



On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

<http://philipsimmonsartistblacksmithguild.com>

President's Letter

March 2014



We had a great gathering of the Guild at the L. W. Paul Living History farm this weekend in Conway, SC, our meetings are the only place I know of you can laugh, meet new friends, see old friends, learn something about blacksmithing, win something useful for a dollar and eat good food till you're about to pop. Thanks to the staff of the farm for hosting the meeting, cooking up a good low country purlieu for lunch and to Walter Hill for the excellent demonstration that he performed. Walter repurposed two old tools, a worn out file and a brick mason's hammer into an inshave (something between a draw knife and a scorp) and a small carpenter's adz. These tools were orders from his customers, something I need to learn how to do, make money from scrap steel. Walter has always impressed me as a demonstrator, he describes in

detail what he is doing while he is working and tells you where the metal is going before he hits it. He also educated us by introducing a new word. You know how rough and pitted a burnt piece of steel can get? This is called "crustified." Now, you know too!

This event was also busy with elections - we elected two Board Members a Vice President and a President. They are as follows;

Board Members

Mike DuBois and Jason Jaco

Vice President

Meck Hartfield

President

Jesse Barfield

Meck decided to step down as President and made himself available for the Vice President position. He has done a very good job these past two years and will continue to serve us well as VP and Librarian, if you weren't there Saturday please give him your thanks when you see him. I would like to thank you for placing your trust in me to lead the Guild this year as your President. The Board Members and myself will need your support and ideas to keep us successful and to continue improving and growing. Our Iron in the Hat was smashing success we took in \$955.00, that's almost an entire scholarship for one aspiring blacksmith.

We had one new member since the last newsletter, he is Tommy Taylor. Welcome, Tommy.

The April meeting is at Magnolia Gardens on April 26. Ed Berry will be showing what he learned from his scholarship to Campbell on woodworking tools. Bill and Lynda Creek and Ray Pearre will be our hosts. Come to Charleston and enjoy the day.

Thanks; Jesse

Iron in the Hat

Item	Donated By	Won By	Item	Donated By	Won By
Carlton Simmons Demo Piece	Carlton Simmons	Layne Law	Chainsaw Damascus Knife	Jerry Fowler	Hunter Smith
Horseshoe Oyster Knife	Ray Pearre	Jamie Stevens	Wooden Mallet	Bob Hill	Bruce McWhirter
Cable Damascus Knife	Meck Hartfield	Hunter Smith			
Scarf and Dish Cloth	Patricia Hartfield	John Loftin	Router Mat	Jesse Barfield	Barry Myers
Poker	Mike Tucker	Johnny Marks	Horse shoes, complete with nails	Jason Jaco	Travis Polhemus
Ginko Leaf Bottle Opener	Mike Tucker	John Tanner	Twisted Hook	Jason Jaco	Chris Herron
Damacus Knife	Mike Tucker	John Tanner	Split Cross	Duke Baxter	Don Loftin
Anvils Ring Magazines	ABANA	Charles Meyer	Popular Science Oldies	Al Jenkins	Robert Hill V
Beeswax Candles	Anne Suggs	Ray Pearre	Anvils Ring Magazines and Apron Bag	Al Jenkins	Paul Alford
Buckwheat Bread	Anne Suggs	Barry Bazen	Oyster Knife	Barclay McCurdy	Barry Bazen
Philip Simmons Door Knocker	Anne Suggs	LaDonna Burgess			
Ladle	Barry Myers	Jesse Barfield	Iron Basket	Joe Marsh	Travis Ferrel
Dutch Hammer	Bruce McWhirter	Hunter Smith	Cement Truck Spring Sections	Charlie Wells	Barclay McCurdy
Steak Turner	Tony Etheridge	Travis Ferrel	Cement Truck Spring Sections	Charlie Wells	Barry Myers (twice)
Oil Recycling Pan	Peter Mueller	Matt Burgess	Cement Truck Spring Sections	Charlie Wells	Chris Herron
Forged Flint Striker/Fire Kit	Bill Creek	Hunter Smith	Cement Truck Spring Sections	Charlie Wells	LaDonna Burgess
Candy	Sharon Hill	LaDonna Burgess	Cement Truck Spring Sections	Charlie Wells	Bob Hill
ABANA Tee Shirt	ABANA	Bill Creek	Cement Truck Spring Sections	Charlie Wells	Chuck Smith (twice)
ABANA Tee Shirt	ABANA	Anne Suggs	Heart and Scarab Jewelry	Jamie Stevens	Al Jenkins
EZ Weld/Borax	Keith Moon	Layne Law	Heart and Scarab Jewelry	Jamie Stevens	Sharon Hill
Sawblades in Metal Box	Joe Holladay	Josh Weston	Grapefruits and Tiger Paw Cutout	Jamie Stevens	Don Loftin
Tongs Kit	Phil Rosche	Hunter Smith			
Pick Up Tongs	Phil Rosche	Bill Creek			
Knife Kit	Phil Rosche	John Tanner			
Bucket of Sewell Coal	Layne Law	Sharon Hill			

Clay Spencer's Joinery Class

A few months ago I was picked to receive Clay's scholarship for his Traditional Joinery Class at the John C. Campbell Folk School. In this class you can submit your own project or build the table that he has designed for the class. You can see more information on the class at folkschool.org.

Clay is highly respected in the world of blacksmithing and I was excited to go to the class. Below are some explanations of some of the things I learned from Clay. I strongly recommend taking a class from him or watching him demonstrate.

Drawings: Design is your first step. Always have a detailed drawing 1:1 scale is best, or at least a well thought out plan of what you want to make. Transferring the drawing to a metal plate or concrete floor allows checking the work against the plan without burning the drawing.

Collars: Collars should be made to scale for the project to look right. Thinner stock 1/8" thick or so works much better for collars. I spent 2 hours trying to make them with 1/4" stock before Clay mentioned 1/8" would be easier.

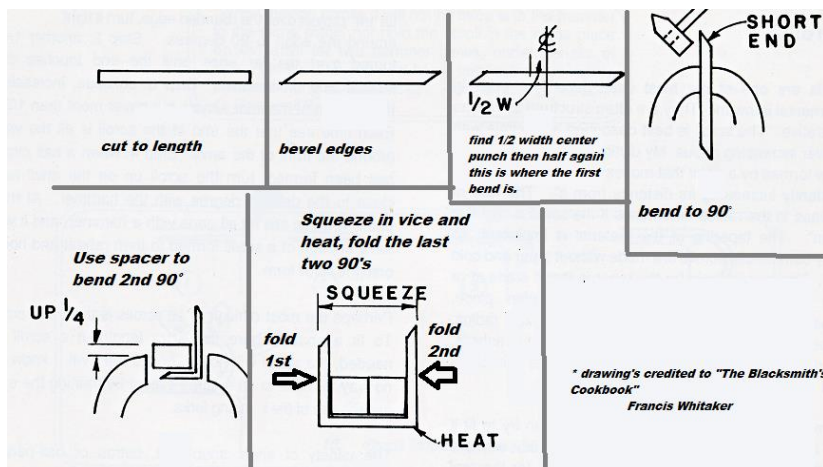
Tapered round stock wrapped as if a vine is a traditional collar which complements organic designs.

Collars should be the length of the perimeter of the pieces you're joining plus 2.5 times the thickness of the collar.

For example, joining 1" square to 1/4" x 1" bar you add the widths together like so:

1" (bottom) + 1 1/4" (side1) + 1" (top) + 1 1/4" (side2) + 2.5x(x is the collar stock thickness). In this example "x" is 1/8" or .125". So the length of the collar is 4.5" + (2.5*.125) or 5/16 which totals 4 13/16".

That's a lot of math!!! I just wrap a string around the pieces to collar with the amount of overlap I want and just measure that. Do a test piece and adjust from there. Not sure if it's the correct way but it's worked for me before. After you cut the collar you will need to bevel the ends to overlap. Collars are hard to learn but once you get the hang of them they go quickly. Below is a picture explaining the collaring process:



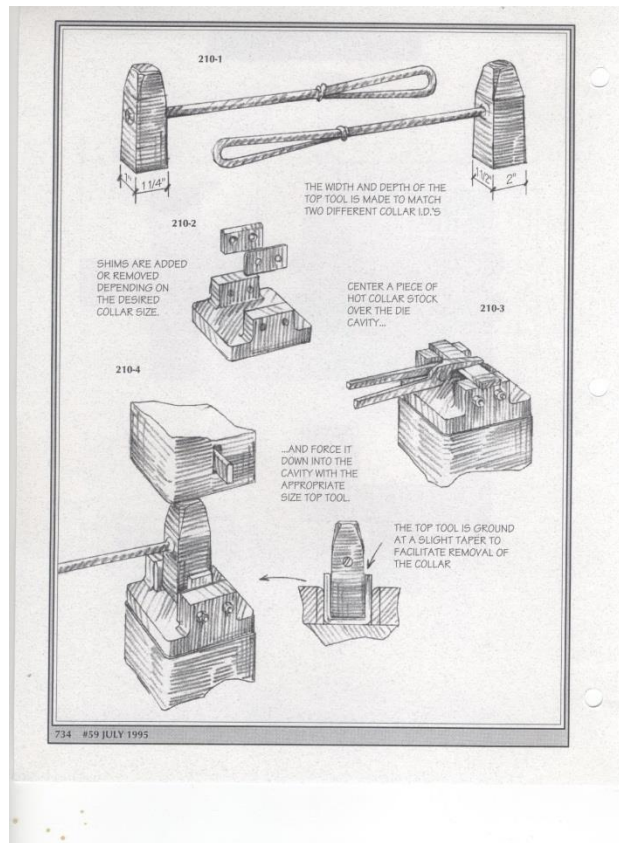
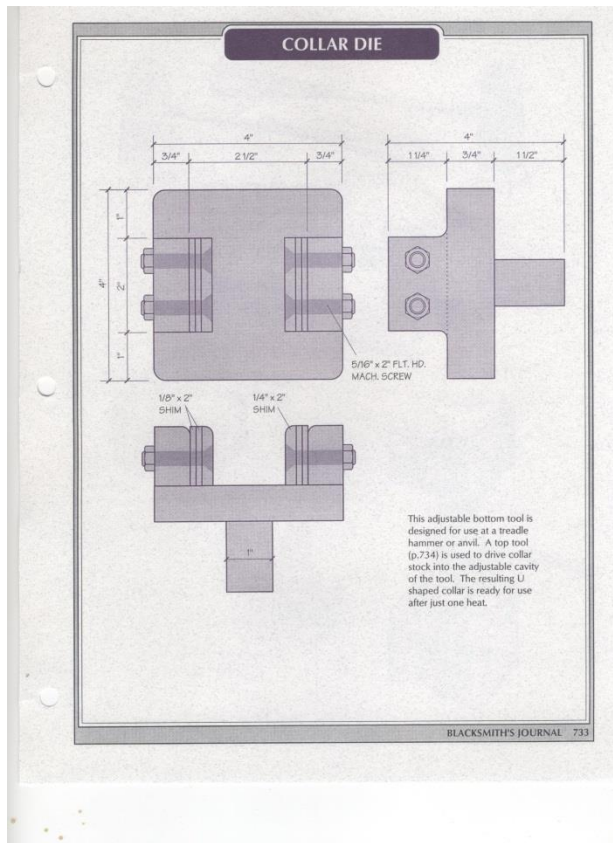
I'd like to thank Clay for choosing me for the Francis Whitaker Scholarship, I learned a lot from the class and look forward to passing on more of what I learned.

Jody Durham

This issue of the newsletter has tended to be mostly with traditional joinery after the Sheldon Browder Class at Ladson and Jody's article from his class. We had a good time with the class. Shel made us make the scrolls by hand and eye, they were hard, so I included the Scroll-o-matic article.

We had a hammer-in at the Living History Park in North Augusta and one of the things I demonstrated was a bolt tong. I found a better way that I hope will correct any errors I may have made in my teaching. Hope you enjoy the articles I have included. Barry

Another Collar bit of information... The two pictures below are Ray Pearre's collar jig. The collar die in the drawings are those from the Blacksmith's Journal.



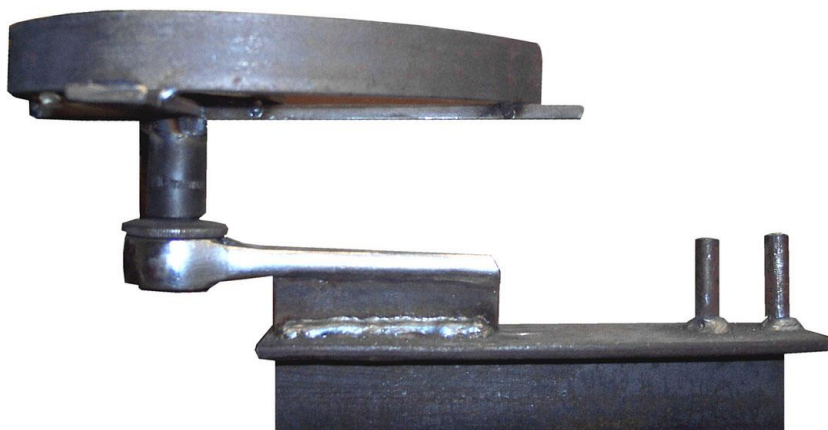
SCROLL-O-MATIC



Michael Sobrado of Dragonforge Ironworks sent this idea to the Blacksmith Journal, Issue 213. These are pictures of Micheal's Scroll-OMatic with one of the 50 or so jigs that I have here for it. My first shop was pretty small and I got tired of knocking things over every time I tried to scroll up some bar or make rings.

I took a 1/2" garage sale Craftsman ratchet and welded it to a piece of angle iron. Put it in the vice, weld a cheap socket to the bottom of your scrolling jig. Draw out the end of your bar as desired and roll up the end around 180 degrees. Vice grip to the scroll jig and pull, push on the bar to back the jig up on the ratchet, repeat until you run out of heated stock.

It works on hot or cold steel. If I make large scrolls I do the first 12" of bar hot to get the taper and the tight scroll in the middle and do the rest cold.





Kneeling: Mike DuBois, Jody Durham, Shel Browder, Tony Etheridge, Steve Alverson.

Standing: Bob Stukes, Charles Meyer, Al Jenkins, John Tanner, Hunter Smith, Barry Myers, Ric Thompson, Ed Sylvester, Peter Mueller, Ed Berry, Jesse Barfield, Bill Creek, and Ray Pearre.

We had a fine class with Shel Browder. The weather could have been better, but it got a lot worse the next week.

Shel's project was a triangular sign holder (shown on the front page and Shel's notes on collars on the website). The horizontal item was a $\frac{3}{4}$ square stock. We welded a collar about $\frac{1}{2}$ " from the end to better support the member. We then made a tenon from the $\frac{1}{2}$ " past the collar. On the other end, leaving a cube of metal on the anvil, draw down the metal with half on/half off blows. This is drawn down to $\frac{1}{8} \times \frac{3}{4}$, and scrolled up.

Finials were formed on the upright, a bean on the top and a spade on the bottom.

The hypotenuse was punched 3" from each end with the end then scrolled. Rivets were handmade from $\frac{3}{8}$ " square stock leaving a nice square head on the rivets.

The hand-formed center "S" scroll was somewhat problematic for some of us. Shel was kind in his comments of encouragement. The encouragement was needed and well recieved...

Hand-forged tenons on the sign hangers, also forged from $\frac{3}{8}$ " square, were riveted into the collars and fitted to the horizontal after very similar loops were forged on each. A good tip from Shel was to punch the holes completely from the inside to give a tapered hole for the riveted head.

The assembly of all the units resulted in the fine looking sign hangers by those able to finish. Some of the hangers had to be finished at home, but all were happy with what they learned, if not how far they progressed. A good time was had by most! Barry

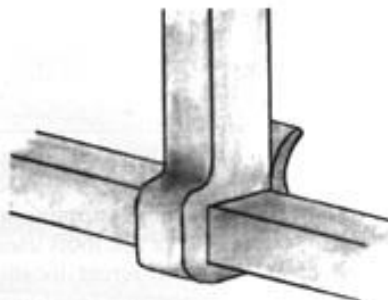
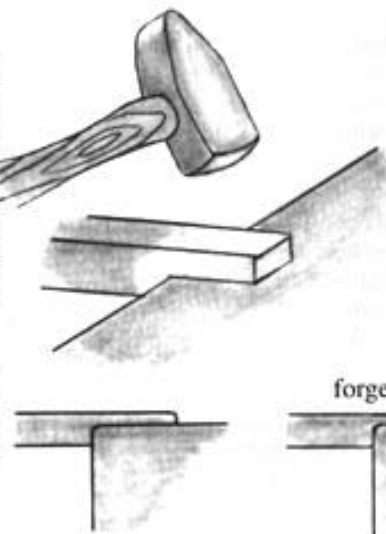
Joinery

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www.traditionalmetalsmith.com

Stock: 1/2" X 1/2" mild steel.

Take a heat on the end of the bar. Set it onto the anvil as shown so that about 3/4" protrudes onto the surface. Holding down hard, drive the stock down, with the hammer face over anvil and space so that a shoulder is established. The edge of the anvil should be some-what sharp where you chose to do this effect.

The shoulder should be about 3/8" deep. Draw out the off-set stock in a long taper. Maintain the 1/2" width of the parent bar as the taper is forged.

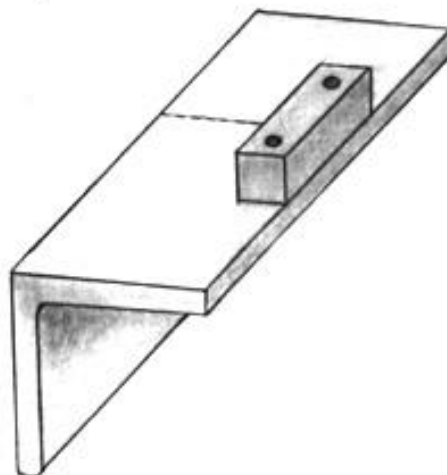


Once the taper is complete, forge a right angle bend as shown.

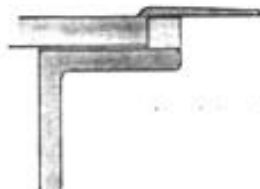
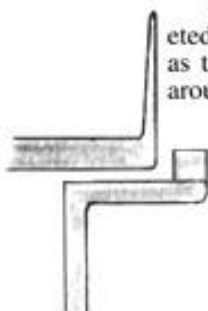
The jig shown makes the next bends far easier and if there are more than a few to do, more similar in result.

Use a piece of 2"x 2" or 3"x 3" angle iron. The opposite leg from the surface the jig occupies will set into a vise for clamping during use. Cut a 2" long piece of bar stock the size that is to be wrapped by the taper. in this example that is 1/2" square bar. Drill the bar as shown. Use that drilled bar as the template to drill the angle iron. Once both are drilled as shown, use two rivets, 3/16" diameter, and seat the bar on the angle iron. Scribe a line into the face of the angle iron at a right angle from the riveted bar to serve as a visual guide for orienting the tapered bars as they are bent.

Clamp the riveted jig in the vise. Take a heat on the tapered end of the 1/2" bar, set the shoulder against the riveted bar, taper up and aligned by the scribe mark. Hold down hard and hammer the two bends as shown.



The resulting cupped recess will now take a bar the size of the one chosen for the riveted bar in the jig. Take a heat on the recessed end of the tapered bar, set such bar stock as the effect calls for into the recess and forge the remaining taper over, thus closing around (wrapping) that bar firmly.



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Bolt Tongs

As the name implies, these tongs are good for holding items such as bolts where the head prevents you from holding the very end. They are also used for holding squares, rounds and some thin flat sections. Square nose tongs like those shown on p. 36 give you a better grip on rounds and squares.

17-1



DRAW OUT ONE END
AS SHOWN.

17-2



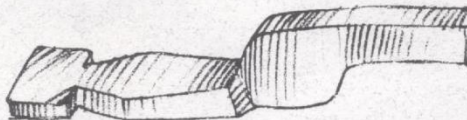
FORM FIRST SHOULDER.

17-3



FORM SECOND SHOULDER.

17-4

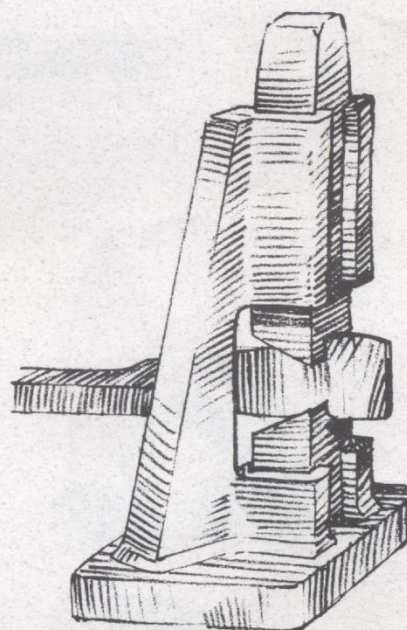
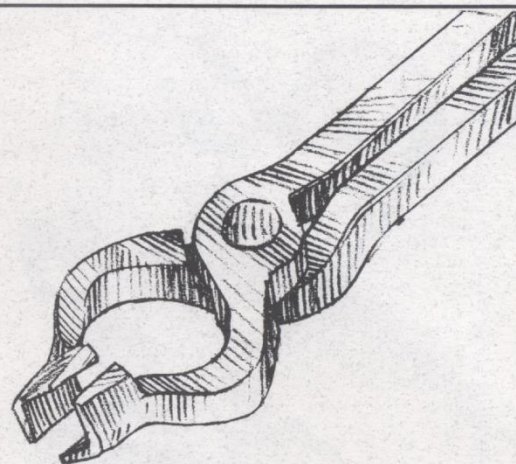


FORM SHOULDERS AT THE
END OF THE JAW.

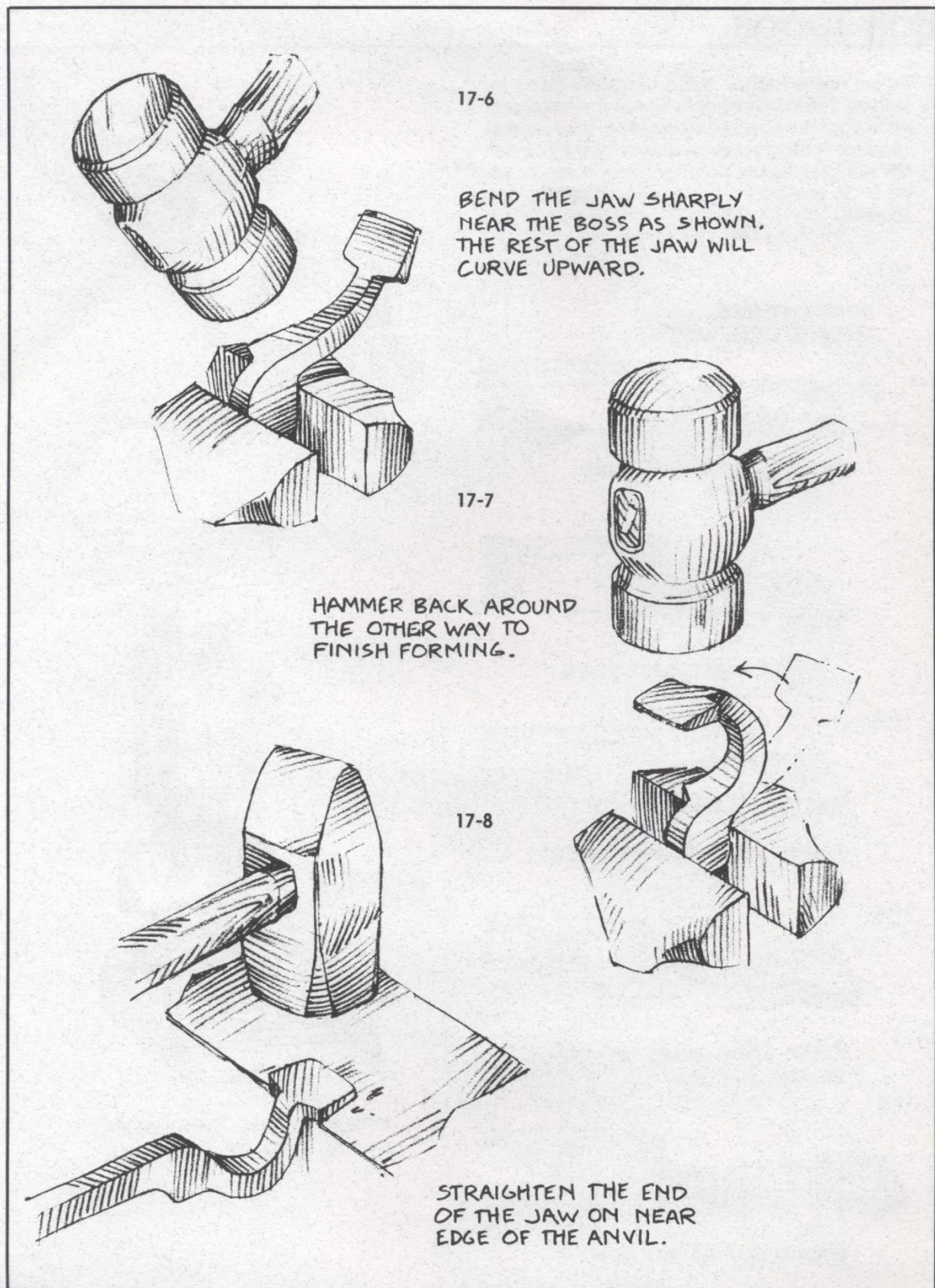
17-5

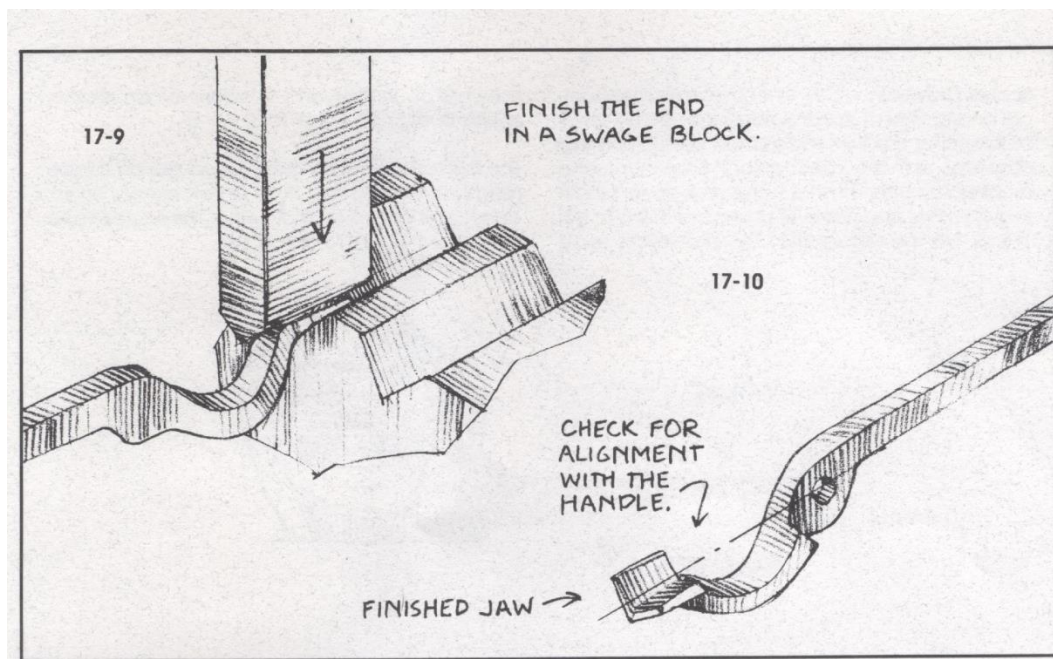


DRAW OUT AS SHOWN.



FORGING THE SHOULDERS
AT THE END OF THE JAW.





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For Sale:

- **Fire Bricks – Brand New, Industrial Grade. \$1 ea. Ed Sylvester 803.414.2487.** These same bricks were as much as \$8 at Madison!
- **Hosfield Bender**, with extension bender and 20 attachments on a nice stand \$900.00. **Sewell coal** for sale. 135# for \$50, Layne Law 843-333-9964
- **Blacksmith Classes:** John Boyd Smith is offering an instructional blacksmithing program at his smithy near Spartanburg. John is internationally known for his realism in forged steel. Call 912-655-9448, email flemingsmith@aol.com, or website JohnBoydSmith.com.
- **Big Chuck o' Iron.** 8"x8"x56" 900+ lbs. mass for anvil, treadle hammer, or tire hammer. \$350 Jeff Hatfield 864-216-3707
- **BigBlu Power Hammer** Big Blu Power Hammer, \$3500 (does not include a/c to operate it. Dan Tull, clear over in Newnan, Ga. 770-253-8396
- **Tire Hammer Plans:** Send check/money order for \$30 to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Includes postage to US and Canadian addresses. Other countries e-mail clay@tirehammer.com for price. 256-558-3658. Tire Hammers for sale contact me for current price. Also, **Beverly Shear Blades Sharpened**, \$41 includes return shipping in US. Remove blades and ship to address above. Extra cost for deep nicks or blades sharpened at wrong angles.
- **Coal:** Grace Fuel Co 1490 Merrimon Ave Asheville, NC 28814, 828-252-6401 or 828-252-2436

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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. 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 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 – 2012” or “Dues for 2013 are due”

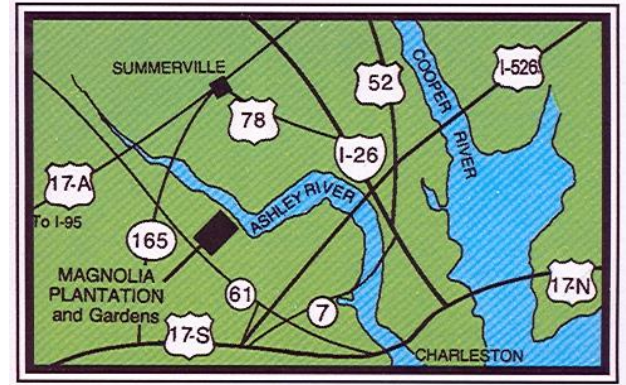
This note is updated for each newsletter. We appreciate your prompt payments.

Come to Magnolia Gardens

April 26, 10 AM!

Bill and Lynda Creek and Ray Pearre are our hosts. Bring a side, drinks or dessert and something nice - maybe something you have forged, for iron in the hat. Ed Berry will demo some of what he learned at John C Campbell about woodworking tools.

Sale of your blacksmith-made items to the public is welcomed! Magnolia Gardens also welcomes your forged items to be sold on consignment in their gift shop.



June Meeting: Westminster at the Marcegill's, Date to be determined.

August Meeting: Historic Camden, Date to be determined

October Meeting: Jeff Hatfield's in Spartanburg, Date to be determined