

On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD



Hello fellow blacksmiths!

Above is the SBA Group Project submission by our Guild. The design is by Obadiah Kuebler. It was completed at Ryan Calloway's shop in Greenville. Jesse Barfield wrangled the project to get it done on time and under budget! There were other contributors that I will try to include in the next newsletter. Thanks to all of you!

Our meeting at the Magnolia Plantation and Gardens was a success. I'd like to thank Ray Pearre and Bill Creek for hosting and providing the chicken!

Josh Weston (whose picture was bumped so that the grill could be featured) was generous enough to demonstrate at the meeting once again. Last year he made a really neat copper spoon/dipper. This time he went big by forging a throwing axe! I picked up a few ideas from the demo, as I am sure others did as well. One of my favorites was Josh's drifting tube. He used along piece of thick wall tubing that was racked to fit the shape of the drift and used it to aid in shaping the eye of the axe. another one was the way he used a chain clamp to hold an angle grinder to allow him to hold the work up to the grinder with both hands.

It was a great demo and some audience participa-

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tion was allowed as Josh needed a striker and blower operator.

We started off the morning with about 45 in attendance and by lunch, I am sure that number rose to almost 60.

As always, I am amazed at the amount of donations to the Iron in the Hat we have at each meeting. We raised \$637.00!

I'd like to thank Jesse Barfield for taking the lead for the last 5 years as President. As the new president I hope to continue Jesse's level of leadership.

Barry say's he and Bob Kaltenbach had a good hammer-in at the Living History Park in North Augusta. Those that attended left full of Bob's jambalaya carrying steak turners and flint strikers, if they hammered diligently and stayed until the end. New members from the hammer-in are Howard Malaby, Steve Ingle, Judy Ingle, Jonathan Moore, and Craig Gray. Other new members are Noelan Dather and Alan Phillips.

Also we had a returning member! Robert "Bob" Thomas has returned from England where he took an apprenticeship and a stray period after the apprenticeship. He has started a blacksmithing business in Charleston! Bob has published a blacksmithing book since he returned: *The Art and Craft of the Blacksmith: Techniques and Inspiration for the Modern Smith*. Ray has a signed copy for the Library.

Please welcome our new members this month! Oh, and we are at 202 members right now! Pretty good as we purged the folks that have not paid their dues for the past year.

One more thing! John Medlin came in second on his appearance on *Forged in Fire*. He made an excellent sword, the other guy's just happened to be prettier. Congratulations, John!

Have a good one, Jody

IRON IN THE HAT

Item	Donated By	Won By
Throwing Axe Demo Piece	Josh Weston	Charles Meyer
Blacksmith Knife	Josh Weston	Chuck Baldwin
RR Iron	Charles Meyer	Jake Langia
Bottle opener	Ray Pearre	Craig Gray
Duck Head Oyster Knife	Ray Pearre	LaDonna Burgess
Lexus Coil Spring	Mickey Thompson	Walter Beard
Forge Kit	Landy Young	Noelan Dather
Wire cable	Jake Langia	David Bush
Cup	David Chambers	Tony Etheridge
Stickers	David Chambers	Walter Beard
Stick' Em Tommy	David Chambers	Ray Pearre
Horseshoers Rasp	Mackey Bryant	Jody Durham
Scraping Tool	Jody Durham	Ben Secrist
Coal Rake	Jesse Barfield	Ray Pearre
Garden Tools	William Rombilus	Al Jenkins
Fork	Garret Still	David Chambers
Cable Damascus Knife	Meck Hartfield	Chuck Baldwin
NASCAR Axle Shaft	Al Jenkins	Bill Burgess
Horseshoe (Big)	Al Jenkins	Jason Charlton
Nuts, Bolts, Screws	Al Jenkins	Jody Durham
Nuts, Bolts, Screws	Al Jenkins	Billy Rombilus
Nuts, Bolts, Screws	Al Jenkins	Billy Rombilus
Throwing Target	Guild	Charles Meyer
RR Spikes	Jason Charlton	Ben Secrist
IPE Scales	Jason Charlton	Walter Beard
IPE Scales	Jason Charlton	Ben Secrist
Oyster Shucker	Duke Baxter	Adrienne Butler
Hanger	David Bush	Charles Meyer
Copper Bracelet	Pam Etheridge	Landy Young
Pendant	Patrick Walters	Adrienne Butler
Coil Spring	Adrienne Butler	Craig Gray
Flint and Steel	Patrick Walters	Johnny Marks
Auger Bits	Johnny Marks	Al Jenkins
		LaDonna Burgess

Blacksmith Dog Joke!



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!



Here is a picture of Turner Hammett, with an award that he forged. It is the People's Choice Award for the Cribbs Kitchen's Burger Cook Off. He presented it to the winner. The competition was to raise money for the Children's Cancer Partners who supported Turner and his family during his stay at the hospital in Charleston. They help pay for meals, gas, hotels. This organization supports over 600 families at any given time. Just thought you might like to see the photo and know that he is doing great.

I had this dog. One day, she was in the shop and I mistakenly dropped a piece of hot metal on her back. She made a bolt for the door....

Here is a picture of it! Actually, I made it for a church door in North Carolina for a friend. Wagon tire, wrought iron and mild steel. Yes, I have a friend! Barry

Remembering Doug Merkel

Photos Courtesy of Jim Kennady

Article by Jennifer Phillips (reprinted from the Hot Iron Sparkle)

The first time I ever saw a professional blacksmithing demonstration from beginning to end was Doug Merkel at Oak Hill Iron during mid-March a long time ago. He demonstrated forging jingle bells, which opened my mind to blacksmithing in ways I hadn't thought of before. He carried the crowd and kept everyone there on the edge of their seats. It's been probably 10 years now since that cold March morning but I will never forget it as the best demonstration I have **still** ever seen.

Even though our houses are less than 20 miles apart, Doug Merkel and I were not particularly close. He traveled quite often for events and to teach others while I stayed up the mountain working mostly from home. I know that Doug taught blacksmithing at John C. Campbell several times every year and he probably taught elsewhere as well because that was who he was. His gentle soul was always available to help a new smith learn how to forge an S-hook. And while some of us, myself included, can get tired of telling a crowd about how hot the forge is for the millionth time, Doug never did. It's been my personal experience that his infinite patience had led him to be such a great educator.



Last year, at about this time, was the only opportunity I'd ever had to sit with Doug, mostly chatting for hours on end. See, my last (fourth and final) pregnancy was rife with complications and I was stuck under my tent unable to leave at the AACB Conference. I could get up and move around a bit but the more I did, the more I threw up, which was already a standard 20-30 times a day. So Doug pulled up chair and just sat there. And for about 6 hours, he didn't leave my side except to help me. He went and bought water and lunch for us, of course never accepting a dime in return, while providing me with some much needed company. We talked about blacksmithing and the new BLU press but we also talked about family and some details of his life. They say it is a great friend indeed who you can sit beside in silence with the quiet being enough to fill the air and let me tell you that we didn't talk the whole time.

The last time I saw Doug was less than a month ago, yet again at the first quarter meeting at Oak Hill Iron in mid-March. While we didn't get to say more than "hi" to each other, I got to see Doug's generous spirit in action once more. You see, every year at this meeting, he would buy \$100 worth of Iron-in-the-Hat tickets and won some of the most prized items, but he didn't do it for items; he did it because Doug believed in supporting the NCABANA scholarship program and teaching young smiths. He did it because he was a great smith and an extraordinary human being.

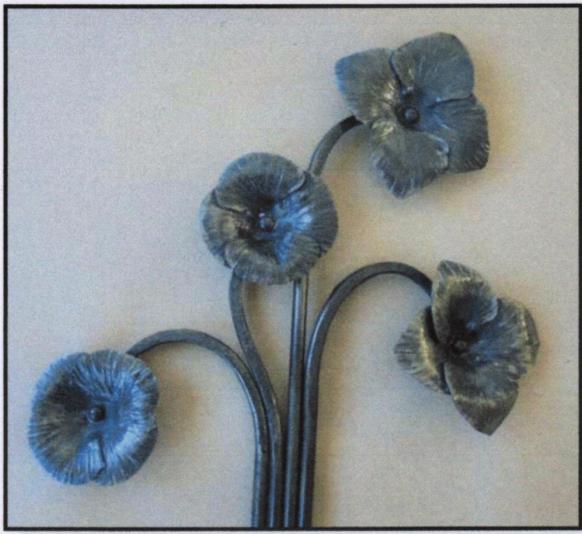
The blacksmithing community has lost a great friend in Doug Merkel and I hope we can all honor him by continuing to teach young smiths with the infinite patience he taught us to use. We miss you, Doug, peace be with your family.

[Doug was one of the first demonstrators I can remember from when I started. He did a lot of projects with glass marbles. I enjoyed his work and his style—Barry]



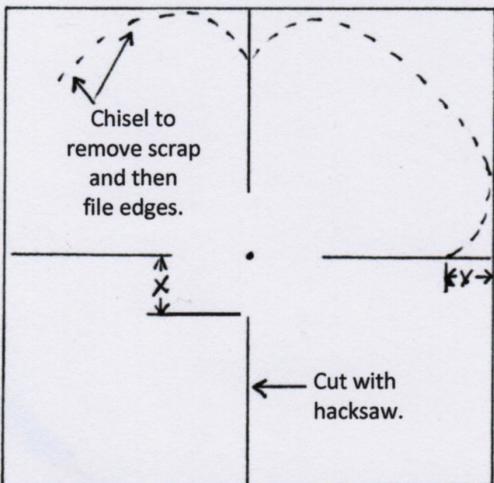
Two Simple Flowers

By Steve Anderson, a MABA member



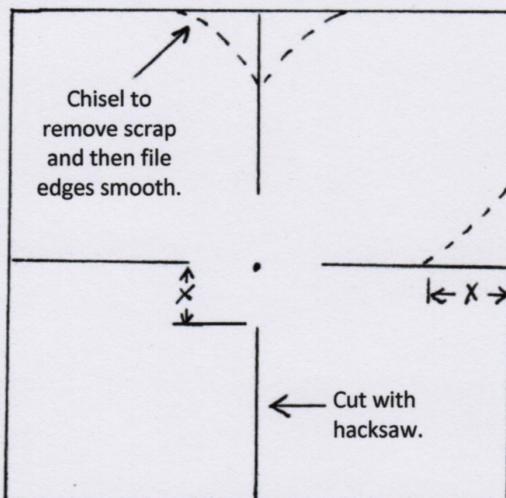
Stock size-16 to 10 gauge sheet steel.

Round Petal Flower ☀



Flower blank	Dimension X	Rivet size
2 x 2	$\frac{3}{8}$	$\frac{3}{16}$
3 x 3	$\frac{7}{16}$	$\frac{1}{4}$
3 $\frac{1}{2}$ x 3 $\frac{1}{2}$	$\frac{1}{2}$	$\frac{1}{4}$
4 x 4	$\frac{9}{16}$	$\frac{1}{4}$

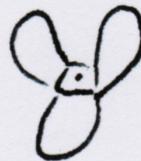
Square Petal Flower ☀



Mark the flower center but don't drill the hole until after forging the petals.

Cut, chisel and file edges.

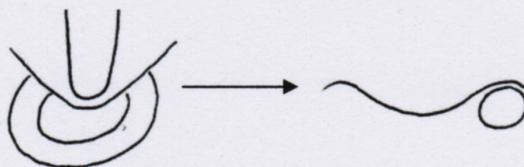
Bend the opposite petals down.
And the other two petals up.



Use a cross pein hammer to spread and texture the petals.



Flatten the petals allowing them to overlap.



Cup the center of the flower down, then curl edges over. Time to drill the rivet hole.

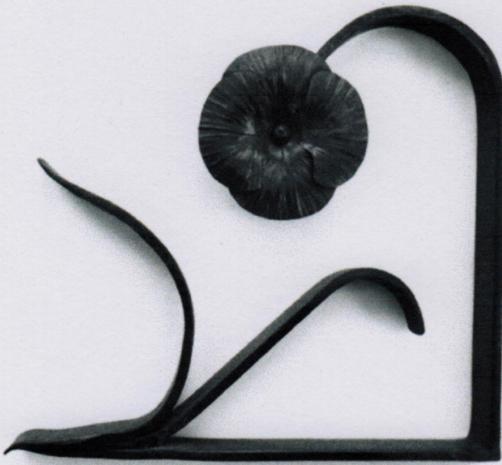
Clean up the flower on a wire wheel, then clear coat and wax to seal.

Attach the flower to
your project using a
plain or decorated
rivet.



Windowsill Flowers

By Steve Anderson, a MABA member



Optional treatments
for the welded end.

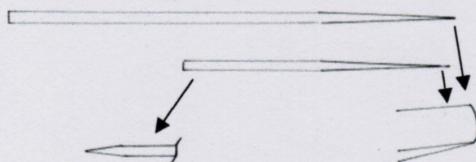
Stock-

Small size: $\frac{1}{4} \times \frac{3}{4}$ inch, two pieces

8 inches and 28 $\frac{1}{2}$ inches

Large size: $\frac{1}{4} \times 1$ inch, two pieces

11 inches and 36 inches



Forge a long thin taper on the flat side of one end of each piece, slightly rounding the end. These ends will form leaves. Then forge a $\frac{3}{4}$ inch scarf on opposite end of the short piece.

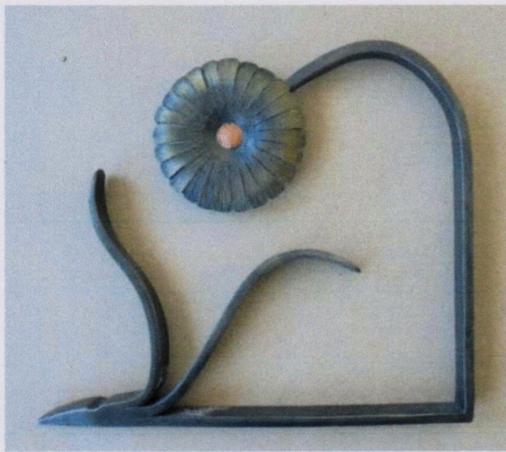


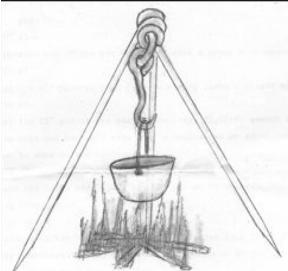
Bend the long piece $7 \frac{1}{2}$ inches from the tapered end on the small stock or 10 inches from the tapered end on the large stock. Insert the scarfed end of the small piece, flux and weld together. Hold pieces with a vise grip when welding. Forge this end down to a point, maintain the original stock width.



Hold welded end in
a vise, then open
and position the
leaves.

Next forge a square corner 10 inches from the welded end on the small stock or 12 inches from the end on the large stock.





Camp Tripod Project

Bill Epps

This camp tripod project was mailed in by Bill Epps. Drawings are by Marco Garcia.

Tools Needed:

Vice
Hammer
Anvil
Hot Cut or Saw
Welder (for the bending jig)

Materials:

1/2" Round x 20 Ft (Cut)
3/4" Round x 4"
2" x 3" Piece of 1/4" Flat Plate

First cut the 1/2" round bar into three pieces 60" long, one Piece 15" long, and one piece 12" long.

Take the 2" x 3" piece of 1/4" flat plate and cut a 1/2" x 1/2" square notch out of the corner. Take a piece of 3/4" round stock 4" long and weld to the plate to make the bending jig (Figure 1.)

Take a good heat on the end a 60" rod and trap the heated end in the notch of the bending jig mounted in the vice. (Figure 2.)

Bend the bar around the jig to form an eye. (Figure 3-B.)

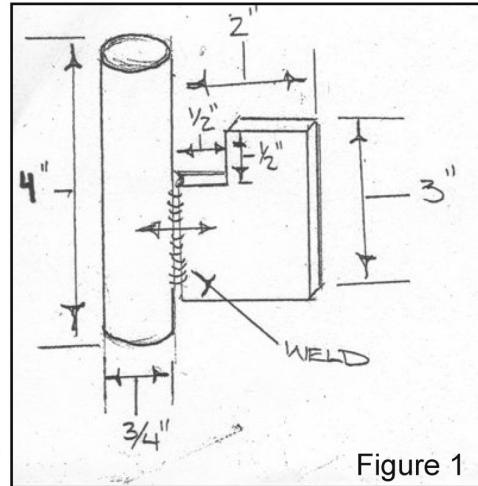


Figure 1

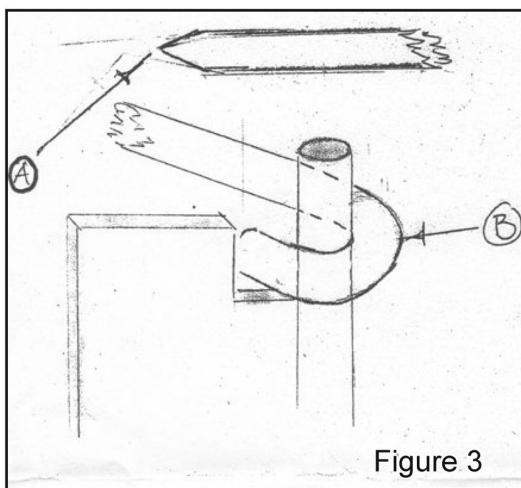


Figure 3

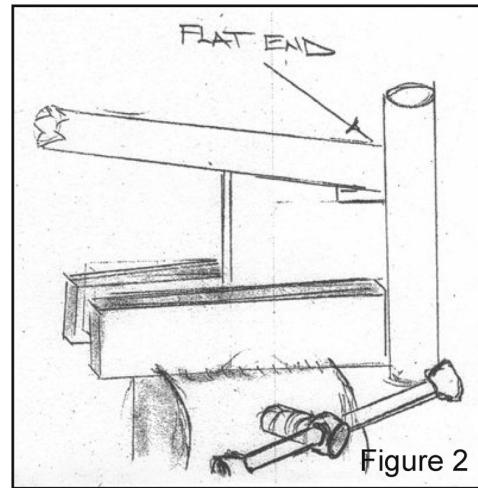


Figure 2

While hot, bend the eye backward to center on the bar over the anvil horn (Figure 4) then quench. Do this for all three 60" pieces.

On the opposite end of the bar from the eye, heat and draw to a point then quench. Do this for all three bars. (Figure 3-A.)

Heat the 15" bar and form a ring leaving a slight opening where the ends come together (Figure 5.)

Take the 12" bar and repeat steps 2 through 4 to create a short piece with an eye and a point (Figure 6-A and D.) While the point end is still hot, bend into a hook (Figure 6-C.) Offset backward with an S-curve to center the hook with the eye as per your preference (Figure 6-B.)

Heat the large ring and place all the eyes onto the ring, then close it up and quench (Figure 7.)

Setting up like the drawing, take the center leg and flip all the way over then spread the other two out. Anchor each leg into the ground. This should hold approximately 200 Lbs.

- Bill Epps

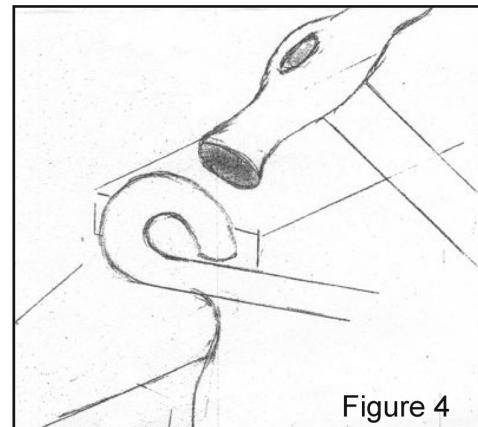
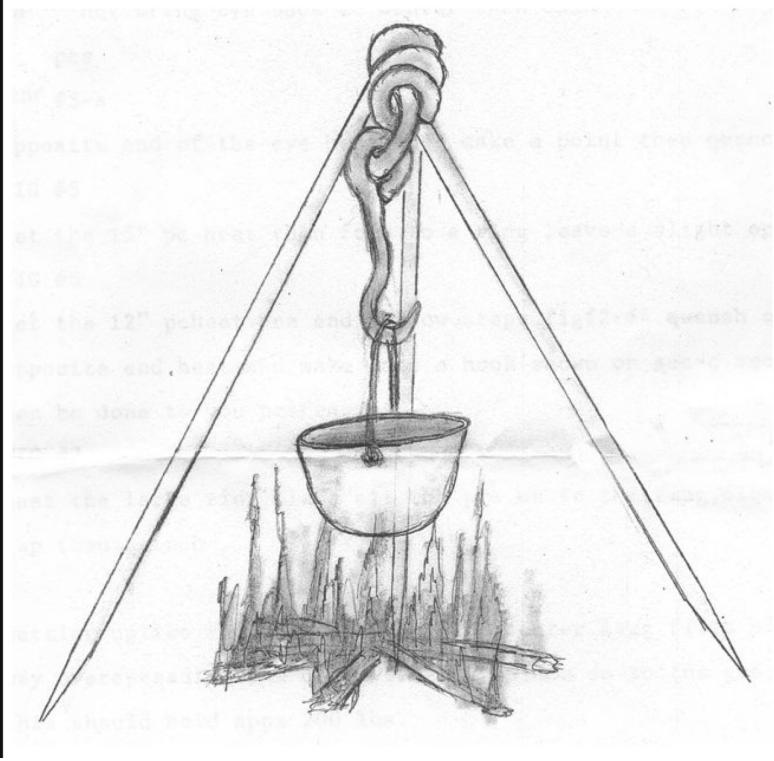


Figure 4

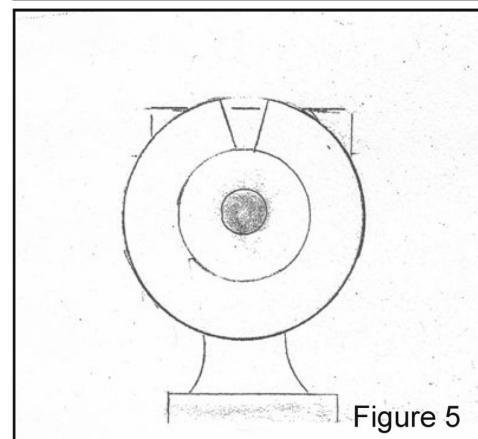


Figure 5

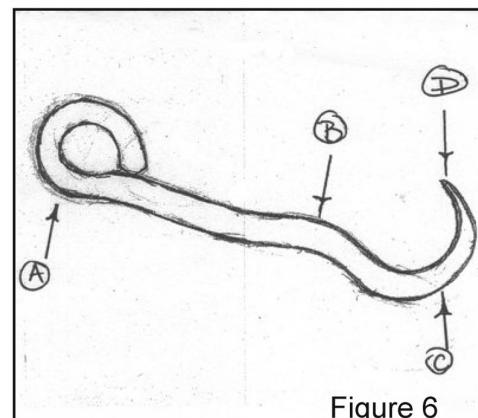


Figure 6

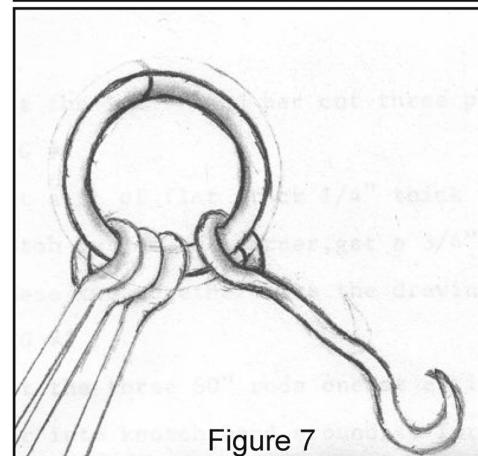


Figure 7

Tool of the Quarter: Keyhole Shovel Making Jig

Article & Pictures by Allan Kress

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Newsletter of the Alabama Forge Council

This is a jig I made to help forge the rough form of a keyhole shovel. You can make a regular shaped shovel head with it or do a little more work to make it into a keyhole shovel head. There are many different styles of shovel heads, these are just two I make. The jig was made by welding together a thick cast plate I had, mild steel handle bent as a spring handle, a molded shovel shape negative for the inside of the jig, round stock to frame the bottom of the shovel and force it around the molded top shape as you hammer the hot blank in it. Figure 1 shows a side view of the jig opened up. Figure 2 shows a shovel blank with the dimensions “7in x 5 1/2in, 16 or 14 gauge” written on it, the jig, and top right is the keyhole shovel

head somewhat shaped, and bottom right is the keyhole shovel head finished. I built this jig to go in my treadle with a 1 inch

tang welded on the bottom. Figure 3 shows the full jig as it sits on the treadle hammer and figure 4 shows that a little closer up. If you don’t have a treadle hammer you can just make the bottom tang to fit your hardie hole on the anvil. You may need to do it in several heats if you do it that way though. Heat up the shovel blank to red/ orange, lift up the jig top and insert the blank as in figure 5. Line it up with the front stops and

hammer with treadle hammer several times. This produces the wrinkled, rough shovel head form shown in figures 6-8.



Figure 2

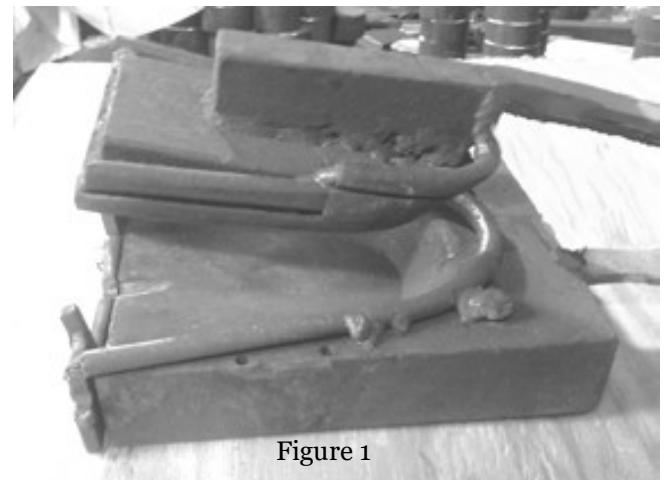


Figure 1

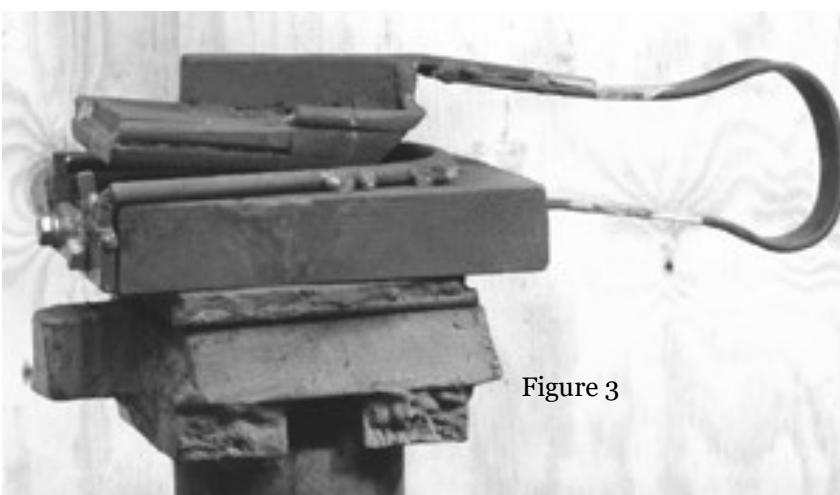


Figure 3

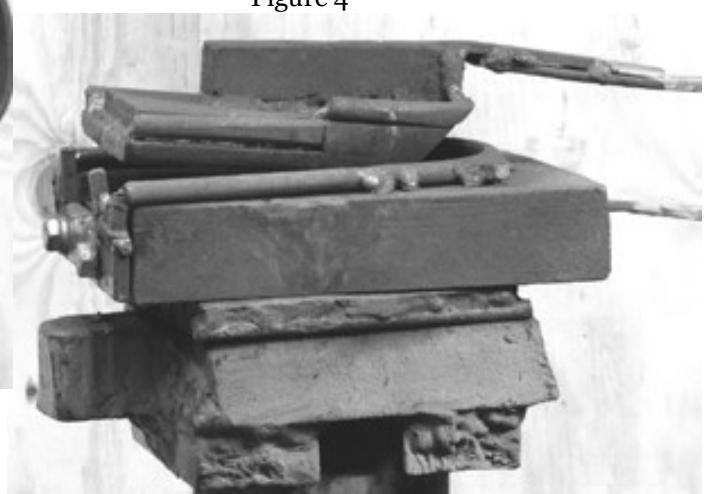


Figure 4

Figure 5

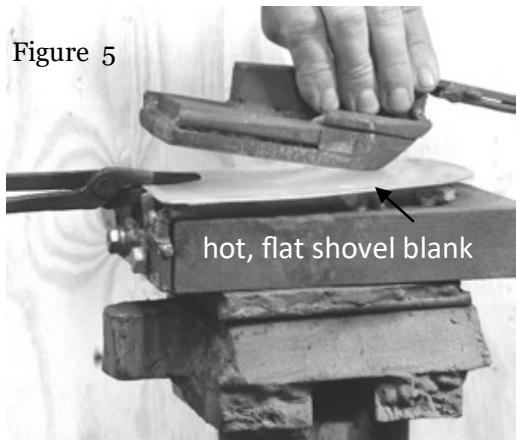
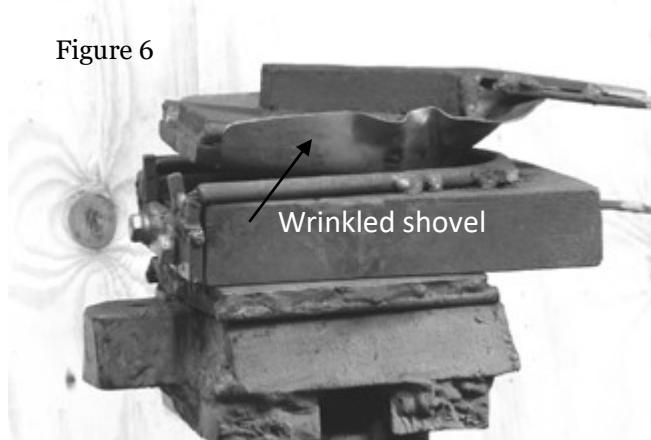
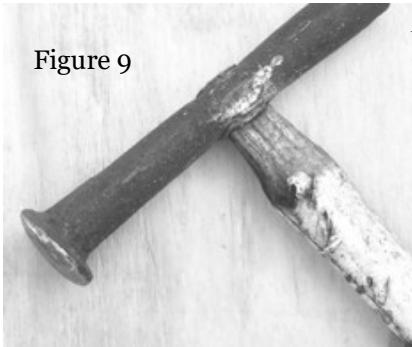


Figure 6



After forging out the rough shovel blank in the jig, anneal it to soften the metal and use a domed hammer to smooth out the sides. See figure 9. Do this process on the anvil face and/or on the horn. Whichever gives you the proper support to smooth the wrinkles out and make the curves. When you complete that process it will look like the shovel head in figure 10 on the left .

Figure 9

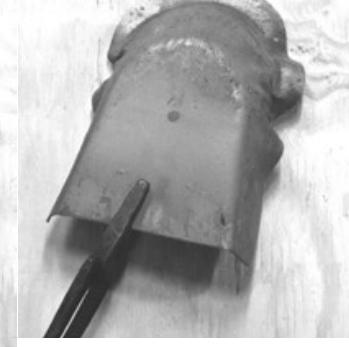


I use this domed hammer which is sort of like an auto body planishing hammer. You can use a different radius but I find this wide, shallow one works well.

Figure 7



Figure 8



No matter which style shovel head you choose to make it is always best to bevel the scooping edge ("break the edge" as in fig. 11). Do this by hammering on the edge of the anvil such that your hammer angle creates a graduated edge or bevel. Many people stop here and that is the shovel head look they want. I take it a step further and make it into a "keyhole" shovel style. To do that I made a side forming jig for my vise.

See figures 12 and 13. It is 5 inches long and curved so I can hammer-form the curve into the sides of the shovel head by using it as a backing plate as in figure 14. When you finish this process it will look like the keyhole shovel head in figure 10 on the right.

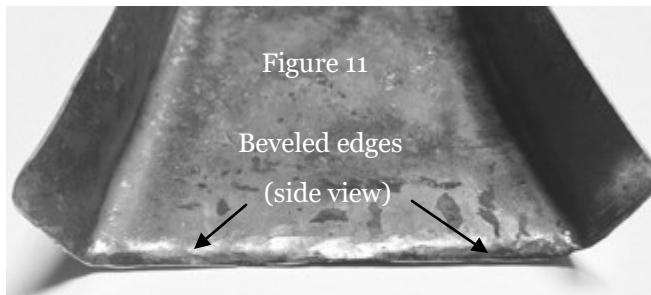
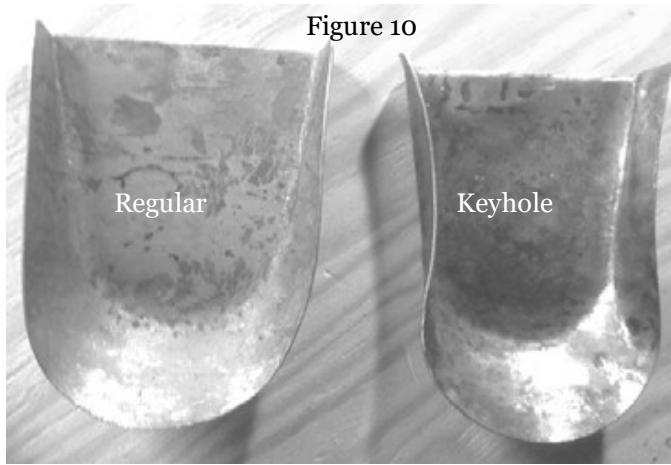


Figure 12

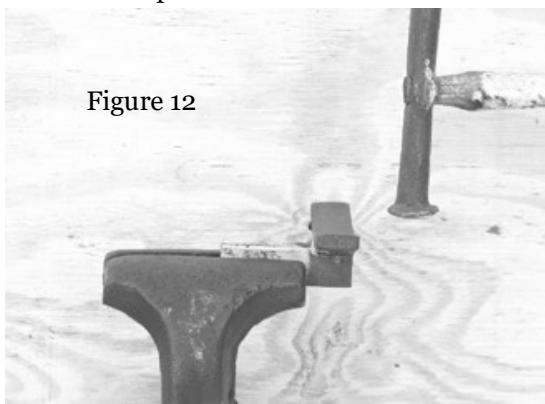


Figure 14

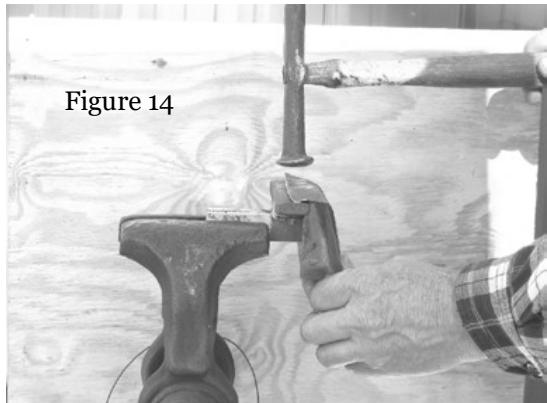
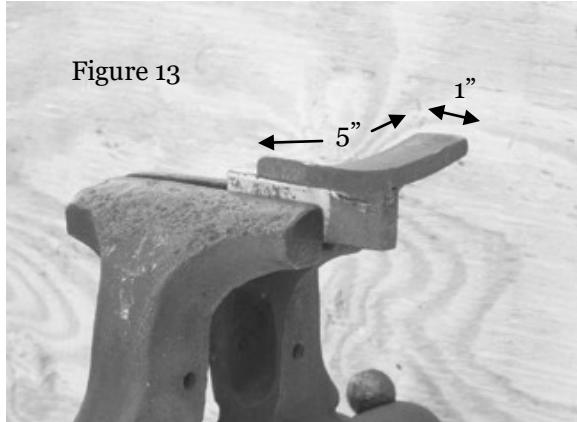


Figure 13



To purchase shovel head blanks or pre-formed shovel heads, contact Allan Kress.
akress@bellsouth.net 256-347-5732

For Sale:

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

Tire Hammer plans by Clay Spencer. Send Paypal for \$30US to clay@tirehammer.com. Or check/money to 73 Penniston Pvt. Dr., Somerville, AL 35670. I can mail a copy or email PDFS.

Beverly shear blades sharpened. Remove blades, mail in small Flat Rate box, include check/money order for \$50, includes return postage. clay@otelco.net, 256-558-3658 .

Forklift tine sections for striking anvils, \$30. Jody Durham, 864-985-3919 ironsmith@gmail.com

Sewell Pea Coal, washed, \$11 per 5 gallon bucket. Will also sell in bulk at lower prices. Derice Hochstetler, Aiken, [803-508-1326](tel:803-508-1326)

Todd Elder is offering Beginning Blacksmithing and Knifemaking Classes. Contact him at (864-978-7232)

Guild Coal: 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 **Mike Tucker** [803-316-3707](tel:803-316-3707)

Upcoming events:

2nd Saturdays Blacksmith demonstrations at Roper Mountain Science Center, Greenville, SC, Anthony Palacino. contact.864-386-5546

3rd Saturdays Blacksmith demonstrations at Hagood Mill, Pickens, SC. Often, our own Griz Hockwalt.

Fall TBD. **Beginners' Class at Magnolia Gardens.** Contact Ray Pearre 843-860-0532 Details to follow by email

2019 Meeting Schedule: August 10—Jesse Barfield has agreed to host at Historic Camden

October—Lexington County Museum

December 7—Ryan Calloway's in Greenville....It may live in infamy...

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 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 – 2018” or “Dues for 2019” are due” or “Dues paid 2019”

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

Come to Westminister

June 8, 10 AM!

The June Meeting will be at the Marcengill's in Westminster.

132 Ringing Anvil Drive, 864-647-1132

Roger and Gail and Jerry and Bessie Fowler are our hosts. Jesse and I trying to get someone to demonstrate for you!

Bring a side, drinks or dessert to contribute for the lunch. Also, bring something nice, maybe something forged for iron in the hat. I guarantee that you will have a good time, or not. Barry

