval ax and swords, Damascus, Japanese arms and armor, scrimshaw, locking blades and on and on. Registration is limited. Pre-register, fee \$125.00. Judd Clem 111 Yorkshire Dr. Athens, AL 35613, 256-232-2645 for more information or visit their website www.afc.abana-chapter.com

May 15-17 **SOUTH EASTERN REGIONAL BLACKSMITHING CONFERENCE**, will be held in Madison, GA. This years demonstrators include father and son team Dan & Mike Boone, Hershel House, Ryan Johnson and Shelton Browder. This is an event not to be missed! Excellent tailgating and vendors galore! For more information contact Barry Myers blmyers647@netscape.net

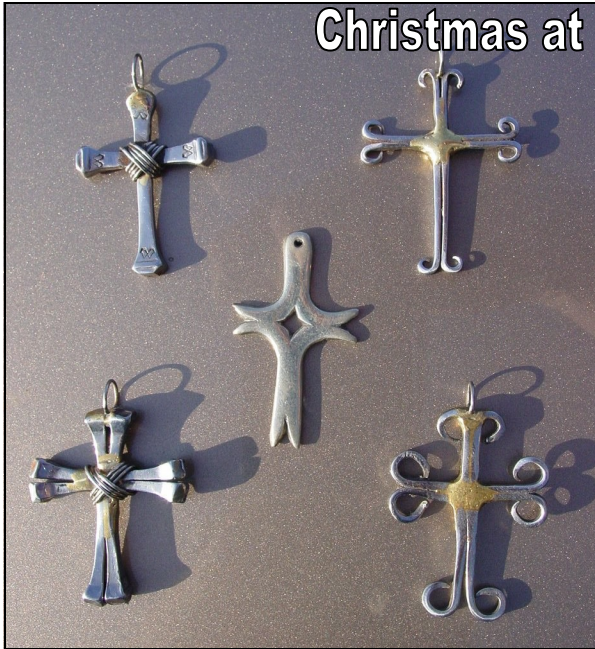
May 30– June 1, **IRONFEST BLACKSMITHING REGIONAL CONFERENCE**, Grapevine, Texas. Featured demonstrators are, Toby Hickman, David Court, Susan Hutchinson and Mark Pearce. In addition, many regional blacksmiths will demonstrate. For more information contact, Verl Underwood 817-626-5909, vaunder@aol.com Conference site: Grapevine Heritage Center, 701 S. Main St., Grapevine Texas.

July 18-20– **UPPER MIDWEST REGIONAL BLACKSMITHING CONFERENCE**. Sponsored by the IBA, IVBA, and UMBA with demonstrations by Clay Spencer “Traditional Joinery with the Treadle Hammer” Kirk Sulen “ Natural forms, animals in sheet metal” and Chuck Patrick “Tool Making-Wood Working and Blacksmithing tools” and Mokume Game– Layered copper, silver and nickel silver. Location: Thresherman’s Renunion Park, Pontiac Illinois. For more information contact John & Lee Biewer, 847-746-8689, leebiewer@sprintmail.com, www.umrbc.com

Locally

WORK DAY AT THE SHOP— April 12th at the Ag Museum. We would appreciate as much assistance as we can get this day. We will be patching leaks in the roof, running more lighting and electrical outlets, covering and locking the coal bin, building anvil and vise stands, capping the forge stacks, taking inventory and general housekeeping. With enough people and tools we can do this in a reasonable amount of time. It has been several years since we have had a day like this and it *really* needs to be done. Contact Bill Pevey to see what you can bring in the way of tools and expertise.

Christmas at Mondays



Ed Wozniak makes some beautiful crosses from horseshoe nails



The food table held enough food for three Christmas parties. What a nice way to bring in a new year.



Tall tales and fellowship were the order of the day. James Monday is pictured here with Tommy Ward and Robert Pyron. Put this meeting on your calendar now for the next Christmas party. This is too much fun to miss.

This 160 pound turkey was not taken during the season but created by James Monday, from copper, with more than a year of labor. This photo can not even come close to doing this piece justice. There were over 3000 rivets used to attach the feathers, see details in bottom pic. With a little luck we might convince James to display this bird at the wine and cheese party. This shows tremendous talent, imagination and perseverance. James displayed it for the first time at the Christmas party. Nice centerpiece for the shop.





Hectic would be a good term to describe the treadle hammer workshop at Jeff Wilson's shop in Birmingham this January. In two and a half days and forty plus hours the group of thirty folks built 30 inline treadle hammers. It couldn't have happened without a lot of work, cooperation and considerable preparation. Clay Spencer was the ramrod while ably assisted by Glenn Jarreau and Ray Robinson. Glenn, Ray and Ray's wife, Mary put in over 175 man hours cutting and drilling hundreds of the smaller pieces, before the workshop. This was quite an experience with the highlight being the drive home with my new hammer in the truck bed. Check out the top right photo of some of the hammers lined up.

Mississippi Forge Council Conference 2003



Honeysuckle candle holder by Jack Brubaker. Steel with copper insert
(from author's collection)

With members of an extended family who were accomplished in painting, silversmithing, bowl turning, wood and metal working, as well as general tinkering, Jack Brubaker was surrounded by art and tools from an early age. Jack's credentials include bachelors and masters degrees in art, and he has taught and exhibited throughout the US and Europe. Jack is a former president of ABANA and has served on the boards of local and national art groups. He has been featured in prestigious publications, and his works are currently displayed in galleries throughout the country as well as in the private collections of prominent collectors and celebrities..

A professional artist blacksmith for over thirty years, Jack enjoys working in a style that features simple, yet dramatic, curving forms. He is also well known an innovative maker of tooling and production jigs. Jack's studio, Jack Brubaker Designs, is located in Bloomington, Indiana. Examples of his work can be seen on his website @ www.jackbrubaker.com

MFC Conference 2003

Friday night May 23rd—	Wine and Cheese Party / Slide show with Jack Brubaker	6:30 pm— until
Saturday May 24th—	Demonstrations by Jack Brubaker	8:00 am— 5:00 pm
	Dinner and Auction	5:00 pm—until
Sunday May 25th-	Demonstrations by Jack Brubaker and MFC members	8:00 am—until

Location

Agriculture And Forestry Museum, 1150 Lakeland Dr. Jackson, MS 39216. Friday night will be in the Museum conference room. Saturday and Sunday demonstrations will be held in the Pavilion in the Small Town Miss. area For more information contact; **MS Forge Council**— Jim Pigott 601-540-6030

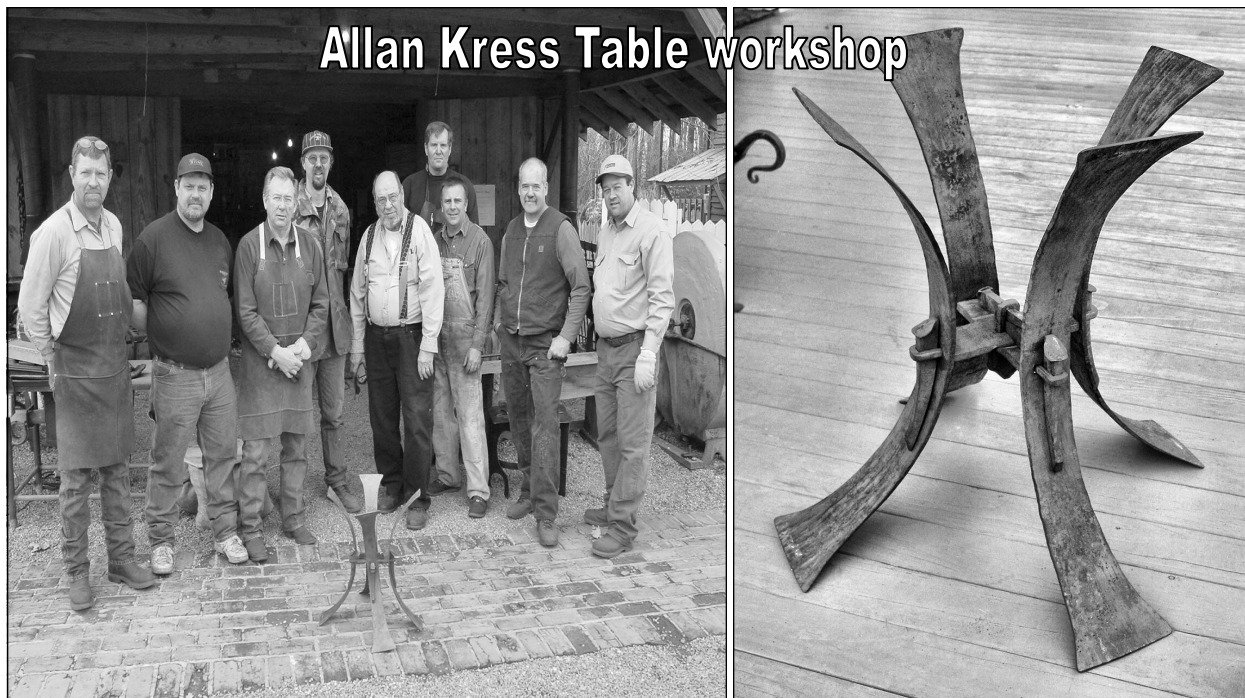
David Williams 601-957-2455

Agriculture Museum— Bettye Thornton 601-713-3365.

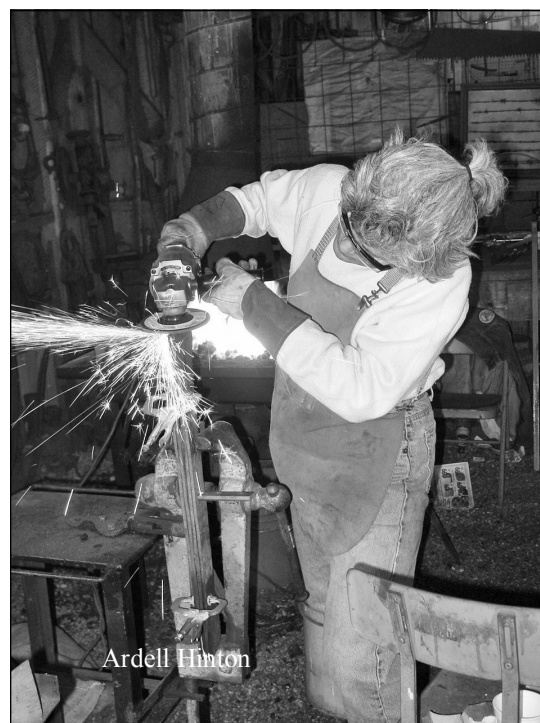
Accommodations: Red Roof Inn, I-55 & High Street 601-969-5006

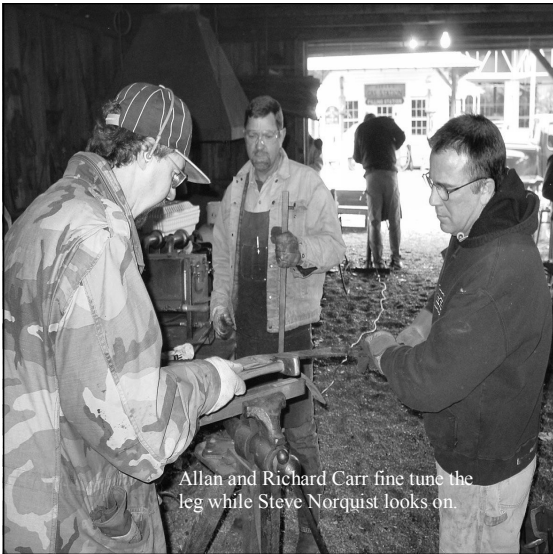
Holiday Inn Express, I-55 & High Street, 601-948-4466

Clarion Hotel, 400 Greymont Av., 601-969-2141

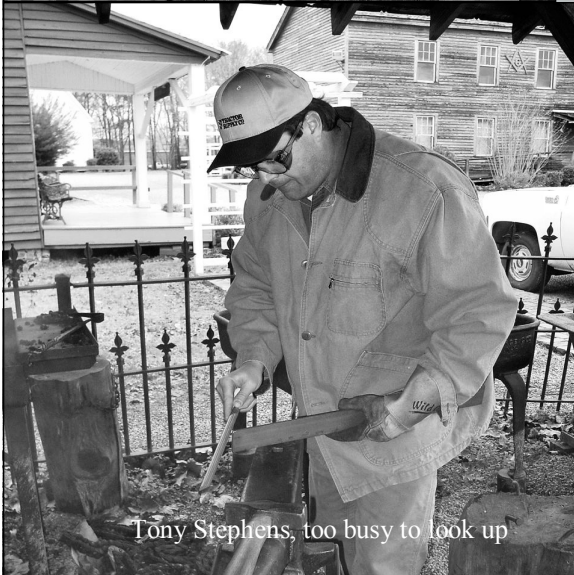


There was a lot of banging, punching, grinding and coal burning going on at the Ag Museum while Allan Kress was in town. Allan took the group of nine MFC members to the next level of blacksmithing over a 3 day weekend of making a table, above right. The table, although contemporary in style, was almost medieval in form with the peg style joinery, see details on opposite page. In the picture, above left, members attending the workshop are, from left, Steve Norquist, Don Cornelison, Charles (Sonny) Johnson, Don Neuenschwander, Richard Carr, Walter Neill, Tony Stephens, back row Allan Kress and Tommy Ward, not shown is Ardell Hinton. Allan has taught and demonstrated several times in Mississippi, he is a very fine instructor/demonstrator. If you haven't yet, invite him to teach a class for your group. You will be a better blacksmith for the experience.

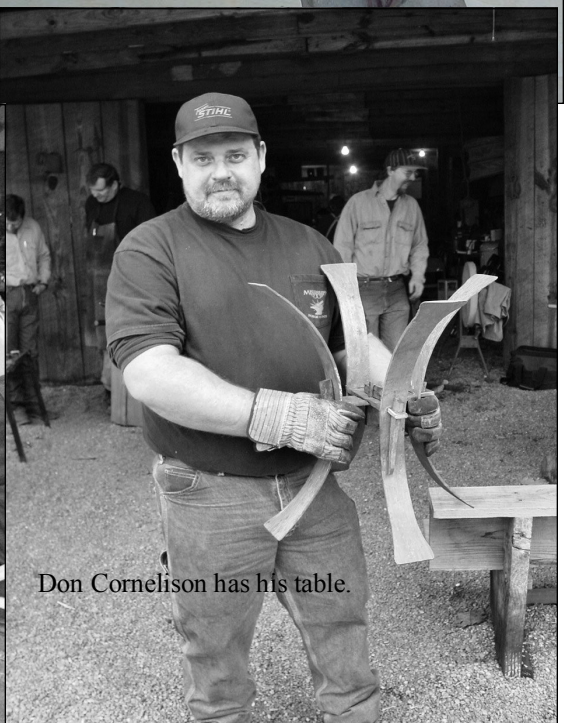




Allan and Richard Carr fine tune the leg while Steve Norquist looks on.



Tony Stephens, too busy to look up



Don Cornelison has his table.

A VISIT TO THE PLANT OF B&W HEADS

By Tommy Ward

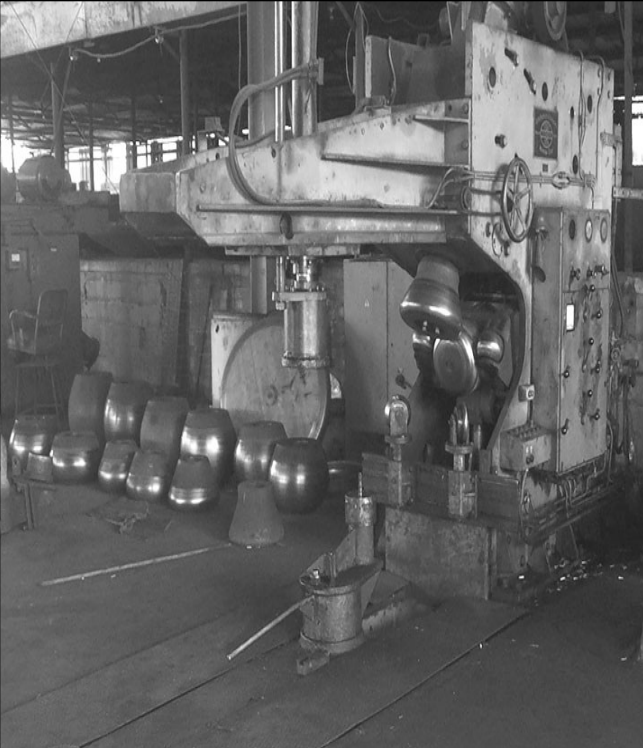
Enroute to Tannehill last fall, Steve Norquist and I stopped by B&W Heads in Moundville, Alabama, to pick up an order of metal tank ends. B&W supplies round tank ends (called “heads” in the trade) primarily to fabricators of tanks and pressure vessels, however applications for the heads are limited only by the imagination, and we’ve been using some of the smaller versions to construct forges and fire pits. B&W can furnish a variety of stock one-piece shapes and sizes ranging from 30” to ap-

proximately 12’ diameter in thicknesses of 3/16” to 7/8”. They also can produce specials and larger segmented domes with virtually no limitation in size. B&W makes the heads on site and office manager Terry Harless graciously arranged for foreman Doug Tingle to give us a tour of the facility.



These are the heads we have been using. On left is a 30” flat bottom w/straight flange— works well as a forge bowl. On right is a 36” dished head w/straight flange – makes a nice fire pit, fountain base, etc.

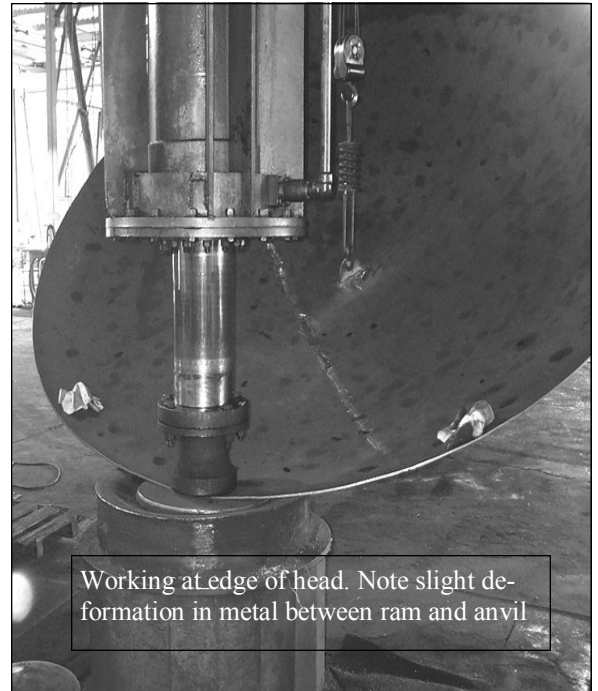
There are two general configurations of heads, “flat “ and “dished”. Both types are cold formed. Heads are usually made of A36 steel, but other materials can be used, and we saw several stainless heads in inventory.



Flange roller

Rolling machine used to form flanges on rim of heads. Some of the dies in the background are the size of small barrels and weigh several hundred pounds

Construction of the head begins by cutting a round blank from sheet stock. If the head is to be flat (termed “flanged only”) the blank dish is fed thru an edge-rolling machine that forms the desired depth and radius of the flange and the head is finished.



Working at edge of head. Note slight deformation in metal between ram and anvil

The creation of a dished head involves making a series of “bumping” passes in a large hydraulic press. The presses were designed by Conrad Wesselhoeft, an



Head suspended from trolley on back side of a press

engineer and principal in the company, and were built and installed on site by B&W employees. Dished heads are basically hand made using a process that is strikingly similar to techniques used by blacksmiths on smaller shapes. If you have ever worked flat stock into a concave form such as a swage block, wood stump, sand bag, etc., you would instantly be familiar with the dynamics at work - B&W just has much bigger "toys".

The blank is suspended in the middle from a chain hoist and depending upon size, one to three men guide the disk as it is

worked in the press. Beginning at the center, the blank is bumped by the ram against the

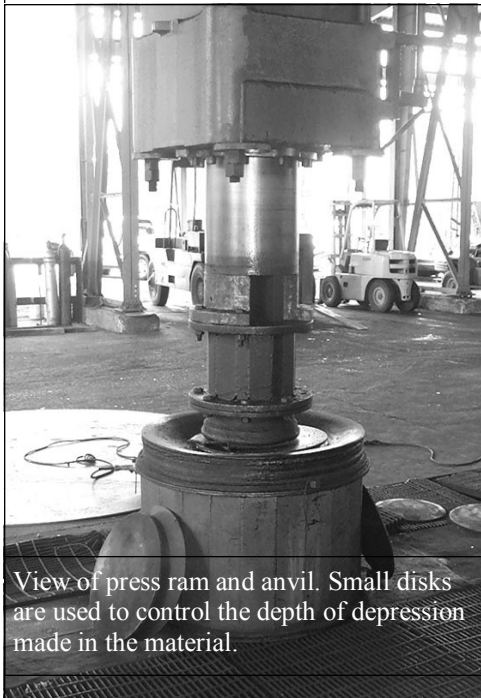
concave shape of a large "anvil". Shims of various thicknesses are placed in the dish of the anvil to control the depth of each bump. The disk is rotated in small increments until a complete circle has been bumped. The blank is then guided so that another slightly wider circle is bumped and the process is repeated until a series of concentric rings has been worked from the center out to the rim of the disk.



B&W employees forming a large head. Note support cable to right of cylinder

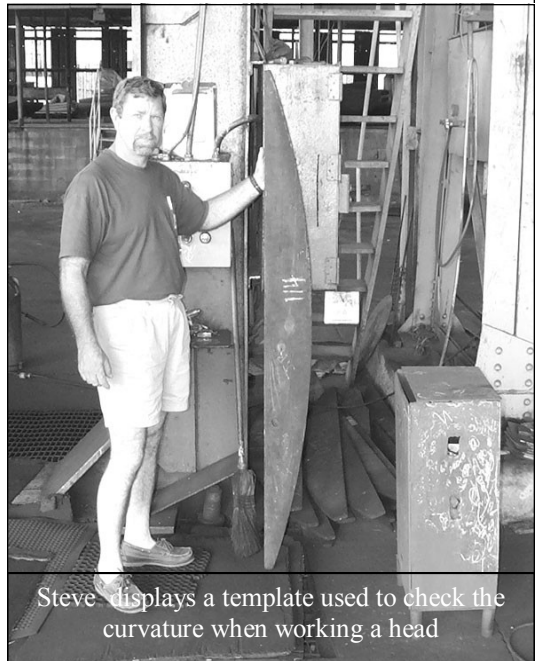


This flywheel driven mechanical press is used to punch holes in heads.



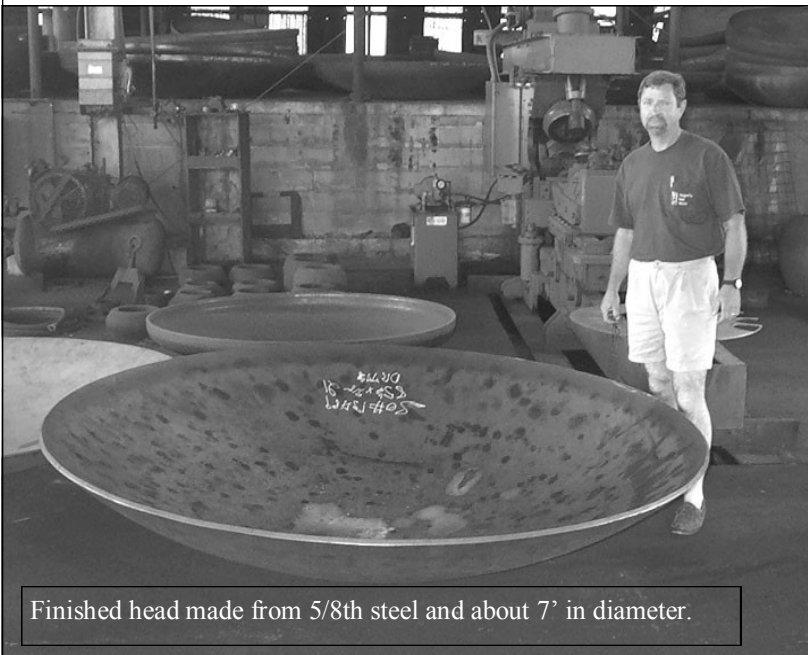
View of press ram and anvil. Small disks are used to control the depth of depression made in the material.

Gauge templates are used to check the progress of the work until the desired shape is achieved. After the dish is formed it is trimmed and the appropriate flange or flare is created in the edge-forming machine.



Steve displays a template used to check the curvature when working a head

Depending upon material thickness and the depth of the dish several passes my



Finished head made from 5/8th steel and about 7' in diameter.

be required to achieve the final shape, and Doug told us that the larger heads we saw being formed could take three to four hours to work. Although created by a hand/eye process we were amazed at the uniformity and accuracy of the finished heads, and it was obvious that the workers were very skilled and experienced.

While B&W is a production operation, Ms Harless has always cheerfully accommodated our questions and "small potato" orders. We are particularly grateful to Ms Harless and Mr. Tingle

for taking time out of their day to satisfy our curiosity and guide us thru the plant.

B&W Heads is located off Cracker Road on the north side of Moundville, Alabama. Moundville is on Highway 69 about fifteen miles south of Tuscaloosa. Their phone number is (205) 371-2212.



B&W foreman Doug Tingle shows MFC veep Steve Norquist a large circle cutting used to trim blanks up to about 10'

Ed. Grove's BLACKSMITH TECHNIQUES

As demonstrated by Ed Grove from Brownfield, Maine at the ABANA International Blacksmith Conference in Alfred College, Alfred, New York on June 29, 1990.

Notes and drawings by Tom Reinertsen

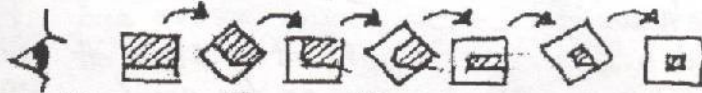
POSITION



Ed's preferred position at the anvil. He can easily reach to work either the near or far edge without changing position thereby saving time and heat. Note - reverse for leftys.

FLUX: For forge welding - Ed Grove doesn't use Borax - feels it's too slippery. Ed prefers the old E-Z Weld (not the new stuff) plus sandstone from the beach which he pulverizes small pieces of with his hammer on the anvil. Good clean river sand is a dependable Flux. clean to use that requires a high heat to melt the sand then surprisingly seems to weld at a less than sparking heat.

CUTTING

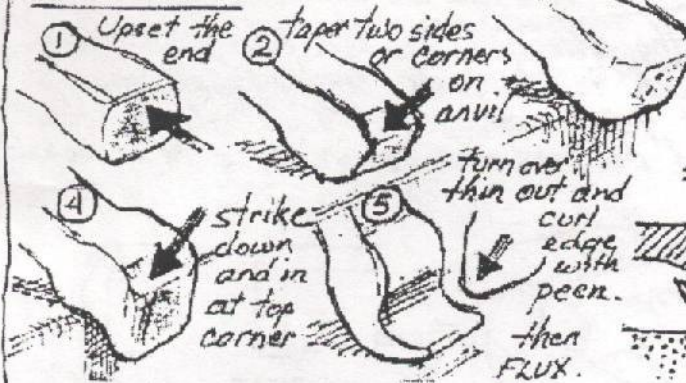


When cutting off stock on the hardie Progress in stages by hitting and rolling away from you 1/8 turn each time. This keeps the stock located on the groove. When almost severed - use hammer or tongs to break off the cut end or if long enough - bend it off by hand. Note. Save scraps for nail making later on.

SAFETY

Cool off your tongs when you finish with them and before you lay them down. This will help avoid a serious mistake later.

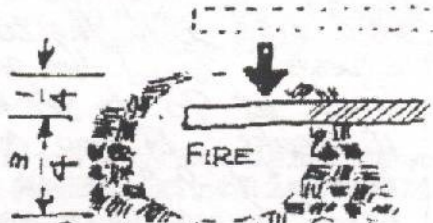
SCARF



Note. This scarf helps prevent slippage plus keeps thick edge bent up and away from heat loss to the anvil for a better forge weld.

WELDING

Keep your Fire **CLEAN** - Don't shove the piece into the fire **DEEP** the long way - press it down from the top **HOT** only part way into the fire. It will stay cleaner.



Cross Section through fire

WELDING Continued.

Watch for color to determine if the piece is at welding heat.

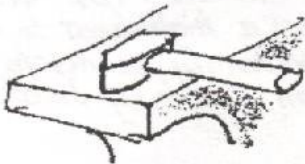
If it looks OILY then it's right for welding. Don't rely on Sparks

Then establish a FAST and ORDERLY welding procedure.

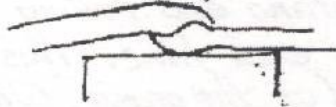
Note. To assure even heat it is sometimes necessary to rotate a piece 180° in fire.

Background Note: As a youth, Ed's apprentice blacksmith responsibilities was welding all the scrap trimmings, bits and pieces together into usable rods for later use.

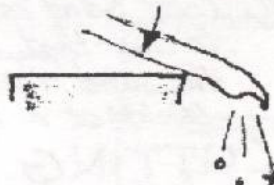
This forge welding job had to be done regardless of the quality of the coal or the weather conditions in Maine.



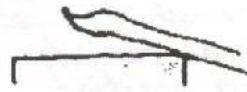
Have hammer on the anvil and ready



Press pieces down against anvil with left hand and strike fast light blows with right hand.



Grasp pieces and sling off or strike off slag on the anvil



Hold the RIGHT hand piece face up on far edge of the anvil.



Place LEFT hand piece on top - release right hand or tongs (Drop them) and quickly grasp hammer.

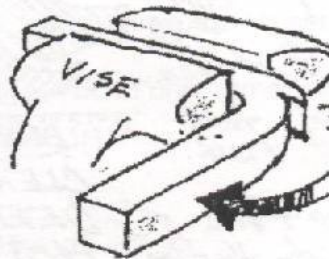
Take a 2nd. welding heat (with flux) if needed to completely weld.



Increase the strength of the hammer blows after the weld is contacted and made while rotating at 90° increments. This blends the shape and refines the grain structure in the weld.

TEST

Allow the piece to cool off slowly - When cold, clamp it in a vise with the weld exposed. Bend the piece back at 90° to see how it breaks. If you can bend it to 90° before it starts breaking you're doing good.



Bend 90°



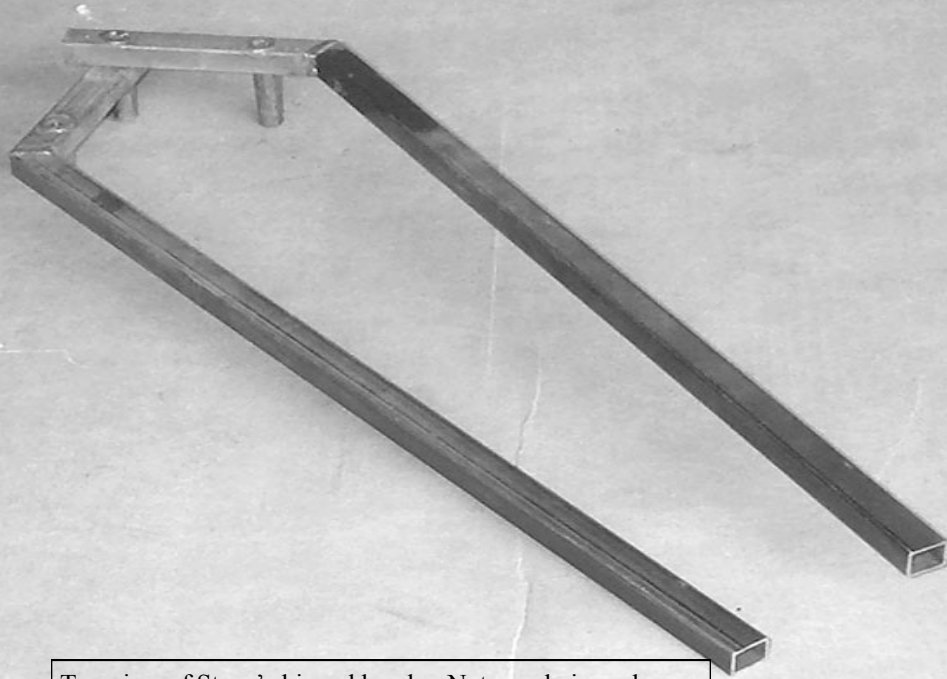
STEVE'S HINGED BENDING FORK

By Tommy Ward

If you've ever used a pair of individual bending forks to tweak or bend a curve and been frustrated by the juggling act required you'll appreciate how effectively this little gizmo accomplishes the task. Steve Norquist didn't tell me what he calls his neat bending device, but it sure does work.

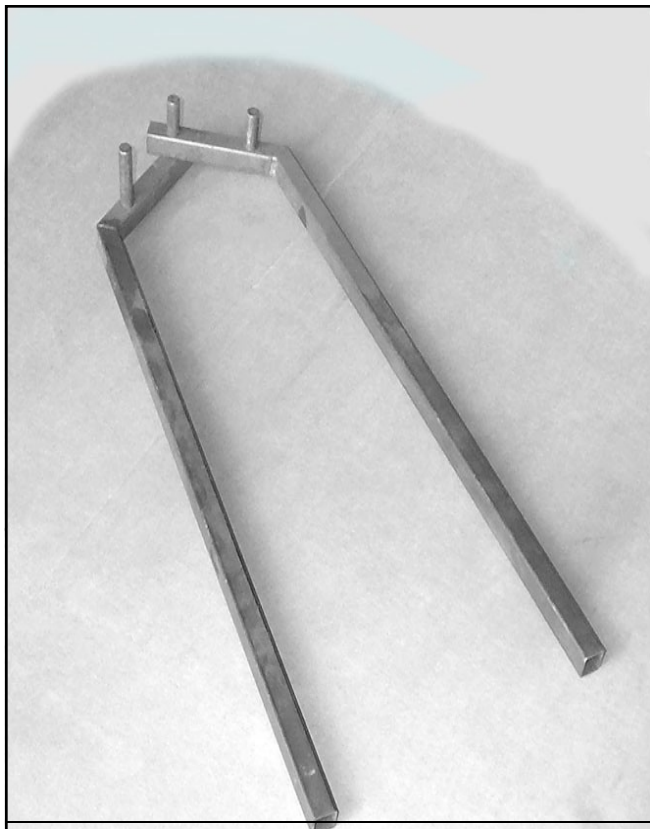
Steve's bender is basically two forks that are combined into a single unit with a pin on one of the forks also serving as a hinge. An angle in each fork arm puts the user's hands closer together. This feature improves ergonomics and control - sort of like operating hedge shears.

Using 3/4" square tube for the arms and 1/2" rod for the bending pins, the bender will cold work flat stock up to 1/4"x 2". The handles are about 21" long, with a second piece of square stock 5-1/4" long welded at a 45 degree angle on the end. Two 1/2" diameter holes, spaced 3" on center, are bored through the working end of each handle. Two 2-3/4" long pins are pushed through the holes and welded flush on the back side of one handle, and a single 2" long pin is welded on the opposite arm in the hole nearest the angle. The remaining open hole in the second arm receives the end pin from the first arm and acts as a hinge.

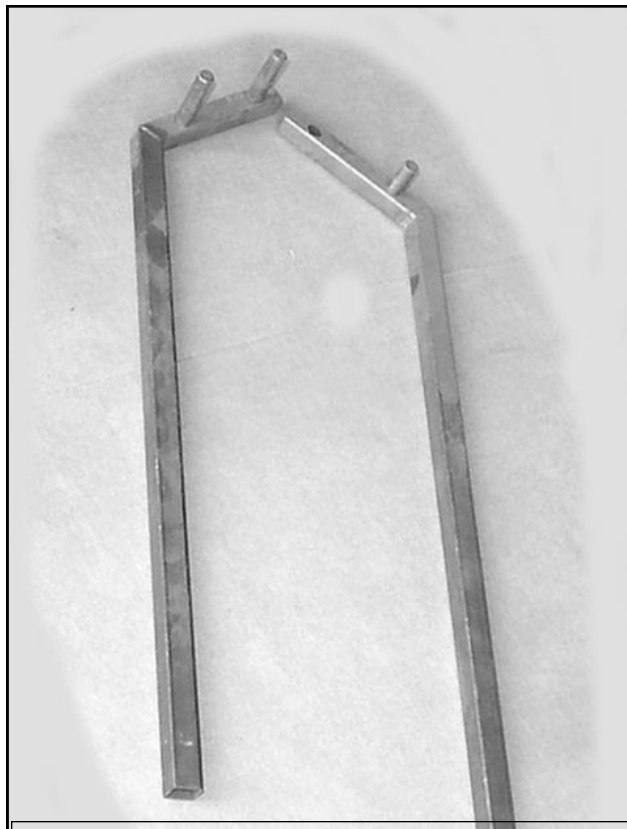


Top view of Steve's hinged bender. Note angle in each arm

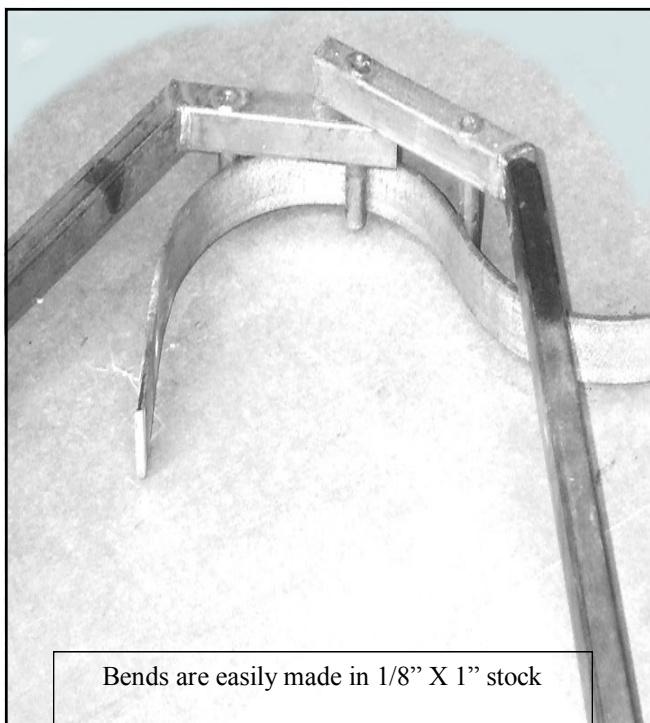
Steve's Fork



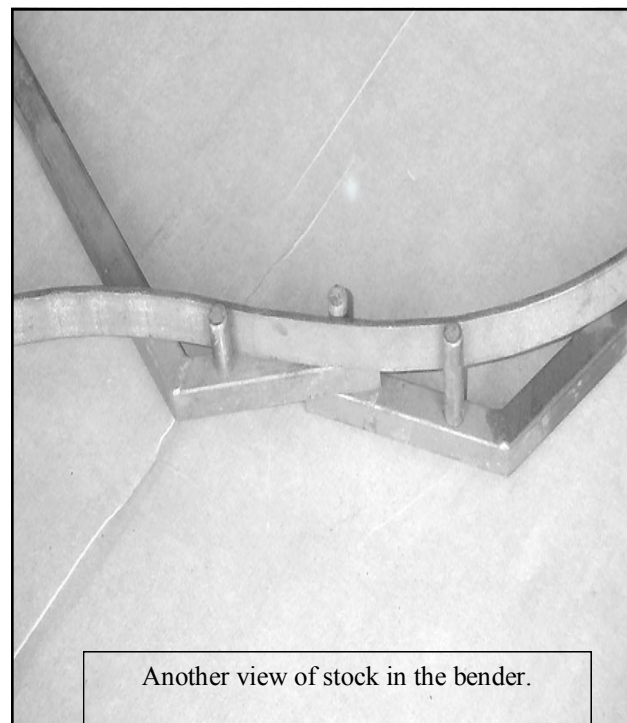
Bottom view. The two outside pins work material against the center hinge pin



Hole in the arm with single pin fits over end pin in the arm with two pins.



Bends are easily made in 1/8" X 1" stock



Another view of stock in the bender.

Sketchbook

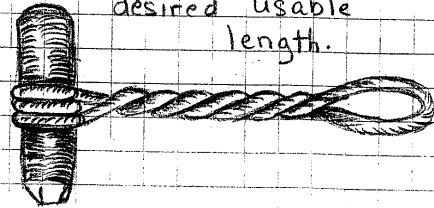



Hot Stamp
As done By Bill Davis

Start with a piece of medium or high carbon steel with a diameter large enough for your design.



customize with a handle or cut to a desired usable length.




Suggestions: 

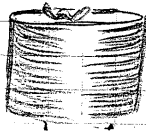
☆ if you can draw it, it can be made into a stamp.

Material needs to be annealed to prevent damage to lettering stamps. Some letters are the same forward and reversed. otherwise you need a set of reverse stamps.

A guide will help you center your stamps and keep multiple letters in a straight line.

Remember to think backwards. If you want M you need to stamp it 

When stamping your letters into the rod, metal is displaced out where the stamp enters. This metal must be filed off. Keep stamping and filing until stamp is as deep as you want it. The deeper the letters are the clearer they will be when stamped into HOT metal.

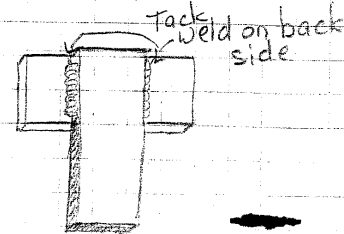


flat stock welded together to form guide



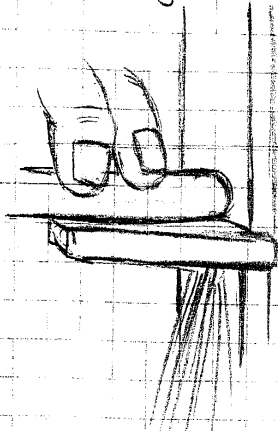
flat stock "any size"

this piece needs to be the right thickness to align stamp up with center of rod. different size letter stamps will require different thickness of guide.

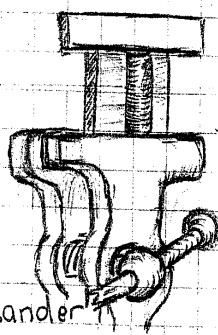


This technique for developing a touch mark was taken from the January 2003 newsletter of the Saltfork Craftsmen organization in Oklahoma.

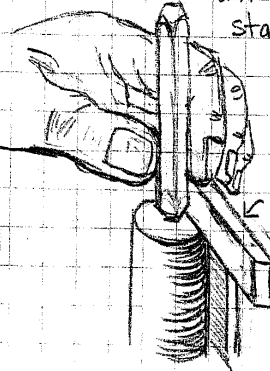
5/8" x 8" Long annealed med. to High carbon steel
grind or file end Flat



Place rod and guide in vise



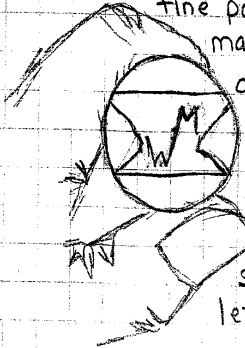
lettering is done with reverse stamps.



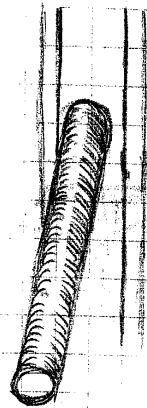
Use a guide to help center stamp on Rod.

Belt sander

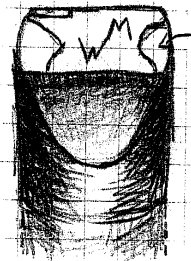
after stamping, use fine point marker to draw shape to be ground around stamped letters.



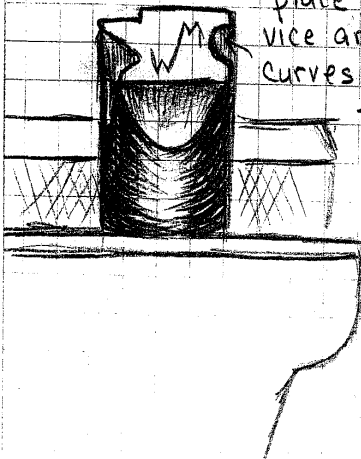
start by grinding or filing flat areas.



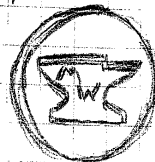
then use a file or dremel to rough in other parts of design



place rod in vice and smooth edges of curves and flat areas of the design to finish.



when stamp is finished Rod can be cut to desired length. Heat treat the stamp end according to the requirements for the steel used. DO NOT treat the end of the rod that will be struck with hammer



to test stamp during filing, stamp into lead.

Classifieds



Poor Julia, local scrap metal artist, has more space than she needs. She has recently purchased a building, shown above, and hopes to find fellow artists/craftsmen to lease space. Approximately 2000 sq ft of warehouse and 850 sq ft of office space is available reasonably priced for any one looking for a place to work/play in an area zoned "industrial". See the site at 4615 Womack Dr. Jackson, off of West Northside Dr. Call Julia Allen at 981-3610 if you are interested.

I have the following for sale:

Treadle hammer, (Clay Spencer design) 70# accurate, hard hitting.
 5'x3' Steel welding table, three feet high on wheels
 225 amp Lincoln welder with 10' extension
 1/2 HP forge blower, almost new
 75# anvil (over 75 years old) good condition, no name
 5" leg vice, good condition
 20 pairs of tongs, various sizes
 10 punches, various sizes, with handles
 Barrel of rail road spikes
 Clayton knot tool with instructions
 2 large 3' tongs
 Various hammers
 4 cutters with handles

\$1500.00 firm

Gil Watkins, 304-727-6331,, anvilgil@charter.net



New Vendor

Bells Novelty Casting Co.
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 bells, etc.

Iron and aluminum castings

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www.bellsandmore.com

Vermilionville, La. A living history museum in Lafayette, La is looking for a smith to work at the village. Anyone interested can contact the Ex. Dir. Cindy Trahan at 337-234-4077

NEW PRODUCT

Take a look at the gloves on the bottom left of this page. I saw them at the Mississippi Building Material Dealers Association convention. These have to be the best designed and constructed gloves you could ask for. There are at least 10 styles designed for various uses. They have general, heavy and extreme utility gloves, framer, box handler, wrench-work, cold condition and womens utility gloves. The gloves shown are Griptec, 3M™ gReptile™ gripping material is strategically located in the palm of the glove, and an additional piece with adhesive backing is provided with the glove to be placed on the grips of tools. When used together as a system it can create up to 300% more gripping strength. This lowers muscle fatigue, decreases transmitted vibration and increases lifting capability.

I referred Ken Murphree to Joe Rooks at Revell Hardware in the hopes that the gloves could be available locally. If you want more information contact Ken at 4414 Malone Road, Memphis, TN 38118
 901-366-7696
 800-624-7806

THE JESKE COMPANY, INC.

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Wally Yader designed swage blocks and cone mandrels. We have forges, firepots, blowers and anvils. Contact Ray Robinson at **Laurel Machine and Foundry Box 1049 810 Front Street Laurel, MS. 601-428-0541**

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ACME PRINTING

After talking to several printing companies, who thought our newsletter was too small a job to deal with, I was referred to the Wagner brothers at Acme Printing. With them there was no question about the size of the newsletter or the quarterly printing. Not only did they give us a good quote but they referred us to Dearing Addressing who takes the printed newsletter and labels and bulk mails the issues for us. All this not only saves us a huge amount of time but they do it for what it was costing us to do it the hard way. Support those that support us. For your printing needs contact

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601-856-7766**



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1

CHRISTMAS PARTY DIRECTIONS

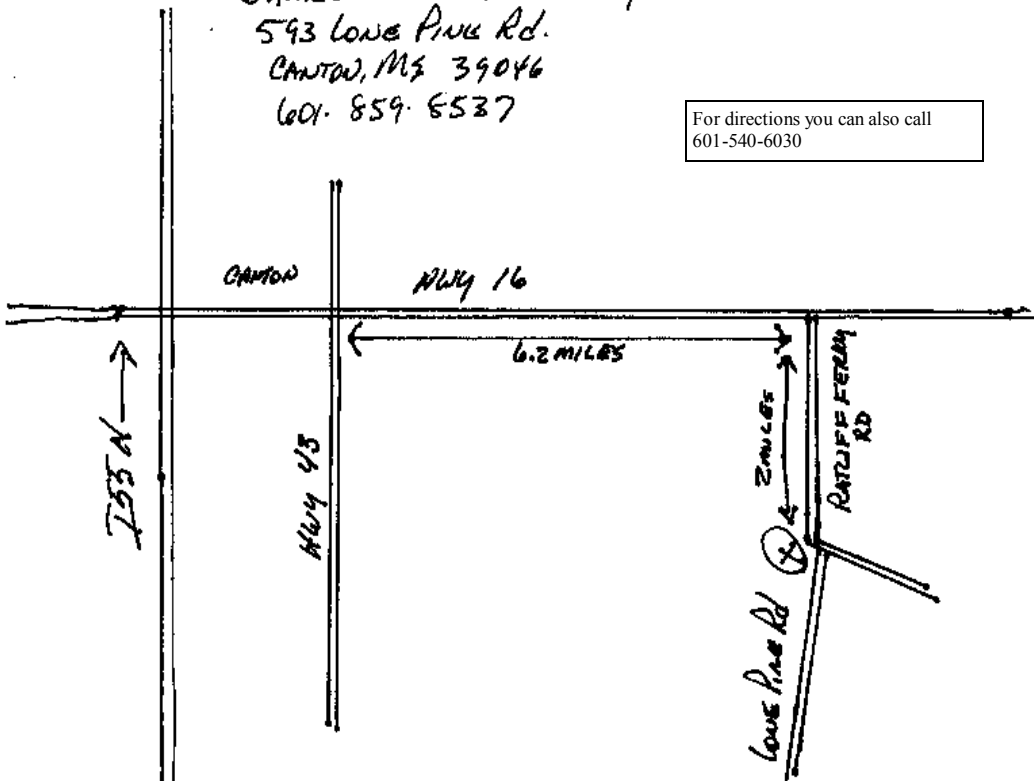
DIRECTIONS TO THE MONDAY HOME

From I-55 take the Hwy 16 exit (CANTON) go east through Canton when you cross Hwy 43 you will go 6.2 miles farther to Ratliff Ferry Rd - go rt - south about 2 miles. When you get to Long Pine Rd you are looking at the Monday Place.

From the Natchez Trace go west on Hwy 16, between mile markers #123 and #124 you will see Ratliff Ferry Rd on your left.

JAMES & LAURA MONDAY
593 LONG PINE RD.
CANTON, MS 39046
601-859-6537

For directions you can also call
601-540-6030



NOT EVEN CLOSE TO SCALE

The March 8th meeting of the Mississippi Forge Council will be held in the shop of James Monday in Canton, MS. This will be a demonstration in working with copper. The meeting will start around 9:00am, business meeting, the demonstration will start no later than 9:30 am. You might want to bring your own refreshments and lunch, I don't know how long we will be there and there is no store close by. If you need any more information you can call James at the number above or Jim Pigott at 601-540-6030

BOB HEATH Has Lots of Good Stuff For Sale

Here Are Some GREAT Books That BOB Wrote

- 1) **Beginning Blacksmithing One Mississippi Journeyman's View**
Paper bound hand stitched typed manuscript well illustrated with drawings.
430 pages. \$ 28.00 retail plus \$ 2.00 shipping. Tells the basics of blacksmithing with some history of iron smelting, forging, hardening and tempering, metallurgy, and basics.
- 2) **How to Make A Blacksmith's Bellows** ---- paper bound 28 pages well illustrated.
It gives details on how to make a leather bellows that is about five feet long, the classic American two chambered bellows that allows a constant flow of air to a forge. \$ 5.00 I pay the shipping.
- 3) **How to Make Chain Mail.** ----paper bound 30 pages It gives the details of EXACTLY how to start out weaving chain mail. Then gives some examples of how to make a coat of chain mail. \$ 5.00 I pay shipping.
- 4) **How to Forge Weld on A Blacksmith's Anvil For Those Who Have Diligently Tried and Failed.** 52 pages paper bound. If a person can't forge weld after reading this book it would be best if he put his hammer up. \$ 10.00 Plus a dollar for shipping or send \$ 11.00.
- 5) **Exposse' of Repousse'**---paper bound 60 pages -- tells how to get started in doing Repousse' type work in sheet metal. Belt buckles, Spanish jingle bells or hawk bells (how to forge them), armor, shields (Greek Hopolite and Medieval), embossing, etc. \$ 10.00 plus a \$ 1.00 for shipping.
- 6) **Quest for the Indian Trade Gun** -- 270 pages-- a treatment on French and English trade guns dug up in Mississippi and Missouri by archaeologists. Tells how they were forged (the barrels) and gives some of the historical details of the differences between the French and English guns. Paper bound hand stitched typed manuscript well illustrated. \$ 22.00 ----I pay postage.

I've sold a lot of these in Australia, some in Holland, Canada, England, and all over the U.S.A. Centaur sells them, Lindsay Books, Inc. in Illinois, Norm Larson, and a few other sellers handle them (Dixie Gun Works, Harpers Ferry West Va., Old Sturbridge Village in Massachusetts, etc. and a few others)

And Below is Some Equipment Bob Has to Sell.

- 1) I still have a fine and very large swage block for sale ---\$ 400
- 2) Line shafting with oil bearing mounts (out of an old gin) - "bull" wheel pulleys etc. \$ 400
- 3) A large Victorian era grinding wheel - large cast iron mount, belt driven with pulleys on the drive shafting. 300
- 4) Hit and miss engine - McCormic Deering 3 HP 1936 (no magneto) but otherwise good, kerosene burner also block, head, crank and piston (no fly wheels) of a "Little Jumbo" by Nelson Brothers (3 hp)
- 5) Some blacksmith vices \$ 75 each.
- 6) If the above items can be sold the shop will be torn down. shop size is 40 X 60 has creosote poles and tin roof that can be sold. Poles and most of the tin roofing is in good shape.

If anyone wants one just send a check to me at the address below.

**Robert M. Heath
1055 Manship St.
Jackson, Mississippi
39202
HEATHIRON@aol.com**

Words of Wisdom

by Francis Whitaker (*FW*) as published in the
California Blacksmith Associations newsletter
&

by Bob Patrick (*BP*) as published in the Mississippi *Upset*



- FW* Get it HOT.
- FW* There is no place on a piece of work that won't be seen.
- FW* Learn forge welding. In traditional work, it is frequently quicker and easier and always more true to the style than making an arc or torch weld and then hiding it.
- FW* Accuracy and precision are prerequisites for producing identical pieces of work.
- FW* Always do your best and strive for perfection.
- FW* If you can finish it in one heat, do it.
- FW* To punch a square hole with four square corners through a bar, slit, upset the bar at the slit to open the hole. Drift to perfectly round. Finally, drift to square.
- FW* On outside work, apply three coats of primer before the finish coat. If each succeeding coat of primer is a different color, thin spots and misses will show and can be corrected. The best treatment for outside work is hot-dip galvanizing.
- FW* In making a scroll, never hit successive blows at the same spot or at the same angle.
- BP* When you do heavy bending don't get the metal too hot.
- BP* Plan your work and improve your skills with practice.
- BP* Don't damage your metal by hammering the fire out of it— only hit blows that will do some good.
- BP* When you're making scrolls, scroll tongs will be most useful. Right handed bent scroll tongs can be of great use for leverage. They can get into places where bending forks can't be used.
- BP* Even if you are using a scroll form, you will usually have some minor adjustments. This is done cold most of the time.
- BP* When you think about too many things at one time your mind shuts down—just like a possum passing out when it gets confused.
- BP* When you are learning to forge, practice doing each step well. Don't try to always make a finished product. For example, first learn to make graceful and proportional scrolls or production of smooth tapers. If you want to improve your work, the important thing is to do each step well.
- BP* Most good work is not complicated, it's very simple!
- BP* When upsetting, hold your arm against your body for support.
- BP* Always wear safety glasses—if you don't you're living dangerously.
- BP* In a coal forge, I prefer EZ Weld. I liked the old EZ Weld better because it contained a magic ingredient—probably industrial waste of some kind, but it welded great.
- BP* When welding, put the flux back further than the actual weld, on the bottom and both sides.
- BP* Flux has several purposes, but primarily it acts as a detergent to clean the metal—the flux turns into glass and glass has an affinity for metal oxides. The metal becomes chemically clean with a molten liquid on top.
- BP* You can tell from the hammer blows if the metal has welded and beating the fire out of it doesn't help the welding process.
- BP* If you have problems welding, it is probably your fire. The flux is not nearly as important as the fire.
- BP* Heating metal too fast will put too much oxygen on it.
- BP* When measuring for one piece of metal to go around another, add the circumference plus twice the thickness (of the collar material).
- BP* When making chisel impressions or other marks on metal, look at the back of the chisel when you strike rather than the chisel edge. This will save your hand and produce greater accuracy.



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 P.O. Box 816
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The Traditional Metalsmith
Blacksmithing: Illustrated & Explained
 By George Dixon, former Head Blacksmith
 Samuel Yellin Metalworkers

Volume 1, Number 3 July 2000
 Volume 1, Number 4 October 2000
 Volume 1, Number 5 February 2001
 Volume 1, Number 6 May 2001

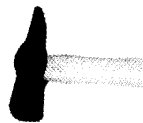
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—

Make check for \$25.00 payable to MFC and send to:

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Jackson, Ms. 39236

MFC is an affiliate of the Artist-Blacksmith Association of North America (ABANA)
Dues are \$25.00 per year and include subscription to The Upset.

Disclosure:

Blacksmithing is inherently a dangerous occupation. You are responsible for using eye, ear and respiratory protection and safe work methods. The Mississippi Forge Council, it's Officers, demonstrators, writers, editors and members specifically disclaim responsibility for any damages, injuries or destruction of property as a result of the use of any information published in the Newsletter, demonstrated at conferences or at meetings. Every effort is made to insure the accuracy and safety of information provided, but the use of any material is solely at the user's own risk.

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