

# On the Anvil NEWSLETTER

PHILIP SIMMONS ARTIST BLACKSMITH GUILD

## INSIDE THIS ISSUE

Iron in the Hat.....	2
Valentine Project .....	3
Challenging Bottle Opener .....	4
For Sale//Upcoming Events .....	6
101 Ways to Die om Your Shop .	7
Veiner.....	8
Officers and Membership Form ..	11
Next Meeting Notice .....	12



Our Guild meeting was held at Revolutionary Park in Camden, SC as we always do in August, a sunny and warm day (OK, it was hot) with about 45 or so members, curious onlookers and wannabes attending. Our demonstrator was Mike Tucker of Tucker's Forge, who has become a full-time blacksmith after his recent retirement from the state school bus maintenance shop in Sumter.

He is very accomplished blacksmith and some of the things he makes are knives, hammers, tools, fire tools / screens and excellent ornamental ironwork. His demo piece was a flux spoon with a handle that had two square pieces twisted in opposite directions and forge welded together on the shaft of the spoon. Quite fancy and unique, I haven't seen one like that, probably could use it to stir a stew if you cleaned the borax off of it first. Don't know if Chris Herron is going to volunteer to pump the bellows again...

After Mike finished the demo and while he had the attention of the crowd he made a motion that we consider suspending the annual dues for Barry Myers and Ray Pearre to honor them because of the amount of work that they have done and continue to do for the Guild. I seconded the motion and we heard no opposition. The bylaws allow for the PSABG to elect a per-

son/persons to be Honorary Life Members and suspend their annual dues with a unanimous vote of the Board which was accomplished the following week.

A short list of their past and present duties include: Barry, vice president and president of the PSABG, president of the Southern Blacksmith Association, wrangler for SBA projects, Newsletter Editor; Ray, Secretary Treasurer, procuring demonstrators, demonstrating, planning hammer ins, planning meals, procuring insurance coverage, I could go on but I won't. It is an honor to have dedicated people like Barry and Ray willing to work to keep the Guild and blacksmithing prosperous and alive for the future. A by-product of their hard work and dedication, they have made the job of president much more manageable and easier to deal with.

Barry and Ray are not the only heroes in the Guild, those that brought sides for the meal to complement the fried chicken hit a home run as well (especially those homemade chocolate chip cookies!).

**Iron in The Hat** was a success with lots of unique forged items, handmade jewelry knives, and a healthy amount of rusty stuff. The total was \$684. Thank you for supporting our Guild.

**New Members** this month are Philip Hultgren, David Miller and Curt Coates.

Please keep Turner Hammett in your prayers. He has had a successful stem cell transplant as treatment for his leukemia. But, he has been found to have osteoporosis which his doctors are confident they can work on to improve. Also, keep Bill and William Creek in your thoughts and prayers as they learn, as we all do, to cope with the loss of Lynda.

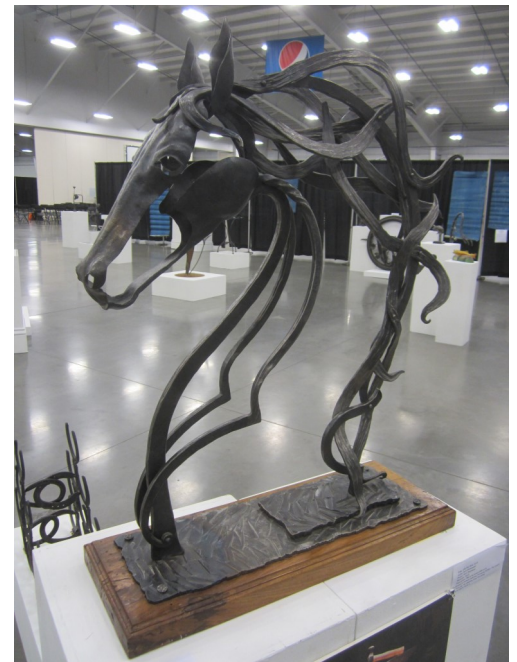
Thanks for your support, Jesse

Philip Simmons Artist Blacksmith Guild  
IRON IN THE HAT

September October 2018

Item	Donated By	Won By
Truck 'O Wood	Joe Holladay	John Tanner
Tee Shirts	PSABG	David Chambers
Nozzle Gel	Blackwell Hardware	Derice Hochstetler
Gloves	Carl Kistner	Heyward Haltiwanger
52100	PSABG	Charles Meyer/Pat Walters
Grinder Wheels/Wire Brushes	Blackwell Hardware	Barry Myers
Chisel	Jesse Barfield	Jamie Herndon
ShoulderHolster	Jesse Barfield	Tony Etheridge
Stick 'em Tommy	David Chambers	Bruce Hester
Bottle Opener	David Chambers	Gerald Alsbrook
Jar Handle and Jar	David Chambers	Michael Merrikan
Candle Holder	Mick Pugh	Brenda Hester
Fork	Barry Myers	David Chambers
Mower Blades	Charles Meyer	David Bush/Bob Kaltenbach
Knet	Pete Bell	ML Tanner
Damascus Knife	Meck Hartfield	Pat Walters
Deer antler	Wylie Hartfield	Heyward Haltiwanger
Timing Chain	Wylie Hartfield	Adrian Butler
Trivet	Todd Elder	Michael Merrikan
5 pcs Railroad Steel	Ken Willis	Philip Hultgren
3 Hook coat rack	Tony Etheridge	Duke Baxter
Ben's Mill Video	Ed Harman	Joe Marsh
Twisted double hook	Derice Hochstetler	Philip Hultgren
Leaf keychain	Derice Hochstetler	Bob Stukes
Aerator Parts	Charles Still	Rick Thompson
Ring Holder	Duke Baxter	Barry Myers/Jamie Herndon
Candle Holder	Duke Baxter	Barry Myers
Candle Holder	Duke Baxter	Jamie Herndon
Candle Holder	Duke Baxter	Bob Kaltenbach
Campfire Poker	Dave Bush	Gerald Alsbrook
Hot Punch	Dave Bush	Landy Young
Candle Holder	Gerald Alsbrook	Jason Jaco
Fire Starter Kit	Heyward Haltiwanger	Wylie Hartfield
Snake	Charles Meyer	Pete Bell
Bolt Cutter Jaws	Tracy Hartfield	Tony Etheridge
RR Spike Knife	Tommy Taylor	Gerald Alsbrook
Oyster Shucker/Bottle Opener	Chuck Baldwin	Duke Baxter
Ironwood Slab	Bob Kaltenbach	Charles Meyer
Purple Heart Slab	Bob Kaltenbach	Tony Etheridge
Rosemary	John Tanner	Jesse Barfield
Soap	Joe Marsh	John Tanner
Shamrock Broach	Joe Marsh	John Tanner/Jesse Barfield
ABANA Fan	Bruce Hester	Tony Etheridge
Antler	Bruce Hester	David Chambers
Mower blades and spikes	Bruce Hester	Brenda Hester
Grass Hopper	Bruce Hester	Gerald Alsbrook
Flower Thingy	Jamie Herndon	Chuck Baldwin
Spoon Demo Piece	Mike Tucker	Jason Jaco
Coil Spring	Patrick Walters	Bruce Hester
RR Spike Snake	Patrick Walters	Adrian Butler
Leaf Hook	Jason Jaco	Bruce Hester
Sea Horse	Jason Jaco	Jamie Herndon

**Not seeing the Content you want?** Submit requests for the kind of info and articles you are interested



The sort of thing you missed seeing if you didn't go to the ABANA Conference! The next one is in New York State—don't miss it!



Tom Latane's Hammer

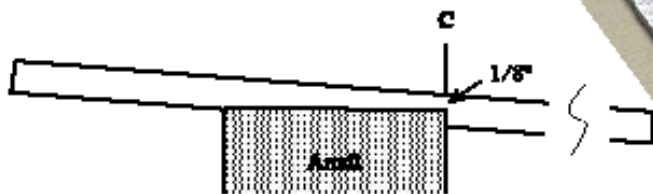
## Valentine

*By Steve Anderson, a MABA member*

Stock:  $1/4 \times 3/4 \times 18-1/2"$

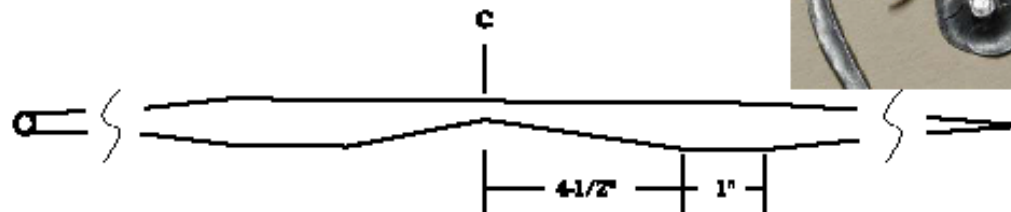
**Heart:** Starting at the center, use half-on half-off blows to forge stock down to  $1/8"$ . Then taper back to  $4-1/2"$  keeping the thickness at  $1/4"$ .

Repeat on the other end.



Forge one end to a long taper. About  $12"$ , keeping the thickness at  $1/4"$ .

Forge the other end down to  $1/4"$  square on the end, with a total length of about  $12-1/4"$ .



Forge the last  $3/4"$  to round, bend 90 degrees, then forge down to make a disc for attaching the flower.



Drill or slit and drift the disc to  $3/16"$ , then counter sink the back side.

Use the horn to form a heart shape.

**FLOWER:** Forge a  $2-1/2"$  flower to be attached to the heart.



**FINISH:** Highlight with brass brush if desired, then coat with Penetrol and 2 coats of wax before assembly, then a final coat afterwards.

**ASSEMBLY:** Rivet the flower to the heart using a leather disc to protect the center of the flower.

**NOTE:** For an asymmetric heart add  $1/4"$  of stock to the long tapered side.



## Challenging Bottle Opener

Jim Pepperl

(Photos by Jim Pepperl)

This little opener came from Jerry Hoffmann's "Blacksmith's Journal" (I highly recommend his series as a resource). Unfortunately I have long ago lost that page; it's in a file, somewhere in the shop. The original size of stock that Hoffman used was  $\frac{1}{4}$ " x  $\frac{3}{4}$ ", which I found a bit petite after all the forging. The instructions were to punch a  $\frac{1}{4}$ " square hole, hot cut three legs, poke the middle one through the hole, forge weld the outer two into a loop and scroll the opposite end, then make a little lip on the end of the post sticking through the bar. Jerry makes wonderfully elegant drawings that look like it would be so simple.

My process is similar to his with a few adjustments and a lot of 'fussing'. I've intentionally made these look confusing with both the scroll and the loop having the false appearance of a function and vaguely resembling commercial openers. One of the problems with small objects is how to hold them for the series of forging operations; this is my solution with this little opener. So let's begin: **(photo 1)**

- Forge  $\frac{1}{4}$  x 1" to  $\frac{5}{16}$ " x  $\frac{13}{16}$ ". This dimension gave me the "Goldilocks" size for what I wanted it to look and feel like. It also provides a little extra material in the three legs for errors in cutting. I work the first set of operations on longer bars making it easier to do; with one on each end of the bar. Once the process has been "discovered" multiples saves time.
- Lay out for a  $\frac{1}{4}$ " slit and drifted hole at  $2 \frac{7}{8}$ " and a cut off line at  $4 \frac{5}{8}$ " from the end of the bar. Center punch these points and forge the little  $\frac{1}{4}$ " hole.
- Lay out lines for the saw cuts, I use  $\frac{1}{4}$ " key stock placed against the edge of the bar and trace that. Stop the saw cuts at  $\frac{9}{16}$ " from the  $\frac{1}{4}$ " hole. I try to make the outer legs slightly wider at the top and narrower at the bottom. I use a portable band saw for cutting. Hot cutting works but alters the dimensions.
- Bend the outer legs to 90 degrees left and right. Forge the center leg square then bend it 90 degrees vertical, in this position I want it to measure  $2 \frac{5}{16}$ " from the bend. This dimension gives me a minimum of  $\frac{9}{16}$ " protruding through the bar after I loop it through the hole. This may vary depending on size of loop. Consistency is important.
- Clean up the saw marks on the two outer legs, leave as much material as possible toward the ends at the weld, bevel ends for welding.
- Poke the center leg through the hole.
- Loop the outer legs and weld, grind and file. There is plenty of material in the lower part of these legs to stretch

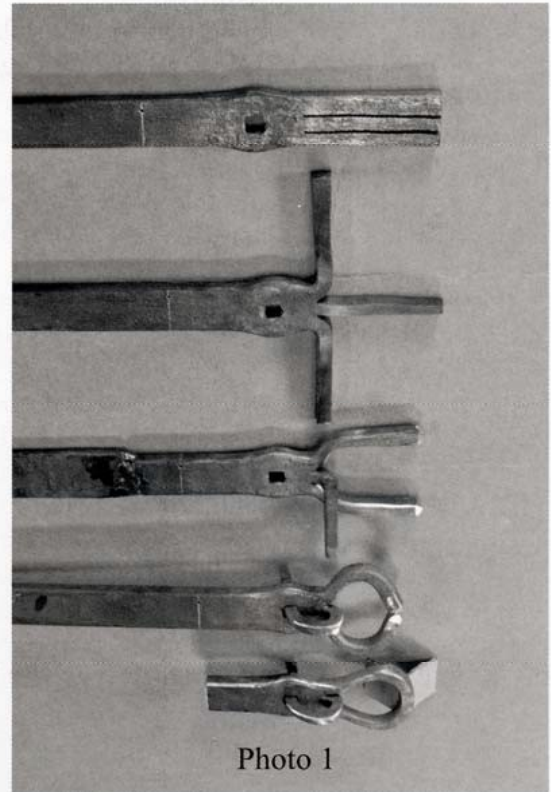


Photo 1

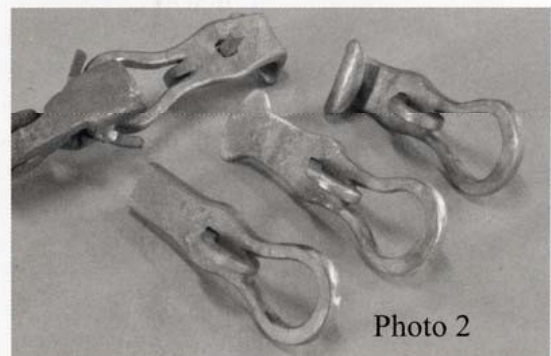


Photo 2



them for a forge weld lap if you have that skill. An inferior electric weld will show up later so make sure it is clean and 100% weld.

- Shape the loop, this is easier after the weld, pinching the crotch area with a rounding hammer and the anvil horn. After I've got the shape I want, I remove some material from the outside of the lower part of the legs to thin them and balance their size from crotch to half way around the curve.

- Cut off at the marked length (4 5/8"), this takes you to the last step (**photo 1**). Now fishtail and scroll the end (**photo 2**). The width of the fishtail is about 1 5/16" and 1 3/4" long measured from the protruding center post. Note the tongs in **photo 3**, flat jaws with a curved welded backstop slightly thinner than the opener loop. This was my solution to holding the little part. I've successfully done the scroll using a locking pliers, but do not recommend that for multiples of these little critters, there is insufficient mass and leverage to back up for forming the scroll. It's hard on your wrist. I use a rounded hammer to roll the scroll to accentuate the natural curve as it is rolled and I do not hit the outside edge of the scroll, only the center area. Because of the short stocky nature of this scroll and the small size of the part it tends to be a little difficult to get a 'nice' shape.

- Now it's time to finish the top loop (**photos 4 and 5**, again, note the tongs in **photo 5**). I frequently use this style to hold hinge barrels to work the strap ends. They are quite handy for holding odd shapes and also flat bar.) I pull the top of the loop out with a cross pein to increase the width then finish with a rounded hammer and fade the chamfer down the length of the leg. The loop is then bent over a 2" diameter mandrel or the anvil horn and a compound curve added with the swage block. A dome tool could also be used for this last curve, it's a small detail, but I find it important (**photo 6**). The finished profile should be a pleasing ogee curve from loop to scroll.

- The last forging step is to form the bottle cap "lift" on the protrusion of the center bar. Grab the small loop in the vise, heat the tip of the bar and 'mash' it down on a piece of 5/16" flat stock (**photo 7**). This is a simultaneous bend and upset. File to shape, the edge should be fairly sharp, then heat and bend the very small lip at the edge to create a catch point (**photo 8**). I use a 1/2" die grinder burr to make a radius indentation. I tell myself they work better that way. The original Hoffman version had a very simple lip which also functioned (**photo 9**).

- Final step: heavy sanding and hot wax.



Photo 3



Photo 4



Photo 5



Photo 6

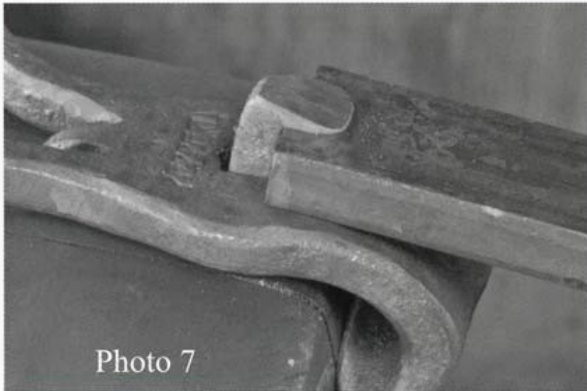


Photo 7



Photo 8

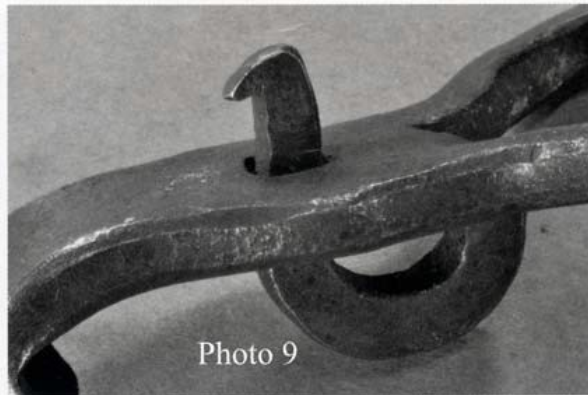


Photo 9

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

## 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.

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

## 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.

October Meeting: October 6 Todd Elder at his Columbia (the city) shop.

State Fair October 12, 13, 14 John Tanner Contact

Autumn on the Ashley Craft Fair at Magnolia Gardens. October 12, 13, 14. There will be an informal hammer-in on Friday, 10/12. Bring a project and join us! Contact Ray Pearre.

Colonial Days, Living History Park, October 20 – 21, Barry Myers demonstrating.

Myrtle Beach Renaissance Fair, November 10 (Marine Corps Birthday) and 11, Contact Ray Pearre.

**December Meeting: December 1, Lexington County Museum, Hayward Haltiwanger to host.**

**2019 Meeting Schedule: February 2nd—Conway, April—Magnolia Gardens, June—Marcengil's, August—Camden, October—Lexington County Museum, December—Ryan Calloway's in Greenville.**

# 101 Ways to Die in your Shop

by **Dominick Andrisani**

This article is part of an ongoing compilation.

Let's face it. Blacksmithing is dangerous. There are a gazillion ways to get hurt, or worse to die, in every shop. I thought it would be enlightening to list a few of them as a friendly safety reminder.

## ***1. You can die from tetanus.***

Tetanus is a bacterium that adversely affects skeletal muscles. In recent years, approximately 11% of reported tetanus cases have been fatal. The highest mortality rates are in unvaccinated people and people over 60 years of age. Tetanus is often associated with rust, especially rusty nails, but this concept is somewhat misleading.

Objects that accumulate rust are often found outdoors, or in places that harbor anaerobic bacteria (like the tetanus bacterium), but the rust itself does not cause tetanus. The rough surface of rusty metal merely provides a prime habitat for tetanus bacteria to reside, and the nail affords a means to puncture skin and deliver bacteria into the wound.

Tetanus can be prevented by vaccination, and the CDC recommends that adults receive a booster vaccine every ten years. Standard care practice in many places is to give the booster to any patient with a puncture wound who is uncertain of when he or she was last vaccinated, or if he or she has had fewer than three lifetime doses of the vaccine. The booster may not prevent a potentially fatal case of tetanus from the current wound, however, as it can take up to two weeks for tetanus antibodies to form. For those of you who think you are hardier than a horse, I want to remind you that Traveller, General Robert E. Lee's favorite horse, stepped on a nail and died of tetanus. Wikipedia

## ***2. You can die from the fumes if you heat galvanized metal in your forge.***

Just ask blacksmith Jim Paw-Paw Wilson. Oh, he died that way! Visit [www.anvilfire.com/iForge](http://www.anvilfire.com/iForge), click on Metal Fume Fever NEW! May 13, 2005.

## ***3. You can die if you lay your acetylene tank on its side for some hours and then pick it back up and use it.***

When free state liquid acetylene exits your torch, it explodes in a way that turns your tank into an improvised explosive device (IED). Next thing you don't know is that your body is in small pieces in the collapsed remains of what used to be your shop.

## ***4. You can die if you run your oxyacetylene torch with the acetylene regulator pressure greater than 15 psi.***

You and the tank can explode with near simultaneity as free state acetylene violently decomposes! [www.baesg.org/acetylene.htm](http://www.baesg.org/acetylene.htm).

## ***5. Injuries resulting from the use of angle grinders are numerous.***

The most common sites injured are the head and face. The high-speed disc of angle grinders does not respect anatomical boundaries or structures and thus the injuries produced can be disfiguring, permanently disabling or even fatal. However, aesthetically pleasing results can be achieved with thorough debridement, resection of wound edges and careful layered functional closure after reduction and fixation of facial bone injuries. I don't think you want to go there! It sounds painful and costly. Be careful! Always wear appropriate eye and face protection, [www.head-face-med.com/content/4/1/1](http://www.head-face-med.com/content/4/1/1).

## ***6. You can get burned.***

While this might not seem obvious, it's best not to wear gloves when blacksmithing. If you pick up hot metal with a gloved hand, the chances are that you will be burned worse than if you grabbed the hot metal barehanded. After you burn your fingers on hot metal, stick your hand in the slack tub and keep it there for a few minutes. This procedure won't cure a thing. It just gives you time to think about what you just did! If your burns are bad, apply some silver sulfadiazine, a sulfa drug (SSD), to prevent and treat infection. It kills a wide variety of bacteria including ones that live in slack tubs. See your doctor or pharmacist, and keep some SSD around.

## ***7. When using rotating machinery like a drill press or some other spinning tool, your hands, face and body can be pulled into the machine and become mangled.***

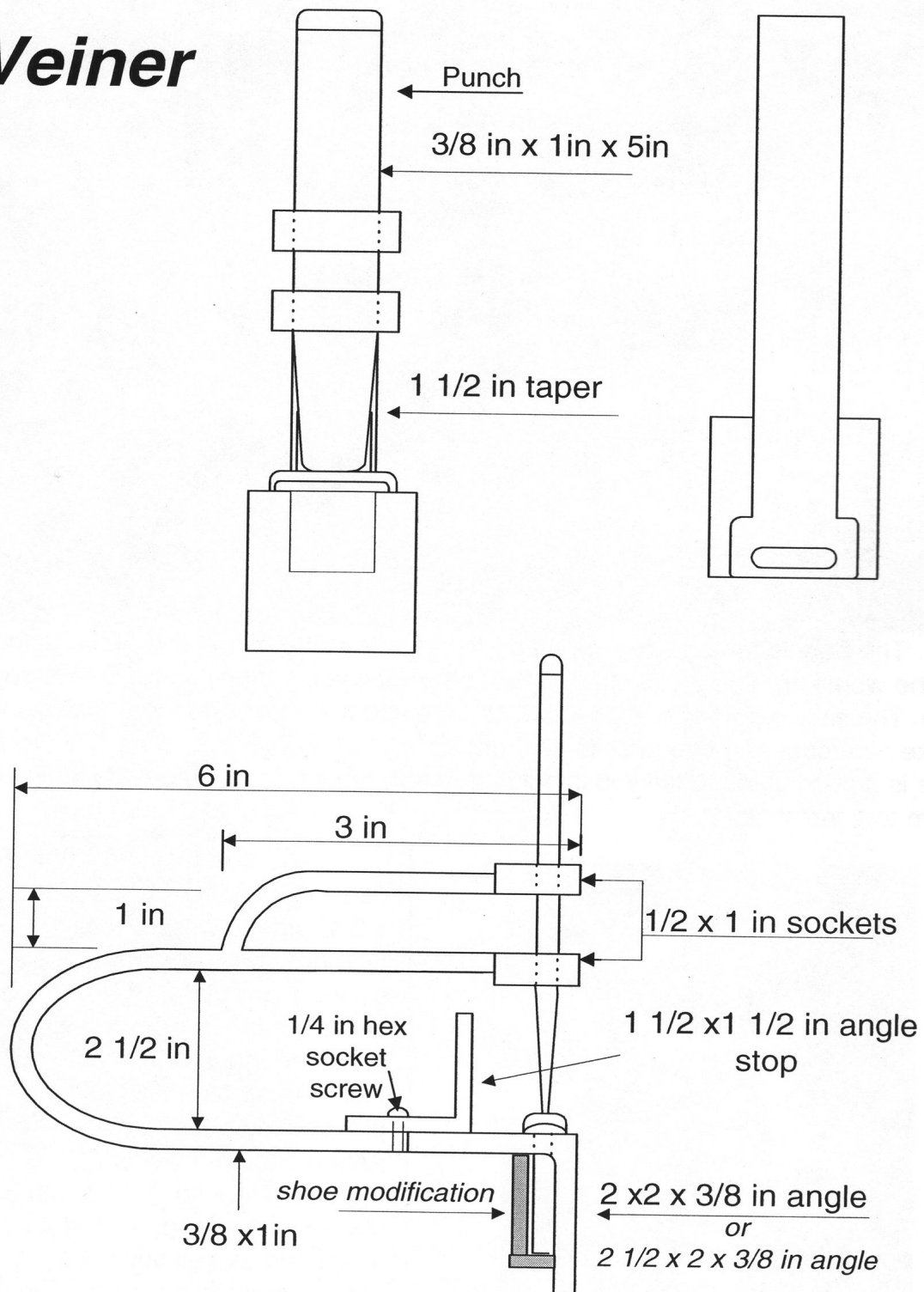
Remove your gloves, loose clothing and long hair before you start the machine.

To be continued....Author's Note. Please email your favorite way to die in your shop to [andrisan@purdue.edu](mailto:andrisan@purdue.edu). Put the word "DIE" in the subject line so that I can rescue your entry from SPAM.

Reprinted from the Indiana Blacksmith Association Forge Fire



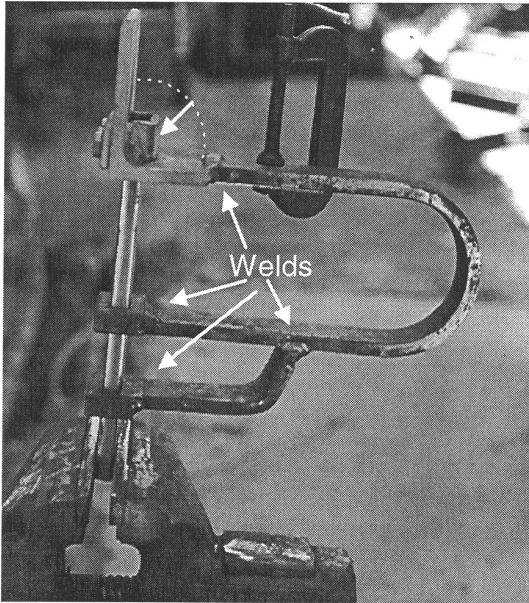
# Veiner



Nahum has made a modification where the bottom tool is located, in order to shim it for better alignment. This is indicated on the drawing as an update and option. You will need to cut the angle steel 2 1/2" wide rather than 2".



A Veiner is nothing more than a stationary chasing tool. You may want to think of it as a top tool-bottom tool set up. When you build your top tool, think of it as a chasing tool. The saddle in the bottom tool needs to receive the top tool plus the metal sheet stock.



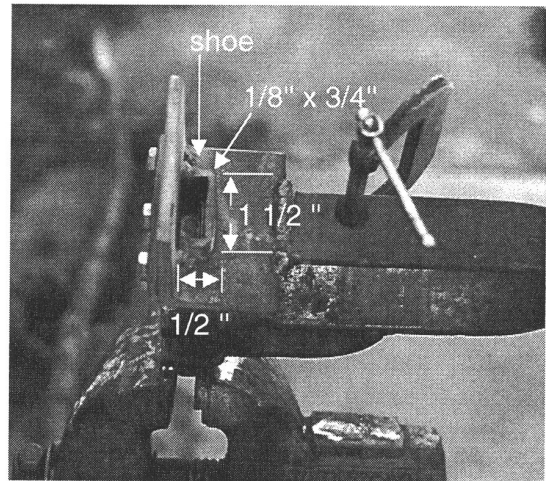
I made the Veiner from  $\frac{3}{8}$ " x 1" mild steel, except for the top tool guides. I made them from  $\frac{1}{2}$ " x 1" mild steel. I cut a slot and filed it out until a piece of  $\frac{3}{8}$ " x 1" stock would slide through it *freely*.

I pre-assembled by welding the top tool guides to the frame pieces. I use a  $\frac{3}{8}$ " x 1" blank top tool to align the frame before I weld it together.

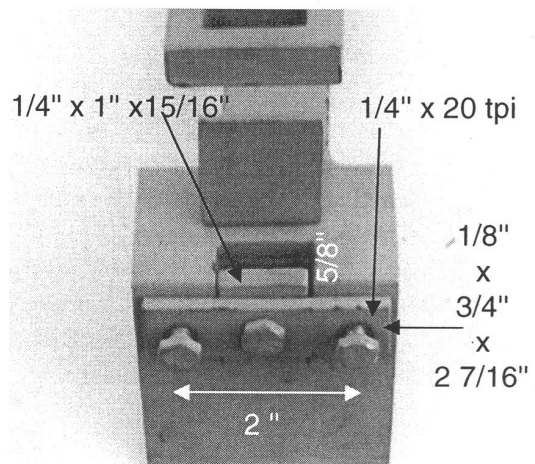
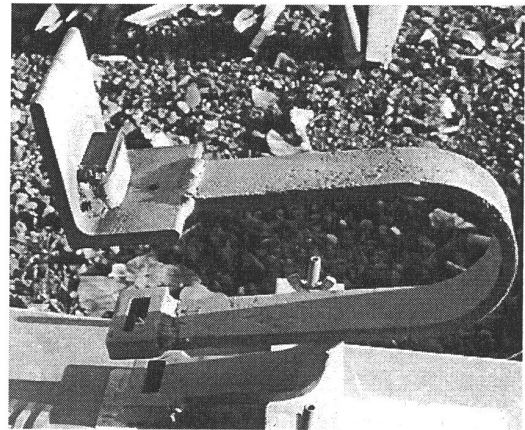
N.H.

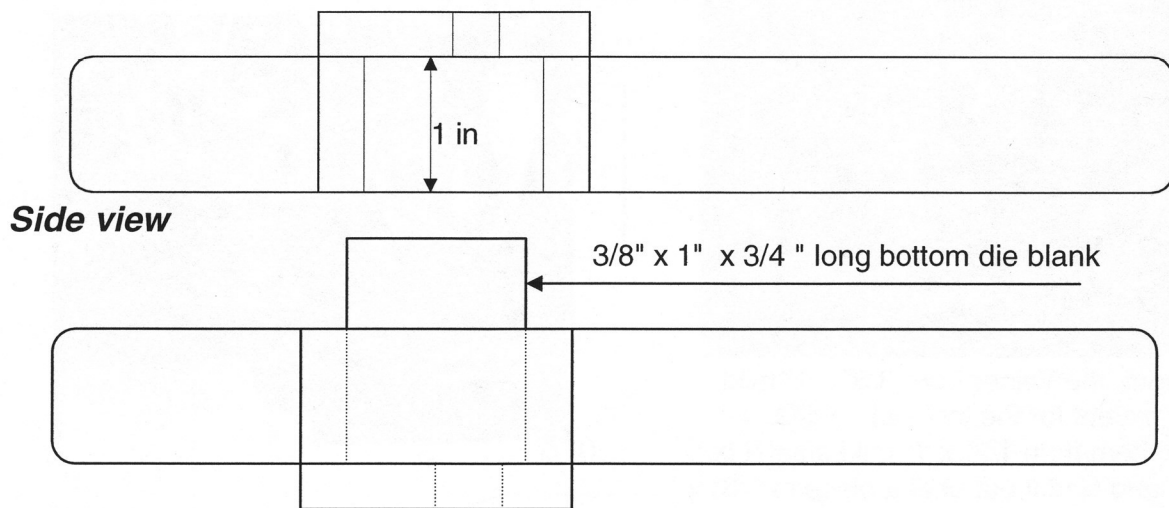
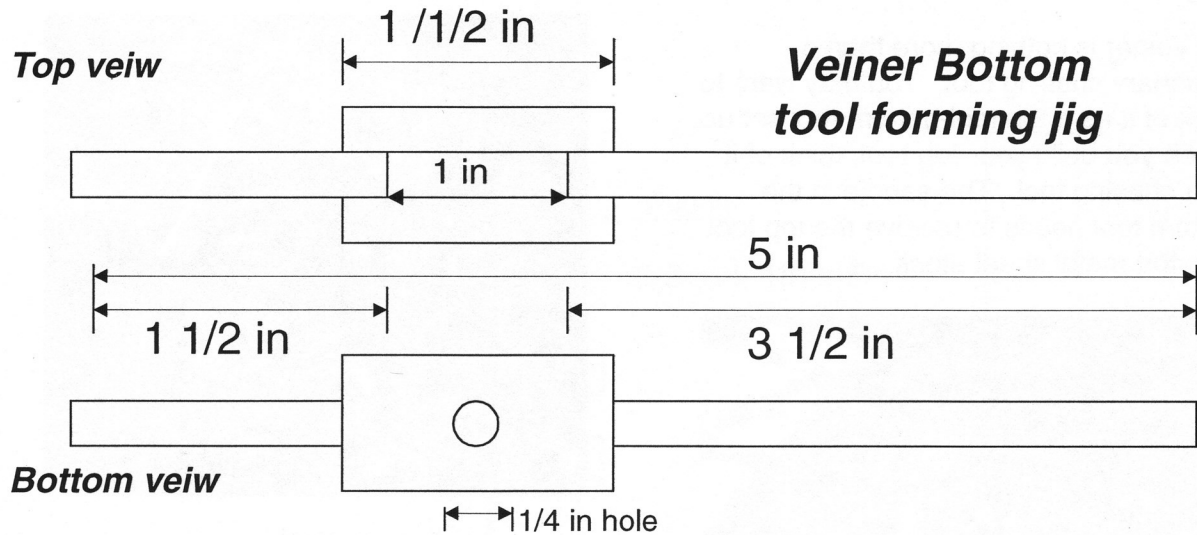
*Modification for bottom tool alignment:*

There is a space cut in the angle iron 1" wide,  $\frac{5}{8}$ " deep and 1" long. The  $\frac{1}{4}$ " x 1" x  $\frac{15}{16}$ " spacer is attached to a  $\frac{1}{8}$ " x  $\frac{3}{4}$ " x  $2\frac{7}{16}$ " spacer bar with a  $\frac{1}{4}$ " x 20 tpi bolt. The spacer bar is attached to the veiner with two  $\frac{1}{4}$ " 20 tpi x  $\frac{1}{2}$ " long bolts.

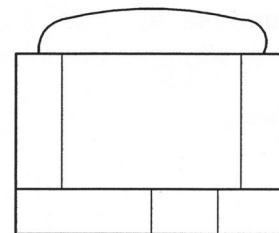


*Shoe assemble*





The Bottom tools are forged in a Jig. It is made out of 3/8" x 1" mild steel. After I cut all the pieces and get ready to weld it up, I wrap a piece of paper (old business card) on to a bottom tool blank, clamp all the jig pieces together and weld it up. Putting the paper around the blank will give you room to put a hot blank in later.



Be sure to drill a 1/4" in the bottom of the pocket. It helps you get the bottom tool out after forging.



## 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 Pisgah 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 – 2017” or “Dues for 2018” are due” or “Dues paid 2018”

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

## October 6, 10 AM

The October Guild Meeting will be at Todd Elder's shop in Cayce.

620B Frink St.

Cayce, SC

Todd will host the meeting and demonstrate an ax for us.

Bring a side or dessert and something nicely forged for Iron-in-the-Hat.

Hope to see you there!