



President's Letter

March, 3, 2010

The last meeting for the Philip Simmons Blacksmith Artist Guild was at L.W. Paul Living History Farm on February 20, 2010. It was hosted by the Hill family and the Conway Museum, I would like to thank them all. For those who didn't make the meeting, you missed a fine demo by Walter Hill and a chicken bog that would make you hurt yourself.

I would also like to add that the date was the 15th anniversary for the Guild. Not too bad.



It just shows what can happen if a group of old country boys get together.

We had another good iron in the hat, thanks to all our members who contributed to it. Sorry, I'm not as entertaining as Barry, but he will be back for the April meeting.

Tony Etheridge was awarded the Memorial Scholarship. This year it is the Darwin Lamb Memorial Scholarship. Tony wants to learn to make tomahawks.

Thanks to all who came to the hammer-in back in January, I hope everyone had fun and learned a little something but most of all, had fun.

I would like to welcome Jesse back to the Board and our new board member Jimmy Suggs.

If you have any questions, you can contact me by email at mike@tuckersforge.com or call me at 803 773-6853.

P.S I still have Iron in the Hat tickets for ABANA for sale.

Keep Darwin Lamb's family in your prayers.

Sincerely, Michael Tucker

Iron-in-the-Hat

| Item | Donated By | Won By |
|---|-----------------|-----------------|
| Leafing Hammer | Mike Tucker | Charlie Wells |
| Cable Damascus Knife | Mike Tucker | Jason Jaco |
| Deer Hoof RR Spike Knife | John Outlaw | Jerry Fowler |
| Grinder Kit | Jerry Fowler | Ray Pearre |
| Hot Cut | Jerry Fowler | Layne Law |
| Cable Damascus Tomahawk | Meck Hartfield | Julia Kennet |
| Cable Damascus Knife | Meck Hartfield | Travis Polhemus |
| Set of Drill Bits | Joe Holladay | Charlie Wells |
| Harness Hooks | Jesse Barfield | James Price |
| Harness Hooks | Jesse Barfield | Layne Law |
| Anvil's Ring Magazines | Jesse Barfield | Layne Law |
| Anvil's Ring Magazines | Jesse Barfield | Julian Thrasher |
| Peanut oil for Quenching | Ray Pearre | Julian Thrasher |
| Blacksmith tongs | Jimmy Suggs | Al Jenkins |
| Bucket of Sewell Coal | Layne Law | Ray Pearre |
| Nicaraguan El Porvenir Coffee | Al Jenkins | Bob Hill |
| Saw Blades/ Knife Material | Al Jenkins | Jamie Stevens |
| Two Hangers | Keith Gunter | Sue Paul |
| Two Hangers | Keith Gunter | Bob Hill |
| One pair Pliers | Keith Gunter | Bob Hill |
| 18th Century Hunting Bag | Bob Hill | Mike DuBois |
| 5160 Steel | Mike DuBois | Ray Pearre |
| Horse Shoes and Rasp | Billy Ridgill | Jesse Barfield |
| Horseshoe Rasps | Billy Ridgill | Jesse Barfield |
| Dozer Tooth | Charles Meyer | Ray Pearre |
| Wooden Mallet | Julian Thrasher | Jimmy Suggs |
| Tapping Fluid | Julian Thrasher | Charlie Wells |
| Wagon Wheel Wrench | Bill Creek | Charles Meyer |
| Trivet | Linda Creek | Layne Law |
| Heat Treated Spring Steel/Blunted Blade | Jamie Stevens | Julian Thrasher |
| Hold Fast | Walter Hill | Keith Gunter |
| Race Car Axle | Jesse Barfield | Pam Campbell |
| Fat Lighter | Ed Tinsley | Jason Jaco |

The Iron-in-the-hat was a very successful effort. Thank you one and all. A small but enthusiastic crowd donated over \$500 to the Scholarship Fund. Thanks again.

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The Mark Asprey class to be held in March at the Old Charleston Forge is full, but there are still “tire-kicker” (observer) positions available. The price is \$25 for one day, \$50 for two or three days. A lot of good information will be imparted! Mark will be teaching joinery and flowers!

Darwin Lamb

For those of you who have not otherwise heard, Darwin Lamb passed away in early January. The newsletter had already been printed so I report it here. I have reproduced his obituary below as printed in the State Newspaper.

We have lost a great friend and teacher. Darwin worked with Te and others to give classes at the University that have started or improved many of our members and others. For me, the biggest effort that he contributed was his effort with the tire hammers. Every time I use my hammer, I think of Darwin. His efforts were well above what anyone else put in to the classes. I hate to think of how many hours he spent welding the superstructures of the seventeen hammers we made in the second class.

Our Guild will miss him. We have tee shirts with pockets because of Darwin. I miss him.



Elgin -- The family of Darwin Selmer Lamb, 63, will receive friends on Monday 6-8 p.m. at Powers Funeral Home, Lugoff. Memorials may be made to Philip Simmons Artist Blacksmith Guild, c/o Mike Tucker, 122 North Salem Ave., Sumter, SC 29150.

Mr. Lamb died Thursday, January 7, 2010. Born in Watertown, SD, and reared in Spearfish, SD, he was the son of Dorraine Shirley Steen Lamb and the late John Francis Lamb. He was a welder by trade and enjoyed blacksmithing. He was a member of the Philip Simmons Artist Blacksmith Guild.

Surviving are his wife of 24 years, Catherine Moore Lamb, mother of Spearfish, SD., daughter, Mary Lynn Thompson and her husband Keith, of Huntsville, Ala.; sons, Robert Bradley of Hartsville, William Lamb and his wife Julie, of Camden, and David Bradley and his wife, Angela, of Camden; brothers, Allen Lamb, Robert Lamb, Rodney Lamb and Donnie Lamb, all of Spearfish, SD, and Roger Lamb of Austin, Texas; and eight grandchildren. He was predeceased by a son, Russell Dean Bradley; and sister Madeline Lamb.

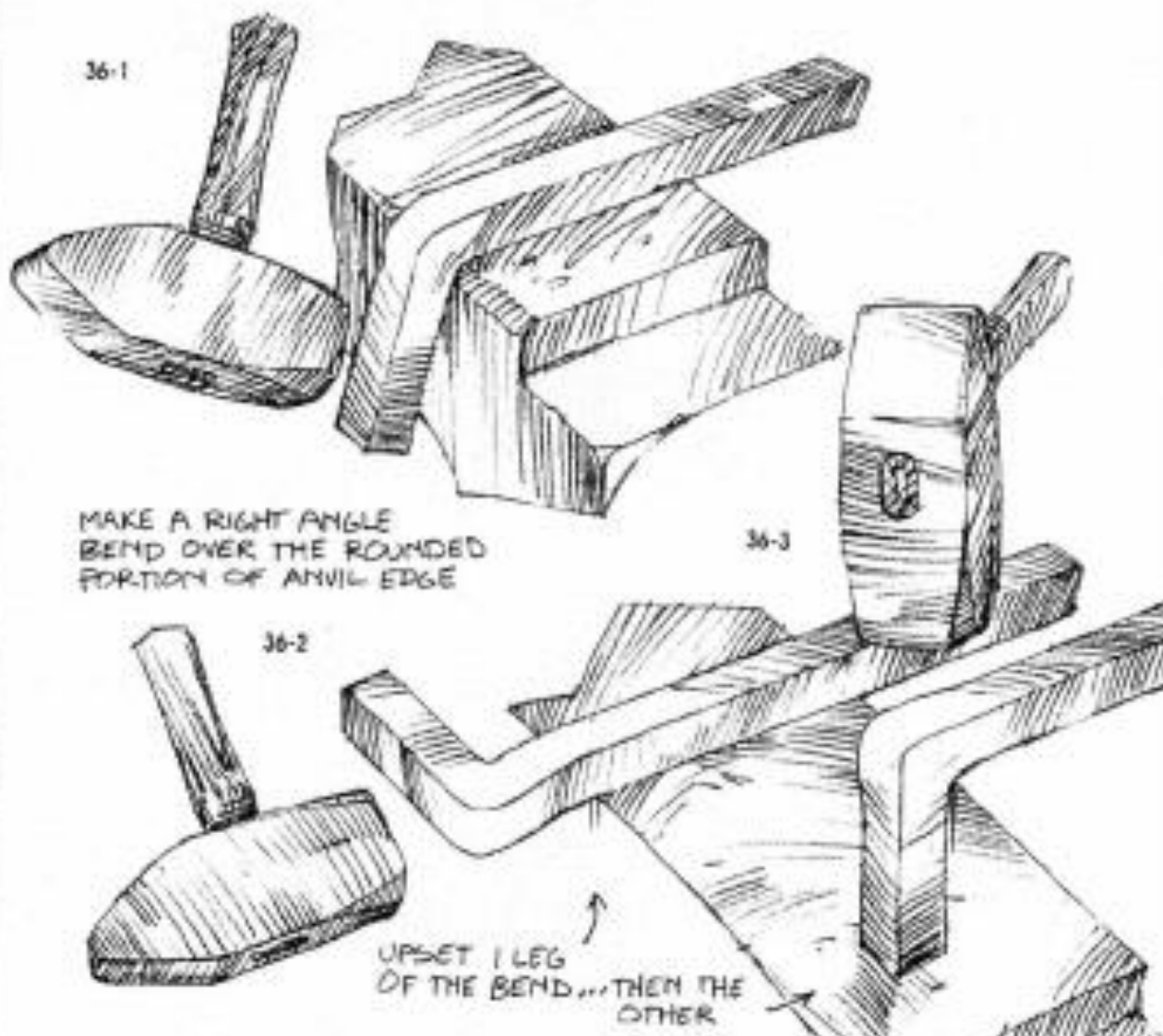
Contributions made to the Guild will go to the Memorial Scholarship Fund.

Walter Hill's demo at the Horry County Museum's Farm in February was a hold fast. A device used to hold something to the anvil or workbench. The starting point on it is the square corner, so I dug up a square corner how-to from *The Blacksmith's Journal*, April 1991. Dan Tull once said that the square corner done right is the hardest thing a blacksmith does.

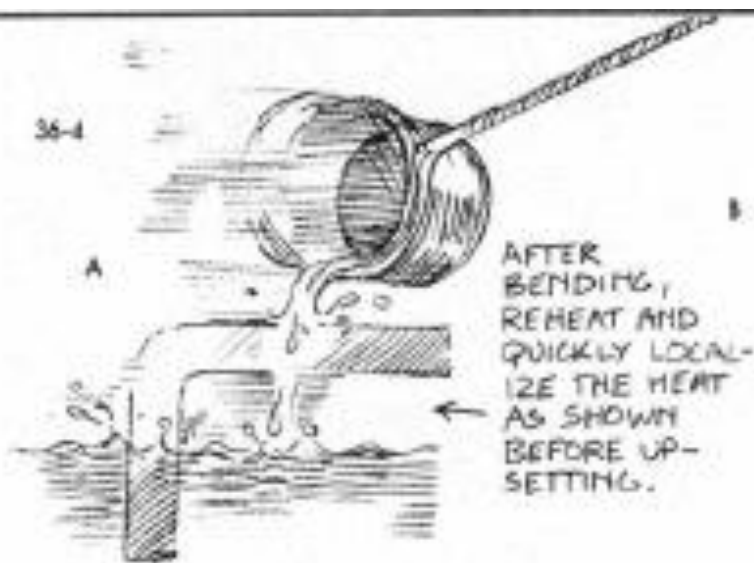
Square Corner

A hot, localized heat is necessary for making a square corner. Hammer blows should be square & solid and the bar should be re-straightened before proceeding if it scrolls away from the hammer. The metal is first upset to move it into the outer edge of the corner;

when enough metal is displaced, it is then drawn further toward the outer edge, and squared up. The inside of the corner should be kept 'open' throughout the process to prevent the metal from folding into itself as shown in ill. 36-4d.

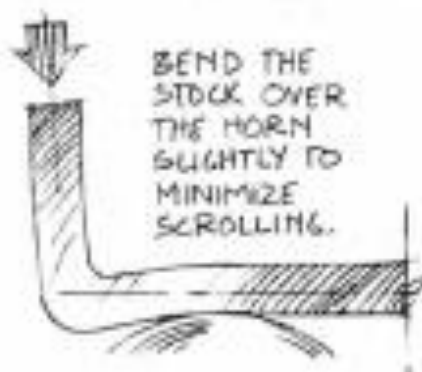


36-4



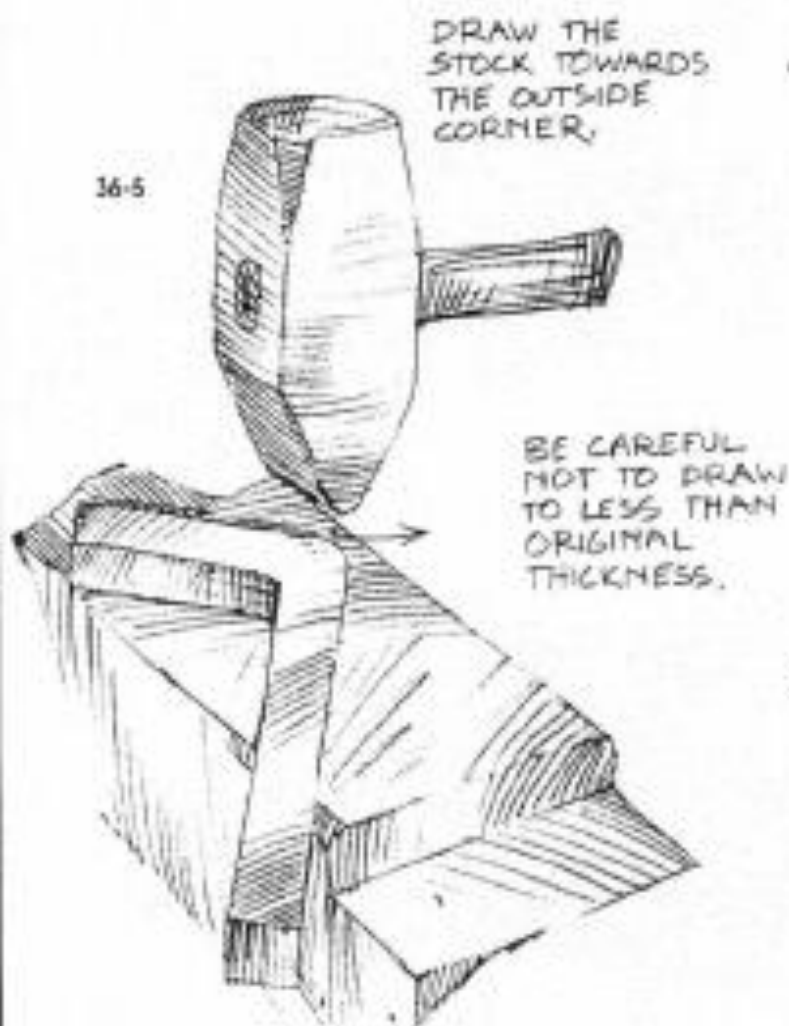
AFTER BENDING, REHEAT AND QUICKLY LOCALIZE THE HEAT AS SHOWN BEFORE UP-SETTING.

B



BEND THE STOCK OVER THE HORN SLIGHTLY TO MINIMIZE SCROLLING.

36-5



DRAW THE STOCK TOWARDS THE OUTSIDE CORNER.

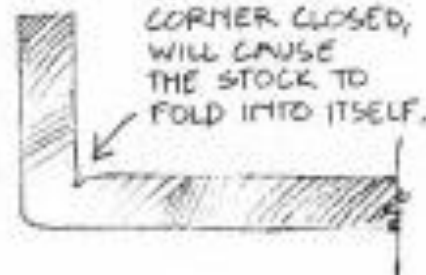
BE CAREFUL NOT TO DRAW TO LESS THAN ORIGINAL THICKNESS.

C

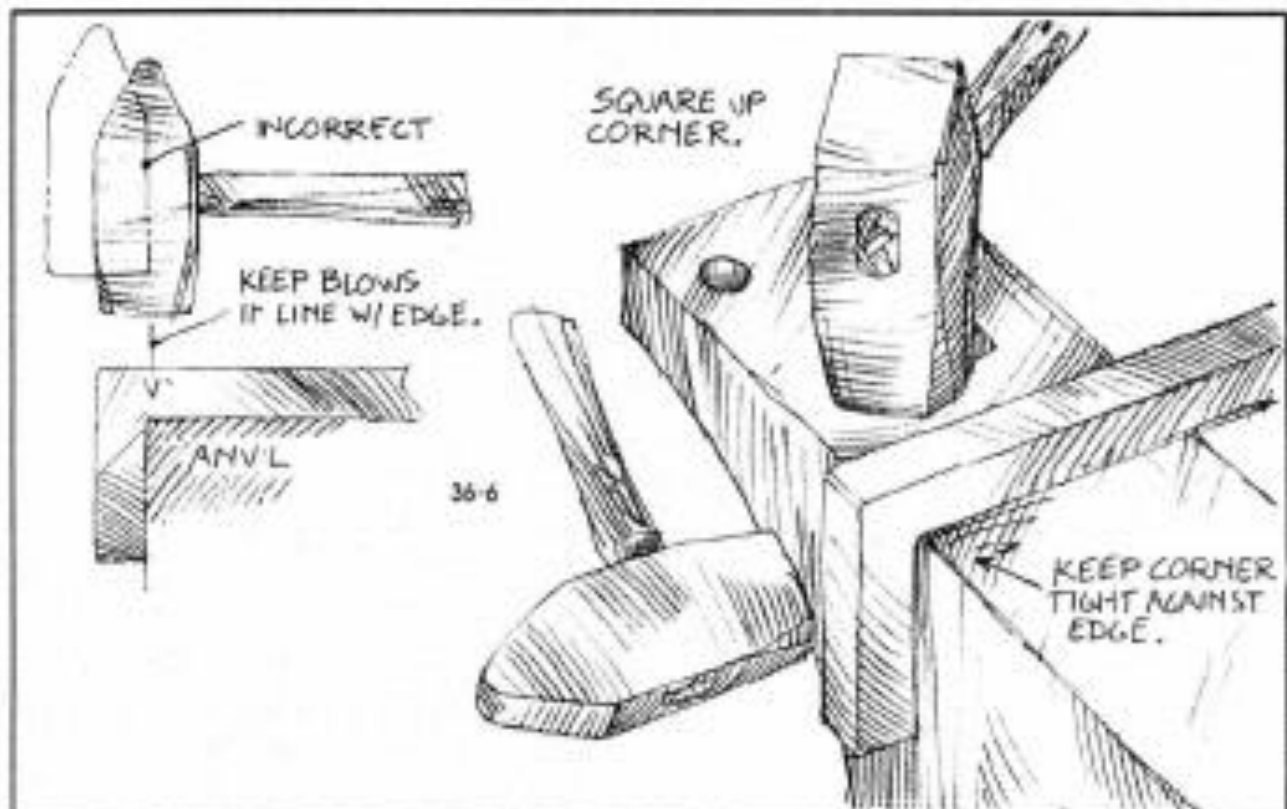


IF THE LEG BECOMES BENT PAST 90° (CLOSED) DURING UP-SETTING, STRAIGHTEN BEFORE PROCEEDING.

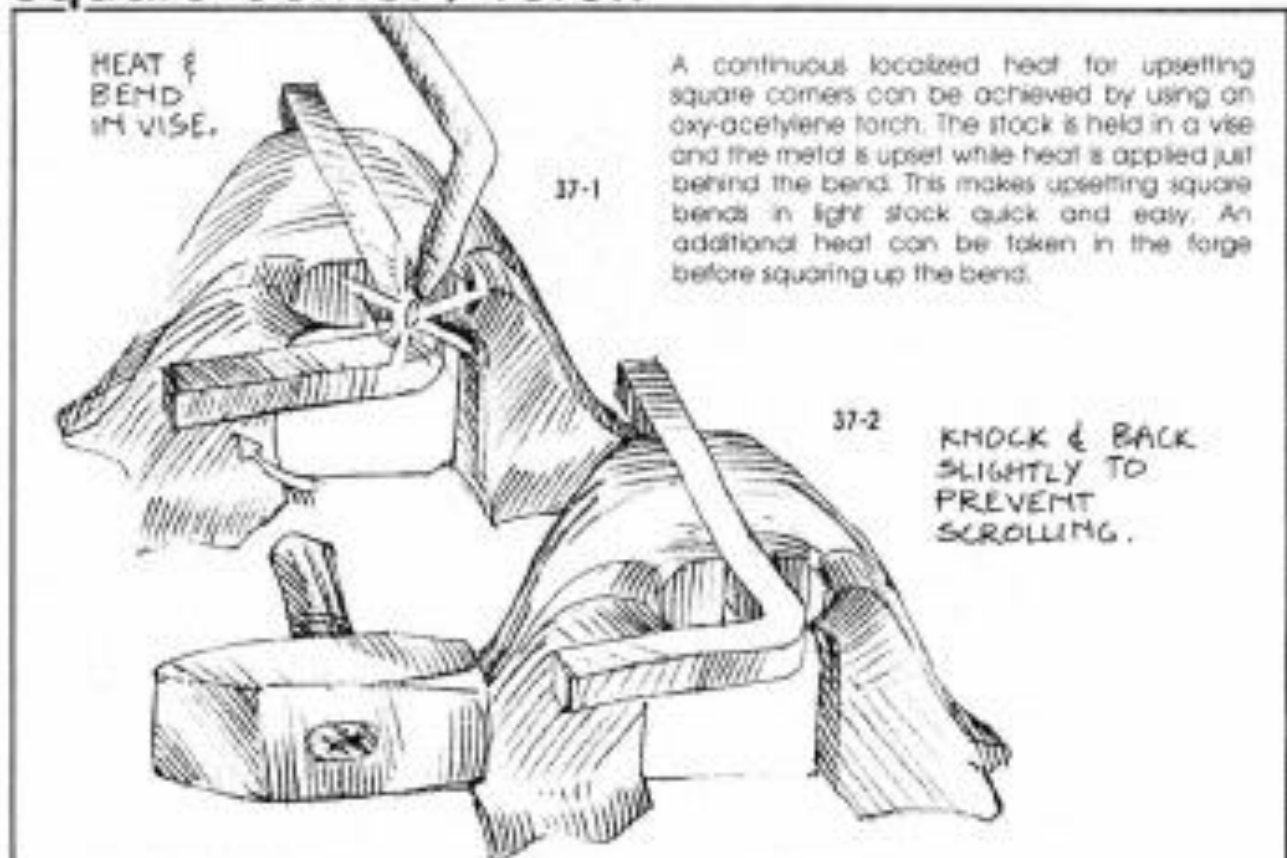
D



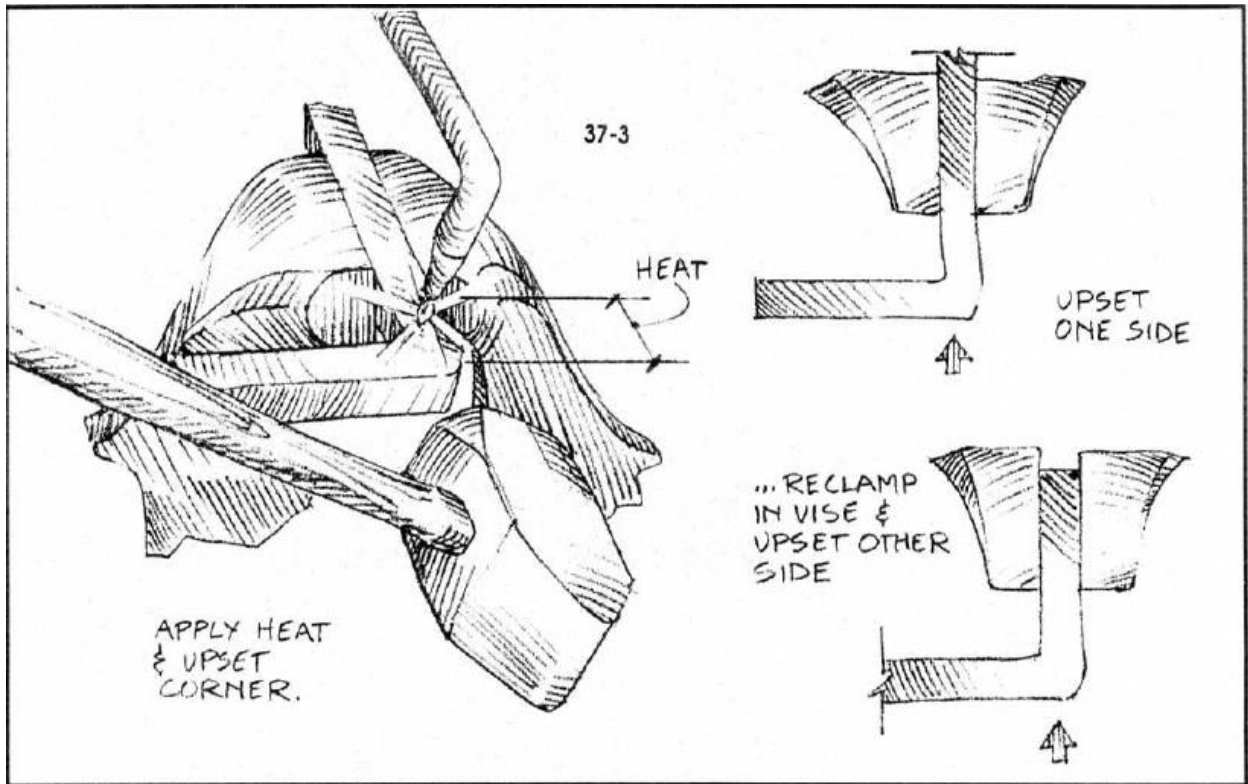
EXCESSIVE HAMMERING, OR HAMMERING WITH THE INSIDE CORNER CLOSED, WILL CAUSE THE STOCK TO FOLD INTO ITSELF.



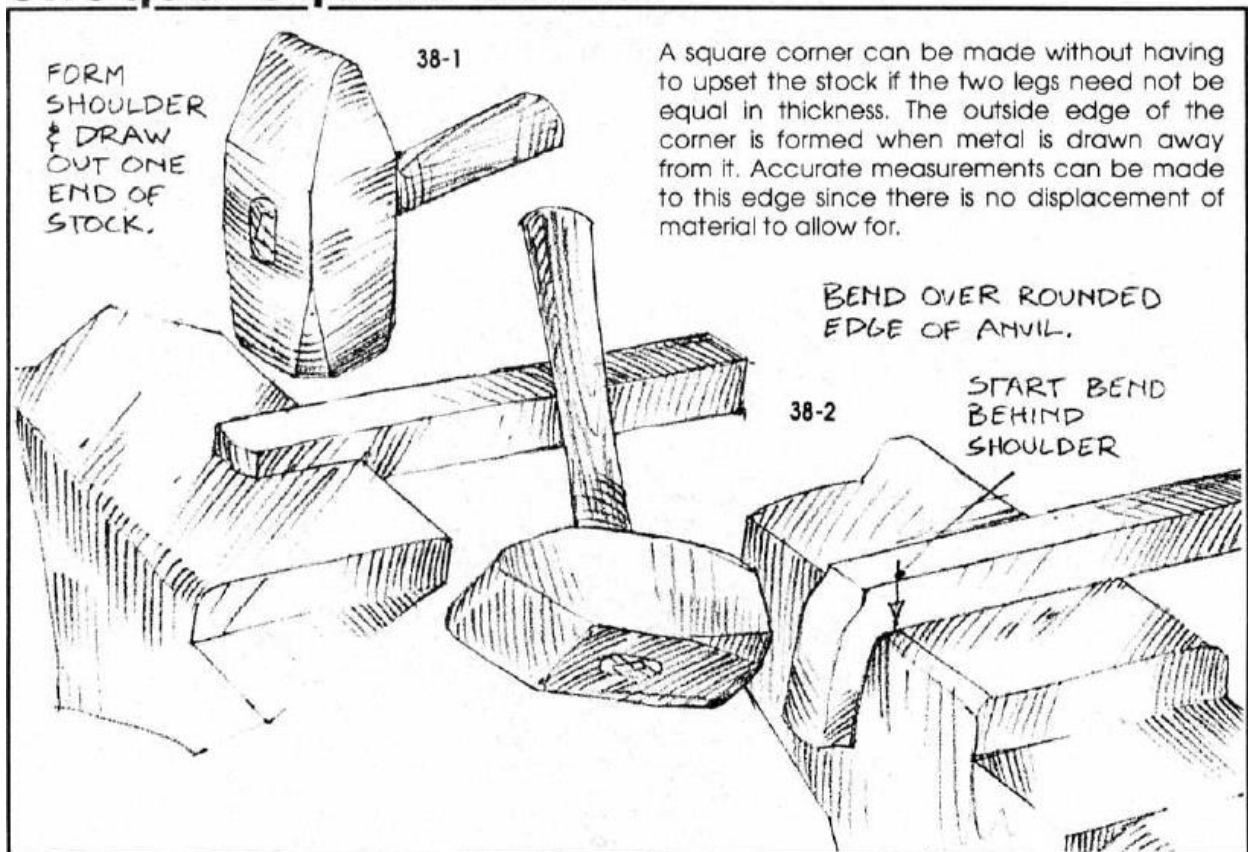
Square Corner / Torch

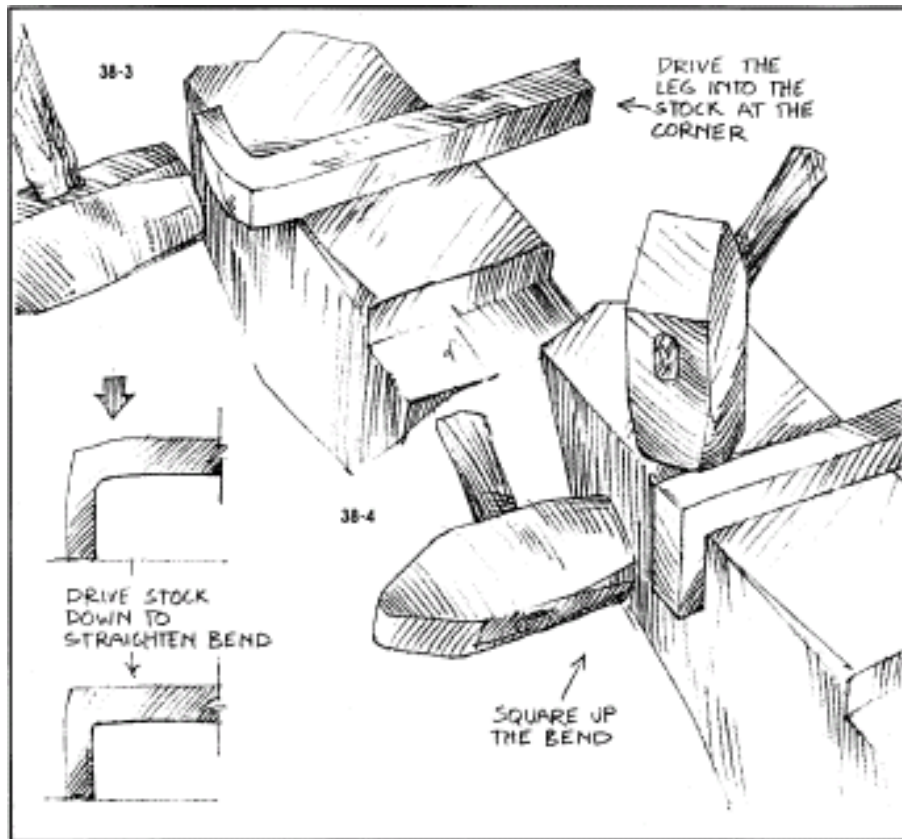


A continuous localized heat for upsetting square corners can be achieved by using an oxy-acetylene torch. The stock is held in a vise and the metal is upset while heat is applied just behind the bend. This makes upsetting square bends in light stock quick and easy. An additional heat can be taken in the forge before squaring up the bend.



Unequal Square Corner





Walter working at the Horry County Museum Farm forge.

Ray Pearre photo

BENDING FORK AND WRENCH

A grader blade is good material from which to make a bending fork and wrench. Two blanks are cut to about the final size ($\frac{1}{8}$ " oversize), and annealed. The legs are formed by drilling a hole at the intersection of the legs and the body, and cutting the resulting ligament. The corners of the legs are filed round and smooth. The legs on the two ends of the fork should be of different sizes to accommodate different sized materials. The handle is forged to size after the jaw is formed. Francis suggests making four forks and wrenches to accommodate a variety of material sizes.

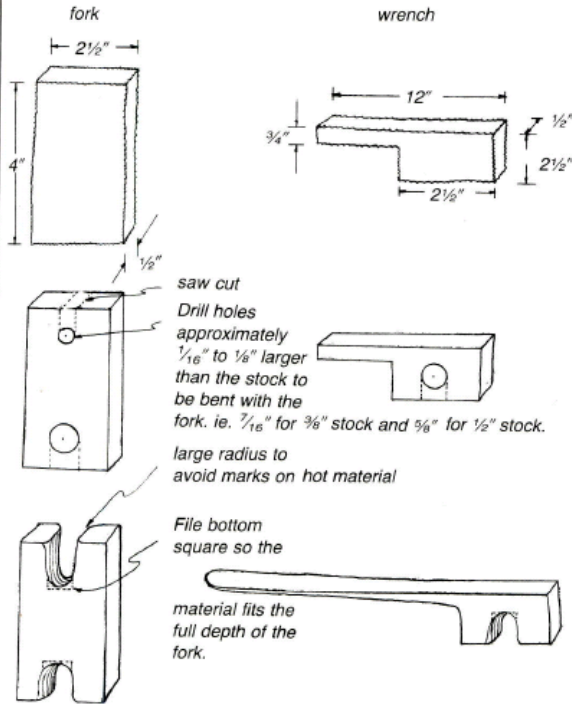


Figure E-1. Bending fork and wrench blanks torch cut from a used grader blade.

BUCKING BAR

A piece of $1\frac{1}{4}$ " tool steel or an old axle makes a good bucking bar. The end of the steel is tapered for about 4". The taper is bent so the top of the bent section is at the main portion of the bar, Figure F-1. Three round cupped holes are driven into the side of the taper. Francis suggested the holes be sized for $\frac{5}{16}$ ", $\frac{1}{4}$ " and $\frac{3}{16}$ " rivet heads using appropriate cone punches (Appendix D), Figure F-1. A bucking bar can be made from mild steel. However, after forging, the bar should be heated to an orange and quenched.

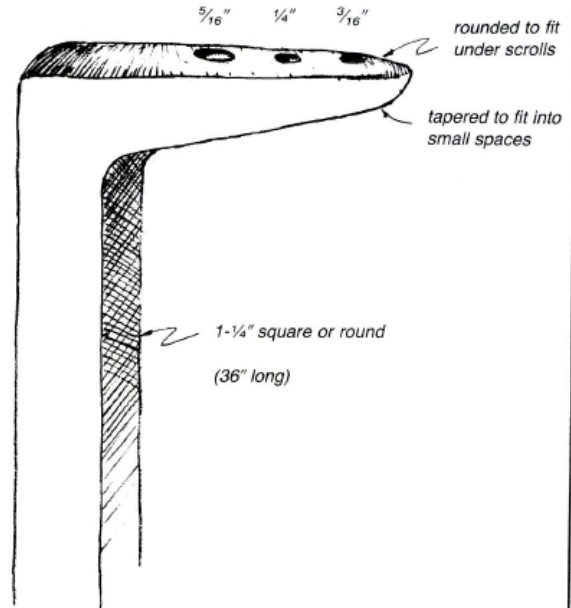


Figure F-1. Bucking bar for backing up rivets in awkward places.

Reprinted from the Spring 1984 Anvil's Ring

Items for Sale

Sewell Coal Layne Law 843-333-9964

Sale of items in this space works! Jack Ratcliff sold his power hammer just this past week!

Have anything for sale? A business card for advertising? Send and I will post it!

Speaking of Business Cards, Ray Bryant, our printer, will print them up for you, contact him:

Bryant's Printing 203 Gregg St Bishopville, SC (803) 484-3500

Barry.

UPSETTING TIPS AND FORGE BRAZING

I first saw this technique demonstrated by Walter Hill several years ago after he took a class with Jerry Darnell. I sure was a faster way to upset for small stock. I found it in one of the old ABANA Anvils Ring magazines. Barry

UPSETTING TIPS AND FORGE BRAZING

Submitted by Bob Patrick

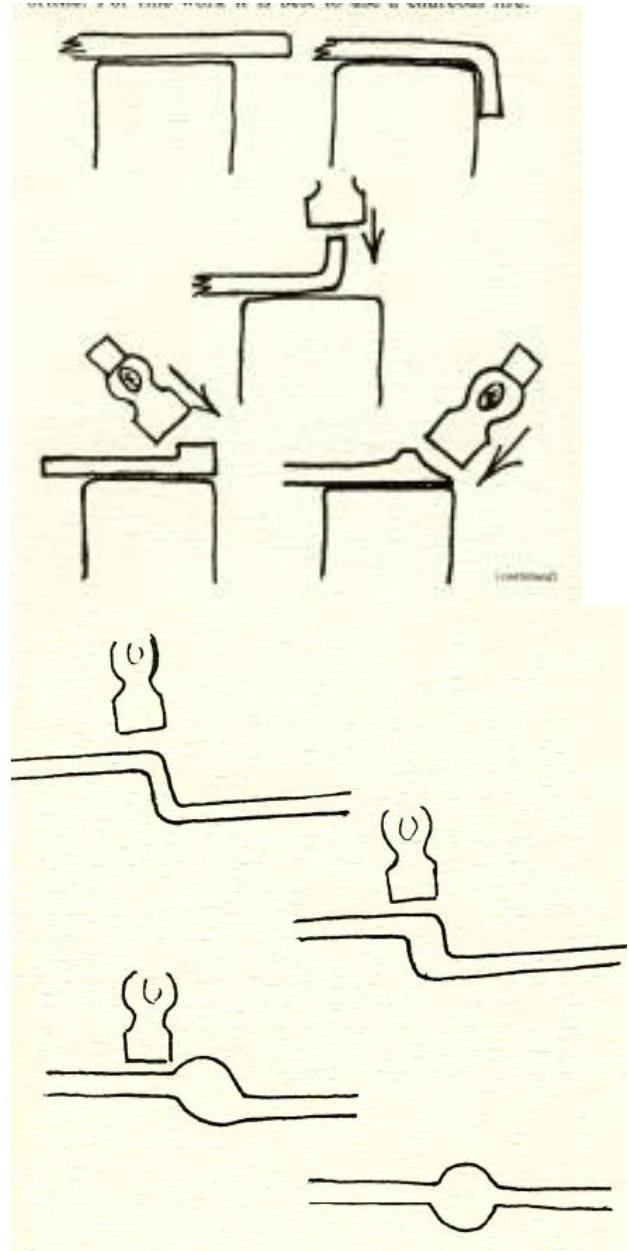
Bethel, Mo.

I hesitate to send in any tips with such experienced older smiths in our membership, still, having made my living as a smith for the past twelve years, I have learned a few things. *(That's the spirit. We all have something to learn and to show. Ed.)*

Upsetting Small Bars

A quick and little known method of upsetting small bars is the following: Heat the bar to a proper forging heat for that particular iron or steel. For a 3/8" square bar, place the bar so that about 1" or a little less extends over the far side of the anvil and bend down at a right angle. The corner of the anvil in this case should have about a 1/4" radius on it. Turning the bent section straight up and carefully directing your blows on it, hammer it down. You must be very careful not to get a fold in the metal. Properly done, this can reduce the time to upset and properly scarf a piece for welding to one heat for light stock. It is not suitable for all types of upsetting, and judgement must be used. The methods can be used for round stock if the work is done in a half round swage. A variant of this method can be used to upset the middle of a small bar for punching and welding. Make a bend as in the diagram and carefully hammer the bend down. These are great time savers, but involve some risk until sufficient experience in them is gained.

Brass has a place in forge brazing as it melts at a somewhat lower temperature than copper, and most of the zinc can be burned out if the brazed joint is done directly in the fire rather than in clay, but brass is more brittle than copper. I also like to use coin bronze, which "copper: pennies are made of. I like bronze because it flows easily and make for a very strong joint. It seems to be a little less affected by sulfur in the coal, which makes brazed joints brittle. For fine work, it is best to use a charcoal fire.



Reprinted from the 1979 Anvil's Ring.

Philip Simmons Artist Blacksmith Guild

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Membership Application

Dues: \$15 per person/family, annually

New member: __/__/__ Renewal: __/__/__

Name: _____

Address: _____

City: _____ State: _____ Zip: _____

Phone: _____ E-mail: _____

Please Remit Dues to: Ray Pearre, 4605 Durant Ave., N. Charleston, SC 29405

APRIL 10th 10 AM

Come to Magnolia Gardens and see Jeff Hatfield
forge flowers and demonstrate joinery!

Bring a side, drinks or dessert and something nice for iron in the hat
Sale of your blacksmith-made items to the Public is welcomed!

Tell the folks at the gate that you are with the Blacksmiths

