

N.J.B.A. Newsletter

NJBA Volume 10, Issue 2 07/24/05

Editors Soapbox

It's Mid-Summer and it's hot!!! We have not had a very good turn out at the last few events so I want to remind you that NJBA is our Association and our participation is what makes us strong. So mark your calendar with the upcoming events, come with a friend or other member, but let's see more members coming out. If you have ideas for meets, etc contact a board member, the contact information is on page two of every newsletter. Remember "WE" are the NJBA.

Larry Brown, Editor

Upcoming events for 2005

Get your calendars out and mark these events down. Please bookmark our web site and check for meet information. Remember most of our meets have an "Iron in the Hat" drawing, so be sure to bring something.

August 5th thru 14th — State Fair in Sussex, NJ. We are going to sponsor a joint tent with Peters Valley. Demonstrators wanted. Contact Bruce Ringier, details on page 4.

August 21st—Hammer-In/ Tool Swap at the Red Mill Museum in Clinton, NJ. Rain Date August 28th. Details on this page.

September 16th - 18th Old Time Engine Show in Washington Crossing State Park. Details on page 4.

September 17th—Peters Valley Pig Roast, A Fundraiser for the Blacksmith shop, teaching facility. Details on page 4.

October 15th—16th—Power hammer rebuilding workshop. See details on page 4.

November 12th—Meet at Tim Millers Shop in Bayport Long Island. Details on page 5.

December 4th—Annual Holiday Party and Jan and Marshall's. Details next newsletter.

Red Mill Museum in Clinton, New Jersey

ANNUAL HAMMER-IN /
TOOL SWAP / NJBA PICNIC

Sunday, August 21, 2005, 10 am till 4pm with a rain date of August 28th

Red Mill Museum Village

56 Main Street

Clinton, NJ 08809

Contact: Adam R. Howard, Blacksmith 908-735-4573

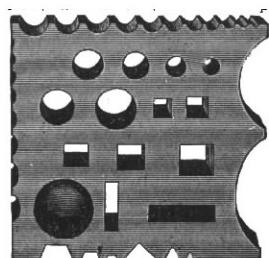
Activities will include demonstrations, the tailgate tool sale, live music, iron in the hat and the NJBA members picnic! In addition to previous years activities, we are inviting all Smiths who wish to exhibit/sell their work and wares to participate. NJBA members or anyone wishing to tailgate, demonstrate or exhibit, will be provided free admission with pre-registration, general admission of \$7 for the public.

Participants may pre-register by calling Adam Howard at the Forge, 908-735-4573 Bring tools, anvils, or any smithing related items and collectibles, bring your checkbooks, bring your appetites!

See you there.....Adam R. Howard, Red Mill Forge

Directions:

I—78 to exit 15, go North from exit onto West Main Street. Go to ahead and onto Old Highway 22 making a left on Leigh Street and then make a left onto Main Street. (These directions are from the map on my computer LB)



New Jersey Blacksmiths Newsletter

The NJBA Web Site!

The NJBA Web Site is up and running at:

<http://njba.abana-chapter.com/>

The Newsletter is at:

<http://members.bellatlantic.net/~vze25jcc/index.htm>

or the site may be linked to from the NJBA web site.

Official NJBA Address

**NJBA
P.O. Box 761
Mt. Laurel NJ 08054**

Rather than use room in the newsletter,
All correspondence between
ABANA and NJBA is now being posted
on the NJBA web site.
If you cannot access it there, contact me
and I will send you copies

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973-702-8475 wfkngb@yahoo.com

Tim Suter, June, 2004
1112 Ladner Ave., Gibbstown, NJ 08027
856-423-4417

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Come join the fun Saturday, Sept. 17, 2005!!

PETER'S VALLEY BLACKSMITHING



Pig Roast / Burgers / Hot Dogs / Salads / Sodas Beer
& Live Band!

To be Auctioned: Artwork, Tools and More!!

To be Raffled: 260 lb. Hay-Budden Anvil

Only \$30 per person – kids under 12 free!

Presented by

Jimmy Clark, Dick Sargent, Bruce Ringier and the
Staff

All proceeds to benefit Peter's Valley Blacksmithing
Department

Call for details 973-948-2393 shop

973-948-5200 office

1:00 PM Hurricane or Shine

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NJBA Welder Raffle

NJBA will be raffling off a Thermal Arc Dragster 85 DC stick welder. This is a 115 volt inverter welder adj. from 8 to 85 amps DC output, it will weld 1/8 steel in a single pass and weighs only 12 pounds. Tickets will be \$1 each and the drawing will be at the annual NJBA picnic/tool swap August 21st (rain date 28th) at the Red Mill in Clinton, NJ. Tickets will be available at all NJBA meets (winner need not be present). If you can't make a meeting, get in touch with John Chobrda and he will gladly mail some to you.

Red Mill's web site is <http://www.theredmill.org/>
John Chobrda contact information:
609-443-3106 jchob@verizon.net

State Fair at Sussex County August 5th- 14th

We want to help provide scheduled demonstrators for the tent that Peter's Valley has at the fair. David has the schedule that Bruce Ringier would like to have filled out. PV will provide forges, tools, supplies. Contact Bruce Ringier or David Macauley to schedule a demo time or just come out to this event!

Directions; The entrance to the fair is on Rt. 206N after the junction of Rt. 15. Look for traffic and signs.

Old Time Engine Show September 16, 17th, and 18

NJBA will again be at the Delaware Valley Old Time Power and Equipment Association's "Days of the Past" Engine Show at Washington Crossing State Park, in Titusville, New Jersey. Come on out and bring the family, there are hay rides for the kids, a metal heads flea market, and a lot to see. We will have a couple of forges going so bring a hammer, also if you have some items for sale we will have a table out. Come on out and join the fun. For more information check out their web site <http://daysofthepast.com/>

Directions:
The Engine Show is located in Washington Crossing State Park off of Rt. 29 (River Rd.) South of Lambertville and North of Trenton signs are posted to show the way.

Peters Valley Fifth Annual Pig Roast and Fund Raiser

On September 18th Peters Valley will hold its fourth annual Pig roast and fund raiser. Please bring or send pieces to donate to the auction. The cost for the day is \$30 with children under 12 free. For more information please call the main office at (973) 948-5200.

Directions to Peters Valley;
Peters Valley Craft Education Center is located at 19 Kuhn Road. in Layton (Sussex Co.). NJ 07851.
(Phone: 201-948-5200).

From Interstate Route 80 West:

Take Exit 34B to NJ Route 15 North. to US Route 206 North. Left onto NJ Route 560 West. Go through the blinking light in the center of Layton, onto NJ Route 640; go about 2 miles and turn right onto NJ Route 615. Go approximately one mile.

From US Route 209 (on the west bank of the Delaware River in Pennsylvania): Take PA Route 739 South across the Dingmans Ferry Bridge. Take the first right at sign to Peters Valley. Go two miles.

NJBA Presents A Little Giant Power Hammer Rebuilding Seminar Given By Sid Suedmeier

Hosted at Roger Dixon's Shop in
Hampton, NJ

This is a two day workshop, Saturday **October 15** and Sunday **October 16**. The cost for the workshop is **\$50** per person. The maximum amount of attendees will be 45. These seats will be filled in the order the checks are received, so register soon to be there!

The last date for registration is August 15, 2005.

In the unlikely event the workshop cannot be filled by this date your checks will be returned.

Lodging is available in nearby Clinton, NJ for those who need to travel further.

The contact for the event is:

Roger Dixon, 3 Thads Hill Rd, Hampton, NJ 08827
908.337.2057 roger.dixon@att.net

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Make checks payable to NJBA and send to contact above.
This seminar covers:

The evaluation of used machines, totally rebuilding a used machine, teach all repairs to students, with alternative repairs, explain which repairs should be done by a machinist, adjustments, judging what size hammer you need.

The History of these hammers.

Safety- Guards, Spring, Short dies, Removing leaded paint, Eye and Respiratory protection, Pouring Babbitt (Safety will be covered prior to pouring the bearings in class)

Disassembly and evaluation of parts

Clean up and rebuilding of parts

Re assembly and adjustment

November Meet At Tim Millers shop in Long Island

Meet is tentatively scheduled for November 12, More information in the November Newsletter. Mark the date on your calendars. All NYC and LI members are asked to contact Tim at (631) 419-1185 to help create an area mailing list for future local events.

NJBA Holiday Party!

The holiday party is to be held on December 4th at Jan and Marshall's house Many thanks again, to Marshall and Jan for opening their home to us in the holiday season. Members are asked to also bring various trivets, candle holders, or other holiday items they are making to the party. Despite the emphasis on blacksmithing, members are encouraged to bring their families. More information in the next newsletter!

Directions to Marshalls' Home:

Marshall and Jan's "cabin" is not on Marshall's farm, but about 3 miles east of it on the same road. Casino Drive is just off Rt. 9, about 3.5 miles north of interstate I. 195 (exit 28), and about 4 miles south of Rt. 33. Either of these routes can be easily reached from the major north-south highways including the Garden State Parkway, the NJ Turnpike, I-295, Rt. 18 or Rt. 34. From Rt. 9 northbound, make a right onto Casino Dr.; southbound, take the jug handle to make a left onto Casino Dr. Continue past Marshalls' Farm to #301 Casino Dr., Howell, N.J.

(ph# 732-938-6577) jlfmib@optonline.net

Report on the Delaware Valley College, A days, April 23—24

By Doug Learn

The last full weekend of April is the time for A-Days at Delaware Valley College in Doylestown. A student fundraising event that is fully-student run, the proceeds go to support the various student organizations on campus. This year was 100th anniversary, and for NJBA the third year that we demonstrated there. John Chobrda brought his trailer and equipment over on Friday, and after work my sons Japh and Calum, wife Fawn and I went over and started to set up. This year the College provided us with a tent that would pass muster with the local fire marshall, so we were all snug and dry for the weekend. Saturday morning dawned cloudy and damp, but with no rain. The family set up and we were joined by Brent Reeb and two co-workers Jim and Quentin.

Throughout the day we demonstrated for the attendees, performing the standard magic with steel, fire and hammer, to the delight of all. I made many small horse-shoes from 1/4 square along with the standard nails, leaves, and other items. Calum and Japh did some sinking of sheet steel for bowls using several sinking forms. Brent, Jim and Quentin also made many larger pieces (hooks, flower crooks, etc.) while keeping the crowds entertained. We only had one older gentleman tell us that, since we weren't shoeing horses, that we were not blacksmiths. Of course, this man and his friend were alumni who had learned to shoe horses at the college in the 1930's.

The sky opened up about 3:30 in the afternoon, thinning the crowd and allowing us to pack up for 5:00 pm. Sunday's weather was drier, but not sunny. Japh brought his iris and daffodil that he made with Jeff Fetty and a couple other pieces from his senior high school project, which were a hit. The crowd was steady and interested throughout the day. Several people signed up for more information on blacksmithing and overall a good time was had by all, both demonstrators and the public. Thanks to NJBA for their continuing support for this demonstration. We will do this again next year. Come help on this pretty campus and see a group of young people doing great things for their school and themselves and demonstrate for the public. And the cow, sheep, goat and pig beauty contests are worth the trip alone.

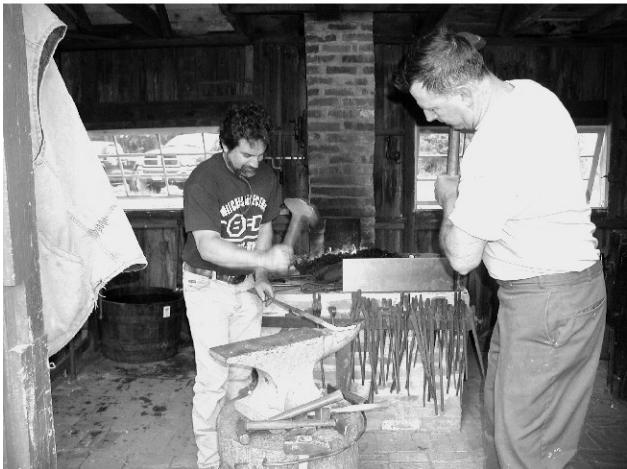
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Applegate Farms Ice Cream Store and Blacksmith Shop



On the afternoon of May 21st. Applegate Farms ice cream store on Rt. 539 in Freehold held their grand opening. The store has a farm motif and on the grounds is the oldest blacksmith shop in Monmouth County, which was recently refurbished by the store owners and NJBA member John Chobrda. On hand to demonstrate that day were NJBA members Mike Erdie, Mitch Swirsky, Jeff Morelli, and John Chobrda. There was a large turnout and a couple of youngsters tried their hand at forging. A fun day was had by all, and the owners were very pleased by our participation.

At the present time details are being worked out and the shop will be available for use by NJBA members, the details will be posted to the membership as soon as they are available. Report by John Chobrda



Mike Erdie and Mitch Swirsky

June Meet at the NJMT

On June 18th There was a meet at the Pine Creek Railroad/ NJ Museum of Transportation outside of Allaire State Park. A tour of the facilities was given for those who hadn't seen the facility. A gas and a coal forge were set up with a regular anvil and a railroad track anvil. The first item forged was a hardy for the anvil from a jack hammer bit, this was done by David Macauley with the young men (I can't remember their names at this time) in attendance acting as strikers. The idea of the meet was to come up with ideas of what to make from railroad spikes, of which NJMT has many. The young men worked on making tomahawks from the spikes with David and Bill Kerr giving instruction on punching the eye and forging out the ends for the blade and spike parts. I made a business card holder from a spike with assistance from one of the young men as a striker while I was splitting the spike. Two pieces of railroad track were torch cut and ground to form horns on the ends for future demonstrations and teaching sessions.
Report by Larry Brown

July Meet at Historic Cold Spring Village

We had a rather good demonstration even this past weekend, July 9,10 2005 at Historical Cold Spring Village. On Saturday, I was joined by Bill Futer and Don Harbart. We set up the equipment a little farther away from the blacksmith shop but in a location that provided shade all day long. We did not use the tarp since we did have the shade. Both Don and Bill provided demonstrations to the public and more importantly supervised some members of the public who wished to try blacksmithing. I saw at least 2 or 3 people trying out blacksmithing. Don worked with a young man named David who is apprenticing at the HCSV shop. They worked on forging a knife out of a railroad spike - looked pretty good. Since the portable forges were pretty busy, I helped interpret in the shop on both Saturday and Sunday. On Saturday I reworked a hot cut into a punch and fixed up a few tongs - what a surprise. We also fixed the handle of the shop's squirrel bellows. The shop also has a canvas sided bellows, but it does not appear to work very well. The squirrel bellows leaks oil pretty badly. Perhaps in the future we can have a work day there to fix both.

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We did find the smaller bellows and the leg vice - there we were tightly packed in the front of the trailer, so I could not easily see them when we working on the trailer roofs. The trailer pulled really well on the highway. No problems with the brake system.

On Sunday I worked on making a rush lamp. Jerry Goldman was working on a candelabra which is part trammel hook, and part copper candle cups. It was quite impressive to watch him sweat solder between the copper piped and dished copper bowls to make the candle holder.

The entire village staff was extremely helpful and accommodating for our demonstrations. They have offered to help reimburse some of our travel costs, so I will be submitting a letter indicating the distances traveled and the tolls. Boy my truck sucks gas when I am pulling that trailer.

On Monday I stopped at the shop of Stephen Bradway who is a copper smith in Rio Grande. He makes some beautiful items including copper cook wear. I went to the shop to pick up a swedge block that Jerry donated to NJBA. For now I have the swedge block at my shop not the trailer - it is a fairly good size block and I don't think we need the extra weight in the trailer. I have smaller swedge block that we could put on the trailer.

Report by David Macauley

Coke Purchase?

Hi all, I have heard good things about this product and I am considering purchasing some. If anyone else interested in trying some out we might be able to get together to save some money.

Contact me, Larry Brown (718) 967-4776

The following are delivered costs of "L Brand"** to 10308 zip code area, my house, prices around a month old.

The total delivered price, including freight, for 10 - 50 LB bags (500 LB) is \$302.00 or \$30.20 per 50 LB bag.

The total delivered price, including freight, for 20 - 50 LB bags (1,000 LB) is \$461.00 or \$23.05 per 50 LB bag.

The total delivered price, including freight, for 40 - 50 LB bags (2,000 LB) is \$705.00 or \$17.63 per 50 LB bag.

If the coke is picked up at the freight companies terminal in Jersey City (zip 07306) the costs are:

The total delivered price, including freight, for 10 - 50 LB bags (500 LB) is \$276.00 or \$27.60 per 50 LB bag.

The total delivered price, including freight, for 20 - 50 LB bags (1,000 LB) is \$422.00 or \$21.10 per 50 LB bag.

The total delivered price, including freight, for 40 - 50 LB bags (2,000 LB) is \$643.00 or \$16.08 per 50 LB bag.

We accept VISA & MasterCard. Thanks for your interest in "L Brand". Ed Avolio, Sales Rep., 800-441-0616

Extra Things to Remember

1. No one can ruin your day without YOUR permission.
2. Most people will be about as happy, as they decide to be.
3. Others can stop you temporarily, but only you can do it permanently.
4. Whatever you are willing to put up with, is exactly what you will have.
5. Success stops when you do.
6. When your ship comes in.... make sure you are willing to unload it.
7. You will never "have it all together."
8. Life is a journey ... not a destination. Enjoy the trip!
9. The biggest lie on the planet: "When I get what I want, I will be happy."
10. The best way to escape your problem is to solve it.
11. I've learned that ultimately, 'takers' lose and 'givers' win.
12. Life's precious moments don't have value, unless they are shared.
13. If you don't start, its certain you won't arrive.
14. We often fear the thing we want the most.
15. He or she who laughs ... lasts.
16. Yesterday was the deadline for all complaints.
17. Look for opportunities ... not guarantees.
18. Life is what's coming not what was.
19. Success is getting up one more time.
20. Now is the most interesting time of all,
21. When things go wrong ... Don't go with them

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Blacksmithing Workshops and Classes:

Peters Valley Craft Education Center

19 Kuhn Rd., Layton, NJ 07851 (973) 948-5200
pv@warwick.net www.pvcrafts.org

Academy of Traditional Arts
Carroll County Farm Museum
500 South Center St. Westminster, MD 21157
(410)848-7775 (410)876-2667

Touchstone Center for Crafts
R.D.#1, Box 60, Farmington, PA 15437
(724)329-1370 Fax: (724)329-1371

John C Campbell Folk School
One Folk School Rd.
Brasstown, NC 28902
1-800-365-5724 www.folkschool.com

Red Mill Forge
Contact Adam Howard about workshops and per diem
use of the shop (908)735-4573

BLACKSMITH TOOLS FOR SALE!

John Chobrda

Has a large selection of tools for sale.
Anvils – Forges - Leg Vices—Blowers
Tongs – Hammers
Will also repair and/or resurface Anvils
Call John for prices and availability
Evening (609) 443-3106

FOR SALE
ALVA ALLEN No. 5T-5, OBI PUNCH PRESS
¾ hp - 3 phase
On rolling iron stand, Excellent condition
Offered for sale at \$325
Contact Bill Ker @ 732-223-4188
Monmouth County, NJ,
Loading available

Business Members

We would like to thank those who joined with our new
Business Membership category
Please show them our support

Marshall Bienstock

663 Casino Dr., Howell, NJ 07731
(732) 938-6577, (732) 780-0871

John Chobrda, Pine Barrens Forge

231 Morrison Ave., Hightstown, NJ 08520
609-443-3106 JChob@earthlink.net

Eric Cuper Artist Blacksmith

109 Lehman Lane, Neshanic Station, NJ 08853
908 642-6420 ericuper@msn.com

Bruce Hay, Jr.

50 Pine St., Lincroft, NJ 07738

Jayesh Shah Architectural Iron Design

950 S. 2nd St., Plainfield, NJ 07063
jay@archirondesign.com

Open Forges

We are looking for members who are interested in opening
their forges up to members as a open forge. This does
not have to be a weekly forge as is Marshall's the others
can meet once or twice a month. Please contact, Larry
Brown, Editor.

We want to encourage all to join us at

Monday Night Open Forge in N.J.

Marshall Bienstock is hosting an open forge in his shop
at 7 pm almost every Monday night (Please call ahead
on holidays to make sure , (732)780-0871)

Open Forge in Long Island

Sunday from 10:00 am to 6pm.
Starting the 1st Sunday in November until the end of
April. Please call ahead to confirm and get directions.
Ron Grabowski, 110 Burlington Blvd. Smithtown, NY
(631) 265-1564
Ronsforge@aol.com

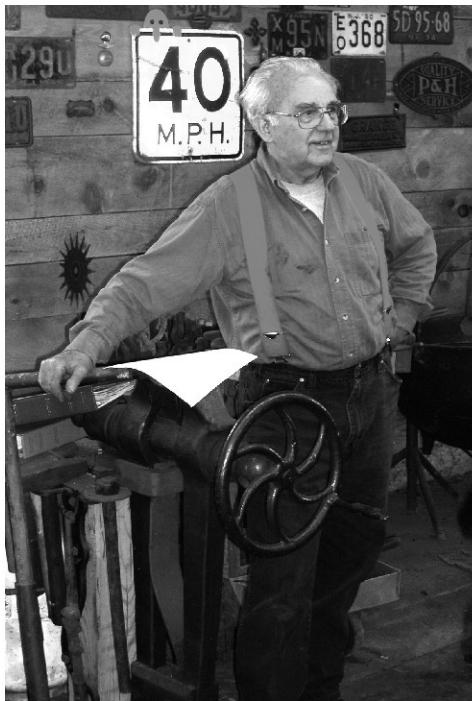


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May Meet at Bruce Ringiers in Wantage, NJ

On Sunday, May 15th Tim Suter gave a "Serendipity Tool Demonstration" on Shop setup, tooling and techniques, Treadle Hammer Tooling and his Air Powered Treadle Hammer.

Tim started by describing his layout table which is 1/2" x 36" x 48" steel plate mounted on a machinist cabinet that has a 3" edge that allows the use of clamps around the edge and has a hardie hole in two of the corners. The hardie holes can be used to hold a vise, bending fork or other anvil tools. The 1/2" plate allows for temporary welding of tools for clamping and bending to the table that can be cut off afterwards and the welds ground off. For heavy hammering he uses a 1" x 12" x 12" plate on the table.



Tim Suter

He next described his "Anvil Buddy" which is a small stand to hold a few tools you are using for the job at hand. The stand is light and easily moved out of the way. He had built a larger stand but it got so heavy it now holds tools not used right now in the corner. The anvil buddy is the same height as the layout table and the chop saw so it can be used as an extension.



Tims Hold Down

He uses a 250# anvil on a stand made from 1/2" plate cut to the shape of the anvil base which is welded to a section of salvaged oxygen cylinder cut to the correct length and in turn welded to a piece of 1/2" x 18" x 18" plate with three pieces of 3/16" x 1 1/2" x 1 1/2" under the base to allow it to sit evenly on the floor. The anvil is bolted down securely with a piece of rubber under it. This gives a quiet stable base that you can stand next to. Tim uses a hold down tool that goes through the hardy hole and that connects with a chain to a foot pedal.



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Tim encourages anyone who does not know how to weld to learn how as it opens up a world of possibilities as far as jigs and tooling.

Tim uses a gas forge, "NC Whisper Daddy", a 3 burner forge that he has modified so that each burner may be controlled separately.

His swadge block is set on a stand so that the top is even with the anvil face whether it is in the vertical or horizontal position. Tim showed a sinking or dishing die that was made from the bottom of an oxygen cylinder. He then talked about various tools and his preferences such as having different hammers for forging and striking tools, gas pliers converted to tongs, a homemade rivet cutter and his smithing magician and the dies he has made.



Tim's swadges and power hammer tools

Tim then demonstrated techniques he uses on his air or foot powered treadle hammer. He showed various swadges and texturing dies and the way he uses them.



Dick Sargent's finial



Dick Sargent's taper tool

Dick Sargent followed Tim and showed a tool he uses for helping to hold and get more leverage with a hand power drill. He then showed a antique finial and a version made with modern materials. Then he demonstrated making a new one showing the fullering dies he had



Finial Parts



Spreading tool

made and a tool for spreading the sides of the finial. Tom Ryan demonstrated next and although I missed it I was told he forged some heavy stock on Bruce's Bradley helve Hammer and demonstrated making some "U" shaped pieces from heavy flat stock.

Many thanks to Bruce Ringier for the efforts he put into this event and for opening his shop to us.

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Scroll Ends

A demonstration by Bill Epps

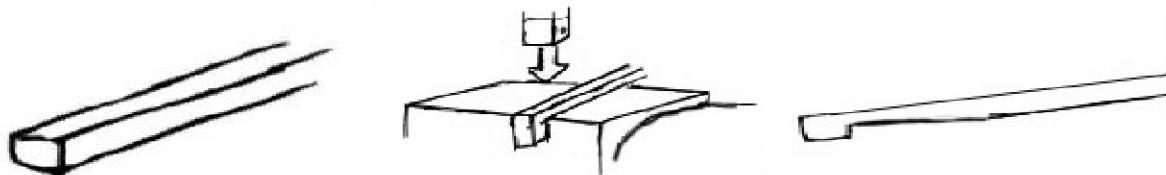
This is also posted on "Anvilfire.Com". This is used with the permission of the Author.
Minor changes have been made to use this in this newsletter.

Tonight's demo is a "Scroll Ends"!

A couple of weeks ago, Jock did a demo on laying out scrolls using a "Grid". Once you have your scroll laid out, what separates QUALITY work from MEIDICOUR is the ends that you put on your scrolls..

We might want to break this up into two sections, because it can get a little bit long. Lets just see how it progresses.

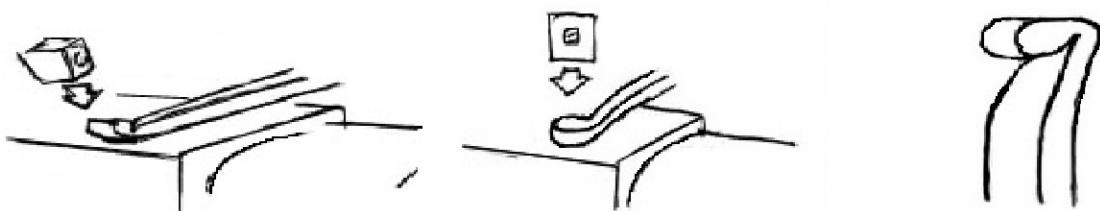
We will do a "Snub-End Scroll" first.



The snub end is made on square or can be done on flat bar. This is 1/2" square stock. I let 1/2" hang over the edge of the anvil and Set It Down. I make a mark on my hammer head to use as a gauge.

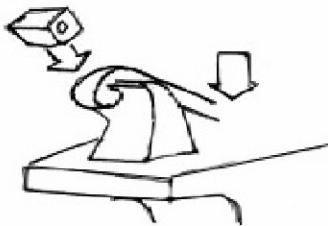
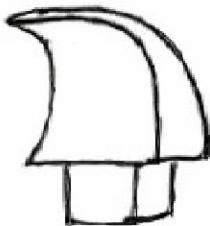


After setting the stock down over the edge of the anvil, hammer the "Top Corner" back into itself at a 45 deg. angle. Then come back to the face of the anvil and flatten it back out to the stock thickness, in this case 1/2" inch.

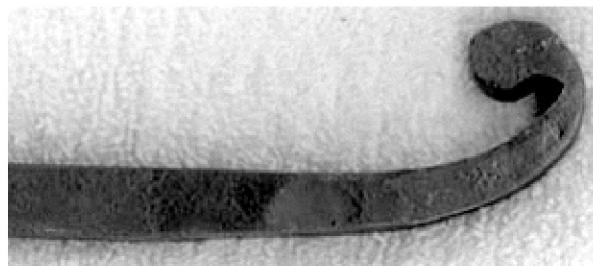


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When you flatten this back out, it generates a "Radius". Now we will have a point and turn it upward and hammer it back into itself. This will start to look like a ball.

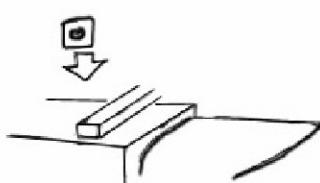


With a "Curved" hardie you put the radius in the base of the snub-end, and make the first 90 degrees of your scroll.

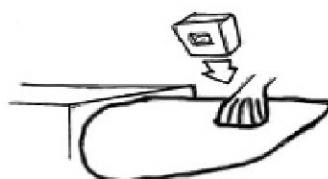


It ends up looking something like this. At this point, it is ready to be reheated and go to the bending jig.

Next is a "Fish Tail Scroll"

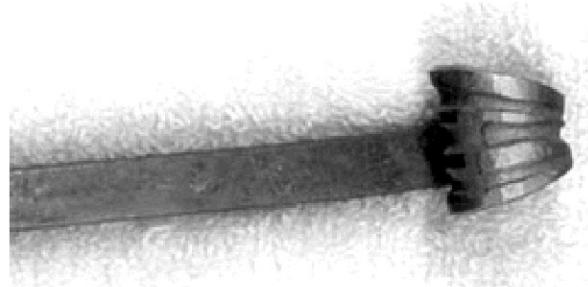


A Fish Tail Scroll is just simply a flared out scroll with embossing in the end.



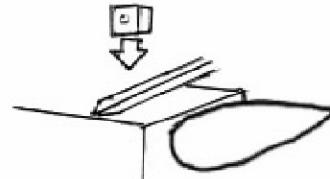
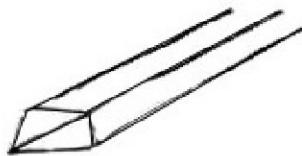
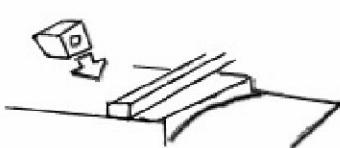
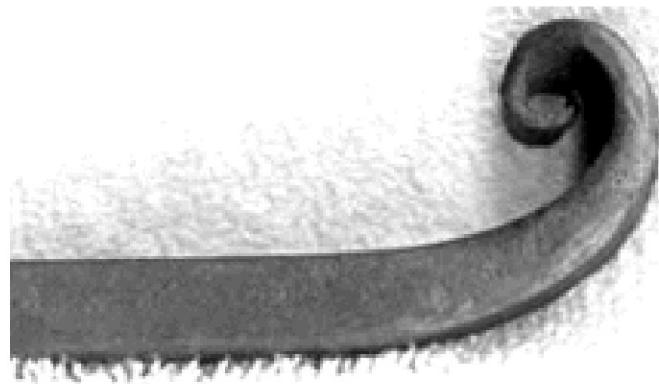
We flare the end and using a "Blunt" chisel, forge the lines in the end of the scroll and shape over the horn.

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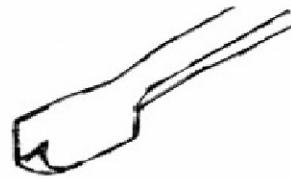


Just roll it back into itself and it looks something like this. Now it is ready to go to the scroll jig.

Next is a "Flared End Scroll" It is the same as a fish tail without the lines.

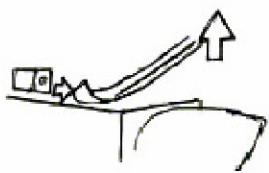


On this one here, I put a short point on it to start with.



Then flatten the end thin, and start curling it back into itself.

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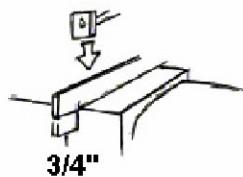
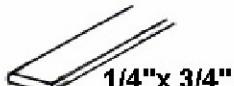


As you are hammering on the end, raise your other hand up, and this gives you a nice roll, just like rolling up cookie dough. You never want to hit the same place twice, keep your holding hand moving upward as you are hammering on the end. This gives a nice look, at this point it is ready for your jig.

The next scroll is a "Penny Scroll"

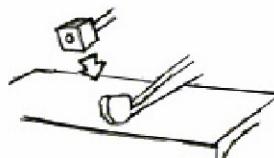
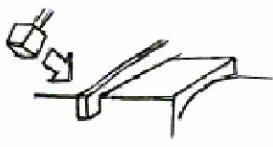
This may seem like "Useless" information, but if you are ever going to make a Gate or a Grille, tables, beds, or just about anything else, you need to know how to offer your client a variety of scroll ends for effect.

Penny Scrolls are done on "Flat Bar".



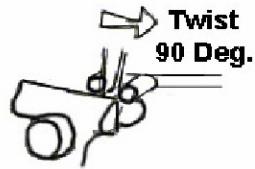
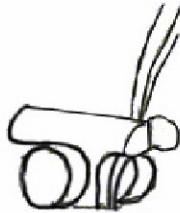
This happens to be 1/4" X 3/4" flat bar. Do the same technique on any size, this just happens to be what I am using. Set it up on the edge of the anvil, let about 3/4" hang over, Set it down. (There Again, using a mark on your hammer head as a Gauge).

Set it down until it has a long narrow taper and comes out to about the same thickness as your material, but continue to flatten it back to keep your width the same.

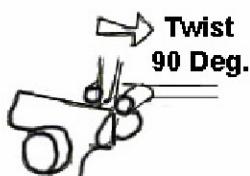


Hammer the top corner back into itself. Lay it down on the face of the anvil, drive that point that appears back into itself also.

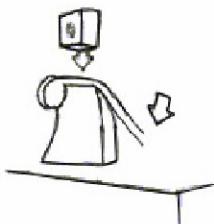
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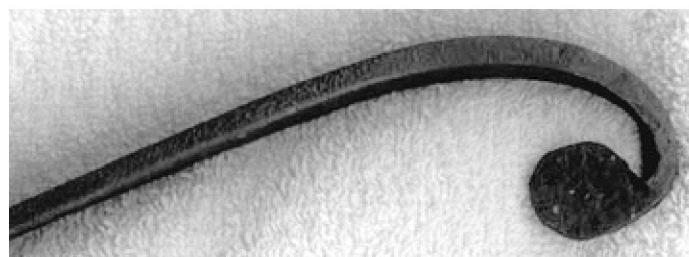
Flatten it back to the original thickness. This makes a cute little flat ball on the end. Take a good heat, clamp in the vice and twist 90 degrees.



Get it good and hot, and hammer the twist out. Put your taper back to the center.



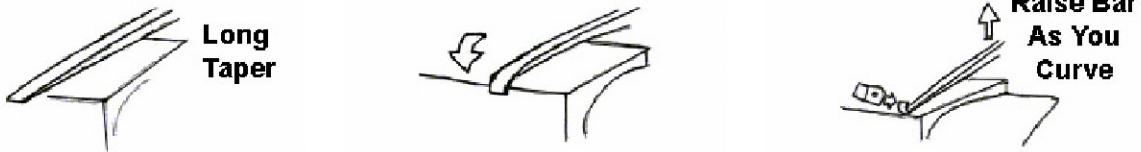
Then I come to my "Curved Shaping Hardie" again, and start the scroll end over it. When it looks like this, you are ready to go to your scroll jig.



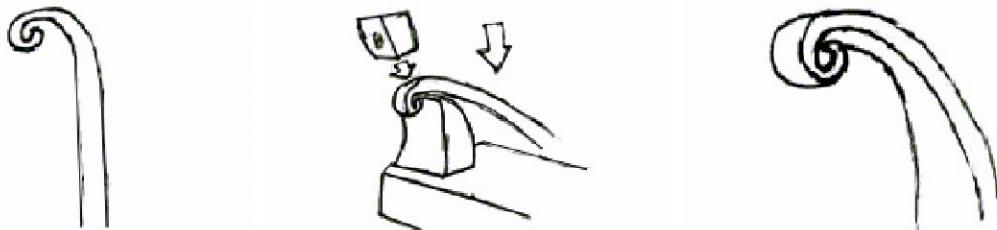
Next we will do a "Rolled End Scroll"

Everybody still with me? Got two more types to do.

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We are going to draw the stock to a long taper, start the end over the edge of the anvil.

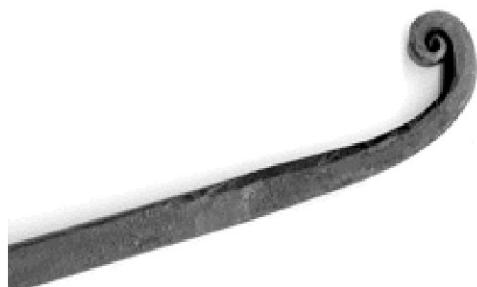


I need to go back and elaborate on one other drawing before I go on.



You start this scroll over the edge of the anvil, turn it back on the face of the anvil and "Roll it Tightly". As you hammer on the end, raise your holding hand up gradually, never hit in the same place twice, this give you a nice tight rolled effect.

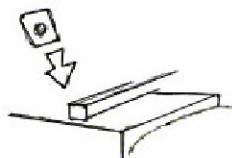
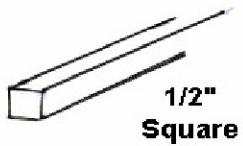
Now using your hardie again, roll the end down.



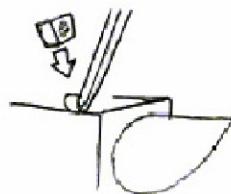
When it looks about like this, it is ready for your jig.

Next we are doing a "Tapered End Scroll".

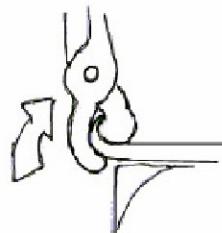
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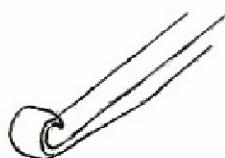
Hammer the edge down to a flat taper, keeping the width the same as the stock size. The taper should be gradual back about 2 1/2 to 3".



Start it over the horn, come to the face and roll it back into itself loosely.

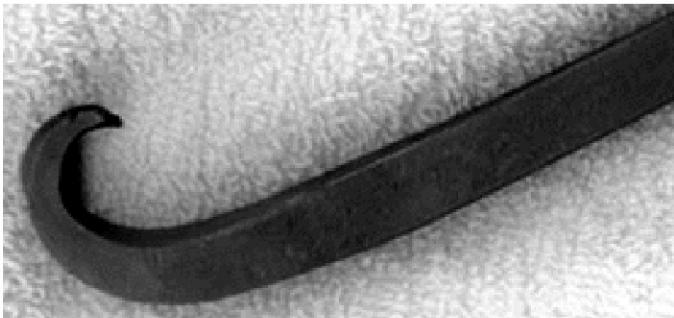


Another version of this, is to use a pair of "Scroll Starting Tongs" to make that first 90 degrees on the end of the stock.



When you get to here, you are ready to go to the jig.

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These are "Six Basic" scroll ends. There are many, many other variations, but this will get anyone started in the scroll making business. Any questions????:)

Q. David-Ewing : I didn't understand what you meant by using a mark on your hammer as a gauge. ??

A. On the side of my hammer, I will make a mark with a piece of soap stone, so I can hold the face of my hammer on the edge of the anvil and have a mark to bring my stock to.

Q. Doug : Did you make that curved hardie?

A. This is just a 1 1/2" square bar drawn to a taper, and curved over gradually with a 1" shank on it.

Q. Ian : Bill does the edge of the anvil not prohibit the stock from being lowered when using the hardie?

A. Ian, No, because the curved hardie is about 6" tall. By the time it hits the edge of the anvil, I have already gone as far as I want to anyhow.

Q. Steve : Bill on the fish tail one how do you make the chisel marks and then curl it over the horn without marring the marks?

A. Steve, you don't hit it very hard, so consequently it really doesn't put hammer marks in it. Your grooves are usually deep enough to keep this from happening.

Comments:

1. **poorboy :** I like a bolt end scroll which is a fishtail with a piece of rod welded onto the flare before it is rolled.

2. **Jock-D :** The bean or snub end scroll is the only time I like to have sharp corners on an anvil.

3. **Steve :** You are a true master smith Bill, Thank you for all of your demo's and the effort that you put forth to answer our questions.

4. **Bill :** An easy way to make the hardie, if you don't have some type of power hammer, you can always cut it with a torch at an angle, and grind it back smooth and weld a hardie shank on it. (Edited, doctored-up and re-arranged somewhat from the web site— L Brown, NJBA. Permission granted by the author, copyright© Bill Epps, iForge is an Andrew Hooper Production)

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Northeast Blacksmiths holds its meets twice a year at the Ashokan Field Campus in New York State.

The Ashokan campus is located in Olivebridge, N.Y., several miles west of Kingston, N.Y. The meets are held the first weekend in May and in the first weekend in October every year. The main demonstration is in the blacksmith shop and there is a "Hands On" workshop for beginners. A main demonstrator is brought in for each meet, food and bunk-house style lodging are provided as part of the cost of the weekend long meet.

Contact : Tim Neu

to register for hammer-ins
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Bill Epps Scroll Ends
Pages; 10 -18**

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NJBA's "year" runs from June to June. If you join mid-year, the postcard will offer a prorated dues option which will then allow you to extend your membership till the following June. The following information will be listed in a roster available to other members.

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