Editorial

Welcome to the first issue of a new ABANA newsletter. We hope to improve our contact with our members by using this method of publication. The plan is to publish quarterly between issues of the Anvil's Ring and to include in it a variety of things of interest to blacksmiths from the newest amateur to the seasoned pro.

Our intention is for this newsletter to be an addition to all the other services for ABANA members. We are not trying to be in competition with any other publication, newsletter, or anyone at all. Yes, we know that some times we will not meet your particular needs or there will be times when we duplicate what you have already read in another publication, but the increased contact between ABANA and its members will benefit us all.

We will specifically try to include lots of things for beginning and amateur smiths without insulting the know how and intelligence of the seasoned veterans. So of course your input is greatly needed. Send us articles, questions, want ads, pictures, and sketches. You can even send nasty notes to the editor if you like, but remember, if you don't send us anything, you will get just what we feel like putting in the newsletter. Anyway, welcome to the new and still nameless ABANA newsletter.
How To Get Publicity . . . Free!
An Interview with Peter Happny

Peter Happny, former board member of ABANA, was recently the subject of an article in Yankee magazine, a nice bit of nationwide publicity. When he was asked how he got it and what it cost him, he said, "It's easy and it's free. You just have to be easy to deal with and be available to the media. Just become a real media whore and you will get all kinds of publicity."

What he really means is that if you want publicity, you have to furnish the media with something a little different. They don't want the same old covered bridge story, or a picture of fall leaves. You're different. Be in the shop and be yourself. Be available at times when many other people are not and let them use photos of a real blacksmith. (You all know that story, "My grandfather was a real blacksmith!") Peter says that using the media takes several actions on your part. Request press releases, give notice of awards you have received, sponsor functions, donate to auctions, do TV spots for organizations doing service and charity work, and give demonstrations at schools. Remember, whenever you do any of these, make sure the public relations work is done. For example, if you are going to give a demo at a school, don't expect the school to publicize your activity. Send the newspaper the notice yourself and invite the photographer to come. That is free advertising.

- Jim Ryan

"Name That Rag" Contest

Contest Deadline: June 15, 1993

This is your newsletter, so what do you want to call it? A few names have been suggested: "The Hammer's Blow", "The Anvil's Clink", "The Smashed Thumb", and a few that are not printable. However, this is an open contest to name the new ABANA newsletter. First prize? Nothing but satisfaction. Send your suggestions (or pick one of the above) to ABANA's newsletter editor: Jim Ryan, 569 S. Grandview Ave, Dubuque, Iowa 52003 or phone (319) 582-5558.

Tips on Textures & Finishes

A few years ago, Jim Wallace of Memphis, TN gave a demonstration in forging iron at Lincoln's New Salem State Park and told us a thing or two about textures while making a coat rack with five hooks. As he made the back plate, he told us that he upsets the edge of the whole piece, then straightens it out again. That gives it a texture that you can't get by just hitting the piece. Nothing looks worse than to have a series of evenly spaced dings put in by somebody with a ball peen hammer, and then let it go at that.

By actually upsetting it and straightening it, you get the authentic appearance of hand work, not dings. Look at the pictures of Kuhn's and Schmirler's work in Europe. It is reported that if the job required square bars, they would start with round bars and make them square, or vise versa. That is the authentic hand hammered look because it is hand produced. And, it is a lot more interesting than the rolled factory finish that regular bars of iron come with now. Try it and see.

Roger Quaintance of Amana, IA likes to get a smooth texture on his ironwork. He has a tumbler he made from a five foot section of 10 inch schedule 20 well casing, which he got at a junk yard. He welded one end closed and put a removable plywood head on the other end with a mechanism to turn it. He uses this for long straight pieces, like fire place tools. He has a 30 inch cement mixer that he uses to tumble anything that is not straight and a sandblaster for unusually shaped pieces or finish work.

Roger puts water and river rock into the tumbler and the cement mixer. He wants to take off all the scale since he puts a black finish on everything, so if there is any scale, part of the paint comes off whenever a bit of scale is loosened. His final finish is polyurethane colored with black pigment that creates a very smooth look.

- Jim Ryan
Floral Bird Feeder Holder

This bird feeder holder is designed to be hung from the corner of a post on a deck. It is a rather generic lily pattern that will give you ideas and a few techniques to apply to other projects you dream up on your own.

Step 1 - The stem is 3' of 1/2' round. Upset one end to about 3/4'' round. (Fig. 1)

Step 2 - Split the other end for 1-1/2" and bend outward to a 90 degree angle. (Fig. 2)

Step 3 - In the upset end, drill some 1/8" holes or whatever will fit for clothes hanger wire. (Fig. 3)

Step 4 - Forge the ends of the split flat and drill a rivet hole in each side. (Fig. 4)

Step 5 - Bend the whole unit upward 90 degrees, 1'' from the end of the split. (Fig. 5)
Step 6 - Curve the rod to the desired pitch.

Step 7 - Cut coat hanger wire into the hook pattern for the pistils of the flower. Insert in the drilled holes at the end of the stem. The longest should go in the center and should stick out about 1/2" past the others. This is the hook for the bird feeder. (Fig. 6)

Note: Make sure that the center hook is turned correctly for the curve of the stem. Epoxy will hold the wires in place. Or you can heat the stem yellow and drive the wires in, letting the stem cool around them. Heating is the traditional way.

Step 8 - The 2 leaves are made of 1/8" x 1" and are 16" and 22" long when tapered to a gentle point. Bend the leaves to a creative shape and weld them across from each other at the base of the stem, the shorter one goes outside the curve and the longer one inside. (Fig. 7)

Clay Spencer makes his leaves interesting by running them sideways through his trip hammer, making each edge taper away from the center. Or it can be done by hand hammering. This tapering makes the cross section into a diamond shape.

Step 9 - The 3 petals are cut from thin sheet iron about 5" long and 2 1/2" across at the widest part. Cut three chisel marks lengthwise to add interest. (Fig. 8)

Step 10 - The 3 petals are welded, soldered, or brazed right below the upset at the end of the stem. Shape the petals before welding them on.

Step 11 - For the base, cut a design of your choice from angle iron about an 8" long piece of 1/8" or 3/16" by 2". This pattern shown was the pattern seen. Drill the two rivet holes to fit the split part of the stem. Drill four holes for 1/4" lag screws, two on each side, to fasten the base to the post. (Fig. 9)
**BGOP Scholarship Fund**

Scholarship money is available to those who have been members in good standing of ABANA's chapter, the Blacksmiths' Guild of the Potomac (BGOP) for two years or more. $1,000 per year is available to cover tuition, room and board, travel costs, and material fees for blacksmithing-related school classes, events, conferences, and workshops. Scholarships will be awarded to the number of recipients that funds allow. Applicants must submit a proposal to the selection committee prior to the March 1, July 1, November 1 deadlines. Recipients will be chosen by the selection committee and approved by the BGOP Board of Directors. 1993 Selection Committee members are Tom Coker, Ed Jackson, and George Anderton. Mail your application to: Tom Coker, 12611 Bluhill Rd, Wheaton, MD 20906-4102. Phone: (301) 942-8573 for complete rules.

**AR Back Issues Index**

A delay in making the index available is finally over! Due to the amazing amount of research donated by ABANA member, Will Hightower of Sterling, Alaska, the index has blossomed into a 74 page publication containing 4,238 specific subjects for referencing! We are excited to have this resource; however, to obtain a copy you must send $10 (includes shipping/handling) to ABANA since it was costly to reproduce. Our many thanks go out to Will for making it all possible to find the wealth of information in the vast number of *Anvil's Ring* back issues still available.

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Floral Bird Feeder Holder
(continued)

**Step 12** - Rivet the lily stem to the base. Make sure that the stem does not ride lose on the angle iron.

**Step 13** - To fasten the base to the post, use four 1/4" x 1" lag screws. Heat the hexagonal head of the screw and forge it square. Or get square head screws and file or chisel a design in the heads.

**Step 14** - Finishing requires a coating that will last a long time outside. First, sand the whole unit thoroughly, then spray with a coat of cold galvanizing spray, available at your welding supplier. The last finishing is about 4 or 5 coats of semigloss. Be sure and coat the inside of the screw heads. If finished properly, it should last 5 years or more before repainting is necessary.
15th Century Candle Holder

Step 1 - For the feet, two pieces 1/8" or 3/16" by 1" will do, about 15" long. Drill or punch a 1/4" hole in the middle of each piece.

Step 2 - Forge a notch near the end with spring fuller, guillotine fuller, or hand held fullers.

Step 3 - Taper both sides toward the notch, keeping the thickness uniform. Leave the square at the end for the foot.

Step 4 - Round off the square to make it into a "penny foot".

Step 5 - Chisel a decorative line from a little above the top of the foot to 1" or 2" from center.

Step 6 - Duplicate these steps for the other end of the piece. Do it the same way and when you're finished and you will have two identical pieces.

Step 7 - Bend the feet out from the legs at about a 60 degree angle, (just eyeball it) and then curve the legs as shown. Fasten the two legs together with 1/4" bolt to hold them in place for aligning the feet until all four touch the table.

Step 8 - For the center pricket, try 3/8" square, about 12" long. Taper one end with a long, thin taper, sharp point.

Step 9 - Put a decorative twist or two in the center of the pricket bar.

Step 10 - Forge or file a 1/4" tenon about 3/4" long. Any book on blacksmithing will tell you how to make one.

Step 11 - For the candle bracket arms, use 20" of 3/8" square. Spread at the center to about a 1" or 1 1/2" area. Drill or punch a 1/4" hole in the center.

Step 12 - Bend three inches of one end to a 90 degree bend.

Step 13 - Spread the 3" area away from the main piece to create a piece that looks like a stick with a flag on it, about 1" x 3" and near 1/8" thick.

Step 14 - Taper the bend area to make a smooth progression from the 3/8" square to the flat area.

Step 15 - Bend the flat area around the horn of the anvil or around a tapered bick to shape the strap bracket. The bottom of the bracket should be about 3/4" in size and the top should taper up to 1". This permits different size candles to fit.

Step 16 - Do the same procedure to the other end of the piece. Care must be taken to see that the strap brackets curl in opposite directions from each other.
Step 17 - Curve the arms up into a U shape, leaving the spread center flat.

Step 18 - Assemble the fixture by removing the 1/4" bolt in Step 7 and putting the pricket tenon through the bracket arms and both foot pieces. Put it all upside down in the vise and peen over the tenon lightly. Remove and check alignment, then finish with a tight peen on the tenon.

Step 19 - Finish with floor wax, boiled linseed oil, varnish, paint, or whatever you like. Do not be concerned if your candle holder is a little out of line. The original is way out of line in the photograph. Be sure to make a hole in the bottom of the candle that is at center. Otherwise it will split. ☮
**Holiday Candle Holder**  
*(Shown on Front Cover)*

**Step 1** - Using a 1/4" x 1" piece, forge a 4" section square and taper at both ends of square section.

**Step 2** - Draw out the handle end thinner and wider to form a slightly pointed shape. Forge the handle shaping concave, lengthwise.

**Step 3** - Twist the square section evenly, leaving the handle and the bulk of the bar in one plane.

**Step 4** - Cut a two inch split in the other end. Spread wider and thinner with the cross peen. Leave the peen marks showing to give it character.

**Step 5** - Spread the feet and curve the whole piece as shown. The handle will curve back under with the concave side underneath.

**Step 6** - Forge the pin from a 1/4" round rod and put a 3/16" tenon on the end, about 1/2" long. At this small size, it is just about as easy to file it to a tenon.

**Step 7** - Cut a 4" circle from 1/8" plate and drill a 3/16" hole in the center.

**Step 8** - Upset the edge of the plate to add a little depth to the wax tray. This can be done over the end of a piece of 3" pipe. Turn up the edge just enough to look nice.

**Step 9** - Center the plate on the legs and mark the spot for the hole and drill to receive the tenon. It is easier to get the tray level after the legs are curved and the tray upset and drilled.

**Step 10** - Rivet the bottom of the pin in the holes to attach the tray.

**Step 11** - Finish by sanding lightly and applying floor wax or some other clear finish. ☀️
Prairie Candle Holder

The candle cup is made from 3/4", 7/8" or 1" seamless tubing, or black iron pipe. Schedule 80 pipe will hold together well but it makes a heavy cup. Try the local hydraulic shop for thin wall seamless tubing, about $1.25 per foot.

Step 1 - Use the ball peen to start spreading the cup on top over the edge of the anvil. Turn the tube to get it even all the way around. Three or four heats will get about 3/16" to 1/4" turned over.

Drill hole for rivet in the center. Enlarge the hole on the under side so that the rivet will hold when ground off flush.

Step 6 - Turn up the corners of the square base about 1/4" to 1/2". Curve them over the edge of the anvil and bend the handle to desired shape.

Step 7 - Rivet the candle cup in place and grind off the base of the rivet flush. A 1/2" rod with a dimple on the end held in your vise will hold the rivet inside the cup.

Step 8 - Finish with floor wax, boiled linseed oil, or varnish.

Step 2 - Straighten up the top by hitting it on the edge of the anvil or hitting the other end of tube.

Step 3 - Neck down the tubing with a 1/2" spring fuller, leaving enough space in the neck for a rivet to go through. Rotate the tube to keep it even.

Step 4 - Cut cup off the tubing with a straight base.

Step 5 - The base of the candle holder is cut from 1/8" x 3" x 9" leaving about a 6" strap for the handle.
MEMBERSHIP APPLICATION

ABANA

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