

On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

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Hello old friends and new ones! October has come and gone and the cool air in the evenings is a blessing for sure!

Our Meeting was held at the Lexington County Museum. located near Columbia, This Museum encompasses 7 acres holding some 36 buildings with history dating back to colonial times and into the Civil war eras. I would Highly recommend taking a tour if you're near the area. I want to thank Hayward Haltiwanger for hosting the meeting for us and providing the chicken for our potluck. The Sides and desserts were brought by our great and generous members and were well enjoyed by the attendees!

Rusty was our Demonstrator for the day, and he showed us more of the ABANA Curriculum. He started with a 1-inch square bar of mild steel and forged a Leafing hammer. He then used Cherry Red, to Case harden it and finished it off by donating it to the Iron in The Hat! There is a write-up on this forging in Marc Aspery's books if you'd like more information. Jason Jaco, our future treasurer, assisted by tending the forge.

Also, if you haven't heard Rusty was just installed as a board member to fill a seat vacated in ABANA. We are all proud of his efforts to serve the greater community and I know he'll do well! Let's try to vote for him during the next election! Rusty did a great job and provided a lot of entertainment to the crowd.

Barry and I ran the Iron in the hat Raffle again. I have got to say we did a good job this time! No huge mistakes and hardly any mix-ups! We had a huge number of items that were donated, over 50 pieces! All totaled we raised \$685. This money is extremely important to the Guild, and we would be hard pressed to keep going without it!

In other news, I am just back from our Guild's vise making class hosted at Jason Jaco's TexasStreet-Works, it was a great 4-day class, but we could have used an extra day for sure! This is the first class I've taken that had pre- and post-homework and it was

quite a challenge! Eddie Rainey taught the class, and he was very knowledgeable and attentive. I hope to finish mine next year as the rest of my year is way too busy.

That's all for now, I hope to see you all in December!

Some of you asked about Meck Hartfield. He is still fighting his skin cancer on his face. The doctors keep removing divots trying to get all of the cancer. They are currently working on his nose. Keep him in your prayers.

Also, you may have seen my email about Robert Campbell's equipment. It has been donated to someone Mrs. Campbell was approached by who is going to create a demonstration forge. It is gone. Robert is not doing well. He had a brain bleed (I assume stroke) in March and that is why we didn't see him at the Marcengill's—the meeting he usually attended. Then he had another more serious stroke in June. He and his wife are going to move to their daughter's home in North Carolina. You can also mention Robert when you talk to the Lord.

We have purchased Clay Spencer's *Flat Die Power Hammer Tools* for the Library. Should you want one for your own library, look for his ad on page 10.

Welcome our new members: Michael Vieb; Steve Dowe; Tommy O'Quinn; Peter Turanec; and Jerry Willmore! We are glad you have joined with us!

Get out there and forge something!

Jody!

Iron in the Hat

Item	Donated By	Won By	Item	Donated By	Won By
2 lots 18 ga steel	John Kneece	Todd Elder	Acrylic Pen Blanks	Jody Durham	Gerald Alsbrook
2 lots 18 ga Aluminum	Dylan Kneece	Melissa Cantrell	Lawnmower Blades	Marcy Brown	Melissa Cantrell
4 oieces Mystery Steel	John Kneece	Melissa Cantrell	Horse Shoes	Marcy Brown	Heyward Haltiwanger
5 pieces Mystery Steel	Dylan Kneece	Melissa Cantrell	Tee Shirt	Melissa Hevir	Dave Bush
Bottle Opener	Todd Elder	JD Norris	Tee Shirt	Melissa Hevir	Jamie Herndon
Hook w/leaf	Jim Looper	John Kneece	Sweet Potato Pie	Ian Haltiwanger	Jason Jaco
Troll Cross	Jim Looper	Steve Cantrell	Marking Knife	Ben Secrist	Steve Cantrell
Hook	Jackson Looper	Steve Cantrell	Bar of 1095	Ralph Kessler	John Kneece
Fiddle Head Garden Stake	Jim Looper	Bill Burgess	Springs	Barry Myers	Todd Elder
Fire Poker	Dave Bush	Duke Baxter			Jody Durham
Farrier's rasp hatchet	Dave Bush	Gerald Alsbrook	EZ Weld	Steve Howell	Jody Durham
Mild Steel Drops	Dave Bush	Lucas Norris	Crescent Flux	Steve Howell	Jody Durham
Trivet	John Tanner	Chris Carroll	High Speed Steel Flux	Steve Howell	Jim Looper
2014 Sign Bracket	Guild	Charlie Meyer	Steel and Silver Neck-lase	Thomas Bosse	Steve Cantrelll
2019 Madison Poster	Guild	Jody Durham	Tool and HC Steel	Tait Lawrence	Melissa Cantrell
2023 Madison Poster	Guild	Chris Carroll	Snow Flakes	Tait Lawrence	Jamie Herndon
Ladle	Mark Conrad	Jim Looper	LP Burner	Tait Lawrence	Steve Dowe
Oyster Shucker	Duke Baxter	ML Tanner	Jump Spring Rings	Tait Lawrence	Ray Pearre
Harness Hook	Jesse Barfield	Barry Myers	RR Track	Tait Lawrence	Jarrod Handrop
Tongs	Tony Etheridge	Marcy Brown	RR Track	Tait Lawrence	Ray Pearre
Spring Fuller	Barry Myers	Ralph Kessler	Abrasive Cutoff Saw	Tait Lawrence	Jamie Herndon
Hook	JD Norris	ML Tanner	Hammer	Tait Lawrence	Jamie Herndon
Pecan Brittle	Cheryl Norris	Barry Myers	Hammer	Tait Lawrence	John Kneece
Scrolling Tongs	Jason Jaco	John Tanner	Leaf Hook	Chris Carroll	Steve Cantrell
Hinge Tongs	Jason Jaco	Thomas Bosse	Flower	Jamie Herndon	Jason Jaco
			Drawings	Jamie Herndon	Jason Jaco
			Leafng Hammer	Rusty and Jason	ML Tanner
			Leafing Hammer Kit	Rusty and Jason	John Tanner



Not seeing the type of information you want to see? Let me know.

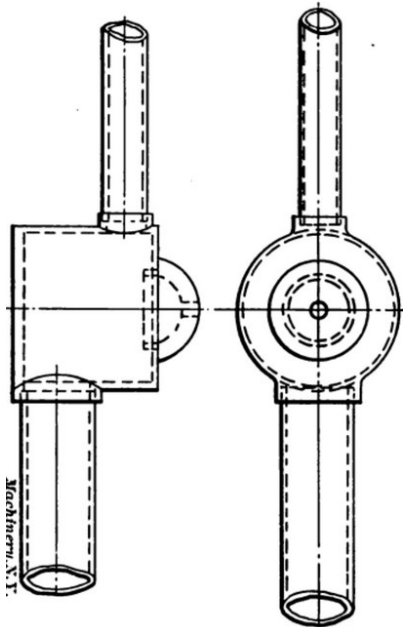
A different spring fuller idea from Jim Carothers

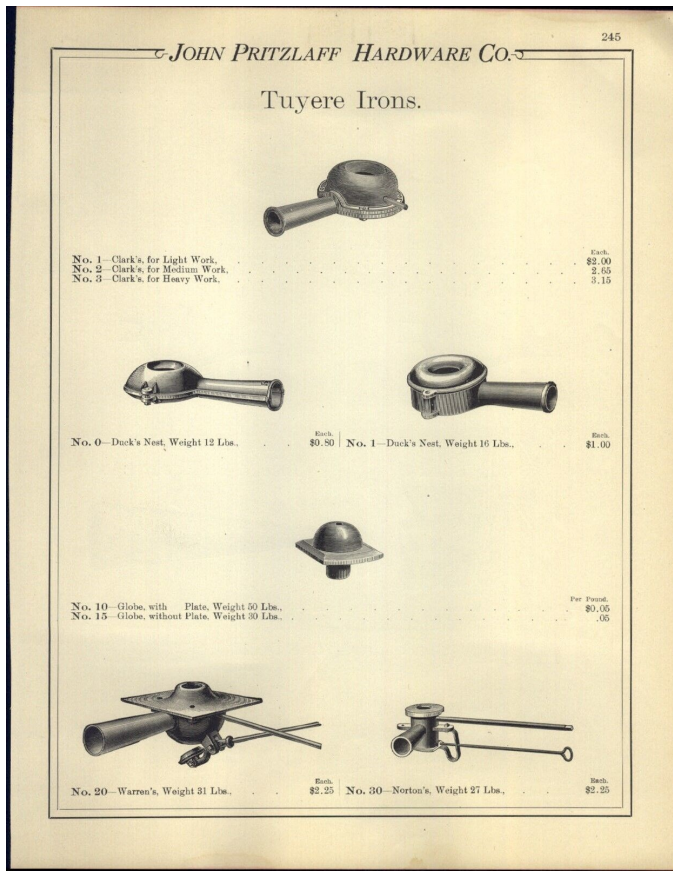


Hemi Forge! It's a hemi!

My old Buffalo forge pot burnt out at the clinker breaker. I was talking to Jim Carothers about other stuff and Jim said he had two cast forge pots! But, he said he had other options in his archive of blacksmith stuff. He said that he used a hemi forge developed by Matt Wills, Augusta, KS, a friend from when he lived "out West" works well for a brake drum forge. Jim says that the clinker forms around the hemi and is easily removed as a crude glass donut when the forge is cleaned. I can't weld, so this is an interesting brake drum forge for those of you who can—or have a friend who can!

Jim thinks the drawing (left) from Machinery Handbook is what inspired Matt's idea for the domed air inlet.



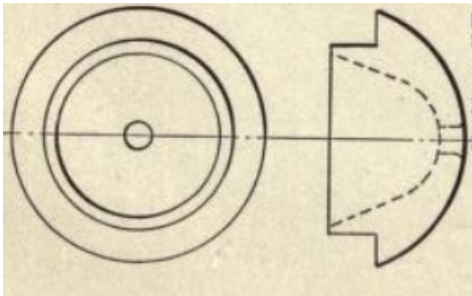
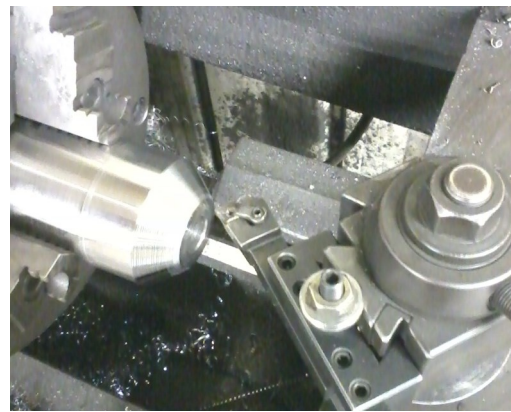


I found this Pritzlaff Hardware Company ad on eBay that shows another possible source of this idea. Matt's hemi was someone else's "dome". And, the domed plate in the one Jim made is much like the plate covering the duck nest tuyere in the lower left of the ad.

Matt gives all credit for inventing the hemi/dome tuyere to James Cran. His work can be found in his 1920s tome, the *Blacksmith Shop Practice*.

Jim machined his hemi from mild steel. Matt said that his friends have been using cast iron mallets or sledge hammers cut in half, then machined into the dome. Matt said that Bob Patrick prefers a slot rather than the hole Cran invented for a wider fire.

Here are some more of Jim and Matt's work to make these replacement parts.



Cran's figure from *Blacksmith Shop Practice*





Snowman Ornament

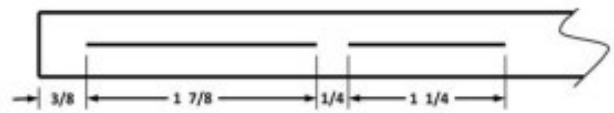
By Steven Spoerre, a MABA member

This snowman consists of two circles, the lower drifted to 1-1/4", and the upper drifted to 7/8".

Calculate the circumference of each circle by multiplying the drift diameter by 3.1416. Calculate the slit lengths by dividing the circumference by 2 and subtracting 1/8" from each. The length of the large slit is 1.84" (just under 1-7/8"), and the length of the small slit is 1.25" (1-1/4").

Divide the width of the stock by 2, to get the space between the slits.

For this snowman lay out the slit lines on both sides of a piece of 3/16 x 1/2 inch flat stock, starting 3/8" from the end.



Use a cold chisel to progressively cut through the two slits from both sides, stopping short of the very ends. When the chisel breaks through, open the slit just enough to get a hacksaw blade through.



Remove most of the chisel "rag" with the saw, and cut to the ends of each slit.

Partially open the slits cold over the hardie hole with a slitting chisel.



Reprinted from the Upsetter, Newsletter of the Michigan Artist Blacksmith Association

Heat the bar and drift the large hole first.



Round up the hole on the anvil's horn, or a cone mandrel. Taking as many heats as necessary.



Open the slit, then heat the bar and drift the second hole. Tweak the area between the two holes so they are aligned above each other.



Again, round up the hole on the anvil's horn, or a cone mandrel.

Flatten the snowman's body. File any sharp edges inside the circles and break any sharp corners around the outside



Grind off the end tab so the bottom circle visually has a consistent wall thickness, then break those corners too.

Cut the snowman from the parent stock, leaving enough to have the impression of a top hat.

Add a circular hat brim that slips down to the top of the head. Cut a 1" diameter circle from 16 gauge sheet metal. Make the centered hole by drilling two 3/16" holes, chiseling out the bridge between them, then filing to fit over the hat shape.



Drill a 1/16" hole in the hat for the thread or hook to go through. As pictured the ornament weighs 1.7 ounces.



Which Fork Do I Use?

Atticus used the fork seen on the left for a number of steps during his demonstration. The benefit of the uneven "tines" is that you can bypass the one tine when wrapping, a great benefit. You can use this fork in an anvil. The fork design below is one we use at Steel Welding. It can be used in a vise. The advantages are it also has uneven "tines" and a loop which keeps metal in place. Good for keeping material from slipping. The third fork, is an adjustable fork. This can be used in a vise for different size material. No matter which fork you use will help you finish your project!

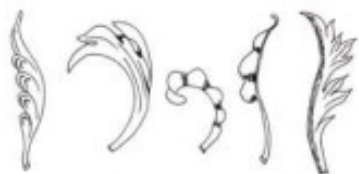


Forks on the left are on separate pieces of angle iron and can be moved closer or farther away from each other to accommodate the project you are working. Make sure the welds are secure and the angle iron is the same. When working with different size material it requires different spacing between the upright posts. You can also place a piece of pipe over the upright to make a larger pin.

Miscellaneous-Assorted Tips from John Steel

1. Plan your work so that you can stamp your name or touchmark on your project before the area becomes inaccessible to get good hit.
2. If you have tight mill scale on hot roll bars, use your torch and turn it up high. The base metal must be cold and run the torch along the metal. The mill scale will "pop" off. Be sure to wear protective goggles etc.
3. Welders chipping hammers make great hand held tools.
4. If you want to simulate a wood grain on a metal sheet- Use a 6" razor wheel and run the razor wheel along the length of the metal. Run parallel lines and carefully leave a space between each run. Do not overlap or cross the "grains". It takes a bit of practice to get the look but can be a very effective technique.
5. No soap stone on you? Use a wet finger to make a mark--on cold steel!
6. If you want to blacken aluminum, purchase Sculpt Nouveau Black Magic. It is a versatile and unique finish for iron, steel, stainless steel, brass, bronze, aluminum or copper. sculptnouveau.com they are located in Escondido, CA 760-432-8242

This article was reprinted from the Pittsburgh Area Artist Blacksmith Association



Water Leaves

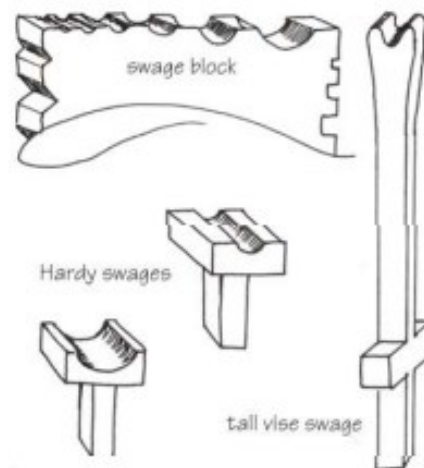
by Eden Sanders, San Andreas, California,
based on photographs taken by John Graham
during Mark Aspery's Weaverville demonstration

CBA Skill Level: II



Water Leaf 1

- rounding hammer
- 2" x 1/8" flat stock
- anvil block
- 1 Use rounding hammer to narrow the base of the leaf.
 - 2 Cut corners to make a point.
 - 3 Use cross peen to thin edges and elongate the leaf.
 - 4 Use a swage and round edge of anvil for rippled edges.
 - 5 Fold and forge weld on four sides.
- Fold and forge weld on three sides.



Leafing hammer and swage at work.

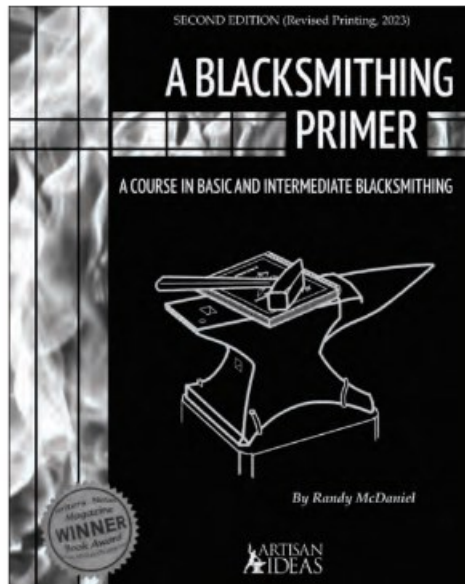


Water Leaf 2

- 1 Round the tip.
- 2 Use cross peen to thin the edges and shape the leaf.
- 3 Flatten out the peen marks with rounding hammer, and scoop the leaf in a 45° swage with a wide cross peen.
- 4 Ripple the edges over rounded edge of anvil and a swage using a leafing hammer.
- 5 Cut bar halfway to fold leaf back over the bar, and forge weld.
- 6 Scarf the end of the weld to suit application.

Scooping the leaf in a 45° swage designed to be used in a vise.





A book review

Randy McDaniel

Artisan North America, Watchung, NJ 07069-6120

www.ArtisanIdeas.com, Tel: 800-843-9567

ISBN 9781737604495

174 pages, Copyright 2023, \$25

If you have been blacksmithing for a while, you are probably familiar with Randy's *A Blacksmith Primer*. I think it is one of the best beginner/intermediate blacksmith book on the shelf.

Randy has updated and corrected any errors that may have been in Model 0, and it is now available in hardcover.

This book tells you the best way to set up your shop for economic operation so that you will be as efficient as possible. It tells you how to make tools from hardies and tongs to reposes' and sculpting chisels.

It gives you real guidance on projects from strap hinges with pintles to wizard and ram heads along with uses for the projects.

I think it is a fine book for any true beginner as well as a reference for most all of us. Enjoy! I think we have a copy in our PSABG Library! Barry

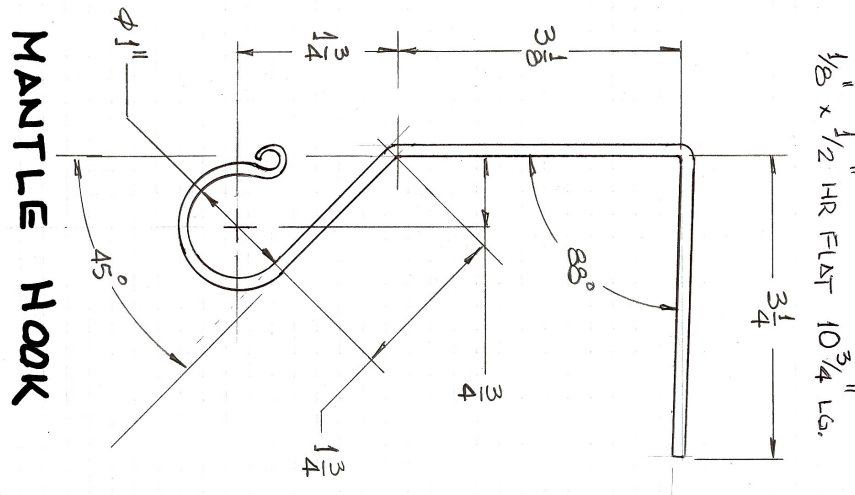
Nonferrous Metals By Carson Sams

While I was at the fair, I had another Smith ask me how do I keep my brass rivets from breaking. I explain to him that I anneal them. He was confused because he was led to believe that all non-ferrous metals were already soft, so how could you make it even softer. I explained by heating up the brass and placing it in water. It would soften it, this lead to more confusion because he was under the impression it would harden it. So as a Smith, I encourage everyone to study as much chemistry, metallurgy, and geometry as you can. I know a lot of it's confusing but stick with it. I thought it was common knowledge on how to make a non-ferrous metal soft. So, here are the very basics,

trying not to get into too much depth about different alloys. To soften copper, brass, bronze and aluminum, you can heat them up and place them in water. This will soften the metal. You may have to do this repetitively pending on your project. And working these metals with a hammer will harden them, the phrase work hardening. You can also heat these metals up and let them cool slowly that will also harden them. This is the complete opposite of a ferrous metal. If you already knew this, my apologies, but I thought it might be worth mentioning to some of our newer Smiths.

Reprinted from *The Virginia Blacksmith*

Here is a mantle hook that I found somewhere (I don't know where). Anyway, it has all the dimensions needed to make a good hook for your kids or grandkids Christmas stockings! Barry



For Sale

Brodbeck 2 by 72 belts available for order through Ben Secrist, see his contact info on the next page.

Todd Elder is offering Beginning Blacksmithing and Knifemaking Classes. Contact him at (864-978-7232)

Guild Coal (in Sumter): 3 buckets, \$30; 6 buckets or 30 gal barrel—\$45.00; 11 buckets - 55 gal barrel - \$ 60.00; 15 buckets - 1/4 ton - \$70.00; 30 buckets - 1/2 ton - \$140.00; 60 buckets - 1 ton - \$280.00. Contact **Walt Beard 803-464-8483 in Sumter.**

Forkruck tine sections for striking anvils. \$30. Jody Durham, 864-985-3919 iron-smith@gmail.com

Clay Spenser's Tire Hammer Plans \$30. clay@tirehammer.com or check/mo to 73 Penniston, AL 35670.

Clay's Book, Flat Die Power Hammer Tools is available from Judd Clem, 111 Yorkshire Drive, Athens, AL 35613, clem.judd@att.net, Master Card, Visa or check,\$30, mailed, \$40 overseas

Upcoming events:

Meeting Schedule:

January Open Forge: January 13. At Tony and Pam Etheridge's forge at 333 Prestige Ct.,Orangeberg. Contact Rusty Osburne, 803-374-7987

February Guild Meeting, L. W. Paul Living History Farm, just north of Conway. February 10. Contact Walter Hill, 843.915.5320

March Open Forge: March 9 and 10 at Jim Pender's forge at 1851 Ribaut Rd, Port Royal, SC 29935 Contact Rusty Osborne,803-374-7987

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Membership Application

___ New Member ___ Renewal

Name: _____ Address: _____

City: _____ State: _____ Zip: _____ Phone: _____

email: _____ Sponsor _____

Dues are \$15.00 per person/family, per year. **Make checks out to PSABG** Please remit to:

C. Ray Pearre, Jr., 4605 Durant Ave., North Charleston, SC 29405

ACKNOWLEDGEMENT AND ASSUMPTION OF RISK

I acknowledge that blacksmithing and related activities are inherently dangerous and involve risks and dangers to participants and spectators that may result in serious injury or death. I have considered these risks and I knowingly assume them. I agree that I am responsible for my own safety during Guild events, including wearing appropriate clothing and protective gear and remaining a safe distance from all dangerous activities. I agree to hold Philip Simmons Artist Blacksmith Guild and guest demonstrators of our craft harmless from liability and expenses arising from of my actions and/or omissions.

When was the last time you paid dues?

There is a note below your address on the last page of our newsletters. It will say something like...

"Dues Last Paid 2022, Dues for 2023 are Due, or Dues Paid for 2023"

This note is usually updated for each newsletter. We appreciate your prompt payments.



Something for the Gamecock fans from Erik Clausen of the California Blacksmith Assoc

December Guild Meeting College of the Building Arts 12/9

134 Columbus St., Charleston, SC

Contact Ray Pearre 843-860-0532

Demo beginning at 10AM

The shop is located on the back of the building,
The entry door and parking is off Line Street.

Bring your own chair,

Maybe a side, dessert, or drinks and forge
something nice for the iron-in-the-hat YOU
might want to win!