



# On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

<http://philipsimmonsartistblacksmithguild.com>

From the President's Anvil:



July 2015

We had our meeting at Roger and Gail Marcengill's timber frame blacksmith/repousse shop with Ryan Calloway demonstrating along with two other smiths, Carey Morton and member Jason Anderson. He and his cohorts did something I haven't seen in a demonstration before - two of them were forging at different anvils at the same time. Ryan started forging a bowl from 1/4" plate using the concave bottom of an oxygen cylinder to shape it and embellishing it with different designs using punches. He then forged the petals of a day lily using 1/8" precut plate, the stalk was of 1/2" square forged round, and the leaves were of 1/8" X 3/4" flat bar, swedged then cut and welded to the stalk. Carey made several feathers using 1" x 1" angle iron. They turned out nice and realistic. Ryan continued with discussing the use of V blocks, hot cuts, monkey tools, top and bottom tools and planishing.

Ryan shared the origin of his knowledge and skills in producing lilies - Howard McCall, one of our Charter members who learned from Master Smith Tom Joyce. Have you ever thought about

who taught you basic blacksmithing skills and how far back these skills go back in time? Boggles the mind! I heard a number of good comments about having two demonstrators working at the same time, made for an interesting learning experience for all of us. Let me know what you thought of it.

Thanks to Roger and Gail for the use of their shop also Jerry & Bessie Fowler for the good BBQ entree and to all the good guild members who brought the sides. It was a great day!

The Iron-in-the-Hat donations were: \$591.00. Thank you one and all - those who donated and those who bought the tickets. New members at the meeting; Patrick Ford, Joshua Waters, Jordan Yarborough, Josh Moore, Joseph Griffin and Jim Bausman (previous member rejoined)

The July 3-5 Magnolia Gardens History Fair sponsored by Ray Pearre and Bill Creek was a success. We had lots of participation from the membership and a Boy Scout in training for his Blacksmithing Merit Badge. Thanks to Bill and Ray for taking the time to set this hammer in up and for being certified BSA instructors. They put in a lot of time making this successful and we were able to stay warm the whole weekend!.

Meck is not doing well. He has lost a lot of weight. His doctors have found an unknown mass on his liver. His spleen is enlarged. His bone marrow is not putting out enough red blood cells, and he has blood clots in his lungs and his arm. Keep him in your prayers. Barry has sent out an email and will continue to keep us up on Meck.

Don't forget to send your request to attend the August Class with Shel to Ray Pearre.

Jesse

## Iron in the Hat

Item	Donated by	Won By	Item	Donated by	Won By
Semi-Square Corner Piton	John Tanner	Johnny Marks	Square Stock	Robert Campbell	S. Weisner
Blower	Jody Durham	Johnny Marks	Garage Door Spring	Jason H. Anderson	John Tanner
Hardy Tool	Jody Durham	Heyward Haltiwanger	Key ring Rack	Todd Elder	Jerry Fowler
Welding Goggles	Joe Marsh	Jody Durham	Spring Steel	Bob Kaltenbach	Ray Pearre
Welding Goggles	Joe Marsh	Ryan Callaway	Forged Feather	Ryan Calloway	Roger Marcengill
Welding Goggles	Joe Marsh	Doyle Harper	Bearing Races and bearings	Perry Thomasson	Ray Pearre
Cowboy Salt and Pepper	Roger and Gail Marcengill	Clyde Umphlet	RR Spikes	Perry Thomasson	Doyle Harper
Door Pull	Roger and Gail Marcengill	Cary Epps	Aluminum Plates	Perry Thomasson	Summer Weisner
Towel Ring	Roger and Gail Marcengill	Clyde Umphlet	316 SS Cuff	Perry Thomasson	Marsha Madore
L Dragonfly	Roger and Gail Marcengill	Pam Etheridge	Homemade Vanilla	Karla Herron	Summer Weisner
S Dragonfly	Roger and Gail Marcengill	Johnny Marks	Ferric Chloride	Chris Herron	Heyward Haltiwanger
Steak Turner	Ray Pearre	Chris Herron	Ferric Chloride	Chris Herron	Rick Thompson twice
Tee Shirt	Guild	Gail Marcengill	Ferric Chloride	Chris Herron	John Tanner
Candle Holder	Jerry Fowler	Clyde Umphlet	Ferric Chloride	Chris Herron	Ray Pearre
Hoof Knife	Cary Epps	S. Weisner	Earrings, Knife	Pam Etheridge	Josh Waters
Horseshoe Rasps	Cary Epps	Doyle Harper	Dog Bottle Opener	Tony Etheridge	Ray Pearre
3/4" W1 Round Stock	Jesse Barfield	John Tanner	Spike Openers	Jim Bausman	Clyde Umphlet
			Buggy Axle	Jim Weisner	Rick Thompson
			Cable Knife	Johnny Keaton	S. Weisner
			Demo Bowl	Ryan Calloway	Perry Thomasson

## 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

**Does your shop have extra work? Do you know of opportunities that our members might be suited for? Welding, piece work at the forge? This economy is still trying to recover as are some of our members. Let Ray, Jesse or Barry know and we will try to match your work up with the skills of one of the smiths. Thanks.**

News from Madison: The winner of the 2015 SBA People's Choice Award was Gerald Duberly's Crab! Second place is Eddie Rainey's Gothic Bench Vice; and third place is Tom Sheet's Dragonfly.

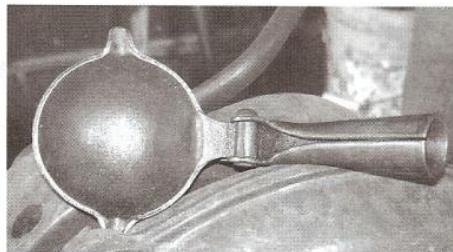
The winner of the Floyd Daniel Award is John Myers; friend of Alex Bealer, historian of the beginning of the movement in Georgia, keeper and loaner of the best set of historic paperwork for digitization to the Blacksmith Archives, ABANA's grant to revive their own archives, and the push to iron out the beginning of the SBA. Thanks John!!!!

See more on Page 7 -9

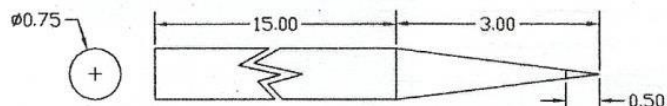
## Folding a Lead Spoon

Project by Jim Stuart, a MABA member

Photo by Tim Lange



Before you can start on your lead spoon you will need to hammer out a mandrel. Start out with a piece of 3/4" diameter by 16" long bar. Hammer out a 3" long taper and then cut the first 1/2" off.



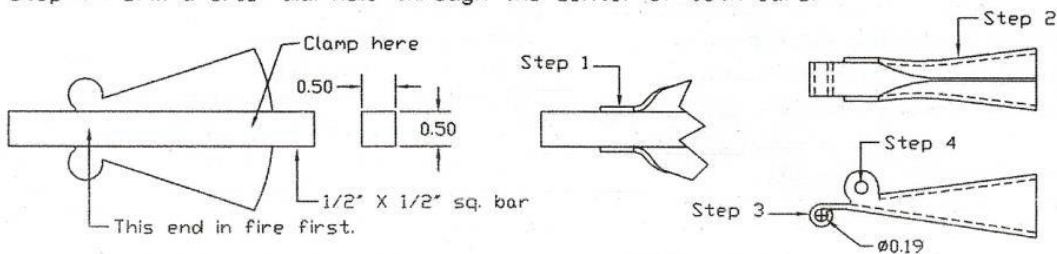
Step 1 : Down the center of your handle blank clamp a piece of 1/2" square bar. Place the end of the handle blank in to the fire, with the sq. bar on top. After the end takes on a red heat place in vice and hammer the two ears around the 1/2" square bar.

Step 2 : Place the handle blank back in to the fire.

Take on a good heat and then hammer the opposite end around the mandrel.

Step 3 : Take on a good heat and form the stop around a piece of 3/16" round bar.

Step 4 : Drill a 3/16" dia. hole through the center of both ears.

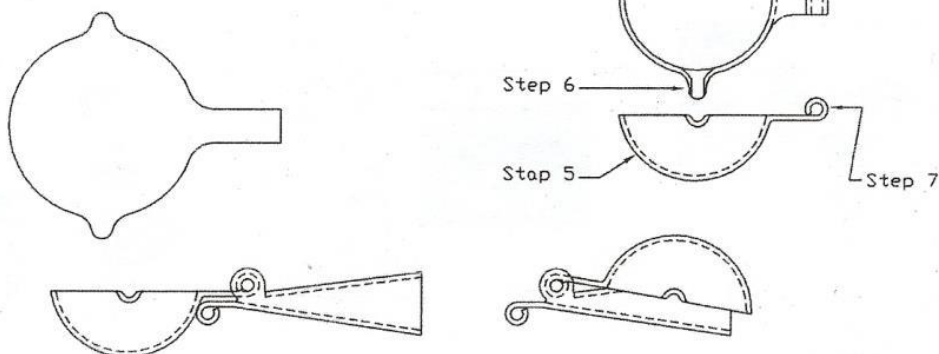


Step 5 : Take a good heat and hammer the bowl shape in to the spoon blank. This can be done with a swage block or a wood block with a bowl shaped impression and a ball peen hammer.

Step 6 : Take a good heat and form the pore spout in to the spoon blank. This can be done with a swage or a wood block with a small half round or a v shaped impression and a cross peen hammer.

Step 7 : Take a good heat and form the hinge around a piece of 3/16" round bar.

Now assemble using a 3/16" rivet.





### Climbing Vine with Leaves - A Forging Idea

The forging problem considered here is how to make a climbing vine with leaves along its length. One solution is to make the vine and a number of individual leaves, and then weld them on. This has its risks, especially if you're not expert at forge welding.

An alternative approach is to make the vine and leaves as one piece, cut from rectangular stock. I've been using stock about 1-inch by 1/4-inch. The accompanying sketches and pictures show the progress on a design element meant to have five leaves, plus one rolled into a bud, on one vine.

The stock is laid out cold as shown in sketch #1, first with pencil, and then with cold chiseling. The marks need to be deep enough to find them when hot. The cuts on the layout lines may be made with a small, sharp, hot cut chisel. As an alternative, the cuts may be made cold with a hacksaw to the extent that there is access. The piece is then heated at the end, and unfolded gently as in sketch #2. As the piece is unfolded, there will be access to make the next saw cut (after cooling it again). I've done it both ways: the cold sawing is precise but requires many heating and cooling cycles, the hot cutting requires a small, sharp chisel to get into every cut location before unfolding. For small work, this also requires a number of heats and care to keep the chisel cool.

With either hot- or cold-cutting, the biggest caution is to avoid overlapping the cuts in the corners. A small tear in the corner will grow into a crack as the forging progresses. Preventing this is by far the biggest problem I've had with this technique. Solutions include: 1) only forge with a good heat, 2) grind/file out cracks as soon as they appear, 3) round out all sharp corners first. I haven't yet tried drilling small holes at each inside corner in the layout, but this might also relieve the sharp corners.

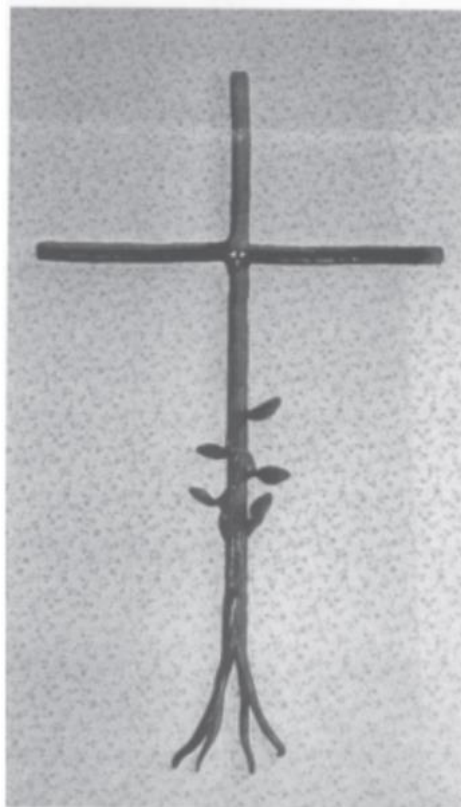
The vine is progressively cut out and unrolled as indicated in sketch #3. When the entire vine is unfolded, then work from one end to the other, forging the leaves and the stems. The diamond shaped leaf blanks can be brought to the anvil to hammer in the two corners on the sides (sketch #4). The leaf blank is then spread sideways with the hammer peen, and textured to suit. The stems are rounded and textured. A systematic pat-

tern of convenience bends, first to the left, and then to the right, will give access to each leaf in turn.

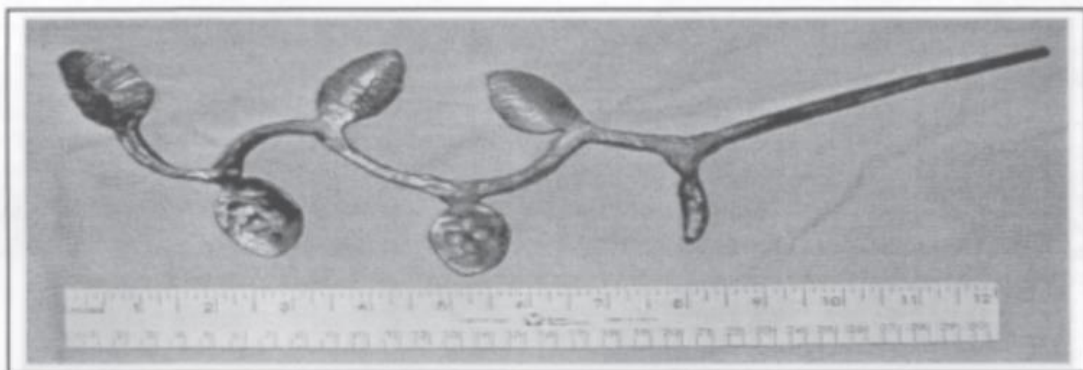
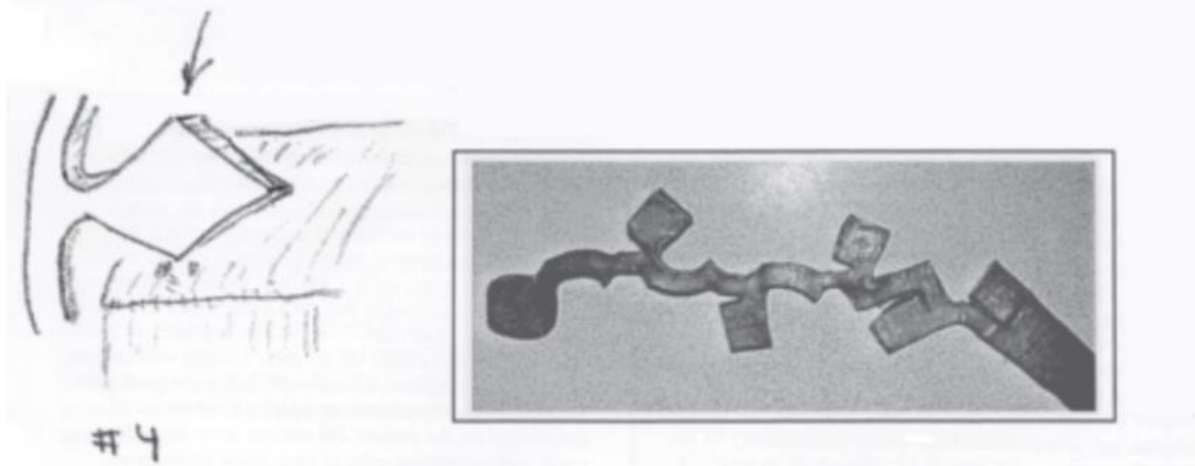
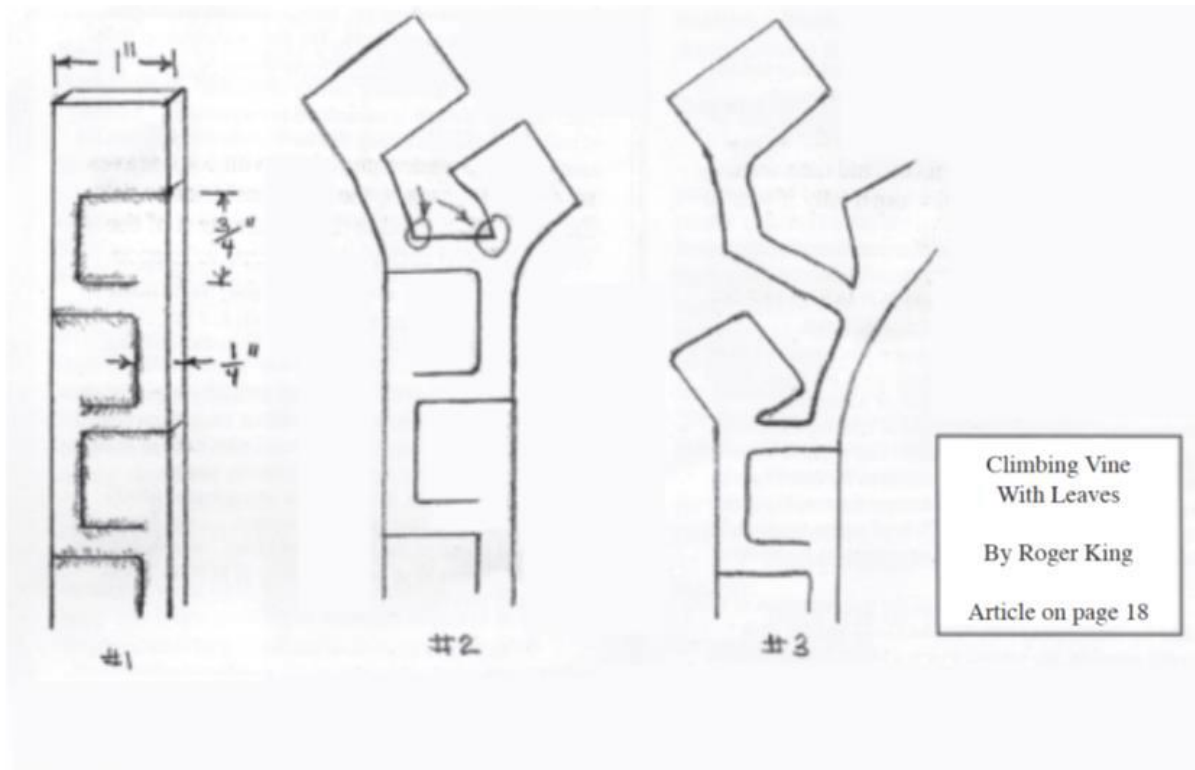
I've made three vines with 5-6 leaves so far. In two cases, the crack that tried to ruin the project occurred in the middle stem of the vine at a sharp corner. This seems to happen when working the leaf immediately adjacent, and the flawed area is not fully hot, nor cold. In one case, I resorted to a repair with the stick welder (which was then hammered out). The third attempt went well because I kept a good heat, and it showed that the technique is quite doable. It is a test of your carefulness in forging.

Roger King

Below - The five-leaf vine was used as a design element in the cross below.



Reprinted from the August 2007 NOB Newsletter



Reprinted from the August 2007 NOB newsletter

## **Working by Hand (*is in Your Mind*)**

**PETER ROSS**

When you hear that phrase “working by hand” do you think of the quiet days on your grandfather’s farm, when work was done at a slow steady pace and the noise of a diesel was years in the future? Working by hand brings up an image of peaceful, careful work— something to dream about when you’re rushing from one job to the next. Anyone who has tried hand tools now and then knows that they are slower than power tools. How did anyone get things done? If they were farming by hand and washing by hand and cooking by hand how did they have the time to build the houses and barns that have stood in this country for 100 years? And build them without power tools.

While some hand tools may be slow, there are ways to make the job go faster. One of these ways is to use fewer numbers. Good workmen back then could add or subtract or read a rule as well as anyone alive today, but they measured without using numbers. How do you do that? Caliper or dividers or a story stick are just as accurate as a tape measure but can be read instantly with no calculations. In some instances they simply held the piece up to the space and traced right on the board where to cut.

Another way to speed up the work is to eliminate accurate measuring whenever you can. A good example in the new blacksmith shop is the strap hinge for the big double doors. Instead of drilling the mounting holes in each hinge, they were punched at the anvil while the hinge was hot. Since the hinge was already hot in order to beat out the

taper, punching didn’t add much time. The holes are not perfectly spaced, but don’t need to be. Since only an approximate spacing is needed quick eye judgment is sufficient and the holes could be punched without measuring.

Even the size of the hole can be approximate. To make a hole you drive a punch though the hot bar. By making the punch taper towards the tip you can make the hole bigger by driving it through farther. As long as you keep a sample bolt handy to check once in a while, you can make holes that fit without having to be precise.

Again, no need for numbers. The hinges themselves vary, too. At a glance they may seem like duplicates, but on closer inspection each is a different length and shape. To make them more alike would increase the time considerably, but not improve the function at all.

When you are in the habit of working this way you start thinking about which details matter in a piece and which ones don’t. There are always a few things that do matter. The hinge eye should fit the hinge pin. The hinge should be flat so it mounts to the door. But it can be longer, or shorter, or the holes can shift. This is the key to working faster once you have the basic hand skills mastered. It allows you to concentrate on the details that are important without being distracted by the ones that are not. When you watch someone work this way, it can seem like the work comes out perfectly, with no measuring or figuring, as if by magic. Actually, it is just knowing what to focus on.

Reprinted from the Hammers Arc, Alex Bealer Blacksmith Assoc.

**If you aren’t getting irritating emails from Barry, email him so that he can get you on his list!**



## Pictures from the SBA Conference at Madison









Bob Kaltenbach and Rick Thompson got to meet Peter Ross and see his kitchen ware. Some of Meck's knives are shown on the previous page along with one of Clay Spencer's caskets. The foot of our section of the room divider project is also shown as well as the top of the project on the front page. Thanks to all who worked on the panel, it was a very well executed piece. They were: Steve Allen, Josh Weston, Jody Durham, Bob Stukes, Bill Creek, Rick Thompson, Jesse Barfield, Ray Pearre, and Gail Marcengill. The show and tell gallery was very good this year.



Ray and Jesse spent a lot of time in the teaching tent.



## For Sale:

- **Fire Bricks – Brand New, Industrial Grade.** \$1 ea. Ed Sylvester 803.414.2487
- **185 Joy Air Compressor, Diesel, John Deere, \$3000.** 185 Sullivan Diesel Air Compressor \$2000, Both the Joy and Sullivan for \$4500 obo. Two Milwaukee portabands, \$100 ea. Lincoln flux core Pro-Welder Mig w/2 extra rolls of wire, \$250. Steam Cleaner – Steam Jenny Model 200 Plus 115 Volts, Diesel Fuel, \$150. Trailer, 20' bed, 3' tongue, 2 axles, needs wheels, \$250 Trailer for backhoe, 13' Bed, 2'Dovetail, 4'6" tongue, No Ramps, 3 axles, \$500. Wilton 6" Bench Vise, \$100 obo. Emglo Shop Air Compressor, 5 hp, 230v, \$500. Contractor's toolbox, 48"x60"x30" w/locks, \$550 obo. Hypertherm Plasma Cutter, Max 42 w/20' torch, \$700 Half inch chain 4 sections of 20 each, 4315 # working load \$50 ea. Compact Metal bender with dies for scrolls \$85, 2 steel boxes, 24"x24"x30" (high) \$280 ea. Charles Meyer, 843-729-5861
- Two (2) 4ft. by 4ft. platen (acorn) tables, \$800.00/ea. 50 lb. Little Giant Hammer, \$2,300.00. 250# Fisher Anvil, Made in 1917 - in excellent condition \$1,000.00. Marvel Band Saw w/ 2 new blades, \$600.00. Double - sprocket Leg Vise, rare - vintage 1920, \$900.00. Bar Twisting Machine, pickets up to 1 1/2 inch, \$2,500.00. 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.
- **Dewalt variable speed deep throat porta band**, as new model DWM120, \$175. **Floor model craftsman drill press** needs belt, \$75. **Shop cart**, \$35. **Gilson Concrete mixer** \$175. **Delta bench 8 inch band saw** model 28-185, needs tires \$75. **Al Jenkins, 843-442-4930.**

## Upcoming Events

- Ryan Calloway is offering Saturday workshop Introductory Welding and blacksmithing class at Creative Iron Works at 12 Andrews St., Greenville S.C. on **July 25<sup>th</sup>, August 22<sup>th</sup>, and August 29<sup>th</sup>**
- **July 3-5** Magnolia Gardens History Fair, join Ray and Bill for Blacksmithing weekend.
- **October 9-11**, Magnolia Gardens Autumn on the Ashley Craft Fair,
- **October 17<sup>th</sup>** is at Tommy Taylors Shop with Chris Herron demonstrating, Johnsonville.
- **November 7-8** Mythical and Medieval Fest, Myrtle Beach
- **December 12<sup>th</sup>** at John and ML Tanners home in Swansea.
- **February, 2016.** Meeting at the Paul Farm in Conway. Walter Hill is host.

**A Bit of History** by Albin Drzewianowski Reprinted from the Blacksmith Guild of Central Maryland

There is a British blacksmith, Gary Huston who has quite a few videos on YouTube. They are quite good. He did one titled "*Mini Farriers Axe*" <https://www.youtube.com/watch?v=pCb8Gddi0tY>

In the video he takes a ball peen hammer and makes a spike out of the peen and an axe blade out of the face of the hammer. The interesting part is that the full sized tool was carried by British military farriers during World War I. When they came upon a horse that was injured and had to be put down, they used the spike to the forehead of the horse to put it out of its misery, and then used the axe to chop off the horse's foot that had its registration number. It was like taking the dog tags of a dead soldier. The farrier turned the foot in for record keeping purposes: what happened to the horse, where, and when. He said that they are still carried today for ceremonial purposes. If you GOOGLE: "farrier's axe" you can learn a little more about this type of axe and see some pictures. In the pictures, they are quite a bit larger than the one that Gary forged out in his demonstration. *You see a lot of these types of axes made from ball peen hammers, but they are usually referred to as a war axe or a Viking axe. Here was a much more mundane/practical purpose for the tool.*

*I'll bet Jerry Fowler or Cary Epps has one of these...Barry*

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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 – 2014” or “Dues for 2015 are due”

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



## August 15, 10 AM

The August Meeting will be at Historic Camden sandwiched between a Shel Browder Class on Friday and Sunday.

In the class, Shel will show us how to make a colonial style divider and kitchen utensils as time and talent permit. He will surprise us at the meeting! The class will cost \$40. There are 3 spots remaining at this time.

Bring a side or dessert and maybe something nicely forged for Iron-in-the-Hat. Don't forget, Ray gives you 5 free tickets if you bring something you have forged for iron in the hat!

Take I-20 to Exit 98, then North on 521 about 2-3 miles on Right

The October meeting is at Tommy Taylors Shop in Johnsonville with Chris Herron demonstrating, on October 17th.