

CHAPTER OF ABANA

# Hot Iron News

VOICE OF THE NORTHWEST BLACKSMITHS ASSOCIATION

WINTER 1992

\$ 4.00 U.S.



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Front Cover:  
"Hail! Hail! The gang's all here!"  
Fall Conference '92  
Photo by Ina Rattenbury

# Big Blacksmiths' Bash at Barnie's! Between Bouts Brotherhood of Beaters Break Bread and Bite Beef! Bodacious Brad Brings Big Bally-hoo! Barnie Beats Best of the Bad Boys! Bravo!

Well, how many of you can bring a cold piece of steel to a red heat with a hand hammer yet? Barnie sure made it look easy!

Was that a great conference or what? Wonderful demonstrators, great food, and BRAND NEW S-2 (the real thing!) chisel blanks for 50¢ each! People were buying them by the case (yes! Barnie really had'em - in cases of 150). If you weren't there, sorry! They're all gone! More than a few eyes popped out when Barnie rolled in a one hundred pound can of CLIMAX welding flux. Said he used to go through one of those a week when he was welding boom chain! With his now famous twelve pound hand hammer no doubt!

Brad Silberberg did some great demos, talked and was just an all round nice guy. Jerry Culberson did his usual terrific job demo-ing, showing

slides of his work and separating the auction folks from their hard earned cash. Many thanks to Barnie and Linda Coski for their warm hospitality. Elsewhere in this issue you can read more about the conference. A common comment and the highest praise was "the conference had a real nice feeling

about it". And after all, isn't that what it's really about?

It was sure nice to see so many old friends - and new ones too. Thank you so much to everyone who helped make this such a wonderful and successful event. I don't usually get gooshy about these things (well, maybe I do, but that's beside the point) but, it sure is nice to see people pitching in to get things done and real warmth everywhere - like the family I never had. Not that I didn't have a family, just that this is like the one I never had!

Our next big event will be the spring conference to be held in Russell Jaqua's shop at Fort Worden in Port Townsend. We have an absolutely incredible all-star lineup for this event, including Michael Bondi, Art Jones, Phil Baldwin, and Russell Jaqua.

Russell, as most of you know, is the Bob Dylan of the blacksmithing world. A tremendous talent who can do more in flat dies than most people can do can do with a wheelbarrow full of tools. Been quite a while since we've seen Russ do his stuff - I can't wait!

Phil Baldwin, the technocrat, plutocrat, autocrat, and sometimes fullacrat blacksmith. I don't know which I enjoy more; watching him work or listening to him talk. Some demonstrators are good blacksmiths and some are good entertainers . . . Phil is both! Talk traditional, modern (whatever that is) Oriental or whatever. Iron, copper, silver, gold, he does it all!

The Bondi shop is turning out some of the finest ironwork in this country, due in no small part to the design and organizational talents of Michael Bondi. Art Jones runs the Bondi shop, relying on his years of experience in the forge shop at Mayer Island Naval Ship Yard and his more recent exposure to the art world.

Boy, conference and Port Townsend, they go together like beer drinking and barfing! Matter of fact, in years gone by we would do all four! Ah, yes! The good ol' days. At the last conference total beer consumption was a shameful seventy-two ounces! Just six frigin bottles among almost one hundred blacksmiths. Jeesh! We're turning into just a buncha old farts I'll tell ya.

# Calendar of Events

Jan 30, 31, 1993	RACER FORGE BUILDING WORKSHOP - at Apex Forge. Gas forges, castable refractory replaces wool in the Northwest Style heat-in-a-can-forge. Everyone participating leaves with a forge. Contact Darryl Nelson at (206) 832-6280.
April 12-14, 1993	POWER HAMMER/ART JONES CONFERENCE WORKSHOP (SEE BIG PROMO THIS ISSUE)
April 15-17, 1993	SPRING CONFERENCE - at Russ Jaqua's shop in Port Townsend, WA - Russ Jaqua event chair.
June 92	BLADE MAKING WORKSHOP -Phil Baldwin, Russell Jaqua at Jaqua's in Port Townsend, WA Contact Phil at (206) 334-5569.
FALL '93 CONFERENCE -	St. Helens. OR

PLEASE NOTE: **Novice Workshops** will be held at Jerry Culberson's Old Cedar Forge in Allyn, WA as soon as he has 12 people registered for a class. Contact Gene Chapman (206) 297-2495.

**OPEN FORGE** At Grant Sarver's shop (APEX FORGE, 2311 Ross Way, Tacoma) Every Friday from 5:00 P.M. til the cows come home! Come mangle iron on an industrial scale! Time for talk, chalk, and fun. There will be things for any skill level. Don't be bashful.. The best part is the price - FREE! Please call in advance, (206)572-7460, in case it's cancelled .

## PRESS RELEASES

The Japanese Garden Society, in cooperation with R. M. Martin & Associates, is sponsoring the first annual Garden Form and Function Exhibit to be held April 10-30, 1993 at the

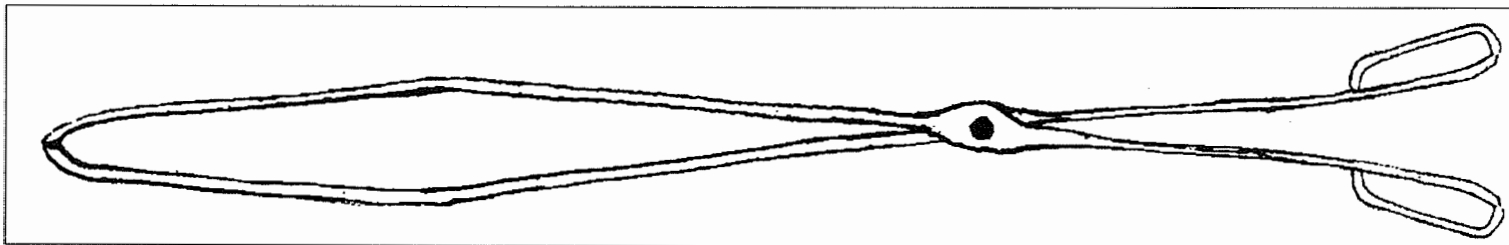
Japanese Garden, Washington Park, Portland, Oregon.

The exhibition will be open to studio furniture and sculpture designers from the Northwest, to include British Columbia and selected guest artists. Interested designers are invited to call or write for further information regarding this exhibition. Specific details regarding eligibility requirements, fees, and show parameters will be identified by receipt of this newsletter.

For information contact: Reid M. Martin  
P.O. Box 10212  
Portland, OR 97210  
(503) 224-3074

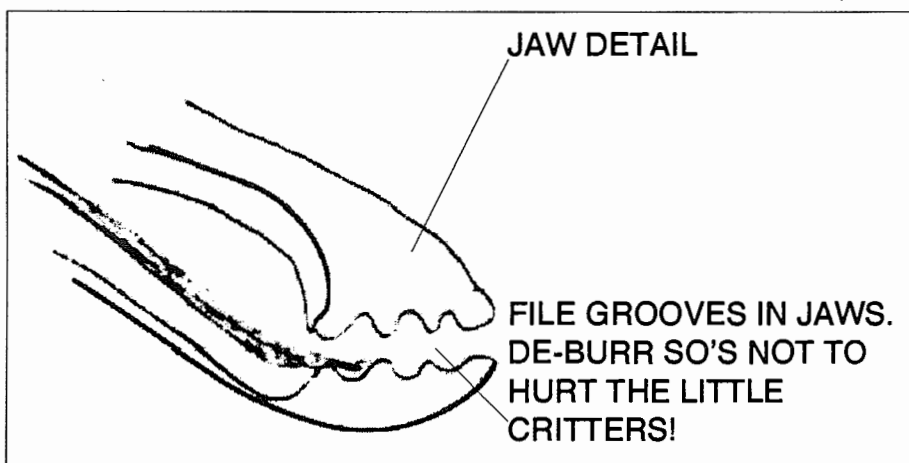
# CHAPMAN'S SLUG TONGS

By GENE CHAPMAN



$\frac{1}{4}$ " or  $\frac{5}{16}$ " stock is a nice size. Makes um lite and doesn't tire the arms.

I have a few flowers and a small garden on the place. I used to use a nail on a long stick for a slug getter. This is a more humane way and not so messy. Just drop them in an old milk carton and send them to your landfill or tie 60 feet of string on it and a weight on the other end. Drop in Dogfish Bay. People steal crabpots like crazy around here. It looks like a crabpot bouy. Nice suprise, eh?



Gene Chapman

\* **Ed. comment:** Gene, is business that slack that you have the time to make items for your personal use? It is nice that you are humane - no salt, nails, heavy boots or . . . . .

\*\* **Prez. comment:** It's articles like this that make me proud to say "Ich bin eine schmied!" or words to that effect. Folks, we're all humbled in the presence of giants like this. It's a sobering thought indeed to realize that by the time Mozart was my age he'd been dead for fifteen years! - Grant. Great job, Gene! Now, about that regular column. I don't know, Gene, now that I think about it . . . .

## CONFERENCE WORKSHOP

### Workshop

#### Goal:

To provide a step by step model for designing a free standing functional object for multiple production using specially designed tooling.

#### Process:

The workshop will start from the beginning of the design process with an inventory and demonstration of tooling possibilities by Art Jones and a market survey of several shops in Port Townsend. The survey will be followed by a discussion of what was learned and a determination of the type(s) and price points of the object to be produced.

After the market survey a group design will be made. The product designed will consist of an object that must consist of at least five separate parts and may include both forged and fabricated elements. Working drawings will be made at this time and evaluated. Visual attractiveness, utility, teamwork and market feedback will be emphasized in the design process.

The tooling and production engineering phase will be lead by Art Jones of Bondi Metals. Art will demonstrate a tooling system developed for the 3B Nazel air hammer. This system will be applied to the production of

**Workshop: "Design for Production"  
& NWBA Spring 1993 Conference  
ART JONES/POWER HAMMER  
Nimba Forge, Pt Townsend, WA  
workshop limit: 12  
April 12-15, 1993**

elements of the group design. The design will be evaluated in terms of production organization and tooling needs. Trial

runs of element fabrication will be conducted to determine the optimal form for efficient production. Each element will be dealt with by a separate team. Art will direct the trial runs and the fabrication of any new tooling needed for the production of the design. As needed the design may be changed to incorporate what has been learned during this process.

The final phase of the workshop will be the team production of a sample for each member of the workshop plus four units. Three are to be sold at auction for the benefit of NWBA and one will be kept with the tooling for educational purposes.

#### Items to be Provided by Workshop Participants:

hand tools	cameras
ideas	forges if you can
drawing supplies	tooling steel

IF YOU WOULD like to participate, please contact Russ Jaqua at (206) 385-5272. The cost per person will be \$200.00.

# PORT TOWNSEND SPRING CONFERENCE 1993

AT NIMBA FORGE APRIL 15,16,17

RUSSELL JAQUA

PHIL BALDWIN

"DESIGN FOR PRODUCTION"

ART JONES

MICHAEL BONDI

#### MOTELS:

Aladdin's Inn at Port Townsend	206-385-3747
Harborside Inn	800-488-4230
Point Hudson Resort	206-385-2828
The Tides Inn	800-VAC-TOWN

#### VICTORIAN HOTELS:

Manresa Castle	800-732-1281
Palace Hotel	800-962-00741

#### CAMPGROUNDS/TRAILER PARKS:

Ft Worden State Park	206-385-4730
Jefferson County Fairgrounds	206-385-1013
Point Hudson Resort	206-385-2828

Port Townsend is considered the Victorian bed-and-breakfast capital of Washington and it also offers other fine accommodation, restaurants and unique shopping.

#### DINING:

Everything from McDonald's to elegant dining are within 2 miles of Nimba Forge.

For a very complete list of the motels, RV/camping facilities, museums, parks, antique shops, restaurants, etc., contact the Port Townsend Chamber of Commerce, 2437 E. Sims Way, Port Townsend, WA 98368, 206-385-2722. It also includes nicely detailed maps of the area.

**DON'T FORGET YOUR AUCTION ITEM!!!**



**1993 SPRING CONFERENCE REGISTRATION**

APRIL 15 - 17, 1993

Nimba Forge, Port Townsend, Washington

**Registration and Fees:**

I am a member of NWBA ( ) I am a member of ABANA ( )

Pre-Registered before April 1st			\$ 35
After April 1st, or walk-in			\$ 40
Spouse			\$ 5
Children	\$5 per child x	=	\$
Additional \$20.00 for non-NWBA member (To become a member)			\$
	TOTAL		\$

**DON'T  
FORGET  
YOUR  
AUCTION  
ITEM!!!**

Make your check payable to NWBA and mail to:

NWBA  
P.O.Box 81041  
Seattle, WA 98108

**DISCLOSURE / ASSUMPTION OF RISK**

I hereby acknowledge that by attending the NWBA Spring 1993 Conference to be held on the property of Washington Satate Parks & Recreation, Ft. Worden, and Russell Jaqua, DBA Nimba Forge, I assume all risks, hazards and dangers that are present on the property by reason of its location, the terrain and the various equipment located on the property. I specifically waive and release Northwest Blacksmith's Association & Bernard Coski of any liability, loss or damage which may occur as a result of my presence on the property.

**ALL ADULTS MUST SIGN:**

Name: \_\_\_\_\_ Print same: \_\_\_\_\_

Spouse: \_\_\_\_\_ Print same: \_\_\_\_\_

Child: \_\_\_\_\_ Print same: \_\_\_\_\_

Child: \_\_\_\_\_ Print same: \_\_\_\_\_

Address: \_\_\_\_\_ Phone: \_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_ Zip: \_\_\_\_\_

**REMEMBER! \$5.00 DISCOUNT FOR AUCTION ITEMS!!!!**

# NWBA BOARD MEETING MINUTES

October 2, 1992

Members Present: Grant Sarver, Joe Elliott, Tom Graham, Jeff Holtby, Dennis Prince, Kent Rudisill, Margaret Byers and Brad Silberberg.

Member Absent: Ike Bay and Ben Atherly

President called meeting to order at 6:30 PM.

Grant - getting bleachers for association. Should be 8' - 10' long so they can be moved by anyone. It cost \$63.00 for 7 day rental on bleacher at Fall Conference. It was discussed having a workshop to build bleachers but it was decided to put them out for bid to members. Kent will draw up plans & bids will be asked for. Must be built by certified welder & be able to complete by and deliver to Spring Conference.

New Business: Joe asked about dividing Ike's responsibilities. He thinks that Chapter Liaison & ABANA Editor should be one job.

Brad explained about how hard it is to get input from Chapters and how important this input is to The Anvil's Ring.

Joe wants the job as Chapter Liaison & ABANA Editor.

Dennis nominates Joe. Kent seconds nomination. Joe is elected unanimously.

Dennis Prince is nominated for Secretary. Kent seconds. Dennis is stuck with it unanimously.

Ike is to receive all financials from Tom Graham.

Federal Non-Profit status is to be applied for. We are 501C Federal status, but never received E.I.#. It needs to be straightened out.

Jeff tried to resign, nice try, but didn't make it.

Jeff & Kent will share the Video job and get help running the camera at conferences.

## Work Shops

Novice Workshop - November 20-22 at Old Cedar Forge. First 13 people on list \$160.00. Second Novice Workshop probably in February.

Forge Building Workshop - January at Apex Forge.

Power Hammer Workshop - Art Jones, sometimes in January.

Bladesmithing - Phil Baldwin & Russ Jaqua in June.

Spring Conference - April 15-17, 1993 at Russ Jaqua's shop in Port Townsend, WA

Fall Conference - Late September, early October at Timberline Lodge, Oregon.

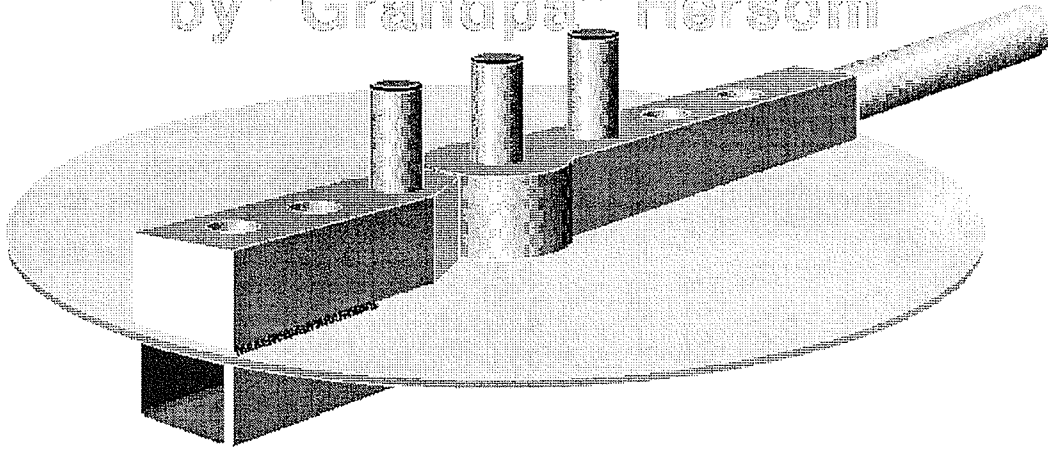
Meeting adjourned 8:00 PM.

Your Scribe,

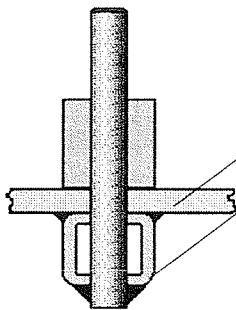
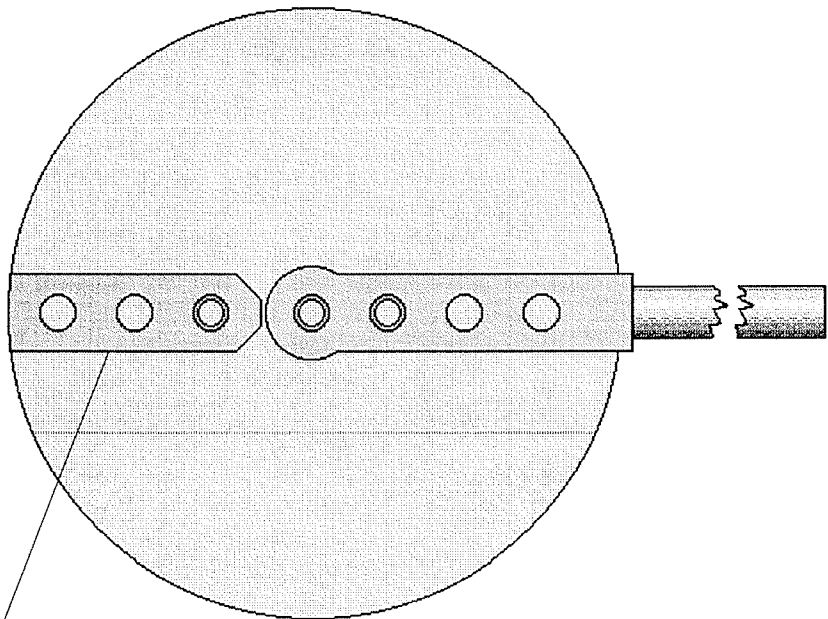
Dennis Prince

# FROM GRAMPA'S TOY SHOP

by "Grandpa" Hersom

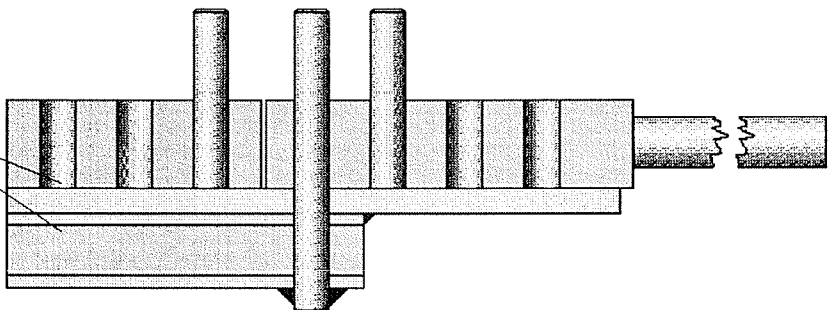


TOP VIEW



END VIEW

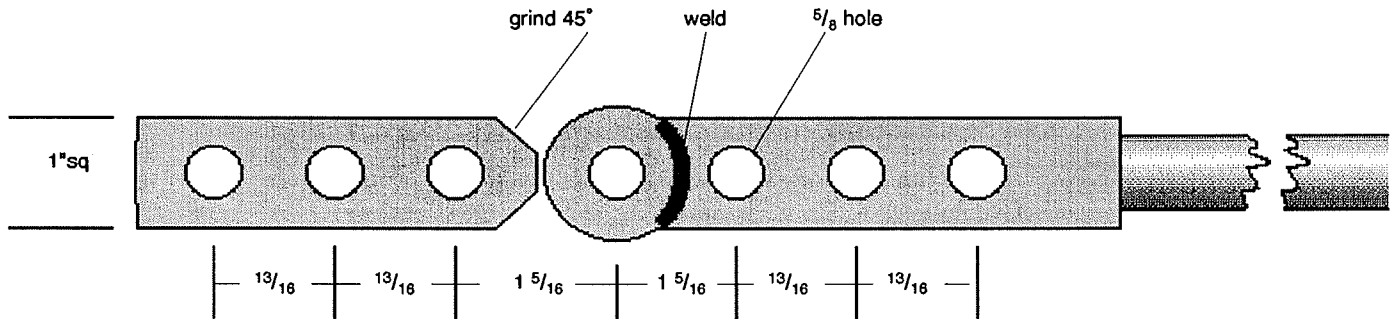
WELD



SIDE VIEW W/ CUT-AWAY

# FROM GRANDPA'S TOY SHOP

"This is the handiest bender not only for scrolls but for other projects as well."



1" square stock with 1 1/4" round boss welded on with 1/16" wall bronze bushing in center hole to take wear. Grind & weld boss deep and grind clean.

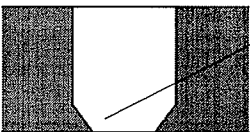
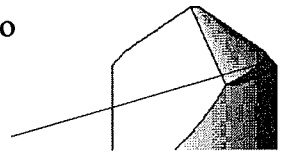
2. Bottom plate is a 1/4" x 8" circle with 1" tube x .125 wall welded to the bottom.

3. Center pin goes thru plate and 1" tube welded to bottom side. Lots of strain on center pin.

4. Bending pins made of tool steel - 2 1/2" - 2" long. I use potato digger bars 5/8" dia. which are already hard.

5. I used 1" square HR iron - maybe should have heat treated(lye) holes. May distort due to side pressures.

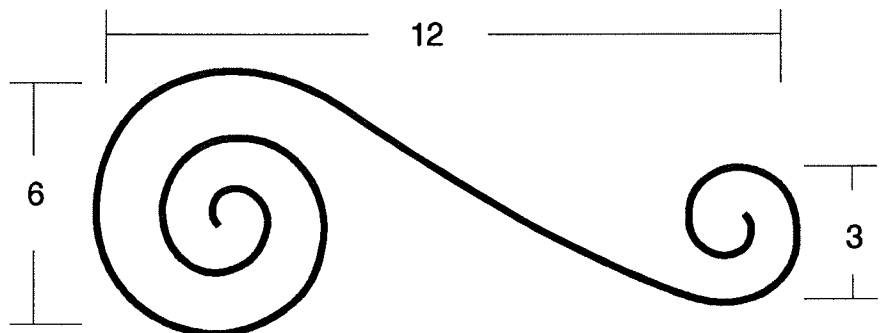
6. Drill holes with pilot drill - 9/16" or 19/32" drill. Then 5/8" drill. Grind corner off 1/8". Makes a type of reamer drill that works on movable arm. Leave a shelf on bottom of hole to keep pins from dragging.



7. Weld 5/8" stub on movable arm. Put 24" long pipe over this for leverage.

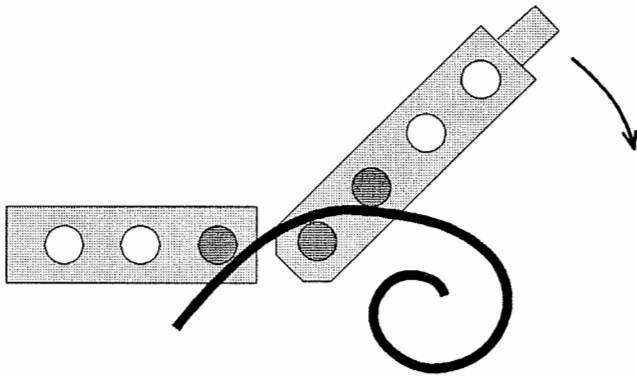
8. 45° angle on stationary block

lets movable arm go back past 90° to help pin clearance and increase chance to bend better, closer.

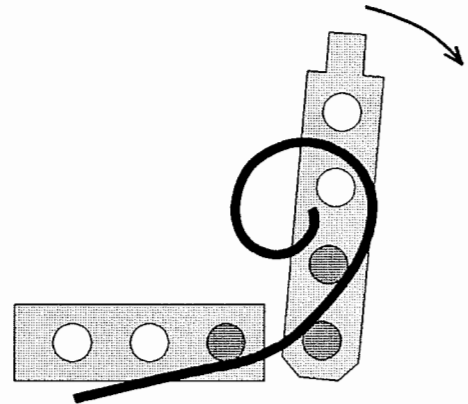


To bend scrolls I use scroll forms to get basic shape, then use 3 pin bender to

# FROM GRANDPA'S TOY SHOP






BEND



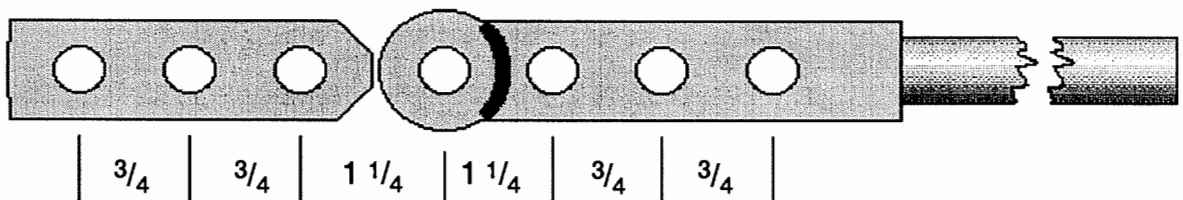
STRAIGHTEN

adjust scroll to proper width and length, etc.

I use a block 1 1/4" square with one square end and other end curved  over center pin. To bend parts square,  round  with pins outside hole. Can bend 1/2" square or round HR bar cold on large radius or small radius hot; 90° bends, etc. To cut down on clearance between pins use pipe or tube over pins or just the center pin.

## FOR MY SMALL BENDER

Same frame, 1/4" x 8" plate and 1" tube on bottom. Same as large bender.



3/4" square stock heat treat(lye), 1/2" potato bar pins, 1 1/16" round center pivot with 1/16" bronze bush. I put wooden dowels (short ones), in empty holes to keep scale out when hot bending.

*Sincerely*

*Grandpa Arrow*

## NWBA FALL CONFERENCE

by Gene Chapman

Summer's gone, pumpkins ripe and Fall Conference. It was held at Barney Coski's shop in Tacoma, Wa. Coski's place is a sight to behold, bulldozers, steam hammers, dies, piles of iron, big shop, equipment sheds, front loaders, motorcycles, press brakes, mills, drills, more piles of iron, grinders, cranes, more motorcycles, all the stuff in blacksmith dreams.

Something new - NWBA "T" shirts and hats. Nice looking.

Friday afternoon Brad Silberberg demo'd some leaves with emphasis on texture. One, a ginkgo leaf looked just like the real thing.

Later, Jerry Culberson did a poz tong demo. Here are a few of Jerry's quotes on:

Ross Perot - I'd hold his money while he ran

B.S. - is short for blacksmith

Poz tongs - you're going for the snake shape

Blacksmithing - learn how to be good

Shoveling - load the back end of the shovel, the front end will take care of itself

What paint is for - Nobody can see what you didn't do

Rivets - I walk around with a pocketful

A spare day - Like your day off, make a couple thousand rivets

Rivet hole - Size to the rivets you got in your pockets

Offsets - Too much makes tongs that can pick up stuff around corners

New word: Misconstrusion

Jerry had a pair of anything tongs - simple, ingenious, good idea.

Friday evening Jerry gave a slide show on his fabulous iron work for a major private client. Weighty, 1,000# plus andirons, 9' tall wine cellar gates,

hinges, locks, pot racks, etc. Great show. He ain't human, how does one man do all that?

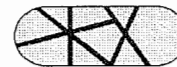
Barney Coski demo'd on found iron, steel and some non-ferrous metals thrown in for good measure. Identification, use & sources. Even a talk on how locomotive boiler tubing was manufactured.

Midnight madness 1B Nazel time, making grapes and art stuff. Jess Spromberg discovers the 50# sledge hammer. Joe Elliott "Best way to clean turtles, cut heads off, stop at gas station, blow up with air hose".

Saturday morning - more new faces and goodies on auction table.

Brad Silberberg began the demo's with a talk on some of his tooling; short stubby tools for power hammer work, the shoe tool mounted on a short handle, texturing tools. Brad made several abstract leaves and squished some iron. He used top tools for design under the power hammer. Brad stressed experimentation to devise different designs.

Saturday afternoon Jerry gave a demo on power hammer work plus a special forge weld without flux. Rumor has it, he can forge weld at room temperature.



3:37 PM Gene C. goes to camper to take nappypoo. Saturday evening pot luck - Barron of Beef by chef Mike Linn was the main course - MMMMM- MMM - super, Mike. Lots of different delicious

Work Under Hammer - sometimes it goes trapezoidal, hexazoidal or hemrroidal or maybe it's art.

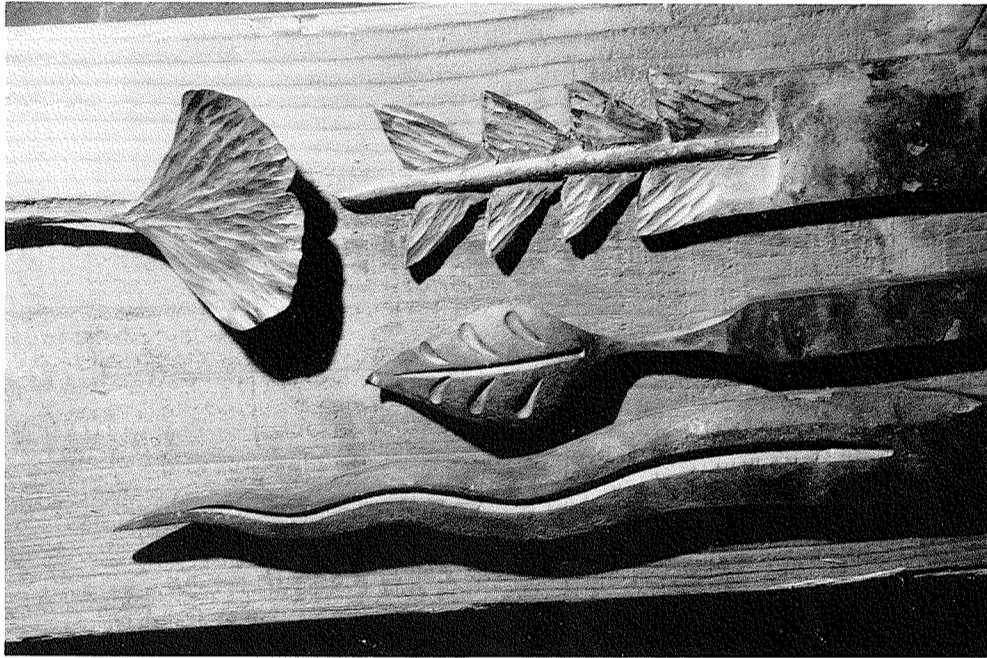
## FALL CONFERENCE

dishes at the potluck. Plenty leftover for Sunday, too.

Before the auction a special presentation was held for Karen Wagner for her dedication and super work as past NWBA Hot Iron News Editor. She brought the newsletter from a few pages to a near magazine format. Many gifts of appreciation were presented. You folks who just couldn't make this event for whatever reason(?) contact Lloyd Hedglin if you have any gifts for Karen.

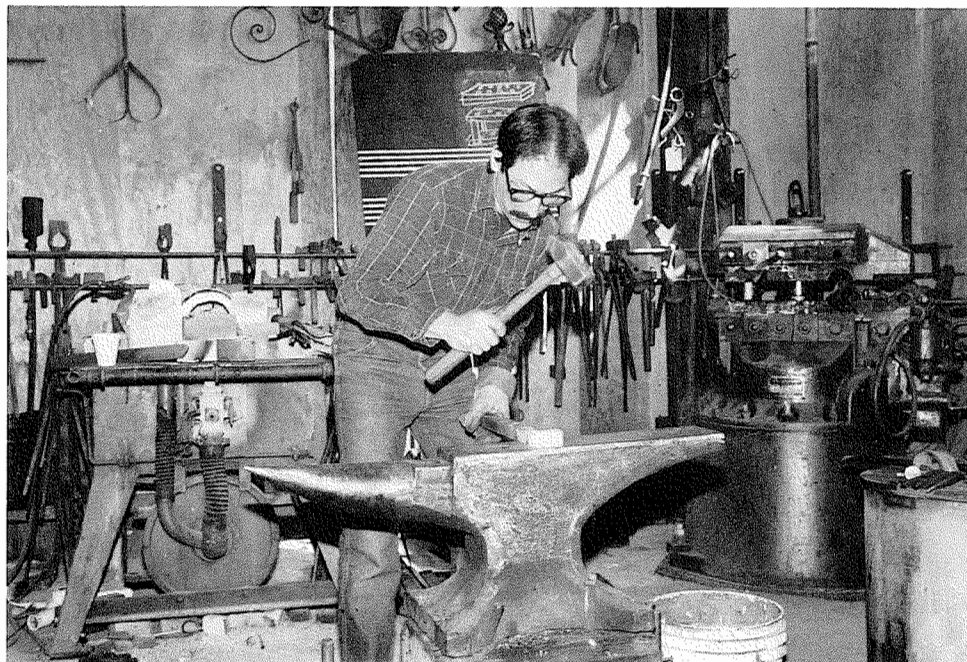
Auction - Jerry was at his usual good form as auctioneer. Dorothy Steigler (BEST FORGED ITEM), George Graves (BEST OTHER CRAFT) and Hugh Eddy (BEST TOOL) received the "Prez" outstanding contribution awards for their auction items. Good show.

Billfolds were well lubed as the auction brought in \$2436.



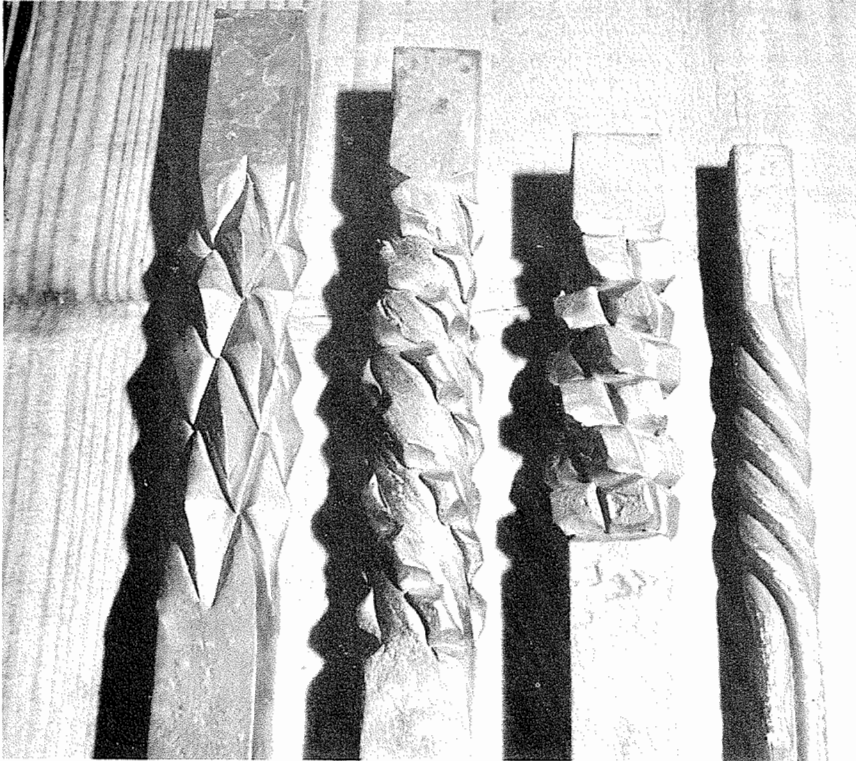
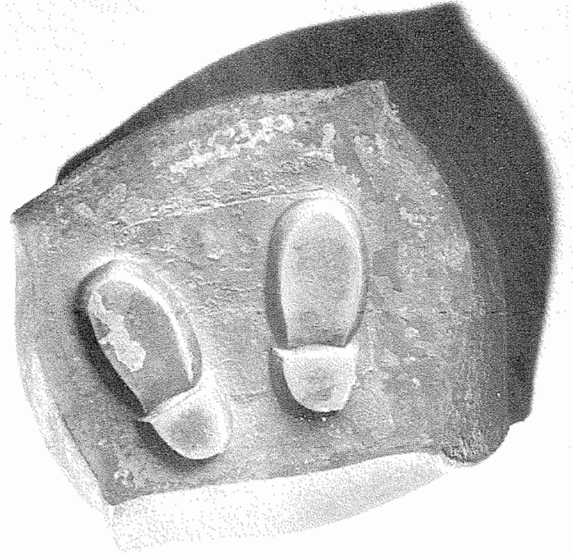
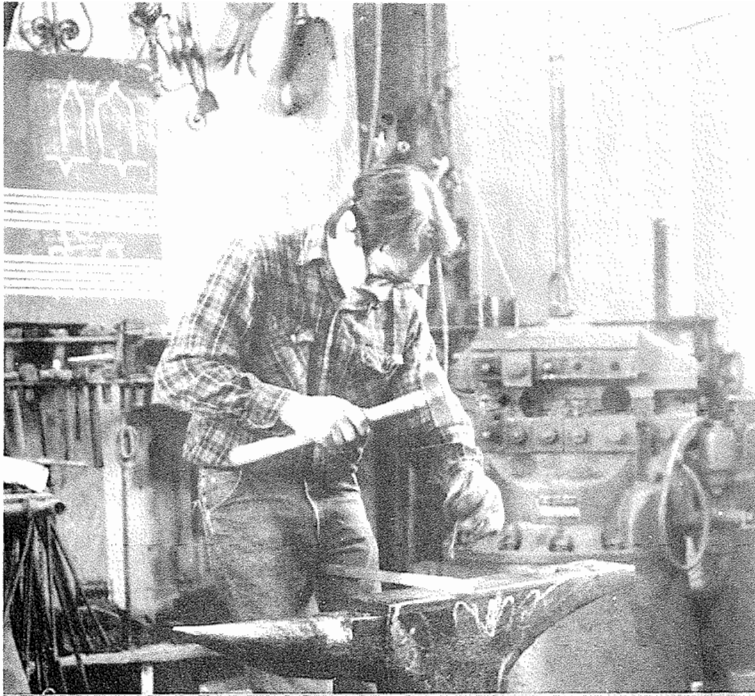
Saturday Midnight Madness - Blacksmith talk, Paul Hinds fire-weld salsa and chips. Squished iron and a 3# bow tie.

Sunday morning - Brad demo'd a nifty dog's head from 1 1/4" square stock, during heats he gave chalk talks on tooling and techniques. After lunch a repeat slide show by Jerry C.



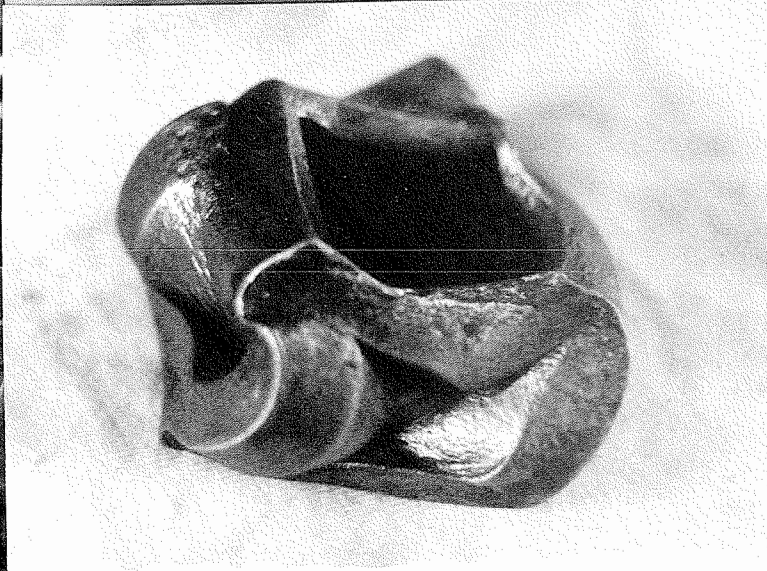
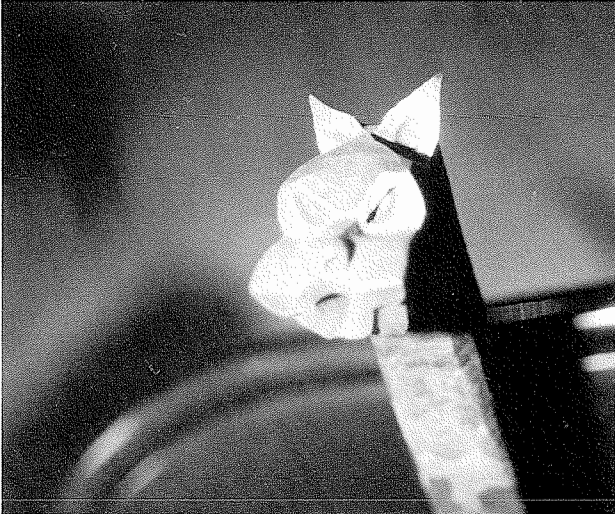
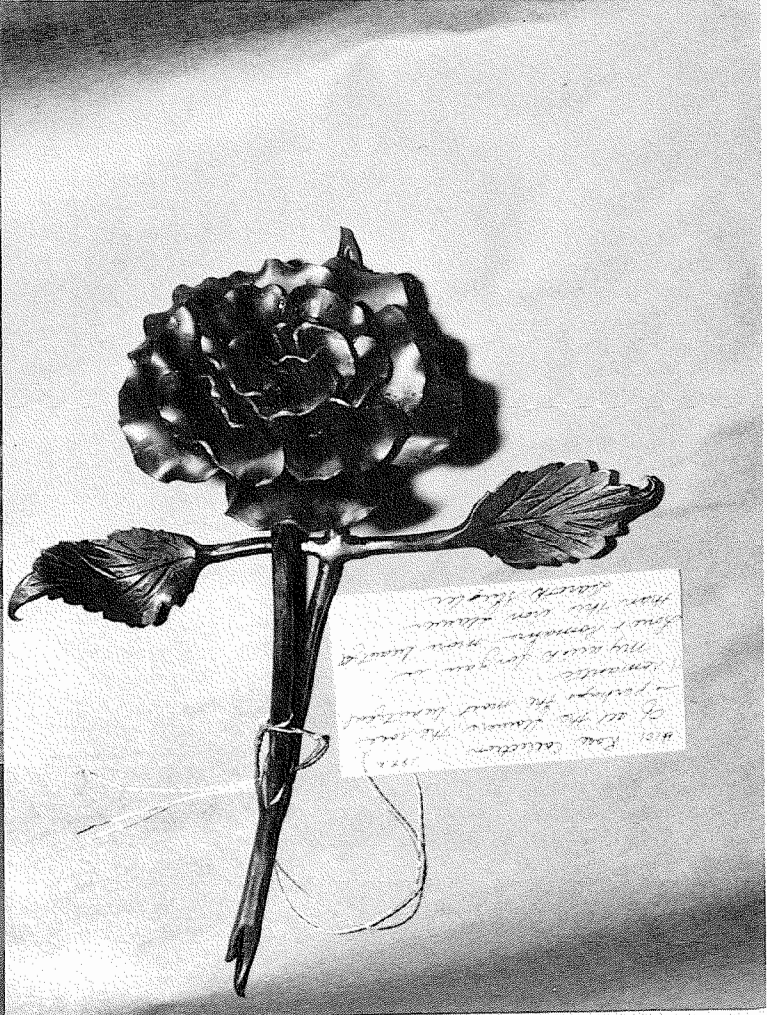
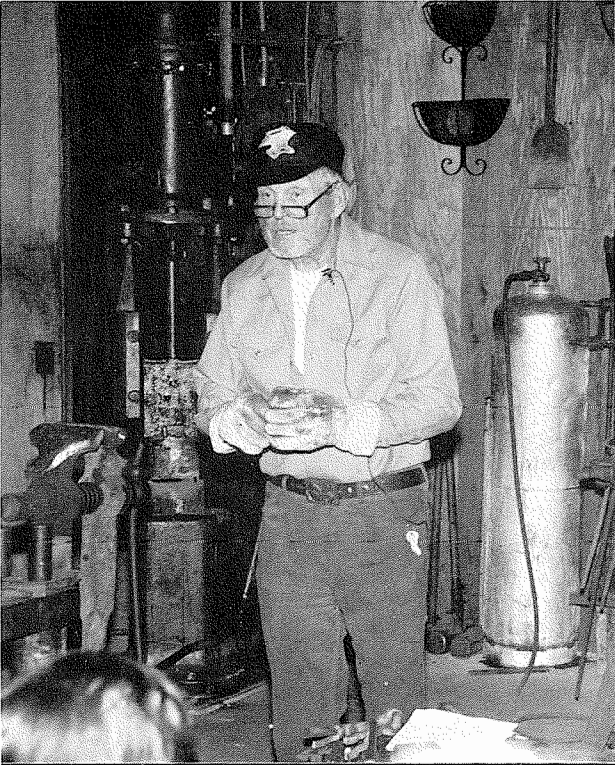
Barney was kept busy hauling S-2 chisel blanks from his vault. They were selling like hotcakes.

About 2:30 PM the conference broke up. Thanks to all who attended, and special thanks to Barney and Linda Coski for putting up with us.

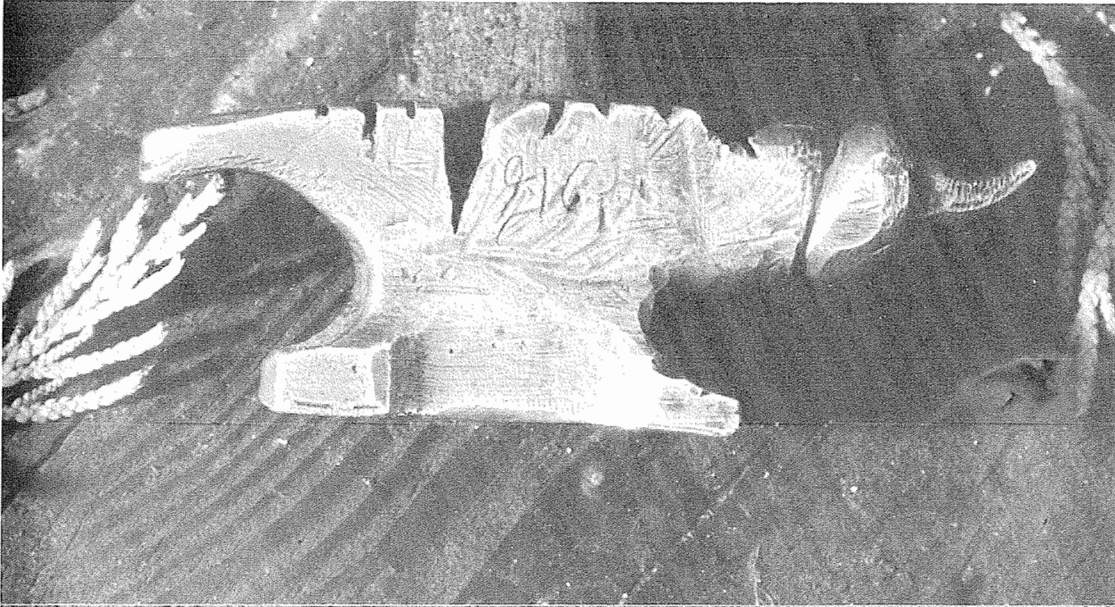


Fall '92 Conference  
TOP LEFT CLOCKWISE:  
Brad Silberberg,  
photo by Al Karg  
Footprints by Brad,  
photo by Lloyd Hedglin  
Jerry's Almost Anything Tongs,  
photo by Lloyd Hedglin  
Brad Silberberg twists,  
photo by Lloyd Hedglin

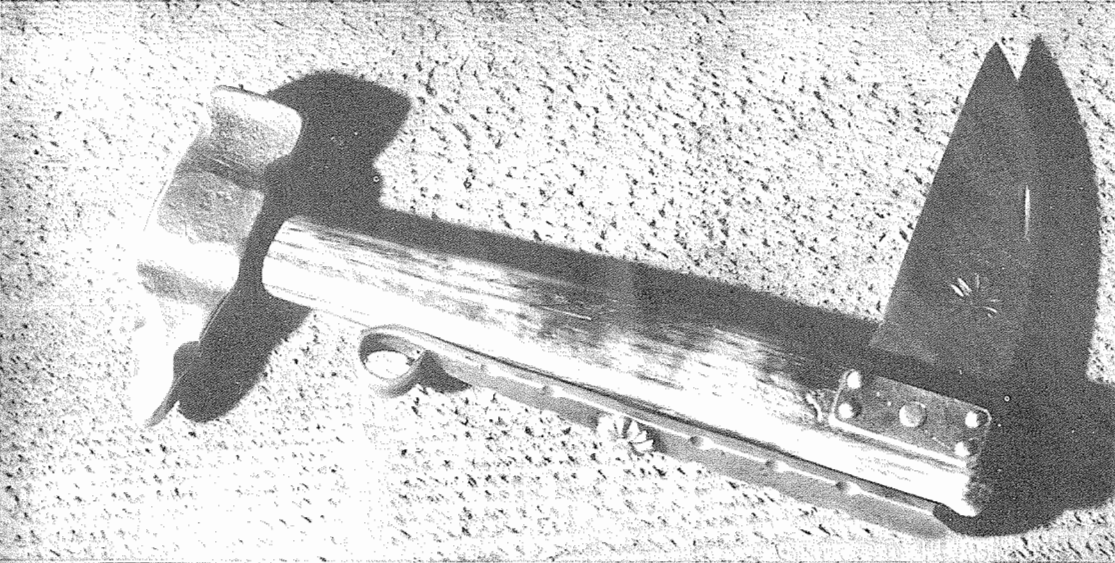




TOP LEFT CLOCKWISE: Barney Coski, photo by Lloyd Hedglin; Rose by Dorothy Steigler, photo by Lloyd Hedglin; Container Shape by Brad Silberberg, photo by Al Karg; Tom Graham, Treasurer, doing his final "official" duties before retiring, photo by Vernell Henderson; Brad Silberberg head, photo by Ina Rattenbury



Gene Chapman's  
Anvil  
photo by Lloyd  
Hedglin



Gene Chapman  
Folding Swiss  
Army Knife,  
photo by Lloyd  
Hedglin



Blademaking  
Workshop  
Samples & Demo  
Items,  
photo by Wayne  
Goddard

# THANKS

To the Members of NWBA:

I cannot put into words just how much I appreciate what the membership did for me at the Fall meeting. I was very moved at the honors bestowed me for my work on the Hot Iron News.

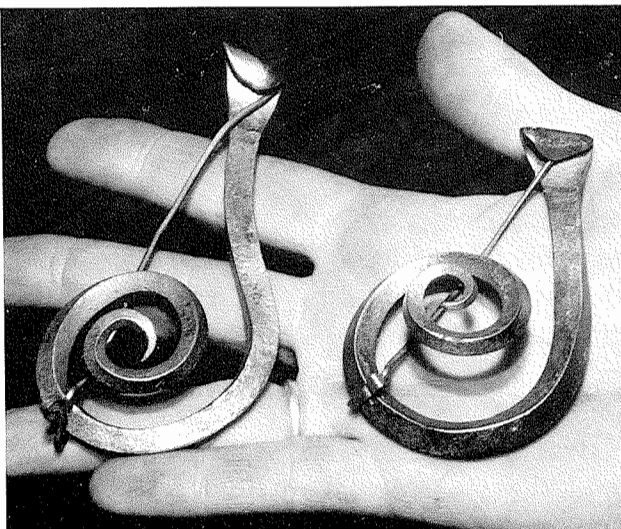
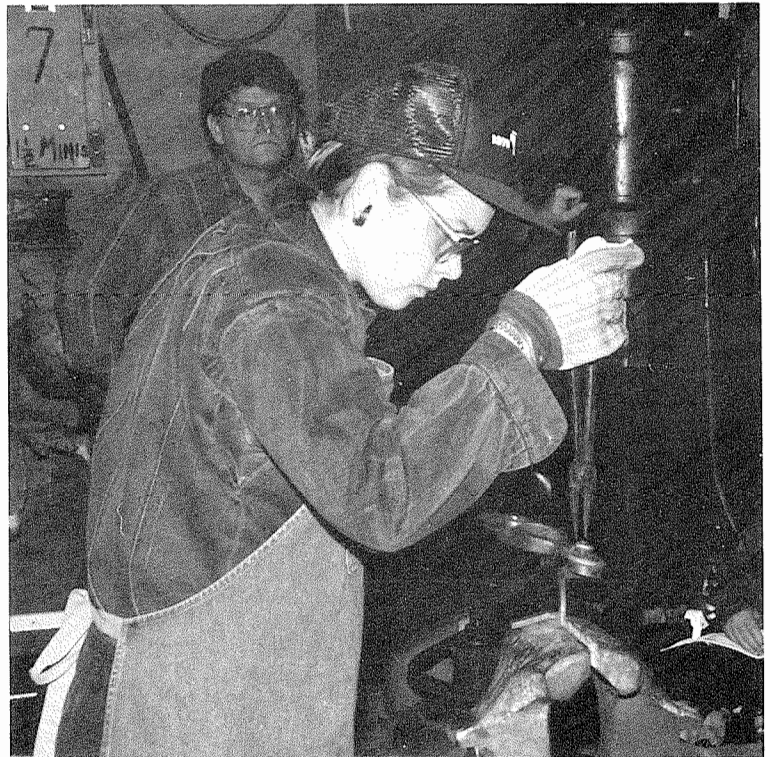
I enjoyed working on the magazine and trying to make it something everyone could use and learn from. BUT- the magazine really was a group effort. So many people contributed articles and photos. The honors belong to the group not just me.

NWBA has been through a lot in the last decade. It has accomplished many things and is growing stronger. I am proud to be part of it and proud of what it has become.

So I wish to thank the NWBA for the honor and the surprise.

Thank you,  
Karen Wagner  
Phoenix Forge

P.S. Phoenix Forge is up and running!



# JERRY CULBERSON

by Ina Rattenbury

**JERRY CULBERSON.** . . blacksmith, farmer, chief engineer, commanding officer, artist, gourmet cook, storyteller, auctioneer, teacher, demonstrator, motivator/encourager, loyal friend.... a person whose trademark is his handlebar mustache, red suspenders, derby hat and who needs only a handshake to bind an agreement.

All this dynamic personality was born into one man on July 10, 1938 in Bay City, Michigan. He will tell you he should have been born 100 years earlier because his likes, dislikes, thoughts, actions and ways would fit better with those who lived then and he would have liked the adventure of conquering the Western frontier. (Whether he was born with that mustache, I'm not sure.)

Big and strong even as a kid, he began working on farms at the age of 7. As is true of today's work, he can tell many stories about those days, and I'll let him fill in the details. It was on the farm he began smithing--a necessary thing in those days. However, work was always the first priority, so he wasn't allowed time to be creative or artistic--just time enough to "fix it" and get back to work. And he worked for a hard taskmaster.



During his high school years, the trend in the trades was toward welding, so the blacksmithing equipment had been stacked in a corner. When the welding class was tasked with building giant-sized animals for playground equipment, it was Jerry who suggested that the forge and smithing tools be dragged out and used to get the necessary curves, angles and joinery that welding wouldn't accomplish. The shop teacher, a blacksmith, was delighted to have the smithing tools used once more. Guess who ended up doing most of the work?

A high school graduate and 17, Jerry joined the U.S. Navy, put in his first hitch, got out, worked for awhile at Dafoe shipyard and the



cement plant, then re-enlisted. Always a hard worker, he was an inspiration to many young men and the leader of troops. He spent 21 of 26 years at sea (six of them in Viet Nam). You may know him as Old Cedar Forge; in the Navy he was Old LDO. As a chief engineer, fire fighter and damage control officer, dry docking officer, and commander of the entire Pacific Fleet, blacksmithing was used, again, when necessary. During these years, woodworking and



# JERRY

furniture building were his hobbies. (He is as fine a worker of wood as he is worker of iron.)

Retiring from the Navy in 1980, he was finally able to pursue that which he had always wanted to do--blacksmithing. His father wasn't a blacksmith nor were his grandfathers or uncles. Blacksmithing is just something that was "in him" waiting to be expressed. At long last he would be able to express himself in iron.

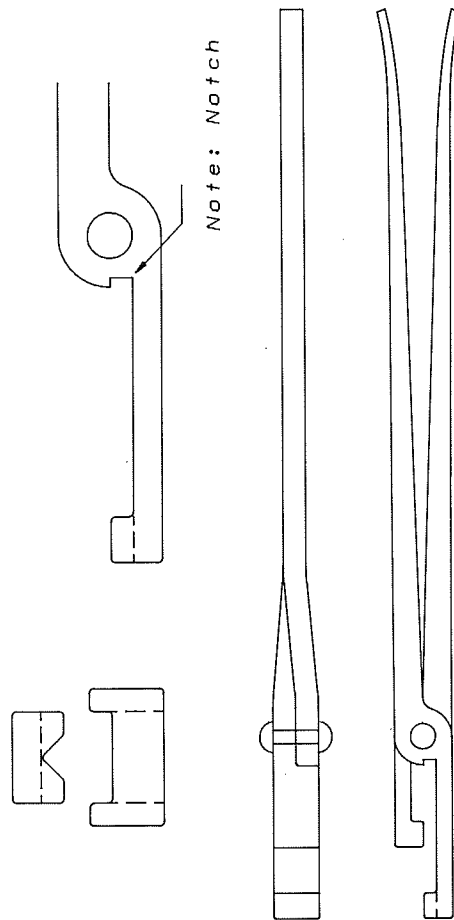
During this time he heard about and joined the Northwest Blacksmiths Association (NWBA) and the Artistic Blacksmiths of North America (ABANA). The rest is history--organizer, past NWBA president, teacher, demonstrator, BS'er, auctioneer and yes, creator of those famous baked beans.

A man who commands and demands respect, one's first impression of Jerry is that he is serious, intense, tough and driven by hard work. And that's all true. But he also has a soft side, possesses a unique sense of humor, is loving and compassionate, has a twinkle in his eye, and is a fascinating conversationalist. He is happiest when spending time with his lady or teaching and demonstrating for those willing to learn. In any conversation his commitment to the craft and the people in it are obvious. He IS one hell-of-a-man.

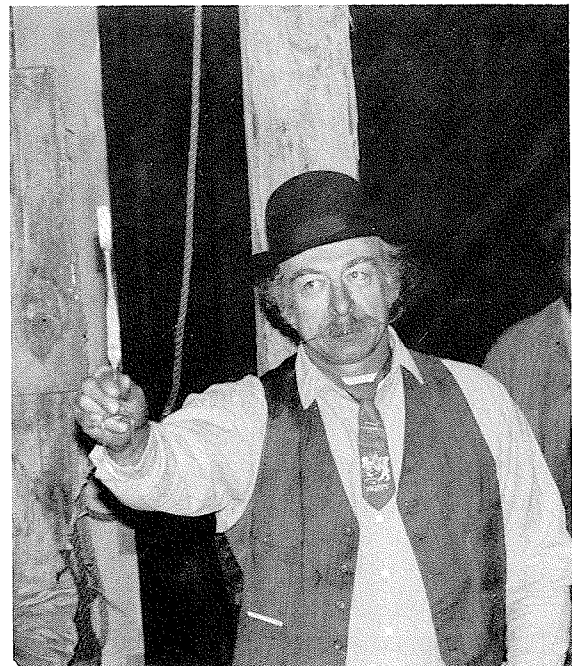
Respectively submitted,

Ina

Jerry Culberson's "Hold (Almost) Anything Tongs"



From A drawing By Hugh Eddy

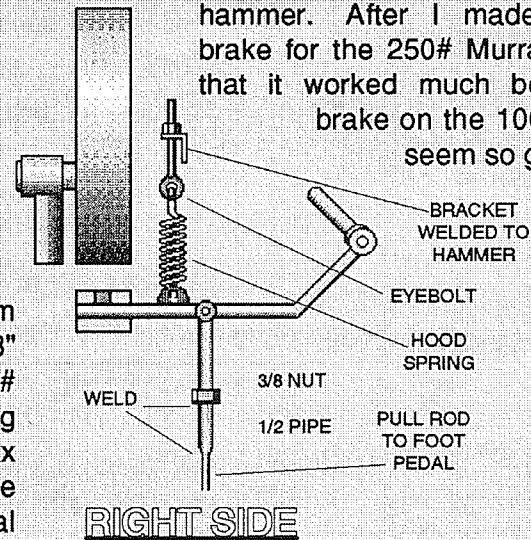
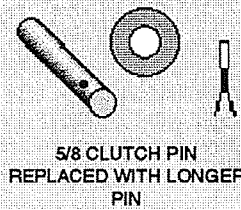
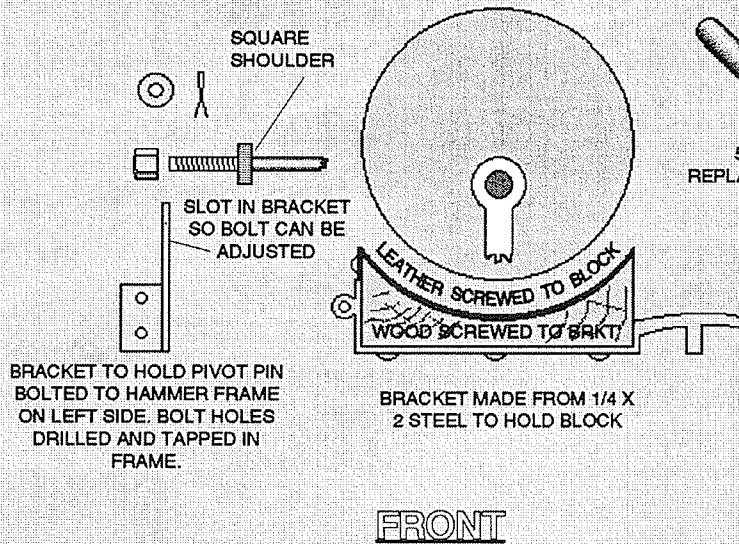


Always the auctioneer

# POWER HAMMER BRAKE

By Clifton Ralph

I have drawn the two brakes that I have on my hammers. A mechanical hammer is made more useful and has better control with a good brake. When I got the brake working on the 100# Murray hammer I thought it worked great. It gave me a lot better control of the hammer. After I made a band brake for the 250# Murray I found that it worked much better. The brake on the 100# doesn't seem so great now.



I bought 4 feet of 3" wide brake shoe material from American Truck Parts for \$55.00. The band brake has 38" of this brake material riveted to the steel band on the 250# Murray. I have 3" x 38" or 114 square inches of braking surface. The leather gripping agent on the 100# has a 2" x 10", or 20 square inches of gripping surface. The brake pivot arm I forged for the band brake, has a mechanical advantage. It is 4" from the pivot pin to the brake band eye, and 15" from the pivot pin to the spring that tightens the brake. The spring on the 100# has a straight pull with no leverage advantage. The band brake stops the heavier hammer better, due to the mechanical advantage and the increased braking surface, than the other brake does on the 100# hammer. I have greater control with the 250# hammer than with the 100# hammer because of the more effective brake. The grease from the front bearing has a tendency to find it's way down to the brake on the 100# Murray making the brake less effective. The band brake on the 250# is above the bearing and has less chance of getting grease from drip and splatter.

The brake could be removed from the 100# by stepping on the floor pedal and removing one cotter key and washer. The band brake is a little more difficult to remove. You have to remove two cotter pins and washers. I bolted the angle iron onto the guide adjusting bolts, and welded a vertical offset bracket to it, to mount the pivot pin on the brake arm side of the hammer. I fabricated the angle iron bracket and bolted it to 2 guide bolts, to hold the pull pin in position on the left side of the hammer's counter-weighted flywheel. I prefer using the guide bolts to hold mounting brackets, over welding or drilling holes in the hammer casting. Drilling or welding might cause the hammer's frame to break. If the guide bolts are not long enough to hold a bracket, they could be replaced with longer and better bolts.

Anyway, if you look at the drawings for a couple of days you might be able to understand how these two brakes are made and supposed to work. I plan on making a band brake for the 100#. I hope this will help some of you with a brake for this type of hammer. You don't have to be happy with these brakes, design a better one and let me know about it soon.

Keep Hammerin'.....Clifton Ralph



JERRY CULBERSON'S OLD CEDAR FORGED BLACKSMITH BEAN RECIPE

BY POPULAR REQUEST, HERE IT IS....

Note: Observe all safety precautions and notes.

The Quick Method:

- 4 cans(3lb. 6 oz.) S&W Brick Oven Beans
- 4 cans (15 oz.) Sun Vista (Frijoles Negros) Black Beans
- 2 "large" onions sliced and diced
- 1 or 2 "large" full head garlic squished
- 3 to 8 oz. Gilroy Chopped Prepared Garlic, depending on addiction level
- 1 cube butter
- 4 oz. dark molasses (more or less)
- 2 lbs. good Polska Kielbasa (Hilshire Farms) halved and sliced
- 2 oz. yellow prepared mustard
- 1 teaspoon Cayenne Pepper
- 2 oz. cumin powder (Yes, that's 2 ounces not 2 teaspoons)

Bake in large cast iron Dutch oven for 12 hours at 200 degrees with lid slightly ajar to allow excess moisture to release. Stir about every 45 minutes or so.

The Slow Method

Soak 4 lbs. pintos, 1 lb. red, and 1 lb. black beans overnight in a bucket of water. Add a handful of salt. In the morning drain and rinse. Throw beans in cast iron pot.

Add 1 can (54oz.) of Swanson's Chicken Broth and increase molasses to 6-8 oz. along with all other stuff listed under Quick Method.

Bake for 12 hours at 200' with lid slightly ajar to allow excess moisture to release. If more liquid is needed, add beer or chicken broth--NEVER, NEVER water.

*Note 1:* Garlic and beans baked together assures that maximum methane gas is produced when consumed. Thus, a corresponding increase in horse power can be achieved over beans alone (see Footnotes 1, 2 & 3).

*Note 2:* Garlic/bean methane gas is heavier than air, thus a

well ventilated shop is required (see Footnote 1).

*Note 3:* Garlic/bean gas pressure may reach 9 psi. Thus, the blacksmith should always face his/her gas forge when exhaust is eminent and try to be at least 15 feet away from open flame. Caution: If you smoke, raise your cigarette/cigar above your head for 15 seconds while you exhaust to prevent accidental ignition!

*Note 4:* CAUTION!!!! WARNING!!!! Never eat fruit (non-musical variety) with these beans or a condition known as "sputter" may occur. Spare underwear may be required (see Footnote 1).

*Footnote 1:* Persons wearing boots with jeans tucked in (e.g. Dorothy) must be ever mindful of both the heavier-than-air methane and the fruit sputter. Jeans must be outside of boots to allow methane to escape (some may settle in boots--non-sparking heels recommended). Underwear should be discreetly changed so as not to alarm others who may have consumed fruit salad but who have learned to control "sputter" with a timed release or metered exhaust relief method.

*Footnote 2:* Use extreme caution. Pressure in excess of 9 psi may cause hearing loss (not to mention friends). Please excuse yourself and go outside.

*Footnote 3:* Horse power can sometimes be converted to rpm's or strokes per minute. Caution: Premature "sputter" may occur.

**SAFETY NOTE: HAZARD:** Do not try this at home!! Or at Midnight Madness!!

One of our double-wide members tried to do a moon shot (that is, bearing his buttocks and exhausting) towards a lighted match. The result--defoliated his moon, which was not very attractive any way; destroyed his ass gasket's ability to control sputter; set his Nikes on fire; and stained his bib overalls. And, while quenching himself in the slack tub, ruined the shop cat's drinking water supply.

However, if you simply must try this trick, a flame arrester can be fashioned with four (0000) copper mesh screen. But have a fire extinguisher at the ready.

*Footnote to Footnotes:* For those who enjoy the pure aromatic effect of garlic beans, recommend consumption 3 hours before bedtime with your sweetie. Pull covers up tight to chin. When both of you exhaust (preferably without sputter), flutter the covers.

Enjoy! 



# Oregon Trail Celebration '93

March 20 - 21, 1993

## ATTENTION SATURDAY MARKET VENDORS

In 1993, Oregon will lead the nation's celebration of the 150th anniversary of the largest voluntary migration in recorded history, the "Great Migration" of 1843 across the Oregon National Historic Trail. From Independence, Missouri through Kansas, Nebraska, Wyoming, Idaho, Washington and Oregon federal, state, local and private groups are developing a cooperative celebration in honor of those early emigrants. While the Oregon Trail is the main focus, all of Oregon's emigrant Trails, including the Meek-Elliott Route and the Applegate Trail, will be highlighted in Oregon Trail Celebration '93.

Scheduled for the weekend of March 20-21, 1993, the kickoff celebration will take place on the South Parks in downtown Portland. The Portland weekend will recognize and celebrate descendants of founding families and long-term residents, as well as newcomers who have recently blazed their own trails to Oregon. Re-creations and demonstrations of pioneer life and multi-cultural art, music and historical exhibits will be featured.

We're seeking a few crafts vendors to participate in this weekend celebration who can demonstrate their craft while selling it. We'd like the craft to be representative of pioneer times. Those crafts might include:

Candle making	Soap making
Weaving	Blacksmithing
Pottery	Leather working
Basket making	and so forth . . . .

If you are interested, please contact:

Nancy Goss Duran  
(503) 241-8383

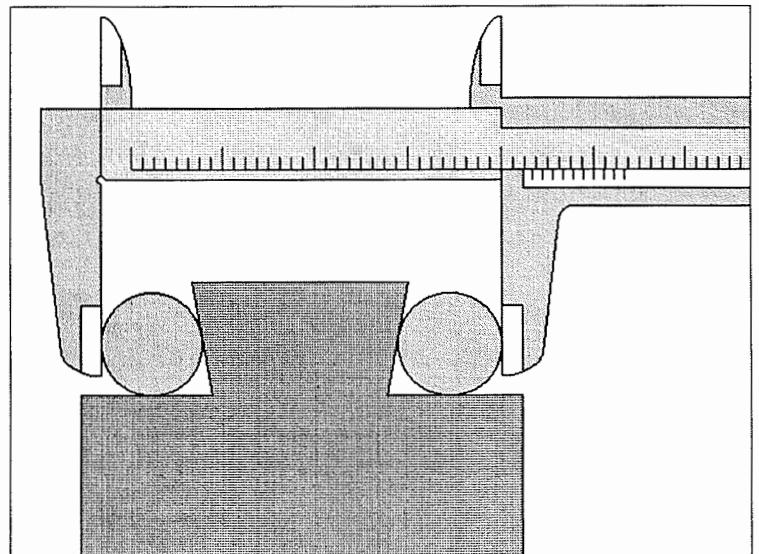
Thank you.

### EVENT COORDINATORS:

Nancy Goss Duran  
Maggie Bendicksen

### NORTHWEST STRATEGIES, INC.

621 S.W. Morrison, Suite 400  
Portland, OR 97205  
Phone: (503) 241-8383 FAX: (503) 299-6503



ACCURATE METHOD OF  
MEASURING A DOVETAIL

## THE QUILTING CORNER

By Ina Rattenbury

- At the Fall Conference the ladies met to catch up on the latest news and to arrange the blocks for the next quilt to be auctioned. Ina pieced the top together and assembled "the sandwich" so that it was ready for hand quilting in November.
- **ATTENTION MEN AND WOMEN:** The next quilting project will be a wall hanging comprised of illustrations of the lives of NWBA members. If you wish to be included in this project, you will need to provide us with your business card (if you have one) and symbols/drawings representing you/your family's life. If you want to participate but don't have a lady who sews or quilts, give your card and drawings to either Ina or Vernell.

Henderson, 36060 Pittsburg Road #2, St. Helens, OR 97051, (503) 397-6131 OR Ina Rattenbury, Old Cedar Forge, East 220 Cronquist Road, Allyn, WA 98524, (206) 275-6769



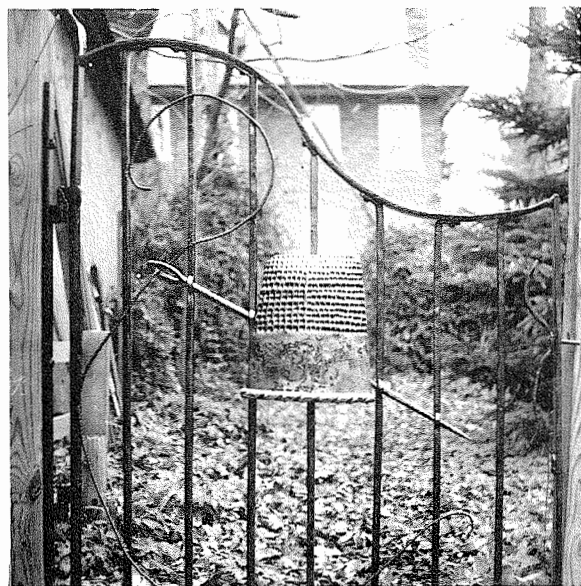
LAYING OUT THE NEXT QUILT.

Photo by Vernell Henderson

Put your ideas/drawings on paper (12-inch square) and include business card. Bring to the Spring Conference or mail to Ina or Vernell. Once collected, those women who wish to participate in making the quilt will be given the fabric on which the graphics will be placed. Ladies who wish to help with this project, give your name, address and phone number to Ina or Vernell.

**Note:** Anything that can be attached to fabric in any manner may be used. You do not need to sew to participate. Buttons, paint, crocheted pieces, fabric, etc. can be used. Be creative and original.

Questions or suggestions? Contact: Vernell



Gate &  
Photo by  
Dan'l  
Moore,  
Coon  
Hollow  
Forge,  
MT

# BLACKSMITHING

A blacksmith was formerly a smith who worked in *black metal* or iron, as distinguished from a white smith, who worked in *white metal* or tin.

The history of the blacksmith is a long and most honorable one. The smith's fire illumines the early pages of history, and the ring of his anvil is one of the remotest sounds we hear. The smith made the first swords and shields and coats-of-mail even before he made the plowshare. The weapons of war were made by him before the simplest machine, but the machine was his later product, and *the machine is one of his lineal descendants*. The same man in the beginning worked the metals in both the plastic and the liquid states, so the *the foundryman* was originally a smith.

The field of the blacksmith has been growing with the growth of the country and the increase of inventions: there are a thousand and one things that he is called upon to make, and his field will widen with the multiplication of industries. The machine works of the time embrace a trio of shops-the machine shop, the foundry and the blacksmith shop-and in the case of a steam-engine works there is also the boiler-shop, which is another distinct outgrowth from the "smithy".

Footnote: Originally the term smith was applied to anyone who made anything. The large family of Smiths are honorably descended from people who in early times accomplished something notable.

## Fluxes

*Fluxes.* -A flux is a substance, as borax, that promotes the fusing of metals; as in soldering tinware rosin is commonly used as a *flux*; the flux forms a skin on the surface of the heated metal and protects it from the attacks of the oxygen in the atmosphere. The light blows given in the first stage of welding expel both flux and scale from the joint. In practice operation the smith often uses a little fine sand to sprinkle over the portions of the work he heats, especially when welding

scarf joints in wrought iron; ordinary borax is often applied for the same purpose, especially with mild steel.

A flux used for uniting steel with wrought iron consists of six parts of powdered limestone mixed with one of sulphur, the ends of the two portions being dipped in the mixture four or five times whilst heating, before actually welding.

When uniting steel with steel, the following is recommended: borax, 4 oz.; washing potash, 4 oz.; and a small quantity of ground glass. All should be melted together and pulverized when cold.

Several authorities give the following recipe for use with steel, and it will repay for the trouble incurred in its manufacture: Take by weight: borax, 14 oz.; sal-ammoniac, 2 oz.; prussiate of potash, 2 oz.; unrusted wrought-iron filings, 1 oz. The whole is ground up with a pestle and mortar and then placed in a sheet-iron pot or crucible (an old pail will do), together with sufficient water to make a paste. The vessel is boiled over a moderate wood fire, the contents being constantly stirred. A mass like pumice stone, streaked with grey and green, results, which is allowed to harden, is cooled, and once more pulverized, when it is ready for use.

Taken from:

"ERECTING AND OPERATING"  
AN EDUCATIONAL TREATISE  
-FOR-  
CONSTRUCTING ENGINEERS, MACHINISTS,  
MILLWRIGHTS AND MASTER BUILDERS  
BY  
WILLIAM ROGERS

Published by  
Theo. Audel & Company  
Copyright, 1907 and 1913

Submitted by John Dorffeld

# ABANA

Artist-Blacksmiths' Association of North America



P.O. Box 1181, Nashville, Indiana 47448  
Executive Secretary, Janelle Gilbert Franklin

Office Hours: 7:30-11:30am & 1:30-4:30pm  
Phone: (812) 988-6919

## ABANA PRESIDENTS MESSAGE December, 1992

Dear ABANA Chapters,

The November ABANA Budget meeting held at Emmert and Jane Studebaker's homestead in Tipp City, Ohio went off without a hitch. Hat's off to Emmert and Jane for once again making their remarkable facility available for our use. Their warm hospitality and excellent facilities provided the perfect atmosphere to help make the annual budget meeting a success. Thanks, Emmert and Jane, we are in your debt once again.

ABANA is in the best shape it has ever been in. From all indications, we are headed for some real good times. ABANA has been lucky enough to have the advice of some very savvy financial minds. One of them, Joe Harris from West Virginia, is now back on the ABANA Board. Joe was a Board member some years back. His banking background and sound advice is one of the reasons we are in such good shape today. He will be the Chairman of the Finance/Audit Committee, a position he held when he left the Board in 1989. Welcome back, Joe! We are tickled to have you back on the Board.

The reason Joe Harris was able to come back to the Board is that Jim Ryan, current Board member, has gone on a special assignment that required him to relinquish his Board position. Our sincere thanks go out to Jim for his service on the ABANA Board. We can expect great things from him in the future!

Louis Mueller, Site Chairman for the 1994 ABANA Conference was in attendance at the November Budget meeting. The Conference Committee is already hard at work planning all the details for the 1994 conference. Louis gave us a look at some preliminary work done by the Site Conference Committee. No detail will be overlooked by these folks -- we can look forward to a super conference in 1994. As time goes by we will get more specific details from them.

**SAFETY TIP FOR THE SEASON:** It is easy to do. A lot of times you don't think anything about it when you do it. What is it you may ask? It is laying a piece of hot iron on the table and walking away. I learned quite a while ago that **unattended hot iron belongs on the floor.** It was a lesson taught to me by a master smith. Some of his students have even handed him the hot end of the iron (A mistake that happens only once per student. "...and you shall know them by the lumps upon their heads...") If you are working with more than one person in your shop, make sure you don't set up the other guy! That also goes for putting hot tongs back in the rack. He might need those fingers for something else.

Have a Very Merry Christmas,

A handwritten signature in cursive script, appearing to read 'Clayton Carr'. The signature is fluid and somewhat stylized, with a prominent 'C' at the beginning.

Clayton Carr  
ABANA President



*ABANA Chapter Liaison Committee*  
December, 1992

**1992 ABANA BOARD ELECTION RESULTS:** Clayton Spencer, Hans Peot, Tom Clark, and Tim Ryan were either elected or re-elected to the ABANA Board.

**BLACKSMITH'S INFORMATION EXCHANGE INTER-NATIONAL:** Paul Lundquist has volunteered to co-ordinate an effort to make available to smiths in Russia, Ukraine, Estonia, Czechoslovakia and other countries information that is available in the west. This will be in the form of books, magazines, photos, drawings, brochures, catalogs, equipment, tooling plans, etc. Anyone who is interested in helping Paul with this project should contact him at 382 Oak Creek Road, Burnsville, NC 28714, Phone:(704) 675-5258, Fax:(704) 675-9196

**PETERS VALLEY NEWS RELEASE:** Peters Valley is offering summer studio assistantships in blacksmithing. For more information and application write to Peters Valley Craft Center, Assistantship Program, 19 Kuhn Road, Layton, NJ 07851, (201) 948-5200. Application deadline: April 1, 1993. Peters Valley is also sponsoring a craft fair July 24-25, 1993. They expect 12-14,000 attendees. For information on booth space and application send SASE to Peters Valley Craft Fair, 19 Kuhn Road, Layton, NJ 07851.

**EVERYTHING YOU ALWAYS WANTED TO KNOW ABOUT SPOONS AND ART KNIVES:** The *National Ornamental Metal Museum* will be featuring the uses of spoons by 47 American artists. At the same time they will feature Art Knives from 13 knife makers and a special exhibit of President Bush's knife presented to him by Daryl Meier. These exhibits will be displayed from Nov 17 - Jan 17.

**ABANA SWITCHBOARD:** Got a problem? Need a source for supplies? Just got a bone to pick! The ABANA Switchboard is there to help you. We can't solve all your problems but we will make every effort to help or find someone who can. For assistance call any ABANA Board Member or the ABANA Office for a referral.

**VOLUNTEERS NEEDED:** ABANA is looking for volunteers that would like to work on some of our committees. If you have a specialty you want to share with us or a desire to become more involved with ABANA call and let us know.

**SCHOLARSHIP PROGRAMS:** Due to the interest created by the scholarship programs that several chapters have adopted, ABANA requests that each chapter with such a program in place, send a copy of your information

(requirements, etc.) to the ABANA office to be kept on file as information available to other chapters and ABANA members. Thank you for your co-operation in our effort to keep our resource files up to date.

**DEMONSTRATORS:** ABANA is in the process of updating the national Demonstrators List. Anyone wishing to be included on this list should send their requirements and description of demonstration to ABANA board member John Pollins III, RFD 5 Box 154, Greensburg, PA 15601.

**YOUNG BLOOD:** The Indiana Blacksmith Association has set into action a plan to contact trade/vocational schools and youth organizations to let them know about chapter hammer-ins and conferences so they will have the opportunity to learn about blacksmithing. This seems to be a good way to get the word out to the youth in your area and create some interest with our young people. Way to go IBA!

**ROAD TRIP:** Need a change from the regular meeting and hammer-in? Check around your area for museums and historical sites that have iron work and blacksmithing displays. Plan a tour for your chapter. It will surprise you at the number of places you can visit in a day.

**BACK TO SCHOOL:** Want to become more proficient with welding; learn more about wood working to compliment your iron work; or learn how to do machine shop work? Check with your local vocational schools. Many schools are offering evening classes that are very reasonably priced and only take up a few hours of your time each week. We are never too old to learn new techniques and improve on our skills.

**THANKS:** ABANA members in your chapter appreciate the reproduction of the monthly chapter mailing information in your newsletters. Please continue to keep the avenues of communication open for those who are interested. If your chapter has information that you would like to share within our chapter mailing network, just submit your info to the ABANA office and it will go out in the next monthly mailing. Please keep sending your newsletters to the Chapter Liaison Committee so we can keep abreast of your events and programs.

**THANKS** to all the chapters that have sent their newsletters our way. Ron Porter, Chapter Liaison Chairman, R.R. 1, Box 64, Bunker Hill, IN 46914.

Membership Application  
Mail to:

Northwest Blacksmith's Association  
PO Box 81041  
Seattle, WA 98108

Membership Application:  New  Renewal  New Address?

Annual dues are \$20 and include a subscription to Hot Iron News. Please make your check to NWBA and mail to the above address.

Date: \_\_\_\_\_ Are you an ABANA member? \_\_\_\_\_

Name: \_\_\_\_\_

Firm: \_\_\_\_\_ Phone: \_\_\_\_\_

Address: \_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_ Zip: \_\_\_\_\_

Country: \_\_\_\_\_



Membership Application for  
**ARTIST-BLACKSMITH' ASSOCIATION OF NORTH AMERICA**  
MAIL TO:  
**ABANA**  
**BOX 1181**  
**Nashville, IN 47448**

Membership in ABANA includes a subscription to the Anvil's Ring, member discounts at conferences and on back issues of the magazines.

Full time student -	\$ 25	Regular member -	\$ 35
Family membership -	\$ 40	Seniors over 65 -	\$ 25
Overseas member -	\$ 45	Contributory -	\$100
Public library -	\$ 25		

Name: \_\_\_\_\_

Street Address: \_\_\_\_\_

City: \_\_\_\_\_ State: \_\_\_\_\_ Zip: \_\_\_\_\_

VISA or MASTERCARD # \_\_\_\_\_ Expiration: \_\_\_\_\_

Checks or money orders must be written on a US Bank in US Funds.

# CLASSIFIEDS

**FOR SALE:** Lg. forge - vent hood, lg. anvil, long spring vise, swage block, bolt swaging dies, wagon tire roll, square hole punch, hardy hole tools, forge tongs(45 sets), hammers, flating hammers, chisel hammers, 25# trip hammer(new), oven, much more, antique lathe, Senca Falls, \$7500 for everything. Contact Jim's Welding, 10217 N. McAlister Road, Island City, OR 97850.

David Norrie is looking for either full time or short term help to work in an architectural forging shop near Toronto, Ontario. Short term help would come in and work for the duration of a project, averaging from 1-3 months. Accommodation would be provided. People must be confident with basic forging skills as they apply to artistic architectural ironwork. If you are interested call David at (705) 357- 2714 or write to him at R.R. #3, Sunderland, ONT., Canada, 10C 1H0.

**WANTED TO BUY:** 50# Little Giant powerhammer. This would be for a trade for a 150# Beaudry with a broken base. Might make a nice sharpening hammer when fixed. Call Berkley Tack, 503-556-7975

**STERLING SILVER PINS.** Limited quantities, NWBA Commemorative Pins, \$17.00 each. Contact Ike Bay, P.O. Box 81041, Seattle, WA 98108.

**FOR SALE:** Blackheat Welding Compound - no fuss, no mess. Weld from room temperature up to a black heat. Organic, manure based, aged, hardly any smell. See B.S. auctioneer next conference.

A LIMITED AMOUNT of New Mexico smithing coal available. \$280.00 per ton. \$16.00 per 100 lbs. Contact Corkey Storer at Heritage Forge, (206) 432-1468 Seattle area.

**WANTED TO RENT** - Part-time smith

seeks space for shop. 400 sq. ft. minimum, between Seattle and South Everett. Call or write: Rob Snyder, 4809 NE 71st Street, Seattle, WA 98115. 206 523-7209.

## Editor's Column

Well, the Fall Conference is over and I know I enjoyed it immensely. The demonstrators were at their finest. Brad Silberberg made some great twists among other things. Barney Coski did some amazing things also. After everyone has gone home, I'll bet there will be a few of you that will try lighting a cigarette on a piece of steel that is a red hot from hand hammering on it, or give up smoking because they can't get their steel hot. Jerry Culberson always gives a great show. This time was no exception.

Thank you to all of the many people who helped to make the conference a success. Barney & Linda for their hospitality. Our great demonstrators. Tom Graham who always is in a location where he can't see what is being demo'd as he is taking your registrations. The ladies that got all that good food on the table for you and then cleaning up afterwards. Mike Linn for taking the time to cook the Baron of Beef. Jeff Holtby for coordinating everything. Bill Carroll for contributing a QUIET forge. Everyone that helped set up Friday morning. Tacoma Steel's Jack Ozolin for donating steel. The people that donated items to the auction. All of you for doing a great job of policing up after yourselves. If I've forgotten anyone it is not intentional. Thank you everyone. This is sounding like the Oscars where the winner starts thanking everyone they have ever known in their entire lifetime, so I may as well thank my bird Bert for not being mad at me for neglecting him. I saw so

little of him that he had started flying into the bathroom to take a shower with me in the morning - he missed me that much.

Plans are already underway for the Spring Conference in Port Townsend. With the line-up that is slated, it will be a "must attend" event.

David Stearns, you won free tickets to the Fall Conference for the article you submitted. I hope you can attend the Spring Conference because your tickets will be held for you at the door. Everyone please keep sending articles, photos, tips, letters, etc. If it gets into my hands, I will print it. It may take time, but you will get published.

Berkley Tack has Lloyd Hedglin's 250# Little Giant going, complete with a new pair of ramp dies. Forged his first Ho-Ram on it suspended from a jib-crane. He really likes the long stroke and good solid blows. He even wore a hard hat as a tribute to Clifton Ralph. (And he says he is a chicken. I doubt it, he's just smart.) He put a guard around the ram and around the flat belt so he can concentrate better when he's not threatened by all that machinery flopping around in front of his nose.

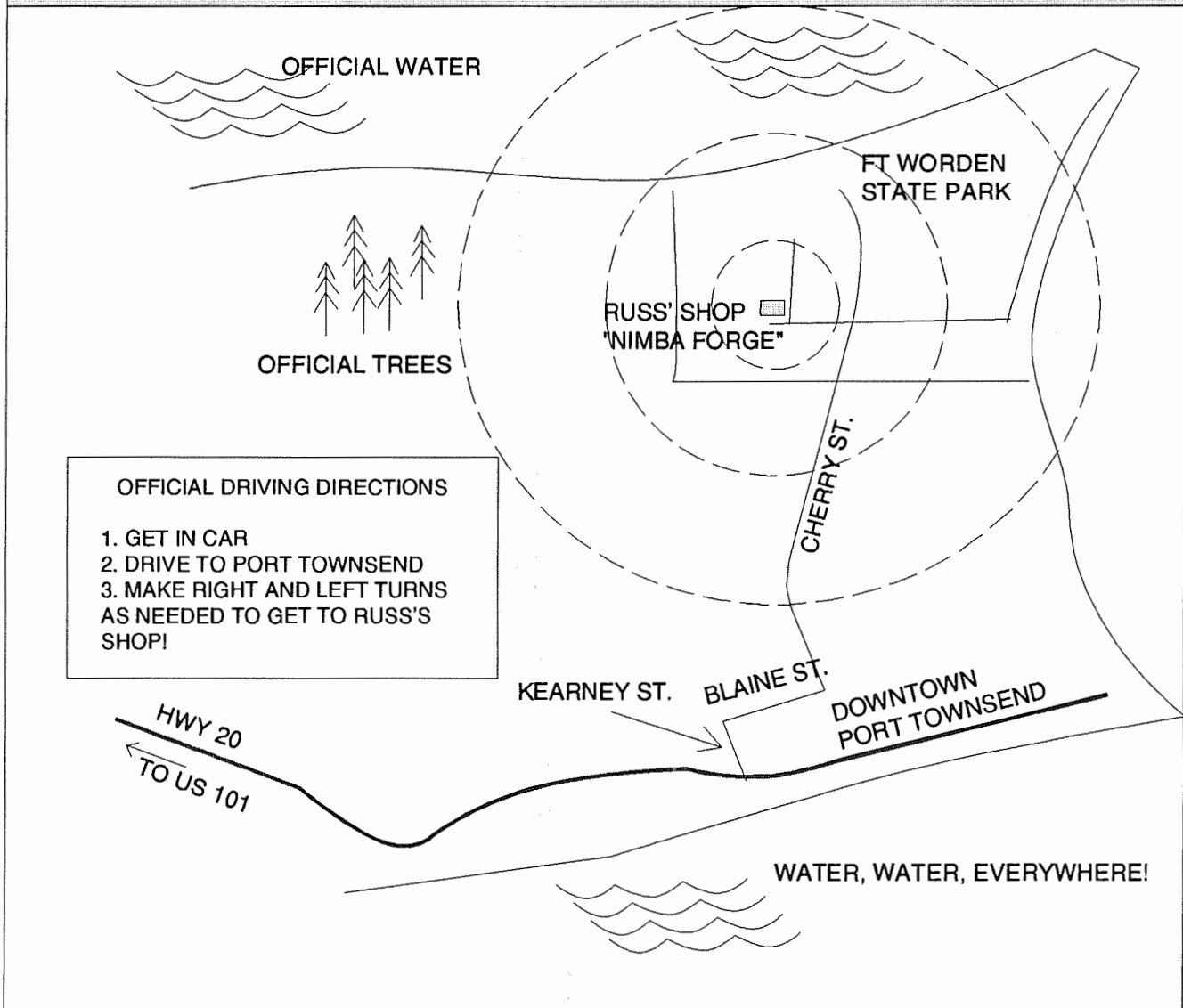
Check the renewal date on your mailing label. If you are getting close to expiring, get it paid so I don't drop you from our mailing list.

Margaret Byers, Editor

From Carol Stull, J.D.'s Forge & Iron, Winthrop, WA:

This amusing but insightful little anecdote was told to me by a young visitor visiting our blacksmith shop. Out of the mouths of babes? "We used to have a blacksmith in our town. But he only made the things he wanted to, so he had to move away and get a real job."

# OFFICIAL SPRING CONFERENCE MAP



## OFFICIAL DRIVING DIRECTIONS

1. GET IN CAR
2. DRIVE TO PORT TOWNSEND
3. MAKE RIGHT AND LEFT TURNS AS NEEDED TO GET TO RUSS'S SHOP!

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