

# On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD



The February meeting at the L.W. Paul Farm was great as usual. The perlow was as great as ever, but the perlow color guard parade was even better! Walter Hill's demo of a flint striker and a tasting spoon were very educational to our members and a nice thing to watch—Oh, yeah, I wasn't there, but I saw the parade on Instagram!

But, I know all of these things to be true! Thanks to the Conway Museum Staff, Walter, Bob and Sharon Hill for all the effort to put on a great meeting as I know it was. Ray, Bob, Todd, and Rusty represented the Guild Officers well. Jody and I will try to do better, but it is hard to make all the meetings.

The Guild is exploring hosting a new schedule of workshops to be held on alternate months from the regular meeting if you, the members have the interest to do it.. The workshops will be open to Guild members only to ensure that we have appropriate insurance coverage.

We are looking to provide an opportunity for new blacksmiths to learn and practice the craft, experienced blacksmiths to work on specific or joint projects, or even for members to work on the ABANA National Curriculum.

The workshop will be from 8 am until 5 pm, on the second Saturday of the month, every other month, starting on March 11, 2023.

Jason Jaco has graciously offered to provide his shop for us to get this kicked off: TexasStreetWorks, 931 Texas Street, Columbia, SC 29201. Ryan Calloway has also offered his shop, so we will have workshops there, too, in

the future.

Jason Jaco, Todd Elder, and Tony Etheridge have offered to provide help and instruction for attendees as needed and I am sure we will have other smiths that participate and will be willing to share their experience.

There is plenty of flexibility in this opportunity. Nothing is set in stone. The idea is for us to get started, have a set place on the calendar to allow members to plan on attending, and see where it takes us! We hope to see you there!

The Southern Blacksmith Association—the gathering of the 7 ABANA Affiliates in the southeast, is coming. One very important thing to tell you is **there will be no flyer mailed to you this time**. You will be emailed a notice when the registration is up and running. You will have to go to the website and register online! Get one of you children or grandchildren to help you!

Tools are needed for the toolbox that will be raffled off. These may be a tool you have made or one you have and can part with. Any tool not included in the toolbox will be placed in one of the Iron-in-the-Hat raffles for fund raising to pay for the Conference.

Remember that the Conference is only \$55 for you and your family for the three day event. To keep the price down, the brochure not being sent out is one of the ways it has cost \$5000 in the past.

Jason H. Anderson is going to provide the three hour demonstration for us that each of the Guilds will provide. Ryan Calloway represented us last Conference. And I am sure Jason will do well this time.

We need volunteers to man the Green Coal classes - both for a leader to herd the individual instructors who will come from our Guild and instructors from the other groups and for those from our Guild who can take an hour or two to instruct a newbie to make a hook or bottle opener or other project.

Another responsibility for the Conference is the Gallery. This is a chance to sit in the A/C for an hour or two making sure no one walks off with a fellow smith's pride and joy project. You also get a good opportunity to examine all of the beautiful works of art that the smiths have brought to show.

Let me or one of the officers know if you are interested in the off-month classes or if you will volunteer for any of the Conference activities. This is a great Conference and it needs you to keep it great. Step up!

Hope to see all of you at Magnolia Gardens on 4/1

Barry, not Jody...

## INSIDE THIS ISSUE

Iron –in-the-Hat and a tip.....	2
Forging a Coffee Scoop.....	3
Centerpunch Variants.....	6
Forging a Leaf Hammer.....	7
Napkin Ring utorial.....	8
Resources Sources.....	9
kHammer in Photo and	
For Sale/Events.....	10
Officers Page.....	11

# Iron in the Hat

Item	Donated By	Won By	Item	Donated By	Won By
Farriers Rasp	Mackie Bryant	Chuck Baldwin	Pecans	Bill Burgess	Janie Higgins
		Tracy Hartfield	Pecans	LaDonna Burgess	Janie Higgins
		LaDonna Burgess	Cracked Pecans	Pam Bush	Todd Elder
		Hal Cochran	Spring	Rusty Osborne	Mark Ramey
Gate Hook	Bob Hill	Clyde Umphlett	Boot Scraper	Gerald Alsbrook	Curly Lawson
Cable Damascus Knife	Meck Hartfield	Chuck Baldwin	Gear	Clyde Umphlett	Tim Regrat
Copper Bars	Tracy Hartfield	Chuck Baldwin	Draw Knife	Clyde Umphlett	Pat Walters
		Mark Ramey	Metal Stock	Steve Murray	John Ard
Valentine	Sharon Hill	Clyde Umphlett	RR Spikes	Phill Hair	Curly Lawson
Herb Chopper	Mark Ramey	Clyde Umphlett	DVD from 1996	Jimmy Stone	Bruce Hester
Files and Copper Flat	Kenny Cartwright	Valerie Barrineau	Non-marring Hammer	Russell Wilson	Ratt Weaver
Small Bench Vise	Keith Gunter	Tracy Hartfield	Aloe Vera plant	Mary Long	Ray Pearre
Fire Pit Poker	Keith Gunter	Curly Lawson	Spatula	Todd Elder	Tobin Tyler
RR Spike Dagger	Jo Marsh	John Ard	Striker Demo Piece	Walter Hill	Todd Elder
SC Cutting Board	Jo Marsh	Phillip Hair	Tasting Spoon Demo Piece	Walter Hill	Rusty Osborne
			Ornamental Hanger	Dave Bush	Danny Johnson

The Iron-in-the-Hat garnered \$835 from your generous donation and ticket buying! You are terrific! Thank you for your generous support!

New members since the last newsletter are: John Ard; Donald Powis; Tom Regrut; LaDonna "Lawn-mower-blade" Burgess; Brandon Handcock; Timothy Rabon; Oscar Floyd; Mar-cye Brown; Phillip Hair; and Ellen Yaghjian

Returning former members are: Danny Johnson; and Tommy Taylor

Welcome and Welcome Back!



Story board from Nick Rossi, via Facebook with Nick's permission.

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



# Forging a Coffee Scoop

by Barry Myers

I thought about making a coffee scoop for each of my daughters. My wife says she was fine with the 1/8 cup one that came in the set. She doesn't really like my homemade stuff...



So, I knew that I needed to make a disk and then pound it mercilessly into submission. Okay, maybe gently coerce the disk into a bowl so that I could make the bowl and then attach it to a handle. How to decide how big a disk to make?

The first one, I got a piece of brass sheet and cut out a square and started coaxing into my swage block smallest bowl hole. It quilted and wasn't that successful. To YouTube we go! Green Haven Forge ( <https://www.youtube.com/watch?v=Zro3OxCyQD8> ) shows how to forge both the bowl and the handle and rivet on the bowl. Rigoni Ironworks ( <https://www.youtube.com/watch?v=t7ix4tVu3NU> ) shows forging both the handle and the bowl from one piece, and does this guy have some neat tooling for his power hammer! He barely uses a hand hammer! Stage Coach Farm & Forge ( <https://www.youtube.com/watch?v=Dr9n2aPOVOc> ) shows how to hammer out cute leaf handle and a copper ladle bowl.



What they didn't show or I didn't find, was how to tell how big a disk should I start with to come up with an 1/8 cup scoop. I was an engineer in a previous life, well this life but a long time ago.



Mark Aspery tells a story on himself when he quit school and the foreman of the blacksmith shop asked him, "How's your trig?" That is trigonometry for some of us.

Well, you need to dust off your algebra and geometry for this one: decide what volume you wish to achieve, double it and use it to find the radius of the sphere; use that radius to find the area of the outside of the sphere; use that area to find the radius of a circle necessary for the disk! The metal will stretch some, but this will get you very close. I won't make you do that math as I know you all can do that easily.

.....Continued next page

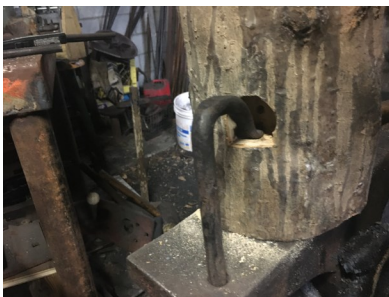
## Coffee Scoop (con't)

So, I have included the following table. If you need to know the calculations for other sizes, give me a call!

1/8 cup scoop	1.7" diameter disk	1/4 cup scoop	2.8" diameter disk
1/3 cup scoop	3.4" diameter disk	1/2 cup scoop	3.9" diameter disk

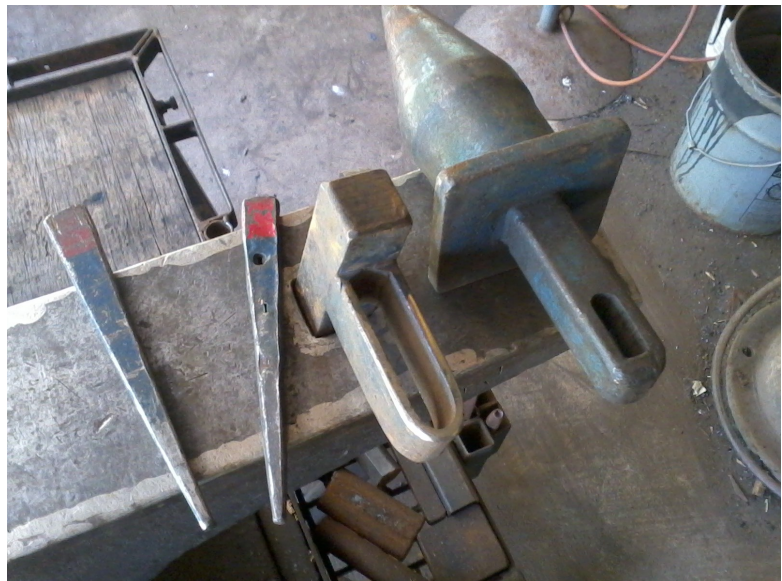
Pounding the disk into submission was another challenge. I found on YouTube a video by Linea Libre ( <https://www.youtube.com/watch?v=U9nMSyLQ-h0&t=304s> ) that showed how to pound the disk into a carved/turned wooden form. He was careful to anneal the disk before it becomes too hard to safely work without splitting the metal. I used brass; he used copper. Your choice. Polish your hammers and other tools that will contact the brass or copper. Any mark or imperfection on the tool will transfer to the work piece and it will show in the final product.

I am not going to get into the coffee scoop business. Maybe not a two off, but not a whole lot of them. So, I am not going to make molds. I did find the Green Haven Forge the most help in forging the bowl. He had a conical hole carved in a stump to hammer his bowl into. I drilled and carved one in a piece of hardwood end grain and used that to hammer my bowl. I also used a polished domed-head railroad bolt to further shape and smooth/planish the bowl.



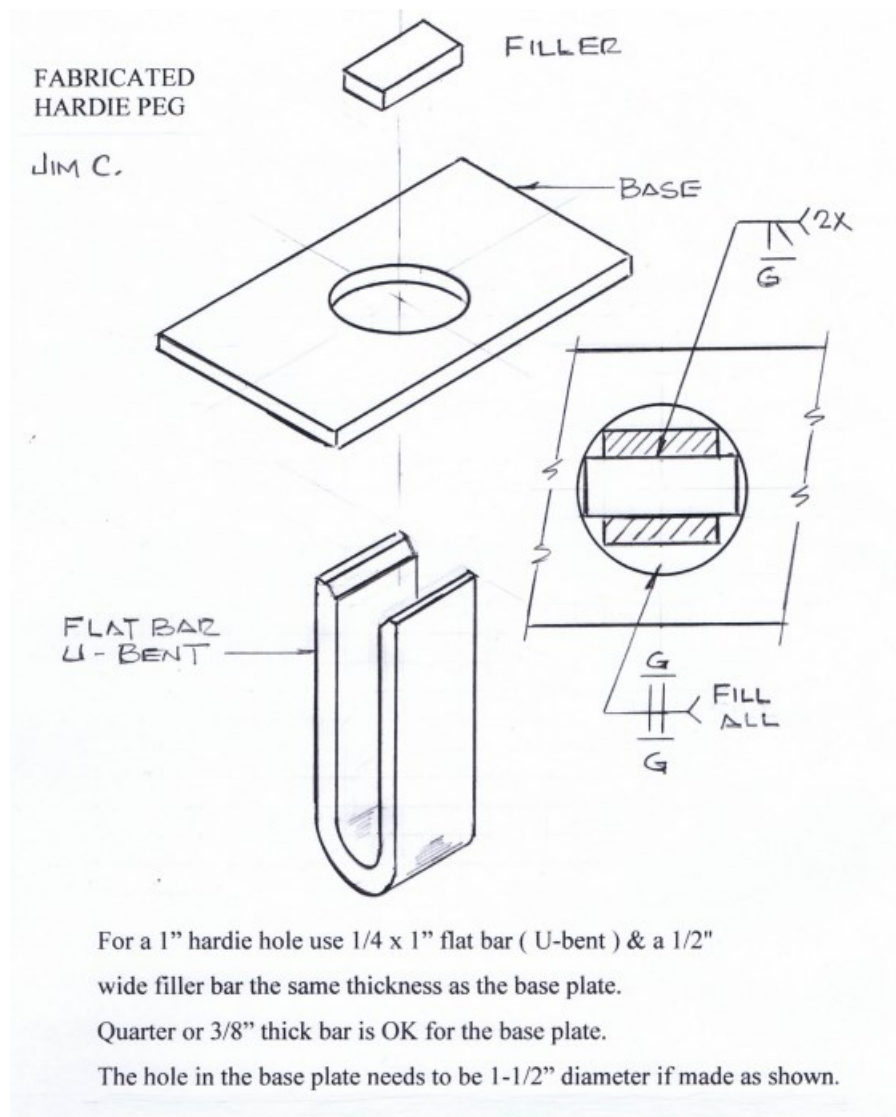
In the process of making the scoops, I found I needed the stump to be stabilized on my anvil. I drilled and chiseled a flat bottom hole in the side of the stump and used a hold fast to stabilize the stump. It worked very well, and I can make a hole on the other side so that I can use the other end, too!

In having this article edited by one of my go-to guys, Jim Carothers, he sent me pictures of his anvil hold downs. Here are some of Jim's fabricated hold downs. More hold downs and Jim's method of fabrication are on the next page.





## Jim Carothers' fabricated hold down



Here are some pictures of Jim's railroad track bolt for use in his anvil. You can adjust his materials plan to fit your anvil.

Barry

# Center Punch Variants

By **Steve Bloom**, *Ironflower Forge*

Since we all have had more time in our forges lately, you might like a shop project.



My first center punch was part of a file - I could not resist considering the 'Flat Bastard' markings. While this has served for 35 years, it has limitations in terms of grip and point sharpening.



Some while back, I acquired a mill and -as a result- a collection of broken end-mills. A 5" scrap piece of 5/8" diameter bar can be drilled to accept 3/8" end-mills. Drill and tap a 10-32 set screw and you are good to go. If you have a knife grinder or a bench grinder and a hand drill, putting a point on is easy.



The next variant came about due to ageing eyes and glasses. I needed a punch that I could position on the work with a bit more precision. The handle is a scrap of 7/8" square tubing (from a NordicTrack if I remember correctly) with a slug of 3/4" square stock welded on. The slug was drilled to accept 3/8" end mills, was slit from the end to the hole and a 1/4" hole with bolt was added to squeeze the slit and lock the end mill in place.

From the 1st Quarter 2021 Northwest Blacksmith Assn's Hot Iron News

I found that for some projects, I needed more precision and a third hand. What I came up with consists of a base (6" x 3.75"), a curved arm (5.5" x 1/4"), a piece of pipe (3/4" Sch 40) and a scaled-up version (7/8" x 6") of the end-mill holder.



After using this unit for awhile, I found it really helpful to add a mount for a small flashlight. Not only does this help when punching, it means I can find a flashlight when I need one. Occasionally I need to drill round stock, so welding up some scrap angle iron as shown here is worth the time. All of these various dimensions were not planned - they just happened to be what I found in the scrap pile.

Thanks to my wonderful wife - Kimmy for proofreading this and many other write-ups.

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Our grateful thank you to Steve Bloom, Ironflower Forge for sharing his work with our readers. Steve served as the Editor of Florida's "Clinker Breaker" for many years.



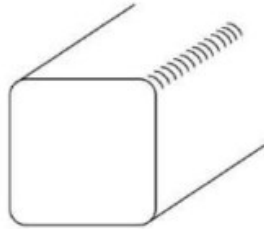
## Leafing Hammer Straight & Cross Pein Mike Mumford, RoadRunner Forge



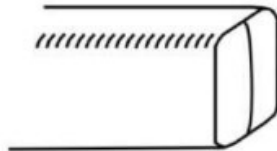
Stock: 8", 3/4" round, 4130

This will make a 1-lb hammer, about 9 1/4" long.

1. Flatten on all 4 sides, creating a rounded-edge square.



2. To avoid fishlips, start the ends by creating a slight chamfer. There should almost be a line across the ends, created by the chamfers. I find this easiest to do in the post vise, using a light hammer and rapid blows.



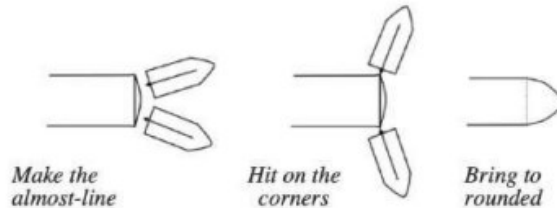
Make sure that the "almost-lines" on the opposite ends are perpendicular to each other, so that you end up with a straight pein and a cross pein.

Once you have the "almost-line" defined, begin to hammer on the sharp corners, working toward the ends becoming roughly round, about 3/8" across, with a smooth transition to the body.

### The Afternoon Blacksmith

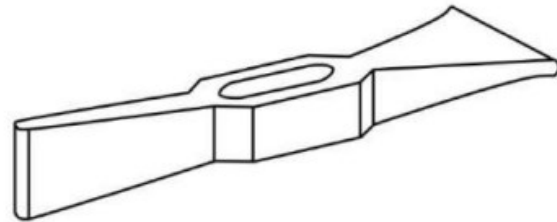
This is the first in a series called "The Afternoon Blacksmith." Drawing on experience at teaching forges, this is a project that a mid-level 1 student could be expected to complete in an afternoon.

This particular example draws on my teaching experience: level 1 students have been able to complete this in a Saturday afternoon class, most recently in July 2022.



3. Mark the center, then punch with a 1/8" x 7/8" slot punch. Drift the eye to desired size.

4. Make a long, straight taper on each end, stopping the taper at about 1/4" from the eye-swell. Note: do one end, then swap and do the other end.



5. Put a slight curve into the hammer (see photo above).

6. Clean and polish the faces. Harden the faces if desired.

7. Attach the handle.

8. Enjoy!

Reprinted from the California Blacksmith Online where Mike is the editor. Thanks, Mike!

# Forged Napkin Ring

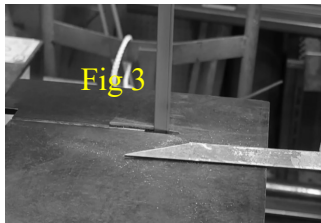
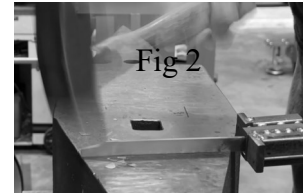
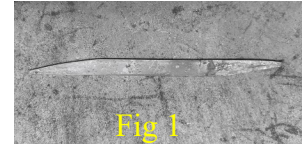
by Bill Kirkley



The following describes the process to forge a napkin ring.

Use flat bar stock 1/2" X 1/8" to make the napkin ring. Both ends of the flat bar are tapered to a length of 1 7/8" at each end, Fig. 1.

If the taper is forged, use 7" long stock, Fig. 2. If the taper is cut, use 8 1/4" stock, Fig. 3.



The taper at each end of the bar is bent over the horn. Fig 5 A bending jig makes the process easier. Fig 6-8. The piece is bent around a 1 1/2" diameter cylinder. Fig 9 – 10. The napkin ring is adjusted cold in the vise. Fig 11 & 12. The napkin ring is heated so it is hot to the touch and finished with paste wax. Fig 13 - 14.

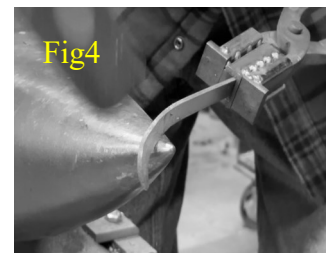


Fig 6



Fig 7



Fig 8



Fig 9



Fig 10

Fig 13



Fig 11



Fig 12

Fig 14





I haven't posted a page like this for a while as I often forget that new smiths don't have the knowledge of good sources for our craft information. I saw this page in the *Anvil's Chorus*, the New York State Designer Blacksmith's newsletter. Thanks to Mark Teece for reminding me. Barry

## Resources

### Sources of materials, tools, and information

#### Steel

Express Metals Outlet

A Klein Steel Company – Rochester, Syracuse,  
Buffalo, Albany

<http://www.expressmetalsoutlet.com>

#### Tool steel and alloy steel

Nolan's Mill and Metal

<https://www.nolansmillandmetal.com>

#### Wrought iron from 1887 Globe Elevators

Old Globe Wood Company  
[www.oldglobewood.com](http://www.oldglobewood.com)

#### General blacksmith supplies

Blacksmith Supply

<http://www.blacksmithsupply.com>

Blacksmith Depot

<http://www.blacksmithsdepot.com>

Centaur Forge

<https://www.centaurforge.com>

Pieh Tools Company Inc.

<http://www.piehtoolco.com>

#### Anvils

Nimba Anvils

<http://www.nimbaanvils.com>

Jymm Hoffman anvil

<http://www.hoffmansforge.com/my-work/anvils/>

#### Swage blocks and cast iron items

Saltfork Craftsmen – swage block and floor cone

<http://www.saltforkcraftsmen.org>

Swage block, anvil cone, fire pot, heading block

Contact Bob Menard

[ballandchainforge@yahoo.com](mailto:ballandchainforge@yahoo.com)

#### Gas forges

Chile Forge

<http://www.chileforge.com>

NC Forge

<https://www.nctoolco.com>

#### Building gas forges and gas forge supplies

Zoeller Forge

<http://www.zoellerforge.com>

Anvil Fire

<http://www.anvilfire.com>

Dave Hammer gas forge build

<https://www.youtube.com/watch?v=PbvG4vVJqCw>

#### Gas forge burners

Hybrid burners

<http://www.hybridburners.com>

Dave hammer simple burner

<https://www.youtube.com/watch?v=VxzdqcPzXj8>

#### Information on a wide range of topics

Anvil Fire

<http://www.anvilfire.com>

I Forge Iron

<https://www.iforgeiron.com>

#### Forging blanks and projects

Quick tongs

Ken's Custom Iron

<https://kensironstore.com>

Stoney Point Forge

<http://www.stoneypointforge.com>

Some sources of 2x72 belts in no particular order of preference: Combat Abrasives, Red Label, Phoenix, Preferred Abrasives, VSM, Trugrit Abrasives, Pop's, Supergrit, Hermes AO 400, 3M Cubitron II, Norton Blaze, Klingspore, Preferred Abrasives Firestorm II, Brodbeck Abrasives

If some of you more-experienced smiths have sites or vendors who the newbys might need to know about, let me know and I will add them in future issues. Barry



### Hammer-In at the North Augusta Living History Park

From Left: Joseph Kursch, John Tanner, Barry Myers, Ed Harmon, Conal Smith, Tony Etheridge.

Missing are Jim Pender, Bob Kaltenbach, Chris Carroll and tire kicker, Mackie Bryant

Most of us even took home a trivet!

## For Sale

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

**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](mailto:ironsmith@gmail.com)**

**Clay Spenser's Tire Hammer Plans \$30. [clay@tirehammer.com](mailto:clay@tirehammer.com) or check/mo to 73 Penniston, AL 35670.**

## Upcoming events:

### Meeting Schedule:

**April 1st Guild Meeting. 4/1 at Magnolia Gardens. Ray Pearre contact.**

**SBA Conference: Madison, Ga. May 18, 19, 20.**

**June Meeting : June 17, Westminster SC at Roger and Gail Marcengill's home and shop.**



## Philip Simmons Artist Blacksmith Guild

<http://philipsimmonsartistblacksmithguild.com/>

### President: Jody Durham

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PO Box 223

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843-457-2755/[ben@fieryice.us](mailto:ben@fieryice.us)

#### Bob Stukes

3125 Old Hwy 52, Moncks Corner, SC 29461  
843-708-3500/[restukes@yahoo.com](mailto:restukes@yahoo.com)

## 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 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 2020, Dues for 2021 are Due, or Dues Paid for 2021"**

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

# **COME to Magnolia Gardens**

**April Meeting, 1/1**

**Demo beginning at 10AM**

**backslapping and glad handing may start somewhat earlier**

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

**XXXX will be doing the demo! Prepare to be dazzled!**

Magnolia Plantation and Gardens is  
located on SC 61 between Charleston and  
Summerville on the river side.

3550 Ashley River Road  
Charleston SC 29414