

On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD



Hello Blacksmiths and friends! Our last meeting was held at Roger and Gayle Marcingiles' home, near my neck of the woods, in Westminster. Ryan Caloway and Owen Reidesel demonstrated at the meeting. They spent some time the day before prepping some pieces for a traditional rose which was attached to an accent piece consisting of a Right angle and curved bottom rocker. The Day of the meeting Owen Started off by making the hard corner 90 degree piece and followed it up by making the Bottom rocker. Ryan and Owen then successfully welded up 7 pieces of $\frac{1}{4}$ x1 bar stock that made up the pedals of the rose. Owen made the job more impressive by not using flux on the welds. Time didn't allow for them to finish the project but they generously donated the first one they made as well as the demoed parts. I am sure this piece will be a great addition to the new owner's home!

Iron in the hat was AWESOME! We had so many forged items and quality rust! It sure was a site to behold! We made _____ from the donations and the guild thanks you all for the generosity!

Also at the meeting our amazing secretary/Treasurer Ray Peare was recognized for over 14 years of membership and service to the Guild. In that time he has only missed 2 meetings and has served us with distinction in the roles he has held. In recognition for his service we offered a scholarship to him and named one in his honor.

Ray has decided to retire, so we are looking to replace him as secretary/

treasurer. We know that he has really big shoes and filling them will be difficult. We also know and do not expect that his replacement will make every meeting. Want to give it a go? Give me a call.

We also recognized Jesse Barfield for all his work as past president and what he does behind the scenes with the SBA conference. He is truly an unsung hero and offers his wise counsel when I need it in the operations of the guild. That all being said, we awarded him a lifetime membership for his service and help!

Thank you both!

Finally, Our Off Month/Forge-In managed by Rusty was also held at Ryan's shop in Greenville just recently. I hope you all saw all the pictures on the Guild's Facebook/Instagrams pages. This picture shows only 11 of the 18 people who came. This is the largest crowd we have had come out! Looks like a lot of learning happened! I stopped by but didn't have the spare time to participate.

Man, it was a true South Carolina summer day! 90 degrees and 90 % humidity, but I saw a lot of smiling faces bearing the heat! I would encourage you all to attend one to get a chance to forge and learn with our other members! Thanks again to Ryan for opening up your shop and helping others learn in our community!

Speaking of heat, I checked and it is going to cool in Camden this August. Rusty is going to demo some of the skills/tools required for the Level I ABANA Curriculum.

Keep the forge lit and the iron hot!

Jody

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Iron in the Hat

Item	Donated By	Won By	Item	Donated By	Won By
Candle Lamp	Roger Marcengill	Weston Haviland	Forged Spatula	Tony Etheridge	Conal Smith
Copper Cardinal	Gail Marcengill	Rame Campbell	Plant Stake w/gems!	Pam Etheridge	Griz Hockwalt
Trivet	Barry Myers	Benjamin Hooks	Plant Hangers	Rick Gifford	Craig Mize
Forge Hoe	David Bush	Marcy Brown	Damascus Knife	Jerry Fowler	ML Tanner
1" Hot Cut Hardy	David Bush	Chris Carroll	Rose Blank	Jody Durham	Benjamin Hooks
Madison Tee Shirt	Guild	Griz Hockwalt	Applerton Jrnl Page	Ted Mays	Valerie Barrineau
		Jesse Barfield	Harpers Weekly Page	Ted Mays	Barry Myers
Forged Tomahawk	Griz Hockwalt	Pam Etheridge	Flint and Steel Kit	Tait Lawrence	Conal Smith
Harley Chain Knife	Griz Hockwalt	Rusty Osborne	Heart	Marcy Brown	Weston Haviland
Scale Bottle Opener	Conal Smith	Weston Haviland	Coal Poker	Marcy Brown	Valerie Barrineau
Crane Wall Hook	Ryan Calloway	Barry Myers	Ball Bearings	Valerie Barrineau	Conal Smith
Leaf Wall Hook	Ryan Calloway	Chris Herron	Blower Fan	Texas Street Works	Jody Durham
Snake!	Ryan Calloway	Barry Myers	Bird Plant Stake	Jason Jaco	Barry Myers
Tea Candle Holder	Ryan Calloway	John Tanner	Short Post Vise	Ryan Calloway	Tait Lawrence
Heart Wall Hook	Ryan Calloway	Carla Herron	Honey	Rame Campbell	Valerie Barrineau
Coil Spring	Chris Carroll	Rick Gifford	Demo Iron Grll/Rose	Owen Rideisel	Chris Carroll
5 strong magnets	Chris Carroll	Jason Jaco	Demo Parts	Owen Riseiesel	Chris Carrol
Aluminum Chunk	Weston Haviland	Tony Etheridge	Striking Plate	Owen Riseisel	Rame Campbell
Cupping Tool	Rusty Osborne	Rick Gifford			



Tom Latane' jig for tilting vise for filing. Tom files a lot...

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

Reprinted with permission from the California Blacksmith Association newsletter

Quickie Bending Wrench Idea from Erin Simmons

We've all seen those fabulous bending wrenches (dog wrench) made by notables such as Mark Aspery, Dennis Dusek, and others.

Instead, here's a quick-and-dirty bending wrench.

One of the things that I like to do is talk with and observe good blacksmiths. At the Hard Rock Hammer-In in 2018, I gleaned this idea from Erin Simmons.

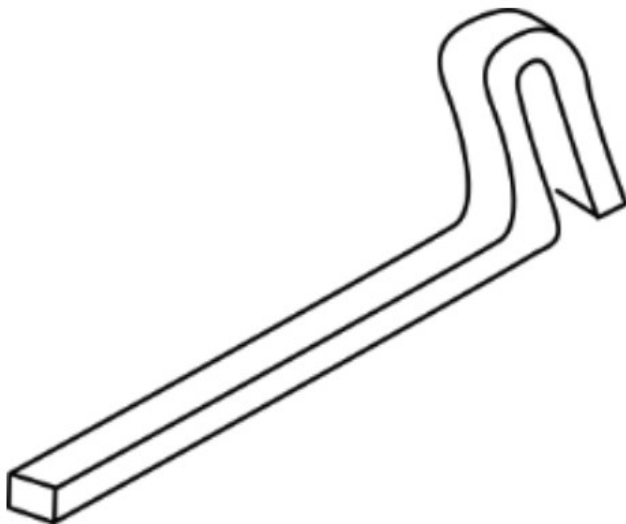
It came in handy a while later when I was teaching at a distant site in Tonopah, NV. I needed a bending wrench, and didn't have either the time or the materials to make one of the "beauties." Fortunately, I had been shown this by Erin, so within a few minutes I was able to make a quick-and-dirty wrench, and get on with the class.

Construction is very simple: form a right angle, fold one end over to make a "U", and line things up.

I now keep a couple of these in my shop - they are very light, and the wide gripping surface is often useful to avoid marring the work.

Thanks, Erin, for the idea!

Material: $\frac{1}{4}$ " x $\frac{3}{4}$ " mild steel

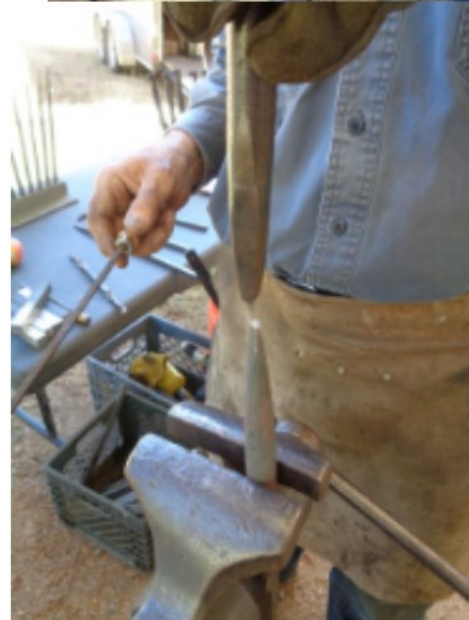


Eye Punch Mark Kochan, Placerville Workshop at Hard Rock 2018

Material: $\frac{3}{4}$ " 4130 or sucker rod

Steps:

1. Taper, then round using square-octagonal-round process
2. Make a flat end, $\sim 3/16$ " diameter
3. Center punch the end
4. Drill or punch with a round-end punch to make concave eye relief
5. File to clean up
6. Harden & temper





Heart Hook With a Ball

By Steve Alling, a MABA member

The Achilles heel of this project is the problem of the two different sizes where the ball and the hook meet. If you're not careful it will crack at that joint. So, this is the process I followed to try and stress that joint the least.

- 1) Mark the stock out.
- 2) Put in the off set to start the ball end. Don't make this neck too thin, when the ball is being formed it will naturally thin.
- 3) Split the heart. Open up the sides and file any rag off. After you have cleaned up the cut, bring

the two legs back together so you have a good place to hold when it comes time to form the ball. I notice a lot of people start with the file 90 degrees to the surface when they file these sharp edges. This makes the sharp edge catch in between the teeth of the file. So start on any sharp edge like this or corners by lowering the file closer to parallel to the surface, and as you push the file forward raise your hand. That way you won't end up with that chatter beginning.

4) Start the ball, this is where a lot of smiths get into trouble. They end up flexing this joint too much by not having the part under the hammer directly over the anvil. This is basically squishing the metal into a ball. The cold shuts won't affect the finish ball. This is where that old adage that the hammer hand is the brawn and the tong hand is the brains. Because you'll be raising and lowering the tong hand and also turning it side to side.

5) Draw out the hook. Here you want to be careful you don't stress the joint between the forging and the ball.

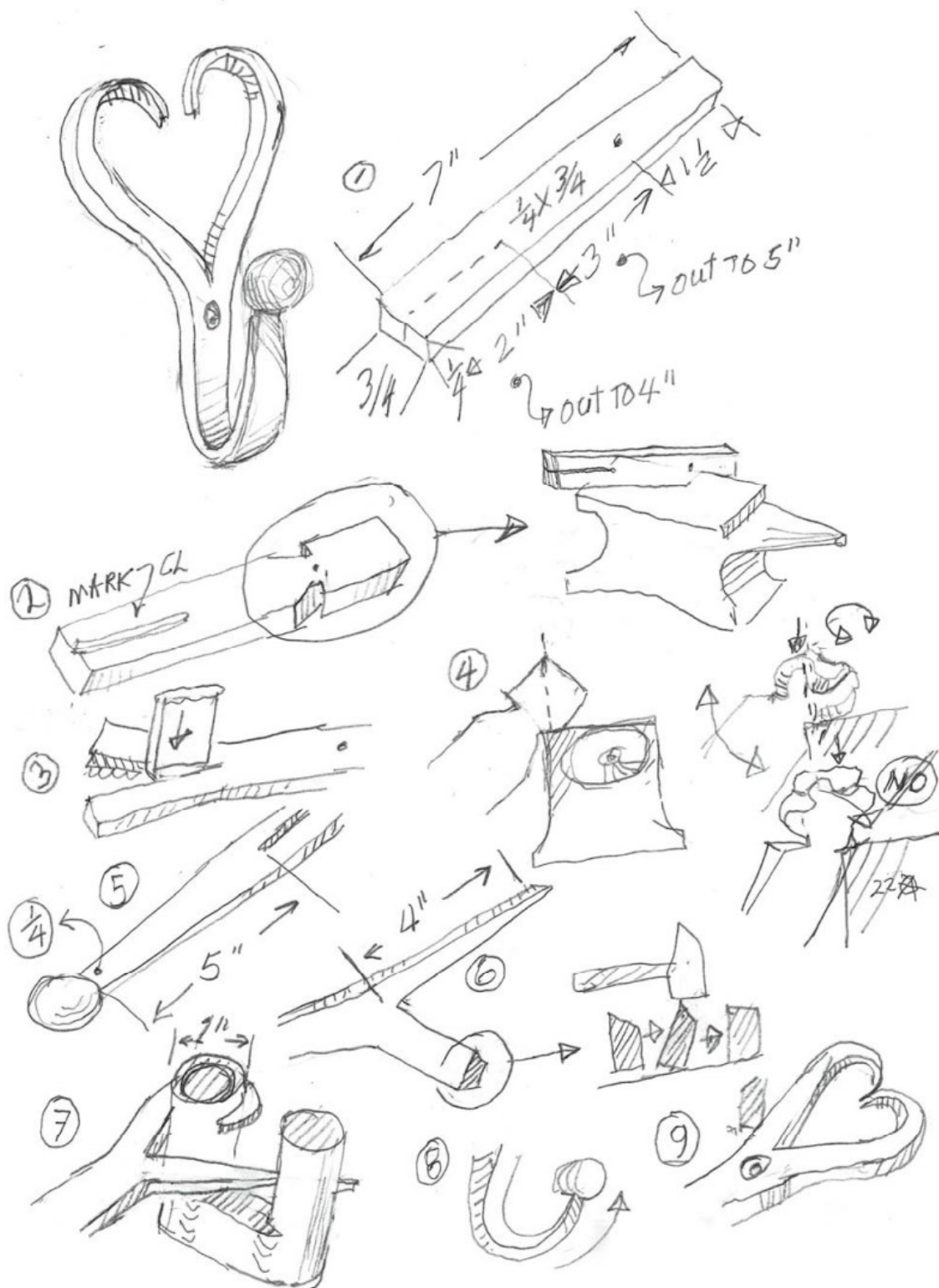
6) Draw out the sides of the heart. You can hold the work with a pair of bolt tongs, that way you won't put stress on the ball joint. These legs will have a angle side left from splitting. When you start forging you want to angle the sharp end up so you can square up the work, then you don't end up with a trapezoid.

7) I added a 1 inch OD (3/4 ID) piece of pipe to one leg of my bending fork which made a convenient size for the heart. When the two legs have been shaped, if they don't meet in the middle they can be tapped together.

8) Bend the hook for the ball.

9) Drill and countersink for hardware.

Reprinted from The Upsetter Newsletter of the Michigan Artist Blacksmith Association



One thing to remember when forging a heart, make sure the edges of the heart touch! No one wants to buy a broken heart! Barry

This 2 page article originally appeared in the Winter 2019 issue of The Hammer's Blow, and is reprinted courtesy of ABANA. All rights reserved

HB

Forging and Twisting Triangular Barstock

by
Travis Fleming of Artistic Anvil
and
Al Stephens of Pequea Valley Forge
Athens, Alabama

Have you ever noticed that when you're looking at a recently completed project, the angel on one shoulder tells you "*That's really nice,*" and the devil on the other shoulder says, "*Yeah, but what if ...?*" Anytime a blacksmith is admiring, dissecting, or re-engineering something, that "*What if ...*" moment always comes around.

One day, while looking at some new twists at Travis Fleming's *Artistic Anvil* forge, Al said that he had never seen a twist with an equilateral triangle cross section. (That old "*what if?*" is a sneaky devil.)

First Tooling

Several days later, Travis stopped by to show Al a perfectly forged equilateral triangle. To form it, he made a bottom tool by cutting a triangle out of a block that could be used under a power hammer. They found that 5/8" round stock was the perfect size to start with.



Image #1

Al then took a 5/8" round piece of S-7, and used his 60 degree "V" tool to make a long triangular top tool and punch.

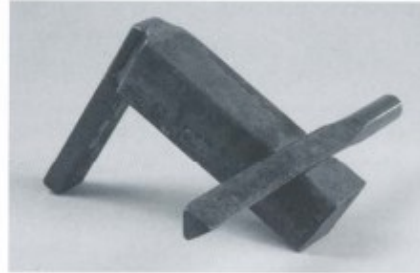


Image #2

Travis had already made several twists, and found he needed a special twisting wrench to hold the triangle material securely. When Al made the wrench, he punched a round hole first, then drifted it with the triangle punch.



Image #3

Al made a block for his power hammer and forged three triangular notches into it, each progressively deeper. He hoped this tool would allow him to work with smaller stock sizes.



Image #4

More Tooling

However, "*what if?*" kicked in again. "*How would they forge a triangle taper?*" Well, they used the S-7 top tool to make a tapered swage block. Al made one for the anvil. Travis made some for the power hammer.

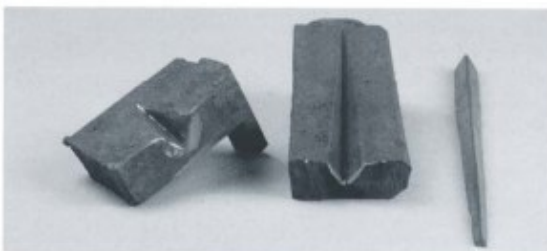


Image #5

This was used first to make a tapered punch by forging a round taper, then forming in the swage so different size twisting wrenches could be made.

Next, they made tongs to hold triangular stock properly. Vise blocks were made next. They discovered that a three-jaw chuck on the lathe would hold stuff perfectly.

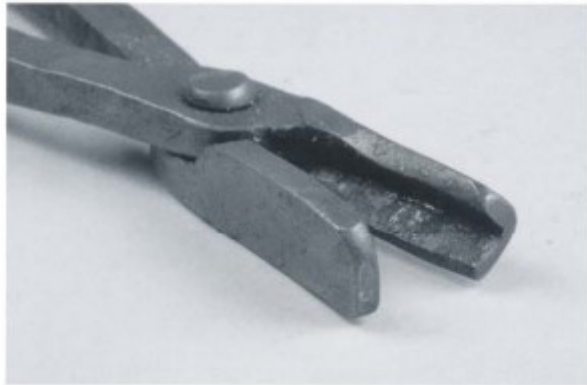


Image #6

Language/terminology/twisting

By this time they realized that they were having problems even talking about what they were experimenting with. They couldn't describe a twist using the standard 1/4, 1/2, 3/4, or full-twist terminology. It had to be 1/3, 2/3, or full. (Or 120 degrees, 240 degrees, or 360 degrees.) They also talked about the number of "flats" or "edges" they counted when twisting. They even numbered the flats on both ends of a piece to help on some early stuff.



Image #7

Applications

Now, what were they going to use these tools, experiments, and terminology to make? A computer search for "hand forged triangles" produced a large variety of dinner bells, some earrings, bracelets and necklaces, and a musical instrument. They found anvil devils and triangle files, but nothing else. Most items used a two-dimensional triangular shaped design element. Al uses flat triangles in several of his production candle holders.

About this time Al had shoulder surgery and was forced to assume old "what if's?" place. Travis began working on a three-legged candle holder, and more "problems" surfaced, such as, *"How do you orient a three-sided leg to show off the fact that it has three sides? Why does a straight twisted shaft appear crooked from different sides? Why does a triangle candle pan only look like it's centered from two points of perspective?"*

A triangular twist can be used anywhere any other twist can be used. The distinction is very subtle, and might be missed, despite all the work that goes into it. Travis and Al have not yet tried splitting, drifting, or mortise and tenon joints with this triangular cross section yet. Perhaps this is why you don't see blacksmiths forging and working with triangular stock.

Challenge

So here's the challenge: Where can we blacksmiths, the undisputed and most talented artist-craftsmen, go with this shape? ■



Image #8: Candle stand, by Travis Fleming. 16" x 7". Travis also made the candle mold so a friend could pour a beeswax triangle candle for it.

This 2 page article, reprinted from the September-October 1997 BAM newsletter

Scrolling on the Diamond

by Walt Hull

Scrolls never seem to go away. You see scrolls or related curves in modern as well as traditional iron work and on the sides of hotrods and Peterbuilt's because they are an obvious and natural answer to the problem of what to do with the end of a line: curl it down to a theoretical vanishing point. A look I've been working with lately is the scroll on the diamond. The shadows on the stock set off the curve dramatically:



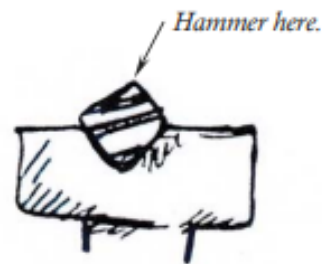
Branching scrolls are visually interesting because they demonstrate that just because you know where a curve has been doesn't mean you know where it's going. Remember that the next time someone gives you "the" mathematical formula for scrolls:



If you split square stock on the diamond you get two pieces with triangular cross-section. To get two branches with diamond cross-section, you have to put them together. Here's an example: cut a piece of 1/2" square bar 16 1/4" long. Mark with a chisel at 8 1/4" from one end and draw each end to 1/4" square, so that one end is 1'-0" from the mark and the other 1'-1" from the mark. Flatten each end on the diamond thus:



At the chisel mark, lay the piece in a V-block and flatten one side (on the diamond) for about 1" either side of the mark:

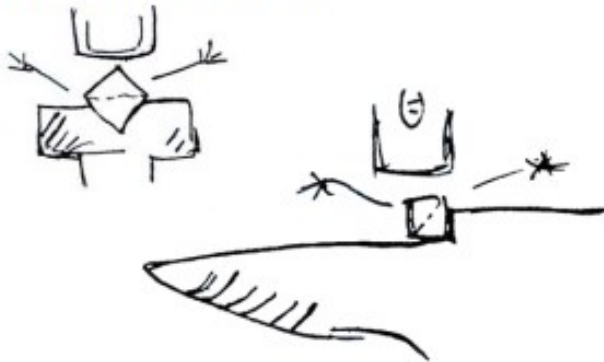


I also like to break the corners slightly with the hammer the full length of the stock for two reasons: I like the look, and if it is necessary to strike the corner in forming or leveling the scroll it won't show as a ding in an otherwise sharp corner.

Now chisel in at the mark and fold the two flats together. Take a heat and weld:



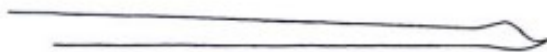
When I weld these I first tap them a couple of times in the V-block to get them stuck and then move to the step and weld on the square:



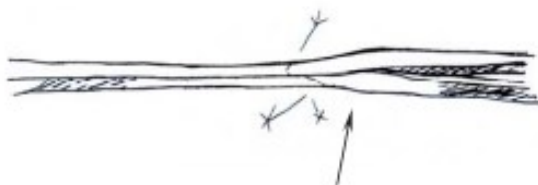
Once you've done a few you'll find it easy to move to the face and scarf in the same heat. Ignore the fact that the branches are on the diamond, and scarf on the square:



Taper and scarf a piece of 5/8" square to match (work on the square – don't let that diamond stuff confuse you at this point) and weld on your other piece.



You should end up with this:



Work this transition smooth at weld heat.

Now you can scroll. Note that you have 2 choices as to how you branch:



Actually, you have to decide clear back there where you flatten the ends, because the flat must lie at 90 to the plane of the scroll.

Scroll the long branch first-



then the other, and then the common part. Be especially careful at the part where they join, lest you get a kink where the thicker material provides greater resistance. Work hot, it is much easier to do this on a form. If you don't have a form for the scroll you want, make it. Use a scrolling wrench to pull the material tight to the form. Be careful to stay on the diamond. Twist is easier to prevent than to correct.

Here's what I ended up with, but the possibilities are literally infinite.



Infinitely Adjustable Vise Jaw Spacer

Michael Wollowski

In the photo below, you see an infinitely adjustable vise jaw spacer. I saw a vise jaw spacer that Clay Spencer made and wanted to build one for myself. His looked like a three dimensional cross and had six useable sizes. In the process of figuring out how to build it, I was wondering whether one could build one with more than six widths. After rejecting several designs, the idea of a circular wedge hit me. It provides infinitely many widths and affords extreme ease of adjustment: just turn the wedge to the desired size. Next, I had to solve the problem of how to hold it in the vise. Again, several ideas were rejected when the magnet occurred to me as the best option. It has several benefits: it moves with the vise jaws, it holds the spacer in its dialed-in position and when you are done with it, just place the magnet and wedge on the post.



Reprinted from The
Newsletter of the
Kootenay Black-
smiths

The wedge is made from a 5" piece of 3/4" mild steel, forged into an 8" long wedge. The wedge tapers gradually to about 1/16" thick. When bending the wedge into a circle, it helps to bend the thick side first. The magnet is about 2" long and can be purchased at Harbor Freight.

For Sale

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.

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.

Forktruck 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:

Meeting Schedule:

August Guild Meeting: Historic Camden. 8/19

Open Forge/Off Month Meeting: September 8th weekend-Forging hosted by Pat and Curly at Pat and Curly's Shop in Myrtle Beach

SC State Fair: 10/12—10/22. John Tanner contact—803-422-4714

October Guild Meeting; Lexington County Museum, 10/28 Heyward Haltiwanger 803-345-3474

Open Forge/Off Month Meeting: November 11-Forging hosted by David Bush in Little Mountain, SC

Myrtle Beach Renaissance Fair: November 11-12 and 18-19, Pat Walters 843-446-6676

December Guild Meeting: 12/9 at the American College of the Building Arts. Contact Ray Pearre 843-860-0532

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

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

COME to the Historic Camden

August Meeting, 8/19

Demo beginning at 10AM

backslapping and glad handing will start somewhat earlier

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

**Rusty Osborne will be demonstrating tools and techniques related to the
Level I ABANA Curriculum. Prepare to be dazzled!**

**Historic Camden is located on US 521, about a mile North of I-20, Exit
98 on the right. If you aren't coming from Sumter, Florence or Colum-
bia, go to I-20, Exit 98 and take 521 North to 222 Broad St.**