PHILIP SIMMONS ARTIST BLACKSMITH GUILD
On the Anvil NEWSLETTER

INSIDE THIS ISSUE

Ellen Durkan at the class with Rick Thompson's 3D printed anvil and stump sculpture

Hello fellow smiths!

It's the first day of Septe*mbe*r as I am writing this, and I am really excited to see the weather and change of the season coming! Our last meeting was held at the historic Revolutionary War site in Camden, and it was the best weather we've had in recent memory there! We had no deaths due to excessive sweat! The site has seen a lot of growth in the past several years. I for one am amazed at the new buildings that have been erected. It is well worth a trip to go and check it out, even if you do not have a fondness for history as I do.

Ray Pearre, our dedicated treasurer/secretary hosted the meeting, did a great job wrangling and getting us going. I was remiss in not thanking him for the hard work he put in hosting the meeting, , It's getting really hard to find enough chicken these days to feed all of us!) so I want to mention it here. You're the man! Jack Hurley did our demo along with help from Rick Thompson. Their young apprentice, Cody Viola also pitched in here and there and operated the bellows as well. Jack demoed a Rams Head on the end of a decorative handle that can be forge welded onto a tool with some traditional ornamental elements added. He finished the piece, and it was added to the iron-in -the-hat. I must say he did an amazing job showing the process and techniques involved. Most of the things I make involve an animal head here and there, so I recognize the quality of work! Great Job all around.

Our Iron in the hat brought in $935. It always impresses me how generous our membership is with its raffles. Two people -Thomas Bosse, Christopher Carroll, joined the Guild at the meeting, Stephen Orman joined by mail and old member Mike Radcliffe returned! Welcome!

We had what I think is a record attendance of 74 people including passers by that stopped to see what we were up to. Jason, Pam and Tony also brought their projects from their class with Ellen Durken. I think we are going in the right direction with the classes being taught in the state. Finally, I'd like to say that this is your guild. If you'd like to see something or have an idea that might help the guild or its membership, please send me or any of the other board members an email or call them! That's all for now,

Barry put the dates for the SBA Conference on page 10. Put them into you planner and plan to make the trek to Madison. It is a great Conference and a great buy for what is offered. The cancelled ABANA conference in Texas this year would have cost an ABANA member $265. Madison costs you $60 for your family!

Forge on!

Jody

Iron in the Hat

Item	Donated By	Won By
3D printed anvil	Rick Thompson	Jake Jacobson
4140 Hot Cut	Todd Elder	Rob Zoken
Micarta Handle Scales	Ben Secrist	Meck Hartfield
Sugar Skull	Jody Durham	Valerie Barrineau
400 Blower Housing	Rusty Osborne	Joe Marsh
Victor Torch Tips	Micheal Merikan	Bruce Hester
2 Sheathed Knives	Joe Holladay	Paul Ingram
Cable Damascus Knife	Mech Hartfield	John Tanner Rob Zoken
Spring	Jake Jacobsen	Mark Ramey
Peach Butter	Jake Jacobsen	Mech Hartfield
Punch/Drift DVD	Mark Ramey	Jake Jacobsen
Trigger Lock	Mark Ramey	Bob Kaltenbach
Monkey Tool Set	Heyward Haltiwanger	Jake Jacobsen
Bucket o' Coal	Paul Gazda	Chuck Baldwin
Damascus Bracelet	Pat Walters	Chuck Baldwin
550 Cord/Z Pack	Chance Sanders	Chris Herron
Ram's Head demo	Jack Hurley	Chris Herron

Item	Donated By	Won By
Peaches	Charles Still	Tony Etheridge
Fredrick's Cross	Charles Still	Barry Myers
Steak Turner	Tony Etheridge	Paul Gazda
Dogwood Stool	Jo Marsh	Russell Wilson
Wood Mallet	Jo Marsh	Rob Zoken
Leather Pouch	Ken Cartwright	Kevin Cook
2x72 Belt	Ken Cartwright	John Tanner
Oyster Knife	Keith Gunter	Russell Wilson
Squirrel Cooker	Keith Gunter	Mark Ramey
RR Spike Dagger	Keith Gunter	Mark Ramey
Ellen Durkan Hook	Jason Jaco	Barry Myers
Sawblade	Thomas Bosse	Keith Gunter
Belt Hatchet	Barry Myers	John Tanner
Spatula	Dave Bush	Valerie Barrineau
Leaf Spring	Dave Bush	Chuck Baldwin
Wrought iron stock	Dave Bush	Thomas Bosse
Tea Towels	Kevin/Susan Cook	Rob Zoken
Leaf Spring	JD Norris	Mark Ramey
Steak Turner	John Tanner	Mike Ratcliff
Candle Holders	Gerald Alsbrook	Jesse Barfield

Jack Hurley, resident blacksmith at Historic Camden with Chris Herron's ram's head trophy! Jack has worked in blacksmithing for a while. He was on the Metals Museum Board of Directors in Memphis for 13 years while a professor of history at the University of Memphis. Demonstrated at the Jackhammer Forge four days a week at the Bradford Farm Bradford Farm near Charlotte.

I saw a news story this week about a kid doing a lab experiment. A bottle of alcohol spilled on his shirt and he was by a Bunsen burner. It lit him up. He was wearing a synthetic material shirt. Burned badly over his torso.

Please **never wear synthetics around the forge** and back up any and all people watching you forge - especially if they are wearing synthetics.

Barry

Photos from the Ellen Durken Class in July. Photos supplied by Rusty Osborne.

Journeyman's Notebook

By David Sandlin

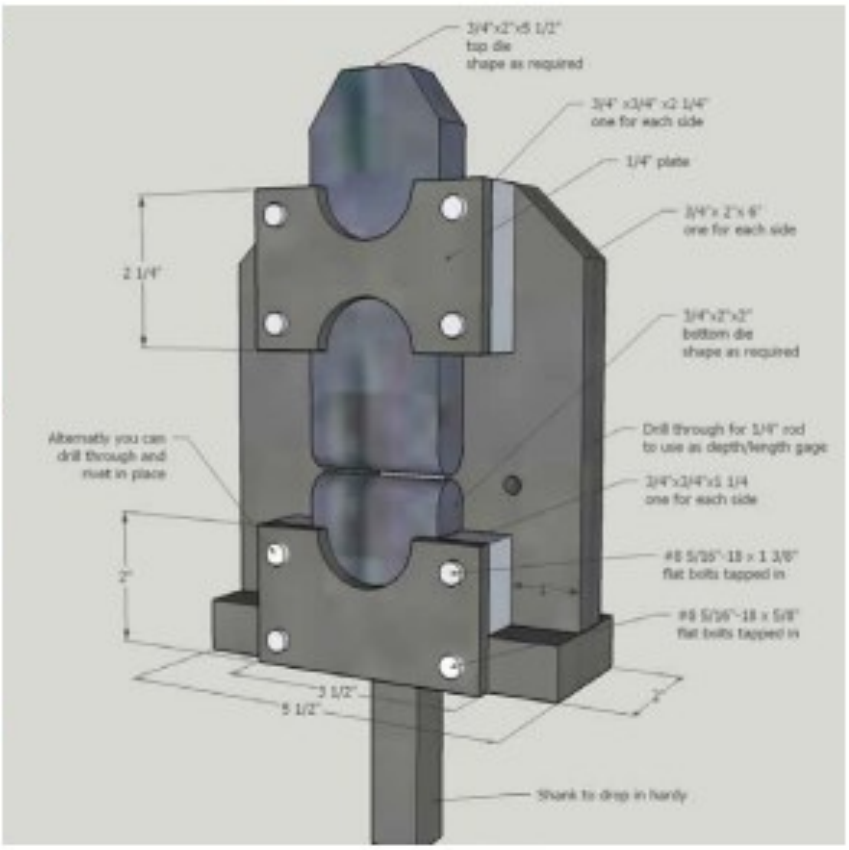
This article re-printed from the January 2022 edition of Clinker Breaker, the newsletter of the Florida Artist Blacksmith Association

I hear and I forget. I see and I remember. I do and I understand. — Confucius

Guillotine tools are great things to have in the shop, especially for the smith who has to work alone. For those of you who've never seen one, a guillotine tool is simply a frame that holds a bar of tooling that slides up and down. Jerry Hoffman's Smithing Magician is a good example. But at $150 for the frame and another $70-$90 per set of dies, buying one is a bit pricy [see Smithing Magician (blacksmithsupply.com)].

Of course you can make one, and there are several plans on the Internet.

For example, I drew this in sketch up (right). However the level of complexity and the time required for the build might put you off. Perhaps welding and rivets are better than bolts?



Bill Epps offers a variation on the guillotine tool that is much simpler to build. It can be made from regular old mild steel, but that would not last as long as a good lawn mower blade or leaf spring.

If you do use mild steel be sure your work is at least red HOT and then keep a spray bottle of water handy to spritz the tool between uses.

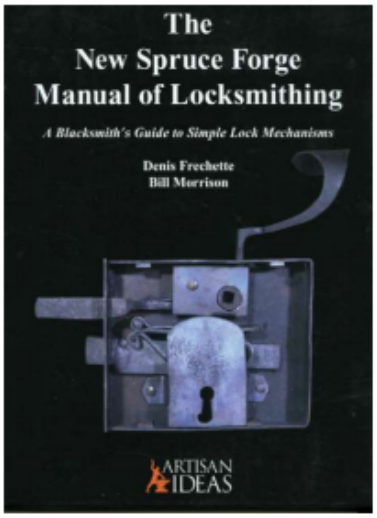
Below are two variations of the Bill Epps Style guillotine tool. Having the top bar a bit long (bottom left picture) allows you to lift the top with your hammer as you put the work in with the other hand.

Some of these words do not copy well. If you can't read them, go to our website to see the original.

I reviewed this book a couple of issues ago and sort of “short shrifted” it. My write-up was woefully inadequate for as much as I thought of the work. Bill Ganoe of the Arizona Artist Blacksmith Association did a much better job in the *Anvil’s Horn*. The copy Artisan Ideas sent me is now in the library. Barry

The New Spruce Forge Manual of Locksmithing: A Blacksmith's Guide to Simple Lock Mechanisms

by **Denis Frechette and Bill Morrison**
Reviewed by Bill Ganoe



While locksmithing isn't a great interest for many blacksmiths, studying the design and building techniques of locks, especially of fairly simple historical locks, can provide valuable insights and shop tips that can be useful in almost any blacksmithing - or even bladesmithing - project.

This book is a great place to start studying lock design and construction. The authors created the original, paperback book, ***The Spruce Forge Manual Of Locksmithing*** in 1999. It was a paperback edition of 118 pages that included patterns and techniques to build five simple, "blacksmith made" locks based on antique originals. The authors hoped this would "introduce the smith to the range of possibilities that can be found using the simplest of tools."

The New Spruce Forge Manual of Locksmithing is a revised and expanded version of the original edition. It is a hardcover book of 304 pages with more than 800 color photos and drawings. The new edition is based on the five types of locks covered in the original edition, because the authors felt they provided the best examples of basic locking mechanisms. In addition to expanded and revised patterns and techniques for building those basic lock mechanisms, the authors added examples "to show how a standard lock mechanism can be adapted to build other types of locks."

The manual is divided into two sections:

In the the first section, **Technical Information,** the authors cover basic concepts and techniques, many of which should already be familiar to the average blacksmith. But any of the illustrations provide slight variations on the photos included in most blacksmithing textbooks such as Mark Aspery's ***The Skills of a Blacksmith*** series. Some of these variations might help improve your understanding of those basic techniques. Among things that might not be familiar to many blacksmiths are a detailed section on forge brazing, a section on benchwork that includes the use of basic chisels and advanced filing. Other sections cover working with sheet metal, creating full scale patterns from a set of plans, and specialized tools that are used for building the locks described in the second section.

The second section, **The Locks: Patterns & Instructions**, provides patterns and detailed step-by-step instructions for 14 different locks. This section shows when and how to used the tools and techniques described in the first section.

The New Spruce Forge Manual of Locksmithing: A Blacksmith's Guide to Simple Lock Mechanisms is a goldmine of information about lock mechanisms and it would be a "must-have" book for anyone interested in basic locks. It would also be useful to blacksmiths who focus on other aspects of the smithing craft.

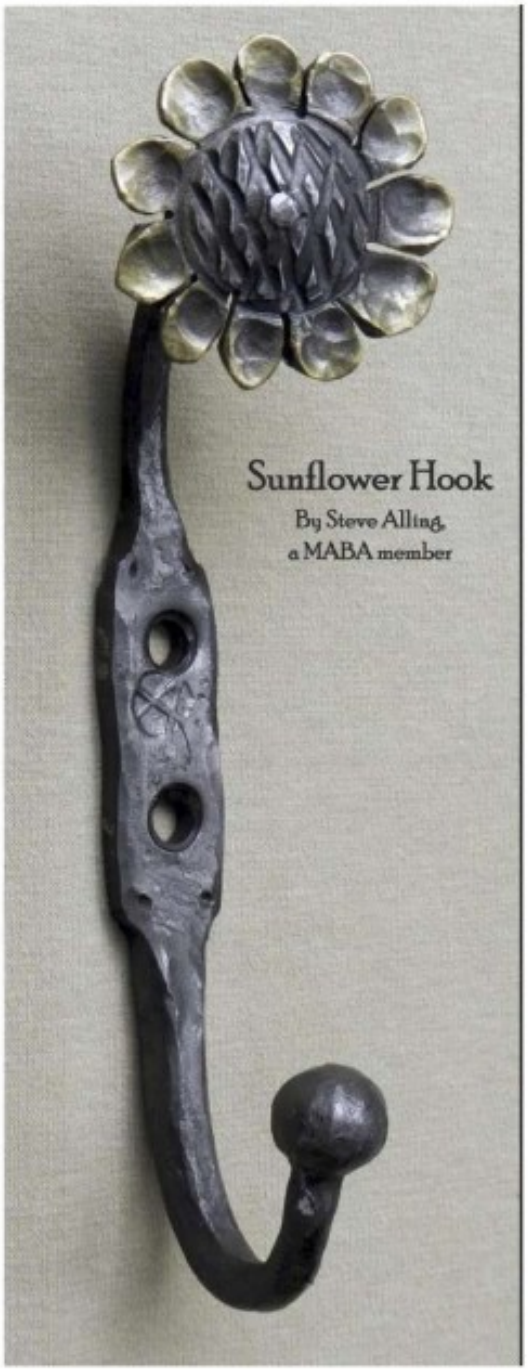
Hardcover, 304 pages, more than 800 color photographs and illustrations. Published 2022.

ISBN: 978-1-7333-250-0-4

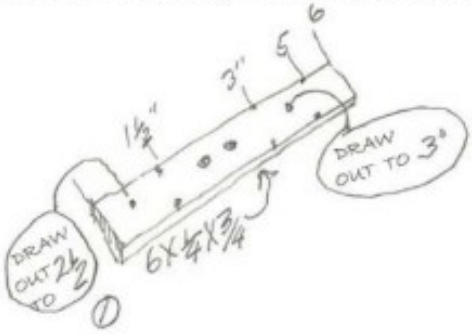
Available from Artisan Ideas, ***www.artisanideas.com***
$44.95

Project - Sunflower Hook

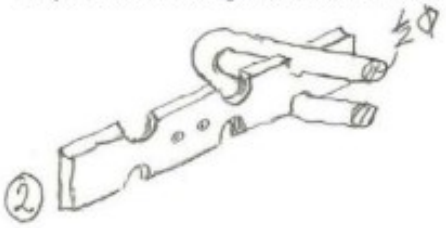
Originally published by Michigan Artist Blacksmith Association July-Aug 2019



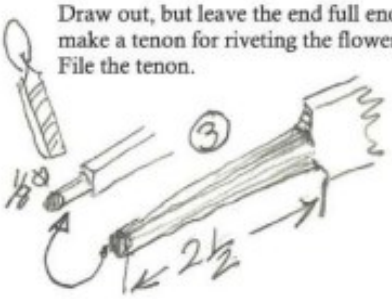
Mark stock out, this may be used as the backside.



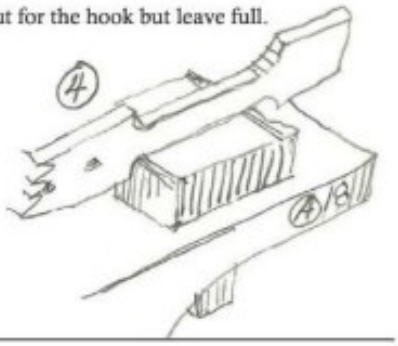
Put your three fullerings in, I used a ½ inch fuller.



Draw out, but leave the end full enough to make a tenon for riveting the flower. File the tenon.



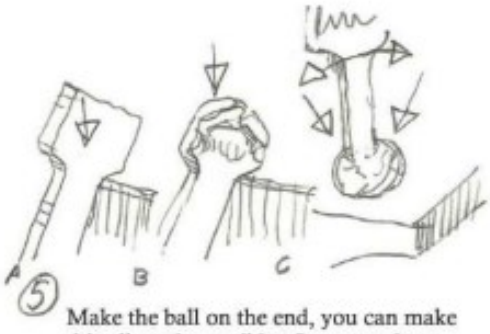
Draw out for the hook but leave full.



THE UPSETTER NEWSLETTER OF THE MICHIGAN ARTIST BLACKSMITH ASSOCIATION JULY-AUG 2019
This article is reprinted courtesy of the Michigan Artist Blacksmith Association "The Upsetter" newsletter July-August 2019.

Project - Sunflower Hook

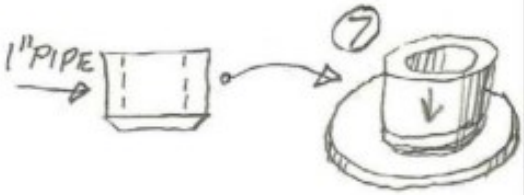
Originally published by Michigan Artist Blacksmith Association July-Aug 2019



Make the ball on the end, you can make this all on the anvil but I sweeten it up with a fullering tool.

Draw out and round up for the hook.

Cut out a round disc 1¾ inches in diameter out of 11 or 18 gauge sheet metal. I made a round fuller out of a short length of 1 inch black pipe by putting a sharp edge on it that gives you a nice round definition for the seeds.



Fuller for the seeds making the lines cross at a 45 or so degree angle so the seeds look like diamonds.

Cut the petals with a 4 ½ inch grinder with a ⅛ inch cutting wheel. This leaves a gap that you wouldn't get by hot cutting and you'll need the gap so the petals don't overlap when fullered out.

File the petals to shape.

With a ball end fuller shape the petals.

Depress from the back with appropriate size ball peen hammer into either wood or a short piece of pipe. Adjust any distortion. By riveting the flower on while the hook is straight you can clamp it in the vise which makes riveting easier. Drill and rivet the flower into place. Now heat the whole thing and bend to the appropriate shape, holes can be drilled for fastening. Clean up and finish.

This article is reprinted with permission courtesy of the Pittsburgh Area Artist-Blacksmith Association Newsletter Feb 2022.

Pittsburgh Area Artist – Blacksmiths Association *February 2022*

Daily Grind by Bob Pickens

For those that have an interest in old sharpening implements, you might have a wet stone grinder in the back of your shop and been planning to put it to good use. These were used to sharpen knives, wood chisels, planers, and various farm equipment. Most of the antique grinding wheels you find will have imperfections such as: a flat spot, it may have grooves in it, and be out of round. To rectify these problems, you will need a way of dressing the wheel with a wheel dressing tool. The flat spot on some of the wheels was caused by the grinding wheel sitting in water and becoming soft in that particular area. The water trough was designed to be drained after use, but this procedure was not always followed. Bob has a collection of grinders dating from the late 1800's to present day. He has found creative solutions in some of the designs.

For instance on the oldest one Bob owns, the bearings can be inserted through the screw hole located on the bearing block. (Photos-Left)) One of his newer models from the 1940's ironically has wooden bearings. The smallest one he acquired is from the turn of the century and measures 12" by 6" overall. It is a hand cranked grinder with a 5" wet stone. Each has its own unique design, but all were used to sharpen implements using a spinning grinding wheel.

Any grinder wheel old or present day needs dressed in some point in time. If you have a flat spot, the wheel must be ground to the lowest point on the wheel. First, make sure the wheel is completely dried out. The correcting procedure takes time, patience and precision. If the wheel has a groove, the wheel must be ground to eradicate the groove. The most common is a hand held star type dresser. For more precise dressing a diamond wheel dressing tool is suggested. There are a number of manufacturers, but they all will correct a wheel with more precision.

Present day high speed wheels are manufactured with a resin and has a shelf life which is determined by the manufacture. This was not an issue in the old days because grinder wheels spun at a very low RPM. Today, the grinder wheel industry has developed in uses not even imagined in days of the past.

Following safety procedures is imperative when dressing a wheel, all precautions must be followed. Dressing cleans away foreign particles and exposes sharp new cutting edges. How to: 1. Place cutter head on tool rest. 2. Firmly push dresser into grinding wheel. 3. If sparking occurs, press harder on dresser. 4. Traverse cutters back and forth across wheel.

Safety Glasses are a must!

Above: Smallest hand-cranked grinder with 5" wheel. Left: Hand held star dresser on a present day grinder. Right: Diamond wheel dressing tool used for more precision.

If you have questions about your unique grinding wheel, call Bob Pickens @ 412-496-9389

Reprinted from North Texas Blacksmith Association—Bellows Blast—May 2022

MAKING A WIDE-EDGE CHISEL

By Kelly Kring, Blacksmith instructor at Dallas College - Brookhaven Campus

Starting with a 3/4" round by six inches long, heat one end in the forge to a bright orange heat. Slightly flatten the end as you would start any chisel. Now, take the bar, holding it upright in your tongs and upset the heated end on the anvil face to maintain a flat surface.

Next heat, go directly to the horn keeping the two flat sides facing the anvil face and tip of the horn, work an upsetting blow over the horn starting in the center of the bar, then moving back and forth from one far side to the other as the chisel begins to widen.

Each heat, maintain the two main flats, but also keep the sides flat and ninety degrees to the soon to be chisel edge. Between the horn and anvil face, widen the chisel end but keep the end rectangular until you reach a two-inch width. Once that's achieved, now start working the length of the chisel blade into the traditional wedge shape on the face of the anvil or across the top of the horn. Remember to maintain the sides of the chisel! Once the edge is down to 3/16" thick and two inches wide, normalize the chisel. This is a good time to flip it around and forge the struck end to a hex for easy "chisel" identification.

There is no need to index this chisel. Some folks prefer to hex the full length of the chisel at this point in the forging. Allow the chisel to cool and sand in the beginning of the beveling for the cutting edge, but do not sharpen the edge yet. Lace a 1/16" or 1/32" flat on the edge. Once that's done, normalize the entire chisel before heat treating.

Heat the cutting end (with the flat edge) to a working orange heat.

Quench out the flat bevel blade in water for a count of ten (moving it a stirring motion) while the shank remains orange hot. Remove from the water and using a file, disk sander, or disk grinder from an angle grinder, and brighten up the entire blade of the chisel, removing as much scale as possible. Watch the heat cooler run from the unquenched shank towards the edge.

Requench the blade up to the royal blue color band when the straw yellow is 1/32" behind the edge. Keep that coloration dipping frequently until the back end has turned dark for at least three minutes. The with quick full immersion dips, quench the entire chisel in water three times. On the forty dip, keep quenched under water until the entire chisel is cold. Now, wire brush the tool to remove as much scale as possible. Sharpen the edge along the direction of the belt sander, or using an angle grinder and vise, grind in a bevel with a short, thick edge for cold cutting steel.

Good luck and let us know how it goes!!!

The following link is to a video made by the author during the beginning period of the 2020 covid shutdown for his class at Brookhaven College. Be forewarned that this is no YouTube quality video!!!

https://www.facebook.com/groups/211138179026298/permalink/1762644870542280/

Below are a set of pictures showing the different stages of forging the wide blade chisel.

(see Chisel photos, page 10)

For Sale

Fire Bricks – Brand New, Industrial Grade. $1 ea. Ed Sylvester 803.414.2487

Beverly Shear blades sharpened , $50+$10 shipping. Send to Scott Kretschmer, 196 Mule Deer Drive, Loveland, Colorado 80537 Call 970 567 2609, email scott@kretschmershops.com.

Anvils for power hammer build (1) Ea 285#, 6" round x 36"tall. Reduced price: $100pic!!! Pick up at JC Campbell Folk School or at Mike's shop. Mike Lamarre 706-374-2983

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 ironsmith@gmail.com

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

Upcoming events:

2022 SC State Fair. October 14, 15 and 16. No home game for USC. John Tanner is the contact, 803-422-4714, blacksmith@comporium.net
SBA Conference!!! May 18,19, and 20. Madison, Ga.
Hammer-in at North Augusta: January 21 at the Living History Park. Bob Kaltehbach and Barry Myers will host. Project will be a scrolled three legged trivet.
South Carolina Knife Maker's Guild having a guild meet at Dan Eastland's, 213 D Riverside Ct, Greer. Nov 19th from 10:30 am till about 3-4pm. Contact Ben Secrist at 843-457-2755

Lyle Wynn's "Tools to Make Tools" class, March 2023. . The class size will be limited to 10-12 participants. Cost: TBD . Jason Jaco is the contact. Jason will show the tools to be made at the October meeting. These are hammer making tools. **This will be a 5-7 day class—Plan your vacation time now!**

2022 Meeting Schedule:

December Meeting: Ryan Calloway and Artistry, December 10, at 12 Andrews St., Greenville.

Philip Simmons Artist Blacksmith Guild

http://philipsimmonsartistblacksmithguild.com/

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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 ASSMPUMPTION 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 2021, Dues for 2022 are Due, or Dues Paid for 2022"

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

COME to the Lexington County Museum

231 Fox St., Lexington, SC

October Meeting, 10/29

Demo beginning at 10AM

Backslapping and glad handing may start somewhat earlier

Bring a side, dessert, or drinks and something that you might want for the iron-in-the-hat

Heyward Haltiwanger and the Lexington County Museum will host

Barry Myers will demonstrate box jaw pliers and they aren't easy so this may be a lot of laughs!