

On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

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Log Holder by William Creek

A few days ago, I popped up on our Facebook page to do a quick test demo on making stippling or background texturing punches. I did not have anything prepared but regarded it as more of a test to see how it would work and it is easy to do. If there is interest and others would like to show how they make or create, I would certainly enjoy seeing more posts on others' processes. Contact me if you are interested in posting a live video and need some guidance, I'll try to help out. Also, if there is a problem that is keeping you from improving your work, post a request for some help and maybe we can resolve it for everyone on the page!

Way back before pandemic times, the Guild officers had discussed and approved a raffle for a scholarship. this will be funded by ticket sales and is meant to foster improvement and add new skills to those that feel uncomfortable with doing a public demo or newsletter article. The raffle is open to anyone in the guild and the winner will have no follow up responsibilities to write or demonstrate from the scholarship, but we would not refuse an article or demo if

the need struck!

It is with sorrow that I say the Mike Tucker, past president and one of our most talented and generous members, has passed away. I always looked forward to seeing Mike at the meeting and enjoyed hearing his boisterous laugh while conversing with everyone. Please hold him and his family in your thoughts and prayers as he will surely be missed.

New members are Conal Smith, Tim Mellichamp, Randall Frasier. Welcome!

I look forward to seeing you all in April. Forge on and wear your safety glasses

Jody

Spring is starting to show itself with the daffodils and camellias starting to sprout and bloom. The new year has passed, and I am looking forward to some Irish culture in March. I hope you all are faring well with the virus and its complications of daily life. There is talk of our members having been vaccinated and the number of new cases are starting to slow so we hopefully are looking at the end of this long tunnel good news it good news!

It is with great pleasure that we have our first meeting scheduled for the year. Look to the back page for the details as usual. With regards to the meeting, I will say that the CDC guidelines will be followed as well as any recommendations from our states DHEC. so please be respectful of others and compliant with the recommendations and of course bring a mask and do the social distance thing. We have decided to use an abundance of caution and not have our communal potluck.

Bring your own victuals unless you want to go hungry....

Be sure to read the last page for a note about DUES!

The Maydole Hammer, submitted by Jim Carothers



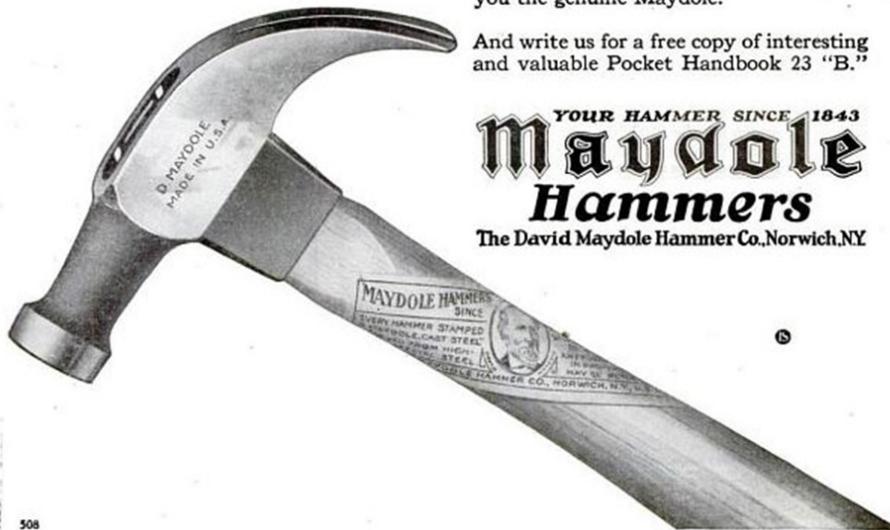
“What’s the Best Hammer?”

“That’s easy. The one with ‘D. Maydole, Made in U.S.A.’ stamped on the head. Ask me about some other tool and I might have a job deciding, but every man that knows tools ‘ll tell you that there’s only one hammer with the ‘hang,’ strength and durability of a Maydole—and that’s another Maydole.”

Maydole Hammers are the result of eighty-four years of accumulated skill and experience devoted exclusively to fashioning fine hammers. Heads are **press-forged** of tool steel; handles are of clear, second-growth, air-dried hickory, put on “for keeps.”

Maydole Hammers are made in all types and weights. Ask your dealer to show you the genuine Maydole.

And write us for a free copy of interesting and valuable Pocket Handbook 23 “B.”



YOUR HAMMER SINCE 1843
Maydole
Hammers
 The David Maydole Hammer Co., Norwich, N.Y.

Norwich, NY 1840: At that time there was no recognized hammer industry; blacksmiths made their own hammers, and similar tools for other artisans as well. Mr. Maydole's blacksmith's hammers did not suit him; oftentimes the heads would fly off, then if the iron was soft (wrought iron with a steel face or faces forged welded on), the head would spread and wear away, while if the

metal was a trifle too hard it would crack or split. But the chief trouble was the head coming loose from the handle – flying off the handle.

There were a number of ideas to solve this problem; one kind had an iron rod running through the handle with nuts at either end, another was made of metal throughout, handle and head being of iron, but all were clumsy and awkward. In regard to the mixing and tempering of the steel, Mr. Maydole only reached a point where he could feel satisfied by many years of experiment, carried on at odd moments in his blacksmith shop.

He finally came very near to his desires in the metal and at the same time hit upon an improvement which led to his being able to put a hammer head onto a handle in such a way that it would stay there; his method was that the head being attached to the handle after the manner of an adz.

The improvement consisted in merely making a longer hole for the handle to go into, thus giving a much firmer hold of the head. He made a number of other changes to his shop blacksmith hammers.

All for his own convenience, however, for he did not dream as yet of going into the manufacture of hammers. He would have hardly benefited from the improvements he had originated, at least not so soon as he did, for very few hammers were ever required in the little village, had not a party of six carpenters come to Norwich to work upon a new church.

As it so happened one of these men had left his hammer at home, and the necessity was so great that he repaired to the village smithy, which David Maydole was then operating, to have one made, there being none at the village store. "Make me a good one," said the carpenter, "as good a one as you know how."

David had in his experiments arrived at some notion of what a hammer ought to be, and knew

that he was able to produce a very superior article, but he was not sure that the workman wanted the best, so he asked him about his willingness to pay a good price, remarking, "But perhaps you don't want to pay for as good a hammer as I can make." To this the carpenter stated, "Yes, I do; I want a good hammer."

So the tool was made, the best one probably that was ever made in the history of iron-working, for it contained several important improvements, all original with Mr. Maydole.

To say that the customer was satisfied would be a mild expression for his feelings. He took the greatest delight in the hammer, showed it to his friends and fellow-workmen, and could not say enough in praise of the young blacksmith and his work.

The result was that on the following day the man's five companions went to the shop and each ordered a Maydole hammer; and when they were done the boss came to the shop and ordered 2 more, intimating that Maydole the blacksmith ought to make his hammers a little better than those Maydole had made for his men. "I can't make any better ones," said honest David. "When I make a thing, I make it as well as I can, no matter who it's for."

Soon after the storekeeper of the village gave him what seemed the magnificent order for two dozen, which in due time were placed on the merchant's shelves. There the hammers chanced to catch the eye of a New York tool merchant, who at once recognized their superior merits; when he left Norwich, it was after giving David Maydole a standing order for as many hammers of that kind as he could make.

This was the beginning of prosperity for David Maydole, for orders increased, and gave him an opportunity of enlarging his works, and of employing more men, thus in the end building up the great industry of which Norwich, NY is justly proud.

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!

How To: Level A Drill Press Table To The Spindle

Original Notes from Saltfork Craftsmen ABA member Adam Hall

Text and Photos: Jim Carothers



The problem at hand – how to accurately align the drill press table with respect to the spindle?

This drill press had recently been used to angle drill some holes by loosening the bolts under the table and rotating (tilting) the table – something like tilting the blade on a table saw. It was now time to put the table back in alignment with the spindle. Since nothing in my shop is really true or exactly level, the use of a simple carpenter's level would not produce an accurate alignment.

Note also that the drill press table shown here can only be aligned in one plane; the other plane is set by how the table and clamp were factory machined to match the drill press column. So alignment in one plane only simplifies things some.

The alignment tool is made from 1/4" round bar or other very stiff wire. One end of the tool is ground to a point.



Chuck on the tool and raise the drill press spindle all the way up. Make sure the spindle stays in the full up position; use the spindle travel lock if necessary.

Make your best guess as to setting the table level (in alignment) with the spindle and lightly tighten the bolts that lock the table tilt angle. Now, crank the table slowly up the column so that the pointer on the tool is just clear of the table face – maybe 1/8" gap to start with.

Turn (rotate by hand) the spindle and alignment tool 180°. Check the pointer on the other side of the table face to see if it is hitting, closer to the table, or further away from the table than your initial gap.

Adjust the tilt of the table as necessary, lightly tighten the bolts again, and repeat Steps 3 & 4 until the pointer barely touches the table face at both positions.



As the Burn Turns By Bob Pickens



Bob Pickens has come up with improvements for the burner of your gas forge. There are several details that can upgrade the burner design made from pipe fittings. One of the concerns is the threads on the pipe connections cause turbulence in the air flow. The threads in the large end of the reducer could be ground out to improve air flow. This can be overlooked but, thread removal can improve the burner's efficiency. Bob decided to forge the parts so when they were welded together, there would be a smooth transition between the fittings. To forge the inlet fitting, he heated and upset 1 1/4" sch 40 pipe. This thickened the wall, so when it was swaged to size it did not split. Not upsetting the pipe resulted in the pipe splitting at the seam every time, so upsetting the pipe is an important step. Bob used a die set and a 40 ton hydraulic press he has in his shop. This procedure is quite involved and may not be possible to address in your own shop.



Top: Sch. 40 pipe on left, upset, forged truncated reducer on right. Below: Die set used with a 40 ton hydraulic press.



What you can do to improve your burner:

He also made an adjusting disc for the air inlet reducer which can be easily made. Air adjustment seems to be a reoccurring problem and annoyance for the user. Adjusting the three screws on the air adjustment disc is time consuming. Additional issues that can occur when adjusting the three screws are that you may be moving the orifice and also getting it out of center. Bob developed an easy solution that can adapt to your existing burner. This idea is something you can do in your shop with common materials you probably have on hand.

How to: (Two Choices!)

Choice A

1. Replace the 3 adjustment screws with 3/4" longer screws to make room for the adjusting disc.
2. The adjusting disc needs to be made of 1 7/8" round 1/4" thick with 1/8" pipe thread in the center.
3. Install underneath the existing air adjustment plate, below the nut, this will allow for easy air adjustment. Just spin "open" for more air or less air! Easy!!!

Choice B

1. Remove the existing air adjustment plate.
2. Make and install new adjusting disc. (See above)
3. Make a support bridge. The bridge is made from 1/8" plate, 6" long. The legs should be about 1 7/8" long with the center drilled to 11/32nd and tapped for 1/8" pipe and attach. There are two suggested methods of attachment.
 - (a) You can weld onto the reducer; however, grind two flat spots to insure a secure weld.
 - (b) Attach by drilling and screwing on the bridge to the sides.



Left: Pipe thread with adjusting disc. The threaded pipe can be purchased at a hardware store in the lamp parts department.

Center: Common pipe fitting reducer. Usually the three screws on top plate must be adjusted to change air flow. With the addition of the adjusting disc, air flow is easily regulated.

Right: Support bridge can be connected to pipe fitting reducer or custom forged reducer to accommodate the air flow adjusting disc.



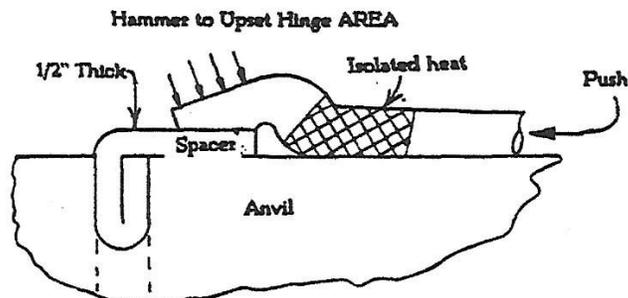
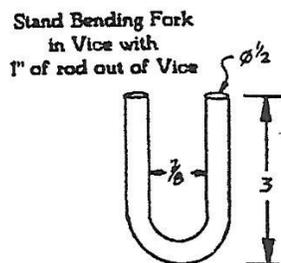
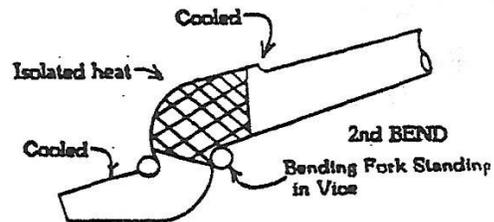
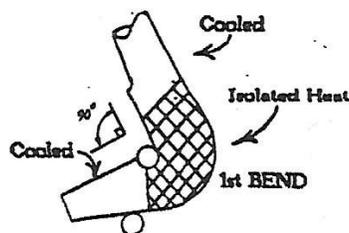
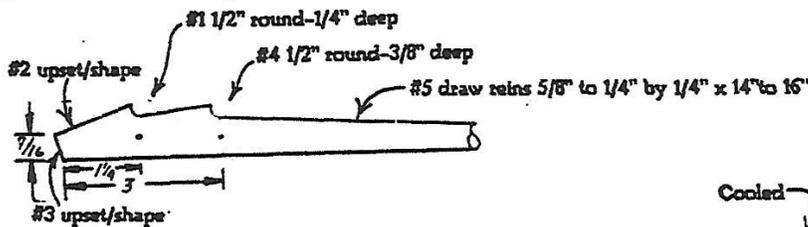
Jody posted a picture series on the Facebook Forum page on the making of Poz tongs. This is the **tong** method shown by Richard "Poz" Poznaniak way back in the 1980s. I found this article on the Northwest Blacksmith Association. If you have access to the internet, and who besides Meck doesn't, go to <https://www.youtube.com/watch?v=KYjnd9-uDbU> This is Black Bear Forge and the guy there does a very good job presenting these tongs. Barry

Poz Tongs

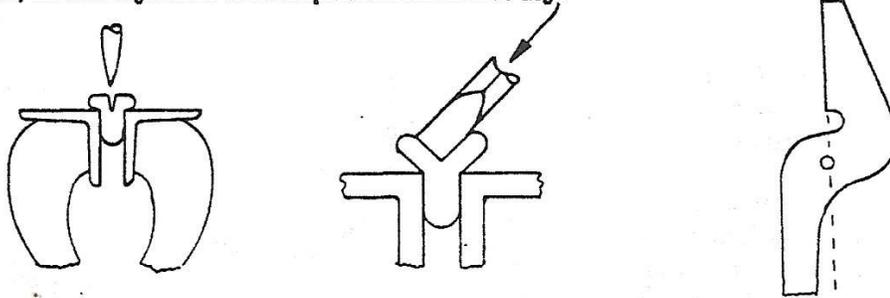
These notes were taken by Dave Van DeValde during the November 88 class at Robb Gunter's "The Fogery School of Blacksmithing".

Material: 1/4"x1" Strap 12" to 14" long of Mild Steel(2 pieces).

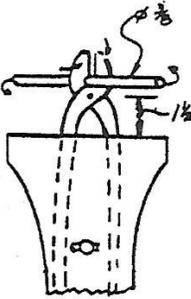
1. Center punch marks at 1 1/4" and 3" from the end of each piece.
2. Heat & hammer a 1/4" deep 1/2" round fuller at the 1/4" mark of both pieces.
3. Upset/taper the front end on on fullered side down to 7/16" on the front tip. Allow the #2 surface to thicken. Do not flatten back to 1/4" thickness.
4. Upset/taper front to 90 degs. from #2 face.
5. Heat and hammer a 3/8" deep 1/2" round fuller at the 3" mark of each piece and taper as shown in #1->#4
6. Starting at the bottom of the 3/8" deep, 1/2" round fuller, draw the reins from 5/8" to 1/4" on a constant taper for the 14"->16" length.



Edge bend long head(s) by isolating heat, water cool where indicated. Yellow heat must be isolated to areas indicated on the drawings. Bend tongs around bending "U", clamped in vice, as indicated in sketches. After both halves have been shaped, heat. Place heated jaw end in center of the vice between two "false jaws angles" (for roughness). Use a hot cut chisel to cut 1/4" deep down the center line of the upset jaw surface. Then, use a Rt. angle FLAT chisel to spread the halves to 90 degs.

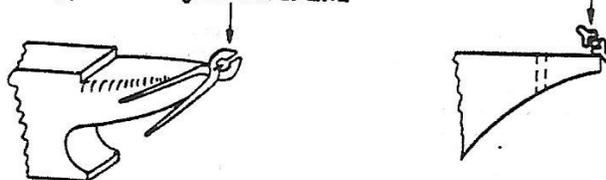


Next, layout tongs to drill. Make sure that the bottom of the throat(s) are even. Mark center line, on top tong half, center punch and drill, realign over 2nd tong half, mark through top tong half, punch and drill. Put rivet through both tong halves and cut off at 1 1/2 times diameter of rivet sticking through. Place in forge, rivet head up. When hot, remove from forge, tap rivet head with shank down (through preloft hole) then carefully turn over on anvil andpeen shank to round head, making sure that the tong halves and rivet head are all tight and in contact.



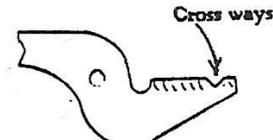
To put the hinge offset in the tongs, heat tongs to 2" below hinge on the reins. Place a rein on either side of the vice screw and tighten leaving 1 1/2" of the reins showing below the rivet. Place a 3/8" rod approx. 16" long in the throat above the rivet and twist horizontally in the direction indicated thereby, compressing the hinge. While gently twisting, use a rounding hammer to knock the tong jaws back vertically. Use twisting wrench to straighten and align tong jaws. Grip hot tong head in vise and bend/adjust reins so that tips of reins are 1 1/2" open open when jaws are closed. Reheat jaw area and start fine dressing/adjusting tong grip. Using a 3/8 or 1/2 sq. rod in the end of the tongs knock opposite flats against the end of the anvil. Make the jaws parallel by tapping down on outside tip of tong w/throat over the anvil tip.

Knock opposite flats against end of anvil

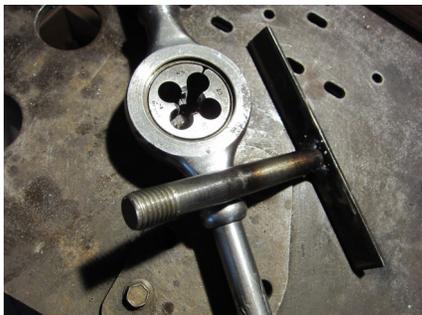


When jaws are sq. and parallel, reheat and tighten (by hammer) the rivet, and start "lapping" the hinge by opening and closing from red heat to until cold. File jaws parallel, dressup squares and file (w/sq. file) cross ways.

The perpendicular "grab" on the tongs must match top and bottom. Heat and bend the ends of the reins slightly outward (for ring keeper). Round all corners and wax or finish as desired.



from The California Blacksmith, California Blacksmiths Association



Shop Tip from Jim Carothers

I recently had to thread some 3/4" bar. It was not worth the trip to town to the local machine shop I usually get help from, so I decided to try it my self here in the home shop. What I found was that I did not have a vise, including my pipe vise, that would hold the 3/4" round bar against the torque required for threading. After a few minutes, it occurred to me to tack weld a torque arm, scrap flat bar, onto the bottom of the round. The torque arm reacts against the sides of the vise; problem solved. Since I only had two pieces to thread, this saved me a lot of time and some money as well.



Mike Tucker passed away last month. Mike was the President of our Guild after me and prior to Meck Hartfield. I don't think he ever forgave me for getting him to agree to be President! He did a lot for the Guild. He was the one who got the materials together and hosted the party to build our forge trailer.

He hosted several hammer-ins to build hammers and other projects. He demonstrated for the Guild and generously donated fine demo projects and even his wonderful hammers, leaf sculptures, knives, herb choppers and so much more. His last demo was when I got him to work like a dog in the heat at Camden in 2018. It was hot. But, Mike only complained a lot...

He taught at our hammer-ins, teaching leaf making techniques to make ginkgoes and magnolia leaves. He was generous with his time and his expertise. He was always there for me. I, and many of the rest of you will miss him.

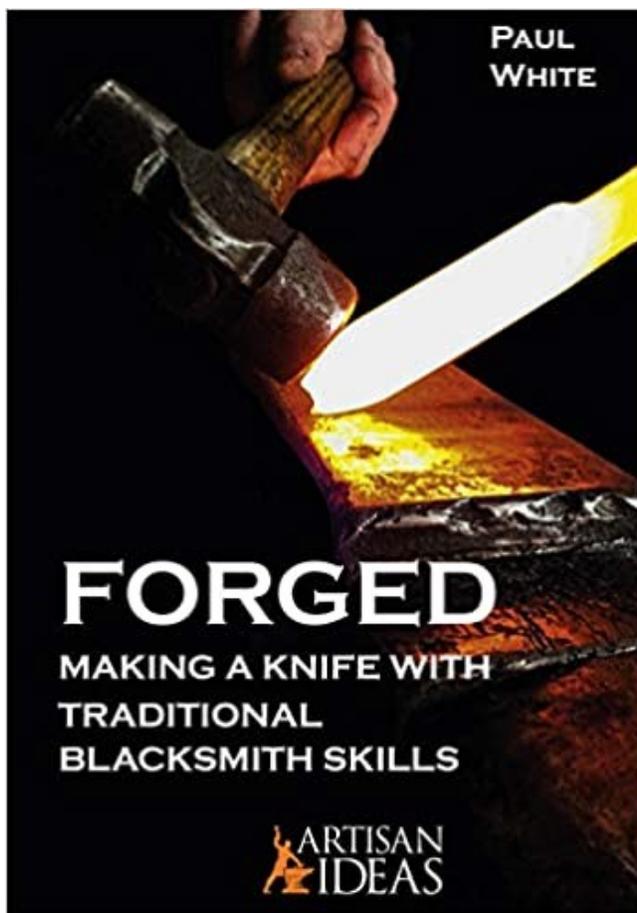
Barry

I was asked to review this book by the publisher. For my labors, he sent me a copy which will go to our library as soon as I see Tony!

This author has a lot of very good information to share, especially to the beginning smith wanting to forge knives - there seems to be a lot of that going around. His heat treating methods are good for the smith with little experience and equipment.

I have been making knives for twenty years and if found his method of hammering out the edge to be enlightening. I like to not advertise my mistakes, but Mr. White shows a fish mouth at the tip of his knife on the cover. It is easy to do, and I have done it, but it can be avoided and I wish Mr. White would have told the beginner how not to allow that to happen.

I particularly like his use of crossbill tongs to keep the blade from warping in the quench. I don't know that I have even seen this type of tong, but I will be making a pair.



The price of this book is about \$30, well worth not having to wait for it to come back to our library from the would-be knife smith who got it first! Barry

Heart Wall Hook Jim Carothers 12-2015



Material: 3/8" square hot rolled steel bar (A-36) x 9" long

Layout per the sketch:

3" long band saw cut on center 2x drill thru 5/32" dia.; counter sink front side; deburr back side

Twist: Put your favorite twist about 1" long below the lower mounting hole.

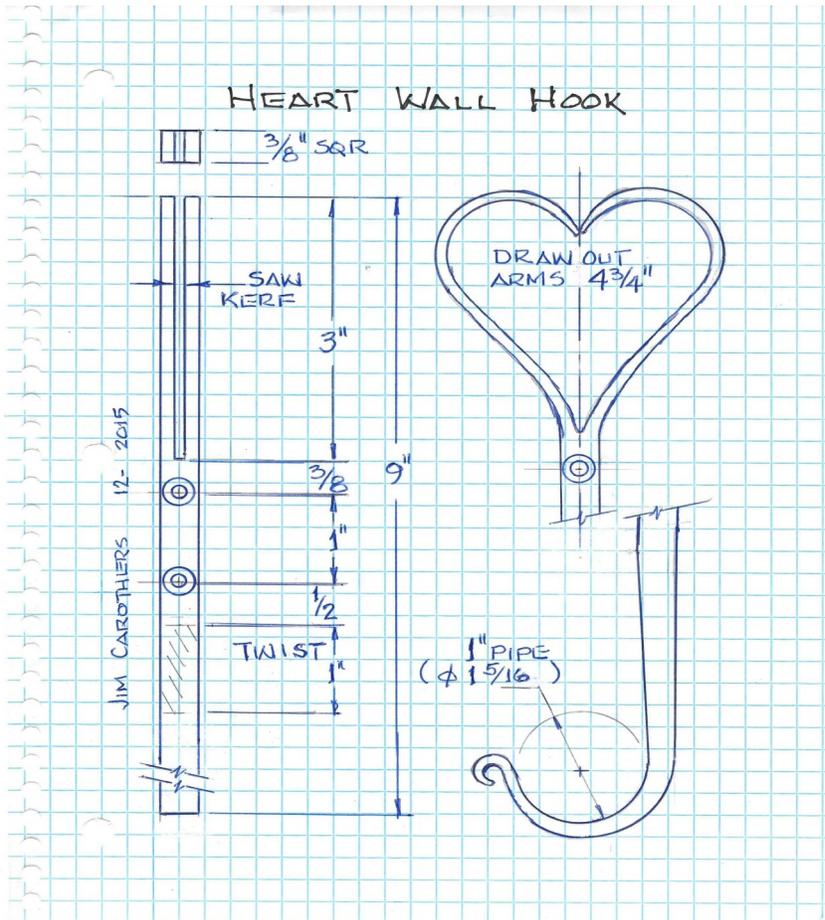
File or grind the back side of the twist flat so that the hook will sit flat against wall.

Arms: Heat and bend out into a wide Vee; draw out and taper to about 4-3/4" long. Check to make sure both arms are the same length

Heart: Close up the arms (check for equal lengths). Heat, spread, and form into a heart. The 4-3/4" long arms will

make a nice heart about 3" wide.

Hook: If you want a penny end or a fish tail scroll end, leave about 1/2 to 3/4" of the full bar to make that detail. Set that 1/2 to 3/4" down on the far edge of the anvil. Draw out the bar above this shoulder into a long taper up to near the end of the twist. If you want a simple pig tail end, draw out the bar from below the twist to a long taper. For the hook and pig tail as shown at about 1-5/16" inside diameter, it takes about 3" of drawn out length.



Touch Mark: A good place to put your touch mark on this piece is on the back side between the two mounting holes.

Three Wrought Nails

By Garey Ford (c), Artist-Blacksmith, Moss Point, MS 11/26/2002

Three nails of wrought a blacksmith made, their purpose was not known.
The soldier said make them strong and straight, for they must hold a load.
The blacksmith made them straight and true, and thick to hold great weight.

These nails were just a job to him; he did not know their fate.

The soldier took the nails and left, he had a job to do.

To drive them in a dogwood cross, to pierce His precious skin.

To let the sins of the whole world come flooding in.

These three nails of wrought held the lot, our Savior passed away.

To rise again and forgive our sins upon that glorious day.

Three nails of wrought from a blacksmith sought.

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

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 **Walt Beard 803-464-8483**

Upcoming events:

Griz Hockwalt is demonstrating at the Bart Garrison Agricultural Museum of South Carolina for special events and tours. The museum is located off of highway 76 in Pendleton S.C, across from Tri-County Tech. February 15th is the next demo from 10 to 3. Beginning in March, Griz will be demonstrating the first Saturday of each month.

2021 Meeting Schedule:

June 12 Roger and Gail Marcengill, Westminster

August 14, Historic Camden

Bob Kaltenbach and Barry Myers are planning a hammer-in on March 27 at the Living History Park in North Augusta. Email Barry or call Bob at 706-799-4703 if you wish to come. We will be outside and socially distancing, but Bob and Barry have had our shots...They plan to make butterfly hinges unless there is something you would rather make.

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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 ASSMPUMPTION 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 – 2019”or“Dues for 2020” are due” or “Dues paid 2020”

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

Come to Magnolia Gardens

April 10, 10 AM!

Bill Creek and Ray Pearre are once again our hosts. We will have a mask requirement, if you have any symptoms STAY HOME!

Bring your own lunch. We do not want to get anyone sick by food that an asymptomatic person might bring from their home.

We will have some extra masks if you haven't received President Biden's free one yet.

We will alert you via email if something crazy happens to the numbers. Remember the new variant virus and we have members coming from Upstate that may have higher numbers (Mountain People...)

Come and be amazed! It will be something really exciting!! Okay, maybe pretty exciting...

LAST CALL!! Look at your address label! If it says "Dues last paid in 2019", this is the last newsletter you will get. To rejoin the Guild you will need to make a payment for the past amount (2020 Dues) and the current year (2021). If it says " Dues last paid for 2020", send Ray a check for 2021!

