

## INSIDE THIS ISSUE

Iron in the Hat .....	2
For Sale//Upcoming Events .....	3
Scroll Jig Setup .....	3
Miniture Anchor .....	4
Air Gate/Micro Swith .....	7
Madison Update .....	9
Carriage Bolt/Header .....	10
Next Meeting Notice .....	12

# On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD



Another brisk morning at the L W Paul Living History Farm in Conway with Walter Hill demonstrating a log fork and a patch knife / striker combination.

He took 5/8" round stock about 5 ft. long and folded over 8 to 10" of it onto itself and executed a faggot weld after which he cut the resultant loop in equal parts to form the tines. Walter sharpened the ends of the tines and then gave the fork its shape. The other end needed attention so he folded over 6" and performed another faggot weld, placed a round mandrel in the eye and twisted it till it looked like a handle. A fore grip location was found by holding the fork handle in one hand and finding a comfortable place to grip the shaft with the other hand, then squaring a 5" section at this point (leaving the hammer marks), following up with a twist.

While attempting to make the patch knife/striker, an unfortunate chain of events caused Walter to burn the knife section beyond recognition. Being the excellent blacksmith that he is, he recovered and made respectable striker anyway (the striker did well in IITH and got many tickets). I wasn't there when all this happened but I heard Barry started talking and distracted

Walter (distracted blacksmith = burned metal), sorry Walter.

A log fork would be commonly seen and used at an 18<sup>th</sup> century hearth to move logs in the hearth along with a striker and flint for starting the fire.

The folks at the farm spent all morning cooking rice pork perlo for lunch along with the sides provided by the ladies of Guild we ate very well and ate a lot.

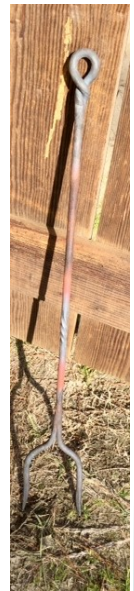
Our thanks to Walter, his family and the staff of the L W Paul farm for their hospitality. Guild members were very generous with sides and deserts for our lunch also IITH items. Some of our members are really excelling with their forging skills as evidenced in the detail and quality of the IITH donations, they make people want to buy tickets. Attendance was excellent, about 50 people were there. IITH brought in a whopping \$735.00

New Members: Joseph Crawford, Coleman Dangerfield, Willy Ziminski, Heath Williams, Shawn Ellis, Will Krasfig, and Kenneth Dodds. We welcome back returning former member John Frick. If only John Frack would come back...

We had an excellent class with Shel Browder. He overestimated our ability to work hard and long. Some of us got close to half finished, but only Todd Elder got to a point where Shel could help him install collars on two of the scrolls he had installed. Don't ask how many of the project trivets are now finished. Barry's is shown on page 2, but he claims it still needs some tweaking. If you want to make one, Jamie has added Shel's instructions to our webpage.

We had an election at the February meeting. It came down to hanging chads, but Todd Elder and Duke Baxter were swept into office by a very enthusiastic voting public. Todd's acceptance speech was memorable and moving.

Remember those of our number unable to attend due to sickness. Let us know if we need to worry about you..



Jesse

## IRON IN THE HAT

Item	Donated By	Won By
Ginko Leaf Candle Holder	Mike Tucker	Todd Elder
Hammer Eye Drift	Guild	Joe Marsh
Bucket o' Sewell Coal	Layne Law	Sharon Hill
Towel Rack	Layne Law	Chuck Baldwin
Dragon Fly	Gail Marcengill	Tanya Ackerman
Pyrimidal Bell	Roger Marcengill	Charlie Wells
Whatyacallit	Gail Marcengill	Anne Suggs
Trace Hook	Jesse Barfield	John Cook
Cowboy Boots Carving	Bob Hill	Keith Gunter
Saw Blade	Hunter Smith	Keith Gunter
Wood	Hunter Smith	Pam Walters
Chainsaw Knife	Meck Hartfield	Chuck Baldwin
Wax (Possibly bee's wax)	Joe Marsh	LaDonna Burgess
Lead	Joe Marsh	Charles Meyer
Brass Hammer Head	Joe Marsh	Jesse Barfield
Steak Turner	Tony Etheridge	LaDonna Burgess
Copper Earrings	Pam Etheridge	Sharon Hill
Jimmy's Coal Shovel	Anne Suggs	Sharon Hill
Framed Farrier Print	Anne Suggs	Gail Marcengill
Blacksmith Lives Matter Decal	Joe Marsh	John Cook
Pavement Breaker Bits	Charlie Meyer	Barry Myers
		Jesse Barfield
		Travis Farrell
		Trad Pierson
Liam Hoffman Handle	Curly Larson	Coleman Dangerfield
Coil Spring Knife	Pat Walters	Keith Williams
Coil Spring	Peter Mueller	Bruce Hester
Coil Spring (other side)	Peter Mueller	Bob Hill
Leaf Spring set (side unknown)	Peter Mueller	Cayd Brown
Small forged hatchet	Todd Elder	Layne Law
Bracelet	LaDonna Burgess	Coleman Dangerfield
Utility Knife	Ed Berry	Barry Myers
Oyster Knife with Bottle Opener	Chuck Baldwin	Joe Marsh
Hot Peppers	Kevin Cook	Anne Suggs
Pickled Peppers	Kevin Cook	Anne Suggs
Earrings	Sharon Hill	Sharon Hill
Fredrick Cross Necklace	Keith Gunter	Charlie Meyer
Homemade Soap	Keith Gunter	Joe Breault
Avon Anvil	Keith Gunter	Clint Snyder
BBQ Tongs(former ThiMaster apparatus)	Barry Myers	Gail Marcengill
Paperbead Necklace	Mary Hill Long	Roger Marcengill
Demo Flint Striker	Walter Hill	Sharon Hill
Grinding Wheels	Keith Gunter	

## BLACKSMITH POEM

One day I passed beside a smithy's door  
 And heard the anvil sound the vesper chime;  
 Then, looking in, I saw upon the floor  
 Old hammers worn with beating years of time.  
 "How many anvils have you here," said I,  
 "To wear and batter all these hammers so?"  
 "Just one," the blacksmith said with twinkling eye;  
 "The anvil wears the hammers out, you know."  
 "And so," said I, "the anvil of God's Word  
 For ages skeptic blows have beat upon.  
 Yes, though the sound of hammers thus was heard,  
 The anvil yet remains; the hammers gone."

-Unknown

Reprinted from the Hammer and Tongs, Newsletter of the Central Maryland Blacksmith Guild

**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!

**Remember  
 to return  
 your library  
 books. Don't  
 make Tony  
 and Pam  
 come to your  
 house! They  
 know where  
 you live, just  
 like creepy  
 Santa...**



## For Sale:

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

**Tire Hammer Plans:** Send a check or money order for \$30US or send \$32US to Paypal.Me/ClaySpencer. [clay@otelco.net](mailto:clay@otelco.net). PDFs will be e-mailed outside US.

**Beverly shear blades sharpened.** Remove your blades and send in USPS small flat rate box with check for \$41US Clay Spencer 73 Penniston Pvt. Drive, Somerville, AL 35670-7103.

**Blacksmith Classes:** Beginner to Advanced. Glenn Owen, Hemmingway. Contact Glenn at [forgeontheridge@yahoo.com](mailto:forgeontheridge@yahoo.com) or [www.forgeontheridge.com](http://www.forgeontheridge.com).

**Forklift tine sections for striking anvils,** \$30. Jody Durham, 864-985-3919 [ironsmith@gmail.com](mailto:ironsmith@gmail.com)

## Upcoming Events

**Battle of Charleston, April 8 & 9.** Legare Farms. Ray Pearre contact.

**April Meeting. April 22.** Bill and Lynda Creek, and Ray Pearre will host us at Magnolia Gardens.

**SBA Conference! May 18-21.** Madison, Ga. We are the host group. Please try to come!

**June Meeting, June 10** at Roger and Gail Marcengill's

**1st Saturday, Blacksmithing, Bladesmithing, Farriering** and art fair at Dreamcatcher Forge near Table Rock 12-4PM vendors, food, music, & games. Come hammer, fellowship, and sell your wares. 265 Mt Bethel Rd, Pickens SC 29671 Shawn Ellis [www.dreamcatcherforge.com](http://www.dreamcatcherforge.com) [Dcforge@gmail.com](mailto:Dcforge@gmail.com) 864-650-4542

**2nd Saturdays Blacksmith demonstrations** at Roper Mountain Science Center, Greenville, SC

**3rd Saturdays Blacksmith demonstrations** at Hagood Mill, Pickens, SC

## Lud's Scrolling Jig Holder-from a Pipe Threader

*Write up by Steven Spoerre, a MABA member*

If you have a small shop or limited “swing” area around your vise, mount your scrolling jig into a mod-ified ratcheting pipe threader. When this combination is clamped into the vise, long pieces of stock can be wrapped around the scrolling jig while standing in one place. Lud Lazarowicz showed this set-up at a Mankel Blacksmith Shop open house years ago.

Replace the thread cutters with spacer blocks that let you drop the scrolling jig into place like a bottom tool falls into the anvil's hardie hole.

Clamp the pipe threader handle in the vise and initially set the toggle so the jig will ratchet away from you.

Now, while you stand in a one place, hold the end of the stock at the starting point on the jig, pull the stock towards you until you reach the shops/areas “swing” limit, then ratchet the jig away from you and form the stock around another portion of the jig. At some point the ratchet toggle will need to be flipped to keep the stock pull direction the same – repeat until the scroll is finished.

The scrolling jig pictured was originally made to clamp in the vise jaws, so it orbits the pipe threader as it's moved for better stock alignment. Ideally the scrolling jig tail should be bent under the scroll, then bent down 90 degrees so the jig would be centered over the ratcheting head.



*Reprinted from The Upsetter, Newsletter of the Michigan Artist Blacksmith Association*



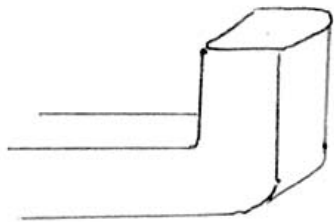


## 1/10 Scale Schooner Anchor

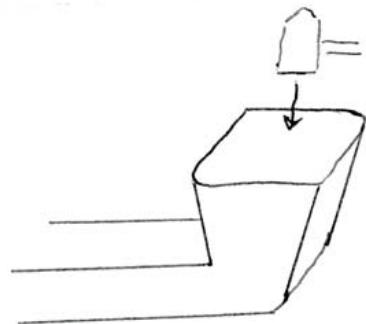
Article and drawings by

Steve Anderson, a MABA member

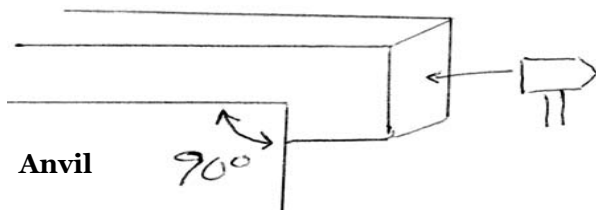
*FLUTES:* Stock 1/2" square



Bend 1-1/2" to 90 degrees.

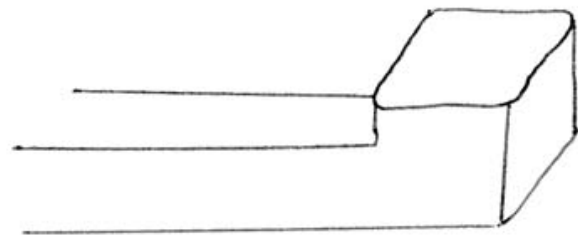


Upset.

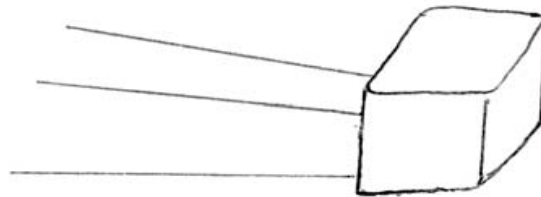


Anvil

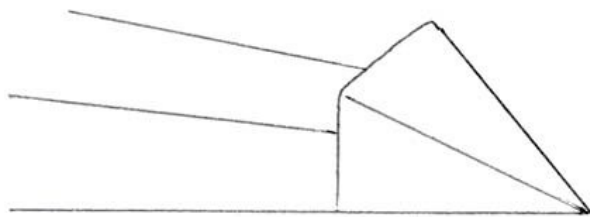
90°



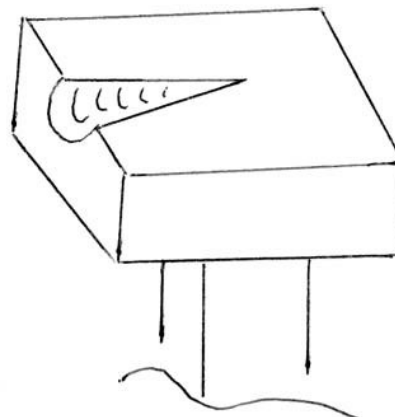
Repeat upsetting and squaring until mass is about 3/16" above stock.



Taper 1/2" stock down to 3/8" square starting about 1" back.



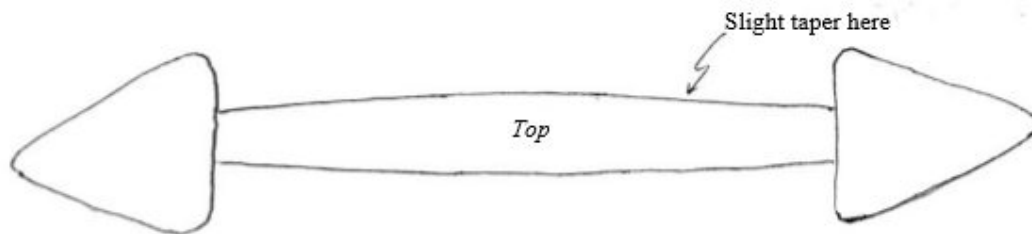
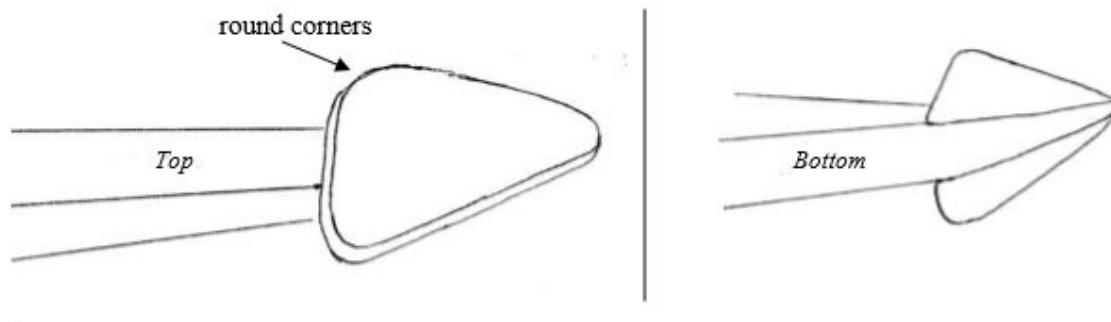
Forge a short, three sided taper on upset end.



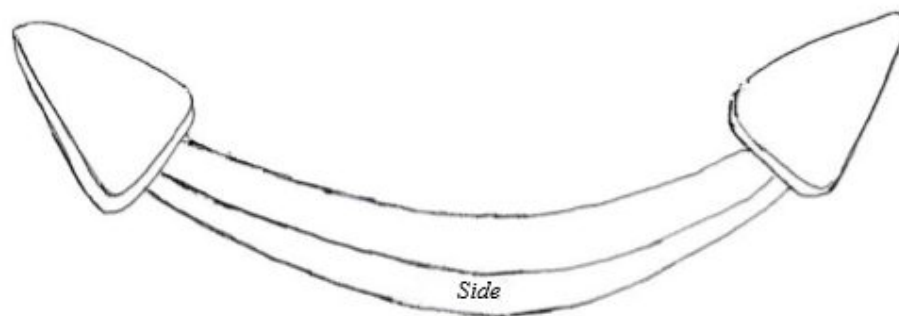
Swage can be made by driving a 3/8" rod into a block at an angle.

Using a small rounding hammer drive the upset end into the swage to form the bottom of the flute and to widen and shape the flute. Stop before the flute hits the bar.

Turn over and forge over anvil edge to maintain 90 degrees.



Cut off to length by adding 6 -1/2" to the forged flute. Then bend to 90 degrees 1-1/2" from the cut end and forge the second flute as before.



Bend to form 1/3 circle where diameter = length of piece before bending.

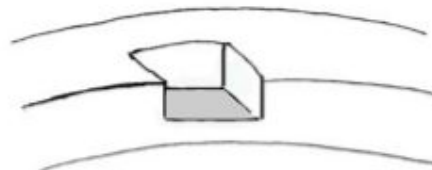
**SHANK:** Stock 1/2" square



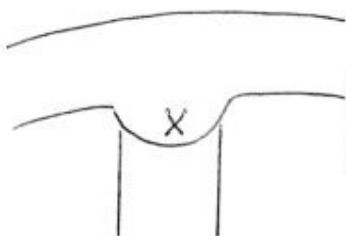
Upset end of 1/2" square to 5/8". Round edges back about 3".



Forge a step scarf 1/4" back for welding.



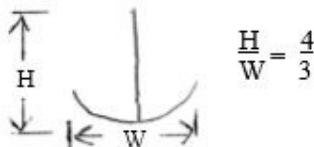
Drive a 5/8" square bar about half way into the center of the fluted bar.



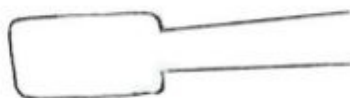
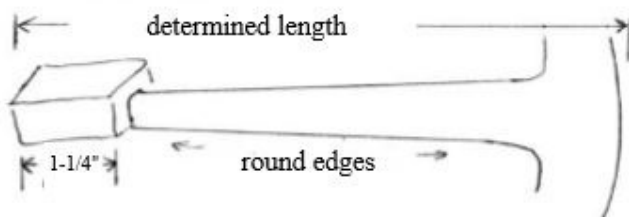
Turn upside down and lay on top of the 5/8" bar to form a scarf at "X".

Flux and weld shank to flutes.

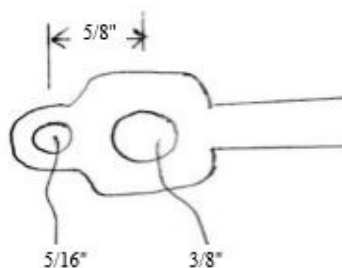
Determine length of shank:



Forge shank down to a taper (leaving 1-1/4" squared at end) to achieve determined length.



Flatten top square end to thickness of shank in the plane parallel to the flutes.



Drill 1/8" pilot holes then slit and drift 5/16" and 3/8" holes. Chamfer 5/16" hole to allow ring to turn easily.

**RING:** 1/4" x 4-1/2" round stock.



Step scarf ends to weld top to bottom. Open ring by twisting sideways in vise and insert into 5/16" hole. Close, flux and weld. Reshape if necessary.



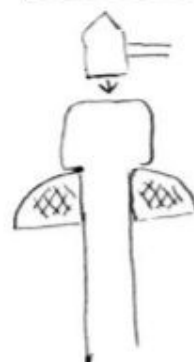
**Optional clevis design:**

Instead of a ring, a clevis made of 1/4" x 4 3/4" round stock can be used, (see clevis on miniature log tongs in Sept/Oct, 2009 issue of The Upsetter).

**CROSS ARM:** 3/8" round stock



Taper slightly leaving 1-1/4" on end.

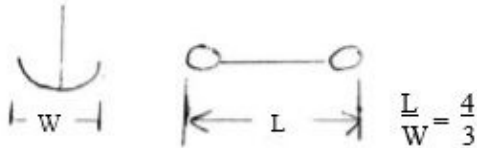


Upset in vise until W=H.



Forge ball on end, tapering back about 1-1/2".

Determine length of cross arm:



Add 1" (for ball) to calculated length and cut to size. Insert cross arm into 3/8" hole in shank before continuing.

Upset 1-1/4" on the cut end and form the second ball, tapering back about 2".

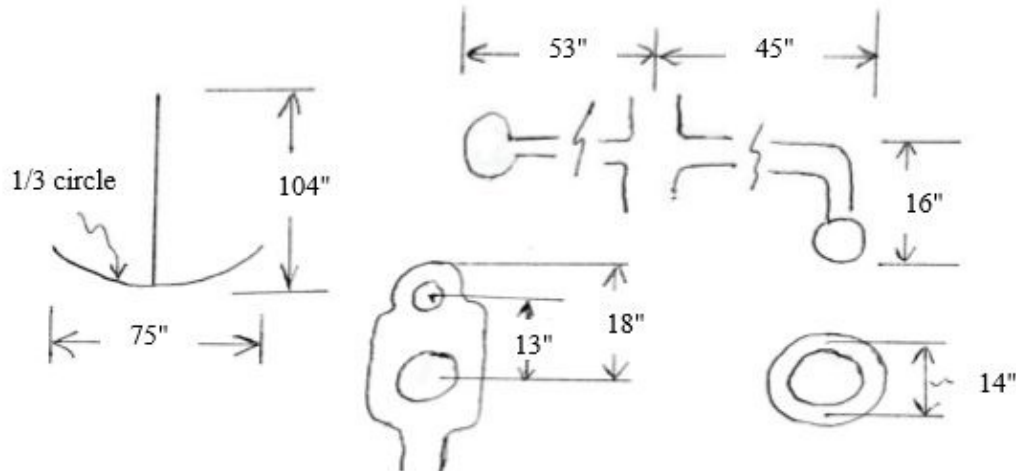
Bend the end back 2" from the end of the ball at 90 degrees to complete the cross arm.

#### **FINISH:**

File to clean up and detail, then apply finish of your choice. I prefer to heat anchor to a red heat, allow it to cool and wire wheel. Then apply Penetrol or clear coat and three coats of wax.

#### **ADDITIONAL SCALES:**

Other sizes (ex. 3/8", 5/8", 3/4", or 1" stock) can be made using the following proportions taken from an actual anchor located at Eagle Harbor, Michigan.



# Coal Forge Air Gate and Micro-Switch

James Allcorn

Some years ago I built an air gate for my coal forge after seeing my first one in use at a Saltfork Conference.

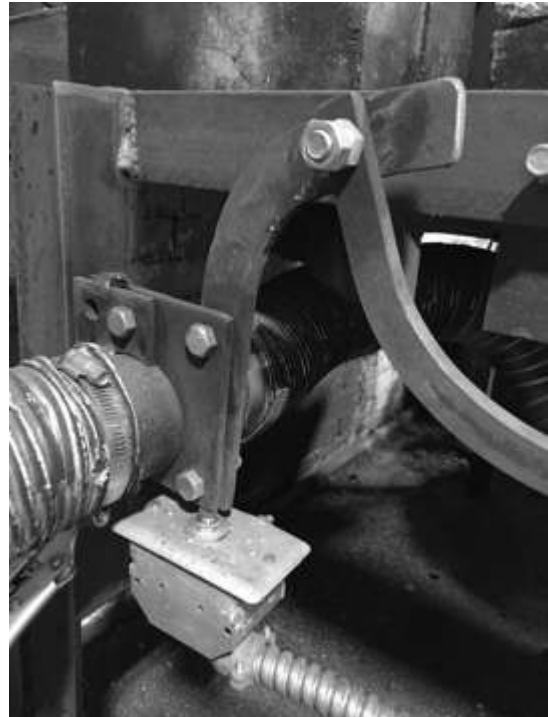
The blower was salvaged from an old clothes dryer and puts out a large volume of air at good pressure. But I wasn't happy with the fact that the blower ran continuously unless switched off.

I came up with the idea to equip my air gate with a momentary off push button switch (SPST NC, meaning that when the switch is at rest the contacts are closed and current flows. Pushing the button opens the contacts and current stops.)

After a bit of experimentation with the position of the switch and the help of a pair of old locking pliers I was in business.

To operate, I just pull the air lever a bit and the switch disengages, the motor starts and air flows regulated by the gate valve.

Returning the lever to the off position engages the switch and the motor stops. As a safety note, all electrical wiring is encased in metal conduit.



Air Gate Closed and Fan Switch in "OFF" posi-



Air Gate Open and Fan Switch in "ON" position.  
Airflow is Adjusted by Gate Position.

Reprinted from the June 2016 Newsletter of the Saltfork Craftsmen Artist-Blacksmith Association



Here is a little information about the upcoming SBA Conference (<http://www.sbaconference.com/index.html>) at Madison:

- There will be no anvil shoot unless something changes. There was a worry about liability from (especially) the FABBA group.
- The demonstrators are Zeevik Gottlieb, Shel Browder, Mike Saari and Gordon Williams. You will enjoy them.
- We are the host group. Mike DuBois is our champion (as he has been for many of us for years...) and chairman for the Conference. Thank him.
- The Group Project is a Philip Simmons Tribute Gate. Jesse is making the frame, others in the Guild have stepped up to make components including Ray Pearre who is making the Simmons' heart motif as the centerpiece. Each of the other six groups will make a 12" circle inclosing a Simmons' signature piece—the snake, palmetto, heron, or fish. There will be multiples of at least one, so duplicates will be strategically located on the gate to complement each other. Barry Myers is heading up the final assembly—the riveting of the rings into the gate we will supply.
- We are making a knife as are each of the other groups to be auctioned off at the Conference. Meck is welding up damascus pieces supplied by members of the Guild. The billet will be forged out to a 10" blade. Other members of the Guild will grind, put on the guard, handle and bolster washer on the back. Bob Hill is going to engrave a Guild Palmetto logo on the butt bolster. Someone will make a sheath (not me). The knives were added to help ensure the Conference doesn't go in the hole! The last time, the project was a big money maker at the auction. Ours is still sitting in Ray's living room.
- As usual, the Alabama (pronounced Al-a-BAM-a) group is going to have a toolbox. Phil Rosche, Joe Marsh and I have signed up to make tongs for the box. You can make a tool for the box! Any blacksmithing tool you want. If they have a duplicate, that is okay. They will pick one and put the others in the iron-in-the-hat. Florida is making the box.
- The admission has gone up \$5. It is still a bargain at \$55 (early) and \$65 (at the door). The flyer has been delayed, but you can download (okay, some of you can...) the form and send it in. Plenty of time.
- There will be more Family Program classes in both number and frequency. The instructors, most of whom are J. C. Campbell teachers, will be offering two classes per day but you still better sign up early as the classes have filled up in the past. There will also be a potter giving classes. The classes will be \$15 this year to account for the increased cost of the instructors.
- The Blue Moon Press will be there to serve your book needs. They will be inside the main building this year.
- Did I mention that we aren't shooting the anvil?

That is all I know at this time. Please come and support Mike and our Guild at the Conference, help with Green Coal classes as an instructor, bring lots of rust to sell, bring lots of money to buy rust, act like you have some sense (to make up for me!), pay attention and learn some stuff that you can share.

Barry



## Carriage Bolt Header Tool

Article and Photographs from Peter Ross

Originally posted on “Museum Blacksmiths and Tinsmiths” Facebook page

I recently had to make a few small carriage bolts so I thought I'd share the steps I used. These are 5/16 diameter bolts about 2 inches long, made from 1/2 inch square wrought iron. First, draw what will be the shank to length and diameter, leaving a long taper from shank to orig stock, then cut. I partially rounded the big end of the tapered area so it forms a rounder head when squashed. Last, at a welding heat, upset the head in a square header. Part of the taper will be forced into the header, making the square section of shank under the head. For longer square section of shank, forge the taper smaller, so it slides partway into the header. may take a few trials to get things just right, but these bolts are nice to have when you want them and not much work to make.



It



Pat Taylor: Is the hole straight or tapered a little ?

Peter Ross: Can do either. this one happens to be straight, but many old carriage bolts have a tapered sq shank, so for that style I would make the header tapered. The bolts in my example above were for use with heavy iron hinges, so the square shank didn't need to be very long- it was fitting a square hole in the hinge. If the bolt is meant to grip in wood then a longer square is needed and a tapered header is best.

Pat Taylor: Did you steel the face of the header?

Peter Ross: For bolts and rivets I usually make headers of mild steel with no hard face. However, I make sure I am only working red or hotter when using it. The real damage to headers comes from continuing to hammer the piece after it cools to black. My bolt headers last many years with no hard steel on top. Now nail headers are a different story.

Reprinted from the **Forge Fire, The Newsletter of the Indiana Blacksmithing Association**

## Philip Simmons Artist Blacksmith Guild

<http://philipsimmonsartistblacksmithguild.com/>

### President: Jesse Barfield

2423 Stribling Circle, Lancaster, SC29720

803-287-0929

[jesstersforge@gmail.com](mailto:jesstersforge@gmail.com)

### Vice President: Jody Durham

767 Lynnhaven Dr., Seneca, SC29678

864-985-3919 [ironsmith@gmail.com](mailto:ironsmith@gmail.com)

### Librarians: Tony and Pam Etheridge

420 Prestige Ct, Orangeburg, SC 29115

803-682-5529

[auntpam1957@gmail.com](mailto:auntpam1957@gmail.com)

### Secretary/Treasurer: Ray Pearre

4605 Durant Ave.,

N. Charleston, SC29405

843-860-0532/[pearrecr@att.net](mailto:pearrecr@att.net)

### Newsletter Editor: Barry Myers

1847 Pigsaw Rd, N. Augusta, SC29841

803-640-5504/ [blmyers647@gmail.com](mailto:blmyers647@gmail.com)

### Webmistress: Jamie Herndon

414 Henry Stabler Rd, Swansea, SC 29160

803-665-7083 [herndonblacksmith@gmail.com](mailto:herndonblacksmith@gmail.com)

### Board Members

#### Todd Elder

708 Vista Farm Court, Lexington, SC 29073

[864-978-7232](tel:864-978-7232)/[elderusc13@gmail.com](mailto:elderusc13@gmail.com)

#### Duke Baxter

1104 Eagle Dr.

Rock Hill, SC, 29732.

[803.370 1455](tel:803-370-1455)/[dukeb@comporium.net](mailto:dukeb@comporium.net)

#### Jason Jaco

29 Woodpine Ct

Columbia, SC 29212

803-799-1865/[texasstreet@hotmail.com](mailto:texasstreet@hotmail.com)

#### Josh Weston

6925 Tanner Hall Blvd.

Hanahan, SC 29410

734-709-9677/[josh.a.weston@gmail.com](mailto:josh.a.weston@gmail.com)

## 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 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 – 2016” or “Dues for 2016 are due” or “Dues paid 2016”

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

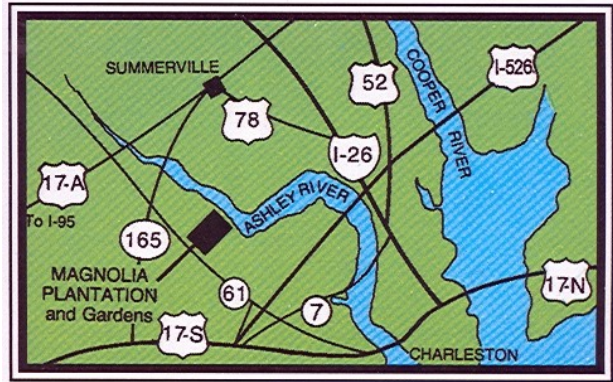
# Come to Magnolia Gardens

## April 22, 10 AM!

Bill and Lynda Creek and Ray Pearre are our hosts. Bring a side, drinks or dessert and something nice - maybe something you have forged, for iron in the hat. Jody Durham will be demonstrating! Something exciting, like chasing, huh!!

Sale of your blacksmith-made items to the public is welcomed!

Another thing, sale of your items to other members is also permitted! Just think about all of those tickets you have put in the cup for one of Meck's knives—you could have bought two from him!!



**Look at your mailing address below.**

**It tells when you last paid your dues.**