



# On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

<http://philipsimmonsartistblacksmithguild.com>

From the President's Anvil:

January 2014



Our February meeting took place at the L. W. Paul Living History farm in Conway, SC with Walter Hill demonstrating. The Staff at the farm and the Hill Family's dedication to this museum and the events that take place make this a meeting that we look forward to each year. The lunch alone was worth the trip to Conway, a perlo with chicken, sausage and rice, there was no shortage of sides and deserts. Thanks to the Staff, Walter and the rest of the Hill family for a memorable day at the farm. The demonstration produced a heart shaped hook (to commemorate St. Valentine's Day) and striker for fire making from an old worn out file. The striker was made from a design that Bob had seen and described to Walter. He left some of the lines of the file on the finished piece to indicate, to anyone who might want to buy it, that it was made of high carbon steel and not something that wouldn't produce a spark when struck with a flint. Walter is a very skilled blacksmith and an equally skilled storyteller, which makes his demonstrations interesting (that

keeps me from falling asleep).

We held elections at this meeting replacing two board members, Bill Creek and Mike Du Bois that were due to rotate off. Please thank them for their service as board members and for all that they continue to do for the Guild. Meck Hartfield, Ray Pearre and I ran unopposed and barely pulled out a win. We will continue as Vice President / Librarian Secretary Treasurer, and President,

We had three candidates for the Board: John Tanner, Ryan Calloway and Josh Weston, with only one vote separating each of the three. Close one! John Tanner and Ryan Calloway are our new Board members. Don't worry Josh, we have plans for you in the future.

The new members since the last newsletter are; Pete Bell, Kevin Cook, Gerald Atkinson, Chris and Turner Hammett, Steve Forbes (not that one), and Jill Leber. Welcome!

Attendance was over 50, Iron in The Hat was the biggest I have seen; \$1026.00!

April will see us at Magnolia Gardens! Josh Weston will be our demonstrator. The day before the April Meeting, Bill Creek and Ray will sponsor a Hammer-in. No specific agenda, so bring a project and your hammer. We will have 8 forges. If you are new to blacksmithing, come on!

We will help you get started.

Jesse

No, really, pay your dues!.....

## **Iron in the Hat**

Item	Donated By	Won By
Wire Brush	Bob Hill	Chris Herron
Wire Brush	Bob Hill	Layne Law
Hammer Head	Bill Burgess	Kevin Cook
Tape	Bill Burgess	Bruce Hester
Chocolates from Asheville	Anne Suggs	John Tanner
Cards	Anne Suggs	Gerald Alsbrook
Traveler	Anne Suggs	Richard Eason
Chainsaw Damascus Knife	Meck Hartfield	Chuck Smith
Handmade Dishcloth	Patricia Hartfield	Keith Gunter
Fire Poker (tool)	Jason Jaco	Layne Law
Fire Poker (tool)	Jason Jaco	Caleb Battle
Foxfire 2	Jesse Barfield	Meck Hartfield
Tools	Jesse Barfield	Bruce Hester
O1 and 4140	Jesse Barfield	Tony Etheridge
RR Spikes	Tommy Taylor	Harry Wiggins
RR Spikes	Tommy Taylor	Andrew Smith
RR Spikes	Tommy Taylor	Layne Law
RR Clips	Tommy Taylor	John Tanner
RR Clips	Tommy Taylor	Ed Berry
RR Clips	Tommy Taylor	Harry Wiggins
L6 Band Saw material	Tommy Taylor	Rick Thompson
L6 Band Saw material	Tommy Taylor	Harry Wiggins
L6 Band Saw material	Tommy Taylor	Chuck Baldwin
L6 Band Saw material	Tommy Taylor	Bill Burgess (twice)
Making Nails Book	Joe Holladay	Jesse Barfield
Making Nails Book	Joe Holladay	Charles Meyer
Making Nails Book	Joe Holladay	Sharon Hill
Making Nails Book	Joe Holladay	Johnny Marks
Making Nails Book	Joe Holladay	Meck Hartfield
Making Nails Book	Joe Holladay	Rick Thompson
6 RR Spikes	Walt Beard	Charles Meyer

Item	Donated By	Won By
Leaf Handle Rake	Glenn Owen	Jamie Stevens
Figure 8 Rake	Glenn Owen	Gerald Alsbrook
Daffy Dill	Layne Law	Jamie Stevens
Turkey Call Kit	Joe Marsh	Bob Hill
Cross Necklace	Keith Gunter	Harry Wiggins
Spikes and Finials	Jimmy Stone	Harry Wiggins
Anvil Tool	John Tanner	Jamie Stevens
Dinner Bell	John Tanner	Ed Sylvester
Knife	Chuck Baldwin	Hunter Smith
Ceramic Cup	Andrew Smith	Keith Gunter
Wiskey Jug	Andrew Smith	Charles Meyer
Cross	Charles Meyer	Pete Bell
Lyle Winn Elephant Bottle Opener ***	Bill Creek	Gerald Alsbrook
Chipping Hammer	Pete Bell	Hunter Smith
Hammock Swing	Carol Bernard	Gerald Alsbrook
Grill Fork	Peter Mueller	Darold Charpia
Muscadine Wine	Karen Wiggins	Jamie Stevens
Aloe Vera Plant	Mary Hill Long	Jamie Stevens
Heart Dinner Bell	Gerald Alsbrook	Anne Suggs
Peach Jam	Sharon Alsbrook	Sharon Hill
Steak Turner	Clyde Umphlet	Walt Beard
Sharon Hill's Body Wash	Sharon Hill	Chris Herron
Clay Goblet	Ed Sylvester	Anne Suggs
Scroll Candle Holder	Ed Sylvester	Charlie Wells
Sword	Ed Sylvester	Charles Meyer
Machete	Ed Sylvester	Curly Lawson
Flower	Jamie Stevens	Pam Etheridge
Copper Pendent	Jamie Stevens	Jason Jaco
Copper Earrings	Jamie Stevens	Chris Herron
Heart Necklace 925 GP	Jamie Stevens	Peter Mueller
Heart Hook Demo Piece	Walter Hill	Jesse Barfield
Flint Striker	Walter Hill	Jesse Barfield

\*\*\* The elephant bottle opener Bill Creek made is an idea shown in the last newsletter from Lyle Winn. I had forgotten where I had found this wonderful idea. Barry

## **Not seeing the content you want?**

Submit requests for the kind of info and articles you are interested in, or better yet,  
Submit an article yourself.

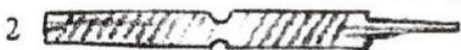
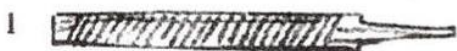
No, really, pay your dues!.....

Walter Hill demonstrated one of these a few years ago at the February meeting. It is a cute little knife, and if you are real good, you can leave the spine of the knife hard for a flint strike. Don't try that on you first attempt.

## Patch Knife

Franklyn Garland  
The Hammer's Blow, Winter 1993-94

This knife is made out of an old file --recycled. Some folks forge the blade first, then the handle. I find the shorter, smaller, forged handle easier to hold for forging the blade. But sometimes, depending on the maker, it's easier to forge the blade with the handle half finished. Complete the handle when the blade is finished.



6 Forge the point.



7 - Curve into cutting edge.



8 - Pack (thin out) edge. Blade will straighten, and also widen, as edge is forged.

9 - Anneal entire piece in wood ashes, lime, or sand. After annealing, clean up the profile and grind the cutting edge. DO NOT grind cutting edge any thinner than approx 1 mm.

**HEAT TREAT:** For best durability, heat treat as follows.

Using acetylene torch, "paint" the cutting edge with flame until non-magnetic. Note: magnet will not stick -- it's a full orange color.

Quench in light oil.

Clean off all excess oil and temper in a household oven at 450 degrees for 30 minutes.

Grind and hone to final edge. A wire brush finish looks good.

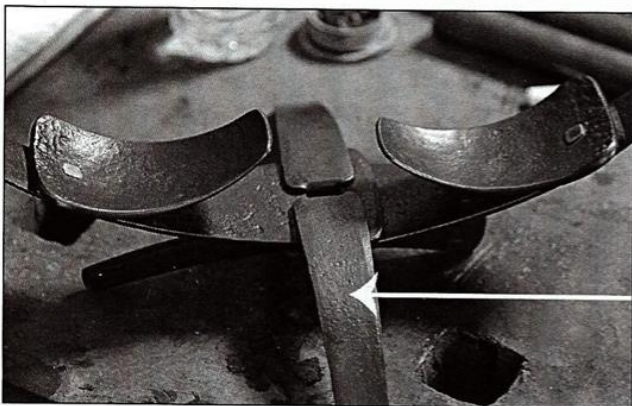


## Folded Eye Tenon Joint

### *A Technique Taught by Daniel Miller*

*story, photos & drawings by Kacy Ganley, Arcata*

*Prior to departing for Southern Illinois University, Kacy received a scholarship from CBA to attend Daniel Miller's workshop in Loomis earlier this year. This article was prepared to fulfill requirements of this scholarship. The work shown in the photographs are demonstration pieces made by Daniel.*



My introduction to Daniel Miller's work was at the 2011 Oktoberfest. I was immediately captivated by his complex and refined joinery and, in particular, the line quality of his work. These characteristics bring a new dimension to what, in his own terms, "is easier than it looks." Daniel's work is intriguing to say the least. He often highlights joinery as an artistic composition, more than just a purely functional means of attaching elements.

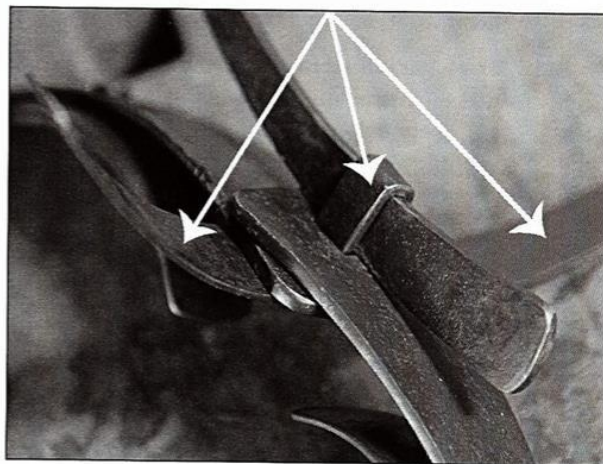
Daniel's workshop at John McLellan's shop this past June covered a few different versions of joinery to practice. There was also the opportunity to gain experience with the fly press. Here, I will be focusing on the folded eye tenon joint that was utilized on the candle holder we made at the demonstration. The joint is fairly easy to accomplish, and Daniel uses it frequently in his work. Rather than slot punching a hole in a tenon to accept a wedge pin, an element is formed and folded to become the tenon and friction catch for the pin.

1. The first step in this particular element is the forming of what will be the tenon and primary legs of the candle holder. The piece is cut from  $\frac{3}{16}$ " plate. The plate is 10" long and  $1\frac{1}{4}$ " wide and cut so that there is a 3" long by  $\frac{5}{8}$ " waist in the middle. This will become the loop of the tenon. The legs or wings are  $3\frac{1}{2}$ " long and taper from the waist to tip. The end of the taper is  $\frac{3}{4}$ " wide and starts  $\frac{3}{4}$ " away from the waist.



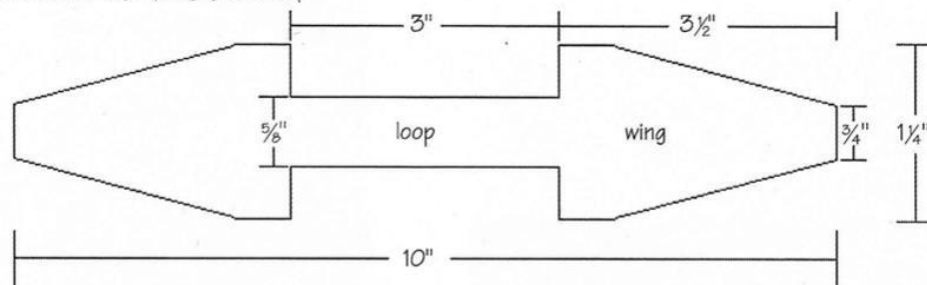
*Daniel Miller*

*This leg and joint are being described.*

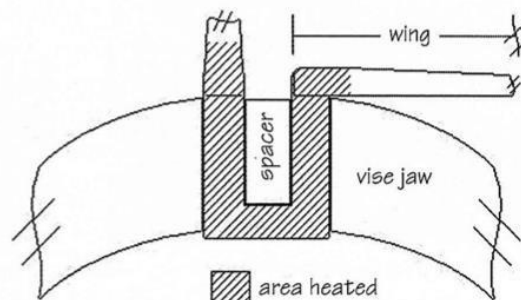
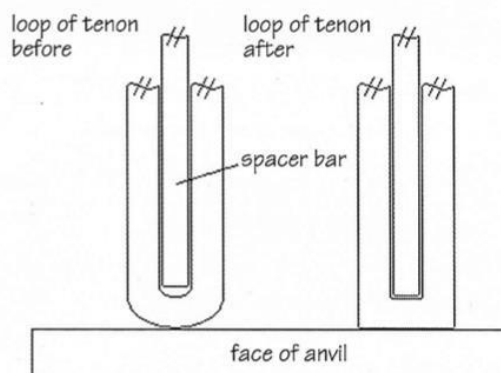


## Folded Eye Tenon Joint

Cutting pattern for legs (wings) and loop



2. After the stock is cut, the wings are drawn out to  $5\frac{1}{2}$ " in length. This should produce a taper in thickness from  $\frac{3}{16}$ " near the waist to  $\frac{1}{16}$ " at the tips. The full thickness of the plate is maintained at the base of the wings where they meet the future joint. The top edges of the wings can also be beveled at this point.
3. Before bending the tenon loop, mark the center of the piece with a punch on what will be the inside of the loop.
4. The wing is then folded in half, taking care that the wings are even, leaving at least a  $\frac{1}{4}$ " space between the halves. If the space is a little over, that is okay. It can be fixed, but if it is too small, it will need to be pried open for the next step.
5. The bottom of the bend is then made square with the aid of a spacer bar. The spacer bar is  $\frac{1}{4}$ " thick by  $1\frac{1}{4}$ " wide and 10" to 12" long. The length is for clearance of the hand from the wings when it is used as a chisel to square the bend on the face of the anvil.
6. The wings are now bent down and perpendicular to the tenon. To keep the loop in the tenon true, the spacer bar is used again, this time on its side. The piece is set in the vise so that the wings are flush on top of the vise jaws. The jaws of the vise must line up properly so that the bend is straight. When heating for the bend, it is best to heat the whole joint from the bottom to about  $\frac{3}{4}$ " up the wings. This is done so that the jaws of the vise won't heat sink too quickly where the wings are to be bent.



## Folded Eye Tenon Joint

7. After the wings are bent, the joint and its transitions to the wings are made true by use of another spacer. The spacer is  $\frac{1}{4}$ " thick by  $\frac{5}{8}$ " wide and  $1\frac{1}{4}$ " long. The base of the joint is heated up into the wings and dropped into a  $\frac{5}{8}$ " square hole. The spacer is then dropped into the gap in the tenon. With everything in place, the transitions are hammered true. At this point, it is fairly easy to add texture to the wings as well.



*The loop should look something like this.*

8. The body of the candle holder consists of two separate additional wings. These are made slightly larger than the wings on the joint, but out of the same thickness plate. Each is punched and drifted with a  $\frac{5}{8}$ " hole to accommodate the tenon, and then drawn out in the same manner as the previous component. The dishes for the candles themselves are made out of much smaller wings that are riveted to the body components.
9. Once the body is punched and drifted, the wedge pin can be made. The pin is made to match the tenon at  $\frac{1}{4}$ " thickness. The pin must taper in such a way as to allow the pin and the legs to sit flush with each other.

This article illustrates the forming of the tenon in the joint and allows for its further use and development. I intentionally did not go into detail on many other aspects and possibilities. ♣



*Kacy (right) and friends at Daniel's workshop.*

Reprinted with permission from the California Blacksmith Association

Daniel Miller was really interesting when we saw him at the ABANA Conference last year in Delaware. His joinery has sparked a lot of smiths to emulate his work. Barry



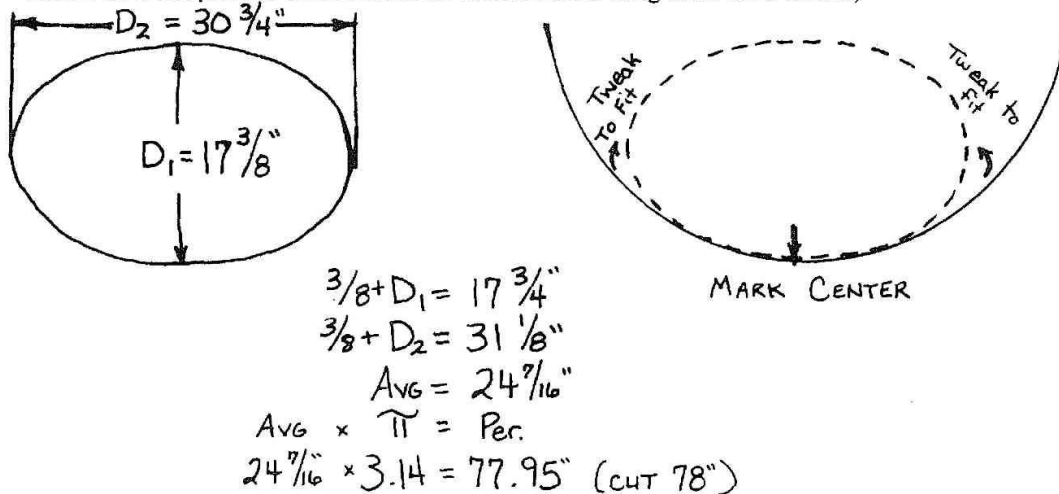


This article is from our own (yeah, we can claim him) Tal Harris and published in the Hot Iron Sparkle in the '90s. This might help you if you have to do any ovals...Barry

## TAL ON OVALS:

Recently an opportunity arose to make an oval to fit an existing wooden sign. This was a good learning experience that may be helpful to others.

First, stock calculation. How much length is needed to make the oval? Below are the dimensions of the piece to be made. Someone told me that you could average the major and minor diameters,  $D_1$ , and  $D_2$ , then multiply by pi ( 3.14 ) and get the perimeter. Being skeptical, I tried this and then measured the full scale drawing with a small traveler and got the same answer within 1/8". To get the centerline dimension of the stock, add 3/8" to  $D_1$  and  $D_2$  ( Because the stock was 3/8" thick and the inside of the oval had to fit the outside of the sign) , find the average, multiply by 3.14 and cut the stock. ( Note: I don't see why this shouldn't work for other ovals, but you may want to do a test piece or double check the measurements using some other means.)



Upset the ends for the weld. ( scarfed on opposite sides )

Now you have a 78" piece to be bent into shape. The stock is thin enough to bend using large bending forks, but it's pretty long to handle alone. While staring at the drawing I had the idea to run this thing through the tire bender to the large radius of the oval. Once this was done a reference mark was made on the stock and the drawing. Now the only major bending was the tighter bends at the ends of the oval with minor adjustments in between. If the piece is tweaked and compared to the drawing as you work towards the ends, the ends will meet when you get back to them. Make sure to keep things level through the bending forks or you will get a spiral

Reprinted from the Hot Iron Sparkle

**“One must not only satisfy the client,  
but one must also satisfy himself”**

Julius Shramm, German Master Blacksmith (1870 – 1945)



NOBODY TELLS THIS TO PEOPLE WHO ARE BEGINNERS  
**I WISH SOMEONE TOLD ME.**  
ALL OF US WHO DO CREATIVE WORK, WE GET INTO IT BECAUSE WE HAVE GOOD TASTE.


---

**BUT THERE IS THIS GAP.**

---

FOR THE FIRST COUPLE YEARS YOU MAKE BUT YOUR TASTE, THE THING THAT GOT YOU  
STUFF, IT'S JUST NOT THAT GOOD. IT'S TRYING INTO THE GAME, IS STILL KILLER. AND YOUR  
TO BE GOOD, IT HAS POTENTIAL, BUT IT'S NOT. TASTE IS WHY YOUR WORK DISAPPOINTS YOU.

**A LOT OF PEOPLE NEVER GET PAST THIS PHASE, THEY QUIT.**  
MOST PEOPLE I KNOW WHO DO INTERESTING, CREATIVE WORK WENT THROUGH YEARS OF THIS.  
WE KNOW OUR WORK DOESN'T HAVE THIS SPECIAL THING THAT WE WANT IT TO HAVE.

**WE ALL GO THROUGH THIS.** 

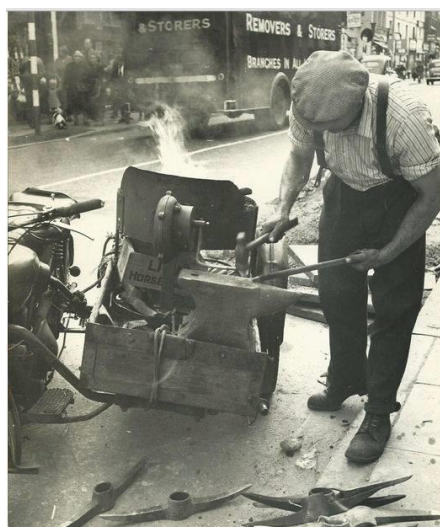
AND IF YOU ARE JUST STARTING OUT OR YOU ARE STILL IN THIS PHASE, YOU  
GOTTA KNOW ITS NORMAL AND THE MOST IMPORTANT THING YOU CAN DO IS

**DO A LOT OF WORK** PUT YOURSELF ON A DEADLINE SO THAT  
EVERY WEEK YOU WILL FINISH ONE STORY.

IT IS ONLY BY GOING THROUGH A VOLUME OF WORK THAT YOU WILL CLOSE THAT GAP  
*AND YOUR WORK WILL BE AS GOOD AS YOUR AMBITIONS*  
AND I TOOK LONGER TO FIGURE OUT HOW TO DO THIS THAN ANYONE I'VE EVER MET.  
IT'S GONNA TAKE AWHILE. **IT'S NORMAL TO TAKE AWHILE.**

**YOU'VE JUST GOTTA FIGHT YOUR WAY THROUGH.**

Saw both of these on the internet. Good advice and an idea for a portable forge!



No, really, pay your dues!.....

## For Sale:

- **Fire Bricks – Brand New, Industrial Grade. \$1 ea. Ed Sylvester 803.414.2487**
- **Hosfield Bender**, with extension bender and 20 attachments on a nice stand \$900.00. **Sewell coal** for sale. 135# for \$45, Layne Law 843-333-9964
- 185 Joy Air Compressor, Diesel, John Deere, \$3000. 185 Sullivan Diesel, 2 for \$5000. Two Milwaukee portabands, \$100 ea. Lincoln flux core Pro-Welder Mig w/2 extra rolls of wire, \$275. Steam Cleaner – Steam Jenny Model 200 Plus 115 Volts, Diesel Fuel, \$200. Trailer, 20' bed, 3' tongue, 2 axles, needs wheels, \$250. 2000 Conquest, Gulfstream 30' Camper, Complete, 4 new tires, \$5800. Trailer for backhoe, 13' Bed, 2' Dovetail, 4'6" tongue, No Ramps, 3 axles, \$500. 1997 Ford Super Duty – Rolling Chassis (only), New tires on Front, Rear very good, \$1000. Wilton 6" Bench Vise, \$100 obo. Motorcycle Trailer for dirt bikes, \$250. Welding Machine Trailer, needs tires, \$200 obo. Motorcycle jack stand, needs finished, \$100. Emglo Shop Air Compressor, 5 hp, 230v, \$500. Contractor's toolbox, 48"x60"x30" w/locks, \$600 obo. Hypertherm Plasma Cutter, Max 42 w/20' torch, \$800 Charles Meyer, 843-729-5861
- **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.
- **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.
- **25# Little Giant Power Hammer.** Everything works, No cracks. \$2600. Barry Myers



## Upcoming Events

- Ryan Callaway is offering Saturday workshop Introductory Welding and blacksmithing class at Creative Iron Works at 12 Andrews in Greenville S.C. April 18th and 25th, May 23rd and 30th
- April 10th and 11th South Carolina State Museum
- Contemporary Longrifle Show and Sale <http://scmuseum.org/events/> Free admission with Bob Hill and Barry Myers demonstrating/talking on gun/tomahawk topics.
- April Guild meeting on Saturday, April 18<sup>th</sup>.
- Fire on The Mountain April, 25, Spruce Pines, NC
- May 8th -10th Artisphere, Downtown Greenville, S.C. <http://www.artisphere.us/>
- May 14th -17th Southern Blacksmith Conference, Madison, Ga. <http://www.sbaconference.com/>

### Note that the SBA Conference continues through Sunday

- June meeting, The Marcengill's June 13th
- August meeting, August 8th. The Camden Meeting will be a class with Shel Browder August 7th and 9th, with the Shel demonstrating at the Guild meeting on the 8th.
- October is At Tommy Taylors Shop with Chris Herron demonstrating, Johnsonville.
- December Meeting, December 12th at John and ML Tanners home in Swansea.

## Philip Simmons Artist Blacksmith Guild

<http://philipsimmonsartistblacksmithguild.com/>

### President

**Jesse Barfield**

2423 Stribling Circle, Lancaster, SC29720

803-287-0929

Jesse.Barfield@duke-energy.com

### Vice President and Librarian

**Meck Hartfield**

623 Poston Rd., Johnsonville, SC29555

843-625-9118

thartfield@me.com

### Secretary/Treasurer

**Ray Pearre**

4605 Durant Ave.,

N. Charleston, SC29405

843-860-0532/pearrecr@att.net

### Newsletter Editor

**Barry Myers**

1847 Pisgah Rd, N. Augusta, SC29841

803-640-5504/ blmyers647@gmail.com

### Webmistress

**Jamie Stevens**

414 Henry Stabler Rd, Swansea, SC 29160

803-665-7083 stevensjamie22@yahoo.com

### Board Members

**John Tanner**

208 Copeland Rd., Swansea, SC 29160

803-568-5534

blacksmith@comporium.net

**Ryan Calloway**

12 Andrews St. Greenville, SC 29601

864-386-5546

Ryan@creativeironworks.net

**Jason Jaco**

29 Woodbine Ct

Columbia, SC 29212

803-799-1865/texasstreet@hotmail

**Jody Durham**

767 Lynnhaven Dr., Seneca, SC29678

864-985-3919 ironsmith@gmail.com

## 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 – 2014” or “Dues for 2015 are due”**

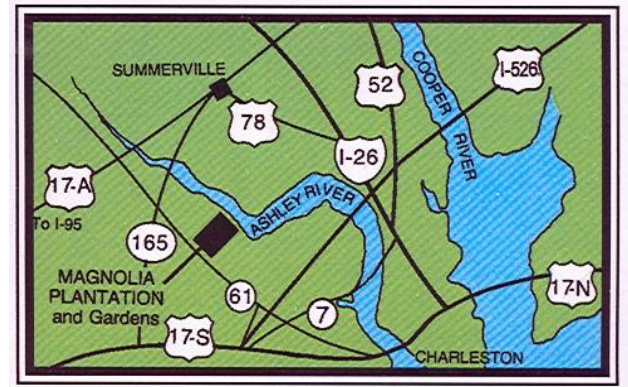
**This note is updated for each newsletter. We appreciate your prompt payments.**

No, really, pay your dues!.....

## **Come to Magnolia Gardens April 18, 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. Josh Weston will be demonstrating axe making! Should be interesting...

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.



**Look at your mailing address below. It tells when  
you last paid your dues.**