

THE HOT IRON SPARKLE

NEWSLETTER OF THE NORTH CAROLINA ARTIST-BLACKSMITH'S ASSOCIATION OF NORTH AMERICA



Volume 33 Number 1

First Quarter 2014



David Billings gets assistance from Josh McMullen while demonstrating punching a Prestige at the quarterly meeting at Flat Rock

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A Message from our President

Greetings All,

22nd FEB 2014

Millers Creek, NC

Folks in these parts are way past ready for spring to arrive with some winter work still pending better weather. Chicken Little said it is supposed to snow again by midweek.

The Board of Trustees met for our yearly planning meeting in January, once again hosted by Steve Barringier at his shop in Mooresville. I am continually grateful for the cooperation and enthusiasm everyone brought to the meeting. The board is working together very well and this makes my job a whole

lot easier. Treasurer Jim Kennady presented the annual report which is highlighted in his part of the newsletter. We are on sound financial footing and able to disperse some funds as our nonprofit status requires. Garrett Dunn continues to do a great job as VP and will have several noteworthy items in his report. Jennifer Phillips continues to do an outstanding job as our Secretary and will be organizing a photo gallery to go in the newsletter and website. Her report will detail actions taken at the annual meeting.

We are taking a bigger position at the Fire on the Mountain blacksmithing festival April 26th in Spruce Pine, NC. We will have the equivalent of a triple booth space, showcasing the winners of Downtown Spruce Pine final contest, our Chapter information table and some common sales space. From our experience there last year this event has the potential to be a very good sales opportunity and it allows us to reach many potential new members.

Recognition is made of two members stepping up to help the organization. John McPherson will be taking over as Librarian. Much thanks to Dick Snow for keeping our publications ready and thanks to John for continuing this service. I am pleased to announce that Eric Wellman will be leading the effort to update and manage our website. I have formed an *ad hoc* committee to work on this project and hope to have the site ready in the next few months.

2014 looks to be another year of improvement for our organization. It is never too early to start making salable inventory for the State Fair as it is only 7 months away. Keep making stuff that pleases you.

Lyle Wheeler, President NC ABANA



Join NC ABANA

Annual dues are \$25 (inside USA), \$35 (outside USA). Make check or money order payable to NC ABANA and send it to:

NC ABANA c/o J. Phillips
97 Trinity Ridge Lane
Banner Elk, NC 28604

For more information email: northcarolina.abana@gmail.com

or visit the NC ABANA website: ncabana.org

NC ABANA Reports

Vice-president's Report



So how come the NC ABANA doesn't have a local chapter close to you? I mean, really, having to drive for hours to get some practice and meet fellow minded metal workers is kind of excessive right? Why doesn't someone do something!!

Well, here is your chance. I am officially offering you the opportunity to start up a local group and have your own meetings right in your own section of the state!! All it takes is for you to invite people over and want to contribute to teaching (or learning!) of blacksmithing. You don't need to be an old pro, you could be brand new to the craft and still start up a local group. We will help you get your group going.

NC ABANA has a very simple policy for local area groups as discussed in article VI of our bylaws. Any group of members can ask the board of directors to establish them as a local group. After we vote for that, the local group can nominate a member of the board after they are established enough to have 6 attending members at their meeting for 6 months. That gives you a direct voice into the organization. We would also like to get a report of your group for the newsletter so we can publicize your meetings and help encourage additional members to come and join you. You can write up your meeting schedule and locations, get out your contact information, and people will be coming out of the woodwork to see what you are up to. Build it and they will come!!

A good meeting has a demonstrator and lunch, and that's about the minimum. The demonstrator can be anyone with something to show and teach. I can come over or I can get someone else to come over to do that – nothing fancy, but we will bring enthusiasm. Lunch can be hot dogs on the grill, again nothing fancy. So do you have access to some kind of forge? I have been to local meetings in lots of states and some were even outside, no shop at all. Sometimes they move around from place to place, other times one person just has it

at their place every time. A basic forge is nice but if you really want to start a group up we can bring over as much stuff as we need to get a meeting together. This is all about keeping at it, not starting with perfection. Every meeting gets a little better, every step goes a little further down the road.

So how do we make it happen? Send me an email at gngdunn@gmail.com. If you are game, we are too.

On another note, we have a winner!! Congratulations to Paul Tooley for getting an NC ABANA scholarship!!! Paul will be attending Roberta Elliot's class at the Folk School. I went to that class myself some years ago when I was just starting and she had us forge welding the second day. Bert is a super teacher and if you ever read this - thank you for a fantastic start. It made a big difference to me. I know Paul is going to make the most of it - the Folk School experience has to be one of the most enjoyable weeks possible in one of the world's most beautiful places.

There is another opportunity I want to talk about and that is the Fire on the Mountain Festival in Spruce Pine. This year it is on Saturday, April 26 and is a 'must do' event for me and my first lady (does a VP have a first lady? I do!). It is part street fair, part mountain vacation, part conference - but all blacksmithing all day. There will be top demonstrators this year including Scott Lankton, Mike Rossi, and Andy Dohner. They set up their demo tent right in the middle of the street and it will be a thrill to watch. Add to that the tail gate sales of blacksmith tools, the other demonstrations going on up and down the street, and the sales of finely made items - you have a fun weekend ready to go.

This will be the second year that NC ABANA will have a booth at the festival and this is where it gets even better. We will be hosting a display of the 'Finials' competition which will be a part of the festival. This competition will highlight the variety of ways you can cleverly decorate the ends of your work. That means that plenty of people will be coming by to have a look at them, and while they are there they can also see your goods for sale. Yes, any member can bring their wares and offer them for sale at the NC ABANA booth with NO Commission!!!! High traffic, no commission, it doesn't get any better than that so pound out those trade goods and come to the festival. I will see you there.

Hammer On!

Garret

Treasurer's Report



2013 Financial Summary

Dues	\$5,775
Heritage Forge Donations at NC State Fair	\$4,485
Heritage Forge Expenses	-\$1,174
Heritage Forge Net	\$3,311
SBA Madison Conference Income	\$2,000
SBA Madison Conference Expense	-\$461
SBA Madison Conference Net	\$1,539
Newsletter Printing and Postage	-\$2,356
Newsletter Editor Fee	-\$1,200
Insurance	-\$1,460
State Wide Quarterly Meetings	-\$640
Other	-\$90
Net	\$4,900
Balance	\$15,900
Scholarship Account	
Income	\$1,687
Scholarships	-\$1,000
Net Balance	\$4,660

Jim Kennady, Treasurer of NC ABANA

Secretary's Report



The business meeting of the NC ABANA chapter was held at the fourth quarter chapter meeting at the Blue Ridge Community College in Flat Rock, NC on November 11th, 2013. The meeting was led by VP Garret Dunn.

The ABANA Conference will be on August 13-16, 2014 in Delaware. Early registration ended in January. A membership with the national ABANA chapter has benefits including discounts at top resellers such as Grainger.

No election ballots were needed for the positions of vice president and secretary with only one nomination per position. Garret Dunn and Jennifer Phillips will continue another two-year term as vice president and secretary respectively.

The first quarter chapter meeting will be at Oak Hill Iron in Morganton, NC on March 22nd, 2014 beginning at 9am.

On January 11th, 2014 the board of directors for NC ABANA held a quorum to discuss business for 2014. Board members present included Lyle Wheeler (President), Garret Dunn (Vice President), Jennifer Phillips (Secretary), Jim Kennady (Treasurer), Marshall Swaringen (Triad Area Blacksmith Chapter Leader), Steve Barringer (Southern Foothills Blacksmith Leader), John Matthews (Blue Ridge Student Blacksmiths Guild Leader), Paul Garrett (Brasstown Blacksmiths Leader), Eric Campbell (Advisor), Richard Howard (Advisor), and Doug Wilson (Editor for Newsletter).

Motions were as follows:

Quarterly meeting demonstrator fee was raised to \$300 a day (\$150 for a half day) plus expenses. Motion passed unanimously with the contingent to revisit on a case-by-case basis for nationally recognized demonstrators.

Tom Willoughby voted (unanimously) as the first quarter demonstrator with a budget of \$700 for demonstrator fee and travel expenses.

Iron-in-the-Hat raffle tickets will now be 6 tickets for \$5. Motion passed unanimously.

Other business included planning the quarterly meetings for 2014, reviewing the treasurer's reports, considering publication of a membership roster, discussing newsletters & scholarships, continuing work on the by-laws, planning events for

2014, and coordinating open NC ABANA positions including a new webmaster, librarian, and representative for the Madison Conference.

If you would like more information about the board meeting or a copy of the board meeting minutes in its entirety, please email Jennifer Phillips the secretary for NC ABANA at northcarolina.abana@gmail.com.

New Members

Dannie Bingman, Sr.	Liberty
Steve Guilmette	Concord
Jacob King	Franklinton
Christopher McKeen	Raleigh
Allan Neuenfeldt	Hampstead
Benjamin C. Reavis	Boonville

Joseph E. Whitford	Ernul
Rod Bates	Cedar Mountain
Henry Bunn	Apex
John Charvat	Asheboro
Christian "CJ" Magro, Jr.	York, SC
Michael Vickery	Hampstead

Summary of publication and meeting dates for NC ABANA

<u>Quarter</u>	<u>Submission</u>	<u>Publication</u>	<u>Meeting</u>	<u>Location</u>
1	22 February	11 March	22 March	Morganton
2	31 May	13 June	28 June	Winston-Salem
3	11 August	29 August	13 September	Alternate years Manteo/Raleigh area
4	tbd	tbd	1 November	Brasstown

Tool Steel for Sale

After supplying the materials for a recent tire hammer & tool build, I am now offering competitively priced tool steels to the local blacksmithing and horseshoeing communities. I have a small inventory of S-7 and H13 rounds in stock. Other sizes, shapes, and tool steel types can generally be delivered in about a week.

Contact *Walt Beckwith* for a quote or more information c/o

Woods Edge
 3745 Swarthmore Rd.
 Durham, NC 27707
 1-919-309-5667 or by e-mail at: wbeckwith@mindspring.com

NC State Fair 2014

Article by Eric Campbell

Once again, thank you to everyone who helped make 2013 a banner year for the NC ABANA demo at the NC State Fair Heritage Forge; \$33,314.75 in sales with \$4497.10 going directly to NC ABANA.

In 2013, we had 32 volunteers and a great time of teaching and fellowship was enjoyed by participants and patrons. To see some photos of 2013 State Fair activities, please go to www.facebook.com/heritageforge.

Al Andrews will once again be Master of the Forge at the North Carolina State Fair for the 2014 edition. The fair opens at 3:00 PM Thursday, October 16th and runs through Sunday, October 26th this year.

Eric Campbell will continue to be in charge of the sales area and scheduling the demonstrators, Please contact him directly to arrange demonstration time(s) and delivery of work to be sold.

Looking forward into 2014 we would like to encourage more people to come out and spend a day or more. We would like to encourage everyone to start making items soon as well as consider donating an item to NC ABANA for sale. Our shelves were starting to get a little bare by the middle of the week. As a volunteer you are eligible to receive parking and day passes for the state fair as availability permits.

For the 2014 year we will be continuing with the 2103 fee structure, 20% consignment fee for demonstrators and 25% fee for non-demonstrators. This amount will be deducted from your total sales. Out of this amount will be paid the sales

tax and any transaction fees. The remainder will be retained by the chapter to cover building rental, insurance and operating expenses. After all this, any remaining funds will be retained by the chapter for the general fund.

Two considerations for demonstrators. The forge is fairly well equipped but if you are planning a demo which requires specific tooling please bring your own to assure a good demonstration. The same goes for steel. While there will be some general sizes and quantities available, if your demo requires a specific size of material, bring it with you.

If you have any questions, please feel free to contact Eric Campbell directly at solvarr@gmail.com or 919-264-7868



Forging Colonial Ironwork

Jerry Darnell's new book *Forging Colonial Ironwork* is finally here. It is a compilation of over 22 years of teaching notes at John C Campbell Folk School and various conferences throughout the US. The book is about 120 pages both sides and divided into 4 chapters; Colonial Lighting, 18th Century Hearth Equipment, Early American Hardware, and Hooks and Hangers. There is a mix of 63 different projects from simple to advanced.

The cost is \$20.00 plus 6.75% tax and \$10.00 for shipping and handling. Order by phone, e-mail or visit the salesroom M-F from 10 to 5 and on Sat. 9:30-5.

www.millcreekforge.com

Mill Creek Forge

Jerry Darnell

4512 Busbee Road Seagrove, NC 27341

E-mail forge_on@rtmc.net

Phone: (910) 464-3888 (Shop)

(910) 464-2636 (House)

Need representative to the SBA

We need to identify a new NC ABANA member to serve as our representative to the Southern Blacksmiths Association (SBA). This role has traditionally been performed by the NC ABANA President, but the Board would like to seek others that have an interest in representing our organization.

Every other year on the third weekend in May the Southern Blacksmiths Association holds their conference in Madison, GA. Historically, this was one of the original conferences that revived blacksmithing. There are seven groups in the SBA; Alabama Forge Council (AFC), North Carolina Artist-Blacksmiths Association (NC ABANA), Appalachian Area Chapter of Blacksmiths (AACB), Ocmulgee Blacksmith Guild (OBG), Alex Bealer Blacksmith Association of Georgia (ABBA), Philip Simmons Artist-Blacksmith Guild of South Carolina (PSABG) and the Florida Artist Blacksmith Association (FABA). Last year Cindy Alexander finished serving as NC ABANA's representative and we need to identify a new SBA representative. Many thanks to Cindy for all her years of dedicated service!

The SBA's Madison Conference involves participation by all seven groups. Each year one group is designated as the 'host', who is responsible for organizing the overall conference. The next Madison Conference is being planned now and will be held May 2015. NC ABANA is scheduled to be the 'host' group in 2025. Until 2025, the general duties for the NC ABANA representative include:

- Participate in phone conferences to plan the Madison Conference. Typically phone conference last 1-2 hours and are held every 6 weeks.
- General conference assignments which can change each year; for example, grounds keeping and organizing the auction, registration, t-shirt sales, catering, gallery, tailgate/vendor sales, green coal or demonstrations.
- Work at the conference in Madison, Tuesday through Sunday.
- Independently performing various conference activities, dealing with last minute changes and being able to handle multiple tasks in an efficient and professional manner as requested by the conference chair.

No prior experience is necessary, but flexibility and a willingness to work are required. The ideal representative will be familiar with organizing public events and work as an effective and proactive team player. Travel reimbursement is available. This is an exciting opportunity to interact with a fun-loving group of blacksmiths from throughout the Southeast.

The SBA website has some additional information: <http://www.sbaconference.com/>

Those who are interested or want additional information please contact Jim Kennady, NC ABANA Treasurer. jimkennady@gmail.com 919-528-5636.

Opting Out

NC ABANA is going to publish the full list of members in the 3rd quarter 2014 "Hot Iron Sparkle" newsletter to help connect members across the state. We are going to include members' name, phone number, city, and state.

If you would not like your information published, please contact Jennifer Phillips before July 31st, 2014. Her email is northcarolina.abana@gmail.com and address is 97 Trinity Ridge Lane, Banner Elk, NC 28604.

Regional Reports

Wilkes Teaching Forge

Report from Lyle Wheeler

The Wilkes Teaching Forge (WTF) has met consistently each month and offers the following report:

19th NOV 13 WTF met at the Wilbar Forge hosted by Gary Roath. Lyle began the demonstrations with a leaf/key fob with Dudley following. Gary showed how he starts a bottle opener, then discussed several twist options and finished with an oyster knife at the other end, an impressive piece. Seth worked on a punch from spring steel. We all helped Seth make his first leaf. Lyle gave a report on the State Fair. Gary and Lyle gave reports on their recent classes as instructors at JCCFS.

10th DEC 13 WTF met at the Wilbar Forge hosted by Gary Roath. David Baker led the work session with tooling and cutout blanks for bells inspired by the recent article in the Q4 newsletter. 11 gauge material was used and some success was had in this project. Lyle gave a report from his recent class as instructor at JCCFS. This was the first long weekend class there and the new format was well received.

14th JAN 14 WTF met at the Wheeler Forge hosted by Lyle Wheeler. Special guest William Wheeler was recognized. Will started off the demonstrations by making a bean finial on a piece of 3/16 x 3/4. He then cut it off and made it into a pendant with the forge's touchmark. We all helped new member Chris Souther make his first hook. Gary Roath showed some of his more than 2200 pictures of ironwork from a recent trip to Eastern Europe depicting a multitude of styles of hand forged ironwork. David Baker will represent the group at Old Fashion Days at Stone Mountain State Park in October.

18th FEB 14 WTF met at the Wheeler Forge hosted by Lyle Wheeler. Lyle started the demonstrations with a discussion of production work and showed how he makes a coat hook from 15 inches of 1/4 x 1/2 using common end treatments and a bending jig to form both ends for repeatability. He makes these eight at a time from 10 feet of material in six heats. John Freas took a piece of 5/8" coil spring all the way to annealing for a wood gouge with a tang for handle fitting. The Q1 meeting on 3/22 at Big Blu was announced.

Southern Foothills Blacksmiths

Report and photos from Ray Clontz

The Southern Foothills Blacksmiths have been very busy working on their projects at Steve Barringer's shop the 2nd Sunday of the last 3 months. We have been watching Avery Pierce forge a large Damascus tomahawk from some #60 double roller chain. The next picture show a member grooving a rail road spike before twisting to make a knife.



Forge welding damascus billet under power hammer



Hawk with eye drifted



Damascus hawk polished and ready to etch



Forging a hawk from a carpenter's hammer



Dave Stitt forges a bottle opener from an open end wrench



Lunch is served...Thanks Rebecca!

The January meeting brought over 36 members and guest forging their projects which ranged from knives, tomahawks, to roses and fire pokers.



Brian Swink's just completed teardrop trailer with forged accessories



Paul Garrett from John Campbell Folk School (resident blacksmith) attended the meeting and showed a sign he made for the Cherokee County Arts Council.



Paul Garret's sign for Cherokee County Arts Council



First time visitor with her first hook

The scroll is done the hard way. We need to have a demo on this; looks hard. So much to learn in this craft.

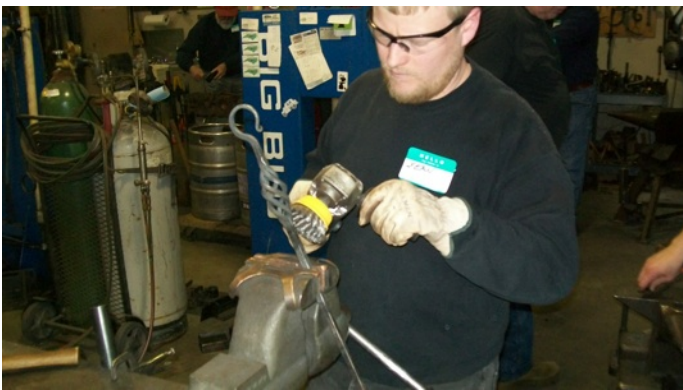
We had over 30 members and visitors at the February meeting on Sunday, February 9th again at Steve Barringer's shop in Mooresville, NC.



Brian Swink forging an adz from a carpenter's hammer. The claws form a convenient handle and keeps the socket from being deformed.



Aubrey Pegg with tongs she forged



Shawn Emmons working on a fire poker with a basket twist



An Aubrey Pegg spike knife

While many members are forging, we have other members interested in making some items such as knives, belt grinders, tire hammers etc. We always have a large dry erase board set up so members that have made an item can help interested members with design concepts using sketches on the board. Sunday, we had sketches on ways of fastening scale handles on knives, sketches on belt grinder concepts and sketches on building tire hammers. We also list sources for items such as blade steel, tomahawk drifts and handles. Sources for tire hammers, such as rod ends, springs spindle hubs, bearing materials, etc. On belt grinders we list sources for the wheels, belts, etc.

The meetings are a great learning source for all attending, from sources for all materials for forging, knife making, machine building etc. Always a great time, thanks again to Steve Barringier for letting us use his shop the second Sunday of each month.

Triad Area Blacksmiths

Report from Marshall Swaringen

The fourth quarter of 2013 had several interesting events for the Triad Area Blacksmiths (TAB). With the sales from the Dixie Classic Fair we were able to purchase a couple of items from Oak Hill Iron Works. We replaced an anvil with a Blu anvil and stand. It is nice to work on an anvil that does not require hearing protection.



Keith Roberts has been our lead story teller at the Dixie Classic Fair for the past couple of fairs. To show our appreciation, we presented him with a Blu hammer. Andy Phillips handled the hammer purchase. He engraved the sides with some of Keith's saying. A big thank you to Andy Phillips and Oak Hill Iron!



Thanksgiving Week Hammering was a huge success. Andy Phillips opened the TAB shop for three days (see the full report later in this issue. - ed). Both forges were busy all day each day. We even had a couple of special guests on Monday, making bells and candy canes.

Looks like TAB may have started a new tradition, Ringing the Anvil, on New Year's Day. Members opened the shop and had a very good turnout.

Our next big event will be at Larry Crews' shop on March 15th hosted by Larry and Darlene Crews. This March meeting is more like a Spring Family Reunion. Lunch will be provided; fish fry if Richard Howard catches any fish or BBQ if he does not. Bring your favorite deserts or snacks to share.

We will end the quarterly report with the famous saying of Billy Phelps - "Get it hot and WHACK it!"

Triangle Area Blacksmiths

Report from Randy Stolz

The Triangle Blacksmiths Guild December meeting was held at Allan Green's shop in Hillsborough, NC. The day started out as overcast with a slight drizzle that progressed to a steady rain by lunch which became a downpour by the afternoon. Despite the weather we had nearly 40 people in attendance including a good number of new members and guest. The focus and morning demonstration was making v-jaw tongs. The demonstration started out well with the first tong hammered out correctly and the jaws formed using a tool I made the previous night. The v-jaw forming tool worked well and simplified the process. All I had to do was flatten the end of a bar, insert it into the tool, and hammer down.

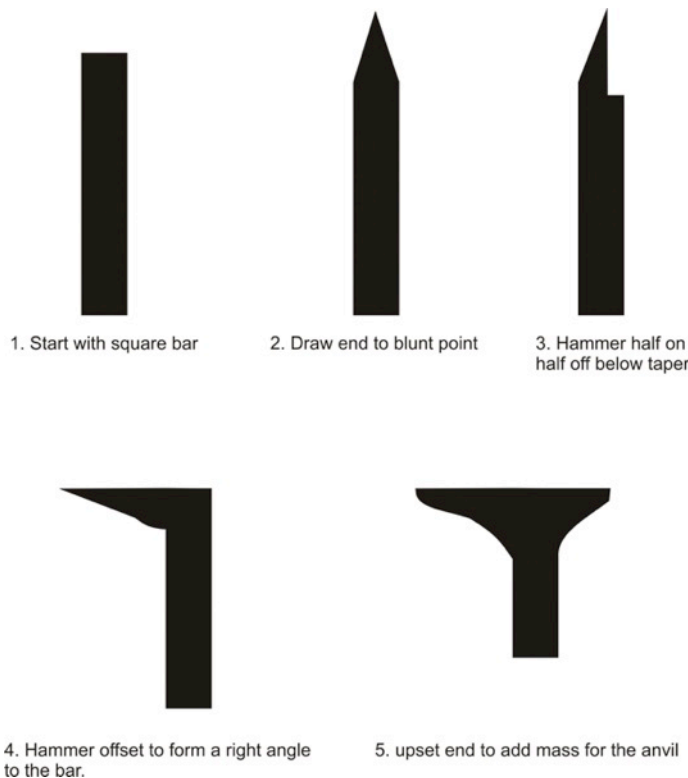


Tool for quickly forming v shaped tong jaws. It has a thick base so it can be used in a vice and a post for use in the hardie hole.

Since the first half of the demonstration went well it was destiny that the second half would not. And sure enough, just as I was finishing up the second half of the tongs, I got distracted and burned the end off of it. I was prepared though with a third piece of the stock already cut to size and I quickly made another and joined the two halves together. Allan had set up multiple forges so following the demonstration everyone was invited to make a pair of tongs for themselves. The rest of the day was consumed, along with an excellent lunch provided by Allan and his wife, with making tongs.

The February meeting of the Triangle Blacksmiths Guild convened at Roger Barbour's shop in Clayton, NC with around 40 members in guest participating. Eric Campbell and myself had discussed making a stake anvil with a square face and a small horn to one side. As the 1 7/8 inch high carbon stock heated in the forge, Eric showed how to make a number of

smaller pieces. Once the thick round bar was hot, we started the process by quickly drawing one end out to a tapered point to form the stake. To form the anvil face and horn we first hammered the end of the bar using half on – half off blows to produce an offset and then folded the offset to one side to give us enough material to make the horn. Then we recruited 4 of our newer members to do some team striking. With a little instruction they quickly learned the process and upset the stock to form the face of the anvil. Given the time constraints we roughed out the stake anvil but did not finish it. Eric will finish it later and hopefully we will have some pictures and an article for the newsletter showing the process.



The above diagram shows the steps to form the face and horn of the stake anvil. To make a double horn anvil you can split the bar, spread out the two halves, and then upset to form the face. The diagram does not show forming the stake, but if you do that first you can form it to fit the hardie hole of your anvil as you upset the bar. This allows you to mount the stake anvil on a stump or the hardie hole of a larger anvil.

Following the demonstration we set up several portable propane forges for open forging.

Brasstown Blacksmiths

Report from Paul Garret

The Brasstown Blacksmiths met on Tuesday the 18th of Feb at Dave Smucker's shop for an evening of forging, BBQ pork and fixings.

After dinner, Dave lit the forge and demo'd some simple tong clips, and tied a couple of knots in small round stock.

In general, there was a lot of show and tell as far as tools were concerned as Dave has lots of them, and most made by him. Dave has tools that make tools. He teaches tool making here at the Folk School in October each year, and is quite knowledgeable about the subject and even more so about heat treating.

After that, Ken Thomas – who was teaching that week at the school, and brought his class over the meeting – demo'd the forging of a ginkgo leaf, and a couple of us tried our own. They are not that hard to do once you know the tricks.

In December, the group met at John Ziegler's home and shop in Moccasin Creek near here for the annual Christmas meeting and potluck with the Alex Bealer group from the Atlanta area. Both John and Lance Ziegler did some demos, and then Torch Mullins, the A/B group President, did a demo as well. It was a great meeting, and even better food.

The BBS group meets on the 3rd Tuesday of even numbered months from 5-9 pm. The next one should be at Butch Dey's shop on hwy. 129 at the NC/GA state line. April 15th. Send you taxes in and come on over.

Event Reports

Brasstown Special Meeting

John C Campbell Folkschool

Report from Paul Garret

Photos by Julie Clark

This year at the annual John C. Campbell Folk School Blacksmith & Fine Craft Auction on November 2nd, 2013, members of NC ABANA and the Appalachian Area Chapter of Blacksmiths (AACB) enjoyed a "Hammer-In" the night before the meeting and auction. The goal was to make a few small items for sale at the silent auction the next day along with one large piece to be sold at the main auction. The money from items sold at both auctions goes towards the John C. Campbell Folk School and its continuing operation.



Paul Garret getting it straight

Aside from folk instructors Paul Garrett (who is also the resident artist at John C. Campbell) and Susan Hutchinson, several additional blacksmiths participated in the Hammer-In including Julie Clark, Lynda Metcalfe, Andy Phillips, Clint Busbee, and Ron Nichols.



(L-R) Linda Metcalf, Ron Nichols, Julie Clark, Susan Hutchinson, Clint Busbee and Paul Garret



The main project was a freestanding fireplace tool set, which sold for \$650 at the Saturday auction.



Jennifer and Andy Phillips work together to forge pieces for the auction

A lot of other small hand-forged items were also sold at the silent auction raising a total of over \$1000 for the folk school

from the blacksmiths alone. The Hammer-In was definitely a success this year and will hopefully be expanded next year so we all aren't forging way past midnight the night before the auction.



Jennifer discussing broom stitching with Clint

On Saturday morning before the auction, there was a demonstration by Clay Spencer held in the blacksmith's shop. He used both a tire hammer and Big Blu power hammer to make tooling, in particular dyes. After the demonstration, the AACB had a short business meeting along with an Iron-in-the-Hat raffle.

Tire Hammer Plans

Send check/money order for \$30 to

Clay Spencer
73 Penniston Pvt. Drive
Somerville, AL 35670-7013

Includes postage to US and Canadian addresses. Other countries e-mail clay@tirehammer.com for price. **256-558-3658**.

Tire Hammers for sale contact me for current price.

Beverly Shears Sharpened

\$41 includes return shipping in US. Remove blades and ship to address above. Extra cost for deep nicks or blades sharpened at wrong angles.

Blacksmith Supply

Tools and Supplies For The Modern Blacksmith

John Elliott

P.O. Box 3766
Chester, Virginia 23831

Phone: 804-530-0290

Fax: 804-530-0290

E-mail: jelliott@blacksmithsupply.com

Website: www.blacksmithsupply.com

NC ABANA Meeting at Flat Rock

Article by Doug Wilson, photos by Doug Wilson and Marty Lyons

NC ABANA's final meeting of the year was held at Flat Rock in the welding shop of Blue Ridge Community College.



The shop and crowd

The featured demonstrator was David Billings who is a full-time smith at Oak Hill Iron. He demonstrated an interesting technical piece called a Prestige.



Andy and Caroline Phillips examine a Prestige



David creates the point for a leaf form



Jeff McMullen holds while David punches an eye



Forming a bend after the leaf form is complete



A finished Prestige



Threading the needle with the leaf form



John Matthews gives an overview of the blacksmith program at Blue Ridge Community College



The leaf is now spread and veined



Bill Brown stepped up to do some impromptu demos. Here he instructs Garret Dunn in striking technique



Adding detailed veins with a chisel



Forging a leaf form



Adding edge indentations to the leaf



Adding coarse veins to the leaf



Forging an upset corner



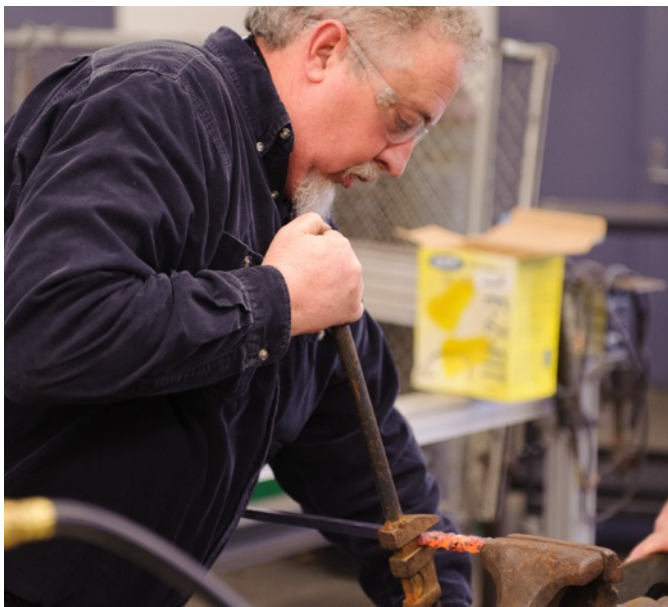
The finished pineapple twist



The finished corner



A new young smith practices technique striking with Garret



Demonstrating a twist

Many thanks to John Matthews for organizing the meeting and for his great hospitality.

Gift Making Workshop

Article by Jennifer and Andy Phillips

It was another successful year for the triad area blacksmith group's third annual gift making workshop. Utilizing the Monday, Tuesday, and Wednesday before Thanksgiving; we had three full days of fun new projects, new faces, and even some visitors from out of state. We made candy canes, jingle bells, and more than a few wall hooks. A lot of the participants only had a small amount of experience, especially the children who were there enjoying a little time off from school for the holiday.

Pictured Below is Jennifer's cousin Hank Allen. He is running a blower on a coal forge as fast as he can go. Hank learned a lot about tending a coal forge during his time there and even got to make a few small things for his family like a wall hook for his mom.



Dannie Bingman Sr., almost half his family to forge, including his grandson. He made a few wall hooks as well and even learned how to do a twist in square bar.



We got to spend a little time team forging on Wednesday and made a toilet paper roll holder for our master bathroom. The flower pattern is something Andy learned from his class with Brian Brazeal last February. Not the best Christmas present but it was sorely needed and gave us an opportunity to sledhammer away together.

We are planning to keep this up so mark it on your calendar and join us next year.



Battle of Forks Road

Article by Marshall Swaringen

The Battle of Forks Road, a Civil War reenactment was held at Cameron Arts Museum in Wilmington, North Carolina February 6 – 9, 2014. Lenny Moore and Joe Allen from the Triad Area Blacksmiths Club participated as blacksmiths.

February 6th and 7th were dedicated as school field trip day. Children in the 4th and 8th grades experienced life during the Civil War. Lenny and Joe taught the students the valuable assets of the blacksmiths during that time in history. In the tradition started by a past member, George Manuel, each class watched a “S” hook being made which was then presented to the class.

February 8th and 9th were the reenactment days. Lenny and Joe lived as Civil War era blacksmiths, camping in tents, cooking over camp fires, and braving the elements.

A few days after the reenactment, Lenny and Joe received an email from the Cameron Arts Museum that contained letters and drawings from the some of the children. One of the drawings had a blacksmith that looked like Popeye; not sure if that was Lenny or Joe. The majority of the children’s comments said the blacksmiths were their favorite event.



Featured Articles

Tong Making

Scholarship Report from Rick Morrison; authored by Samantha Powell

Tong Making, as presented by Peter Ross and written by my daughter, who knows nothing about blacksmithing but owes her dad big time so she wrote it.

NC ABANA Board of Directors and the W. Dean Taylor Memorial Scholarship fund provided the means for our fellow blacksmiths, myself included, to attend a day class on tong making. Peter Ross provided instruction and Amos Tucker was kind enough to supply the class with forges, anvils, and additional equipment as needed. In order to pass along the valuable information gleaned from his instruction. This article serves as a recap of key points that I found particularly helpful.

Our class began with Peter discussing the history of tong making and the benefits of hand forged tongs versus mass production. I'm sure many of us would agree since we have decided to endeavor in the art of blacksmithing! Afterwards, the tutorial began with each student deciding if a left or right handed tong was desired. Tongs are typically held in the non-dominant hand of the user.

This version of tong making begins with using a 5/8" square stock. The jaw is formed with a 1/2 face blow with 1" placed over the curved side of the anvil. The stock is reduced down to 1/2" thick tapering to 3/8", leaving it slightly thicker than the final jaw. The jaw will lose thickness during flattening and shaping.



Next, move to the far side of the anvil and rotate the stock 90° to the left or right depending on which handed tong is desired. (Rotate left to be used by the left hand and vice versa) Position the stock at 45° across the anvil in the same direction as the rotation. After positioning, use half on/half off hits to flatten and create the boss of the tong which is the area where the two tong handles are joined by a rivet later.



Next, to form the transition from the boss to the reins, turn the stock again 90° in the same direction as before, still working on the far side of the anvil. Now at 90° across, flatten about an inch out forming the backside of the boss. At this point each student decides if they are going to draw out or forge weld the reins. Drawing out the reins from the stock is the method I chose to use for the purposes of this class.



The second option is to cut the stock between 4-5" long after flattening the tong head and forge weld it to a 7/16" round bar to create the rein. To do this, begin by upsetting (thickening one dimension by shortening the other) the 7/16" round bar to form the scarf (the end that will be forge welded). Using this technique provides extra material to keep the tongs from having a weak joint at the weld. At this point the tong head and rein are forge welded together.

This entire series is repeated to form the other half of the tong set using whichever rein method is desired. Peter demonstrated both drawing out the rein using a power hammer and forge welding.

Finishing the tong heads to the desired shape takes time and can be modified depending on what its intended use will be. Nearing the end of the class both tong blanks receive a hot punched hole in order to accept the rivet which will hold both pieces together. While the pieces are still hot, work the tong handles back and forth to ensure the tongs have free movement. Now you have a tool that will serve you well in your blacksmithing adventures. Many thanks again to all who were involved in creating this opportunity and special thanks to my daughter Samantha Powell.

Tool for making V-Jaw Tongs

By Randy Stolz

Prior to the December meeting of the Triangle Blacksmiths Guild I made a tool to simplify the process of forming the jaws. There are a number of ways to form v-jaws like using a swage block or the step of the anvil but I figured a hinged tool with a top and bottom die would work well and be faster. With a hinged tool that could be clamped in a vise, all you have to do is flatten the end of your stock, insert it into the jaws of the tool, and hammer down on the top die.



Above, the top and bottom dies are made from 5/8 inch square high carbon cold rolled steel. The bottom plate is 1/2 inch thick steel so it is sturdy enough to mount in a vise and withstand heavy blows. The pivot point is the top of the 1 inch square steel which is also a hardie post. The bolt, nut, and washers are grade 8 hardware. Note that the top of the top die has been flattened to prevent damage to the hammer face.



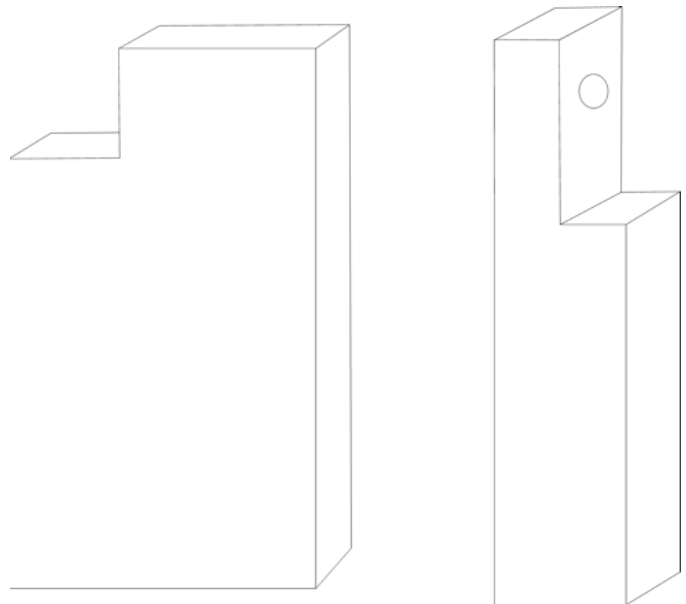
Side view of the tool showing the hardie post.

Making the top die is simple enough. Flatten one end of the bar on the diamond and drill a hole for the bolt. To make the bottom die, I cut the 5/8 inch square stock in half diagonally using a v-block and band saw.



Quick and easy way to make a v-block for your bandsaw or drill press is to weld two pieces of angle to a plate. Above are two pieces of 1 inch x 1 inch x 1/8 inch angle welded to piece of 16 gauge sheet metal to the v is centered on the band saw blade. This jig can be used to saw square stock diagonally or round stock in half.

I made the hardie post and pivot point for the top die one piece instead of welding a post to the bottom and another piece for the pivot point to the top. To do this I notched one corner of the 1/2 inch bottom plate and notched the top of the 1 inch square post. This makes the whole assembly stronger with overlapping shoulders and centers the top die on the plate.



For final assembly, weld the base and post together and mount the upper die so it is higher than the base so you have some space between the upper and lower dies (an 1/8 inch or so). Then position the lower dies, again leaving a gap between the upper and lower dies, and weld into place.

To use the tool, you draw out and flatten the end of your material into a rectangle the length (generally 1 to 1 1/4 inch long) and thickness (1/8 to 3/16 inch for smaller stock). The width of the rectangle will be twice the size of the stock you want

to hold. For instance to make jaws for 1/4 inch stock, make the rectangle 1/2 inch wide so that each side of the v is 1/4 inch tall. Then heat the flattened end, center it in the bottom die, and strike the top die (light blows to start) to form the jaw into a v. It is pretty much the same method you would use to make v-jaws with a swage block but you have a top die to drive the material into lower v notch instead of a chisel or v shaped fuller.

Zoning for Blacksmithing

By Allan Green

I recently discovered some information about operating a blacksmith business (or wood-working, pottery, or any other business for that matter) from one's home. I have always thought that my shop was exempt from planning and zoning hassles because it is on a farm. Not so, as it turns out. Under the current Orange County Unified Development Ordinance (UDO), any resident who operates a facility that produces items for retail or wholesale sales requires a permit. The three possibilities are:

A Home Occupations permit (section 2.22) for uses described in section 5.5.3. The application requires a plot plan, floor plan, and parking plan, but does not require a professionally prepared site plan. These are approved by Planning Department staff.

Uses that do not qualify as Home Occupations currently required zoning as Commercial – Industrial (unless they are already in a commercial use zone). Rezoning applications require a professionally developed site plan (\$1000-1500), public notices, a public hearing, and ultimately, approval by the Board of Commissioners. The process generally takes 4-6 months.

An alternative to (2) is through the Conditional Use Permit process which involves both a rezoning and a Class A Special Use Permit. Again, this requires a professionally prepared site plan, a public hearing and notices, and takes 4-6 months.

While this appears somewhat onerous, there is some good news ahead. First, most home-based blacksmiths (and other craftsmen) would not be affected because they have no retail

business. Those that do, like myself, fall into the Home Occupation category. Other than the \$90.00 fee, the Home Occupation application is a simple affair. Secondly, UDO revisions currently being considered will expand the types and scale of allowable home occupations through creation of a Class B Special Use Permit (SUP) in order to accommodate larger scale/potentially more intrusive home occupations. A Class B SUP is approved by the Board of Adjustment (not the Commissioners), but would require a professional prepared site plan (\$1000 to \$1500), a public hearing and notices and 4-6 months. Additionally, for facilities located on farms that do not qualify as Home Occupations, separate proposed changes would permit Blacksmith forges, at least, as Agriculture Support Enterprises (ASE). In this case, the required permit would still involve a professionally prepared site plan, a public hearing and notices, and 4 to 6 months. The ASE proposal is on the Feb. 24th quarterly public hearing agenda for public comment. If you are affected, it would be a good idea to attend that meeting.

Whether or not those of us who have some level of retail business obtain the stipulated permits is an individual decision. If your business is visible enough to provoke complaints from neighbors, then a permit is probably a good idea. And, if your shop happens to be on your farm, then the proposed UDO revisions will allow quite a substantial operation as an Ag Support Enterprise. Non-Orange County blacksmiths might want to check your own county's zoning and permitting rules.

From the Shop of Samuel Yellin

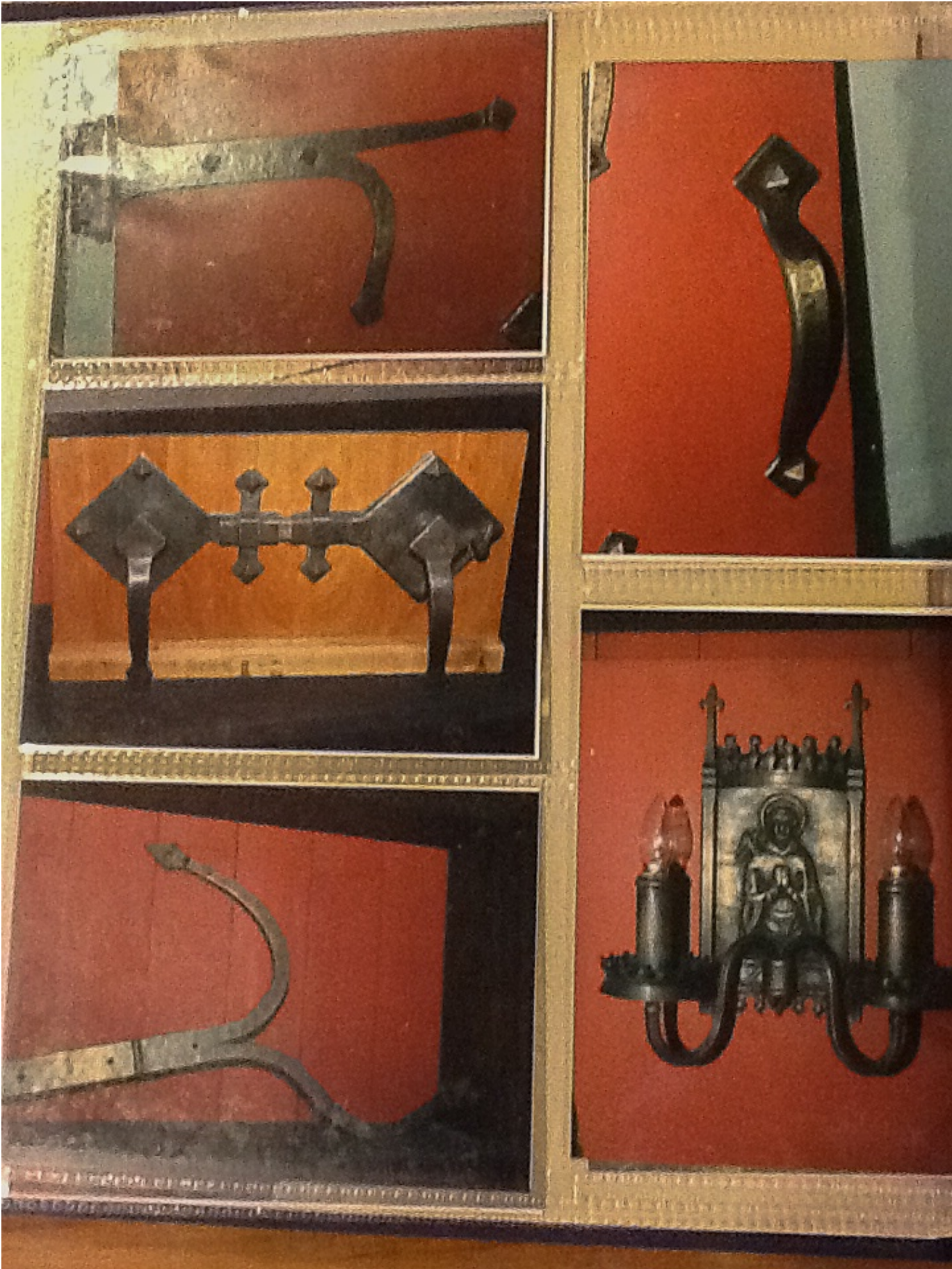
Recently, I received a CD of images from Clay Spencer. On that CD, were over 2000 photos of works from Samuel Yellin's shop. These had been taken in the early 1970s by Jeff Graves who was apparently working for a summer with George Dixon in the last days of the Samuel Yellin Metalworks shop. I will be sharing these photos in the coming issues of THE HOT IRON SPARKLE. The quality of the photos is not always the best. However, they are in many cases the only available documentation of Samuel Yellin pieces









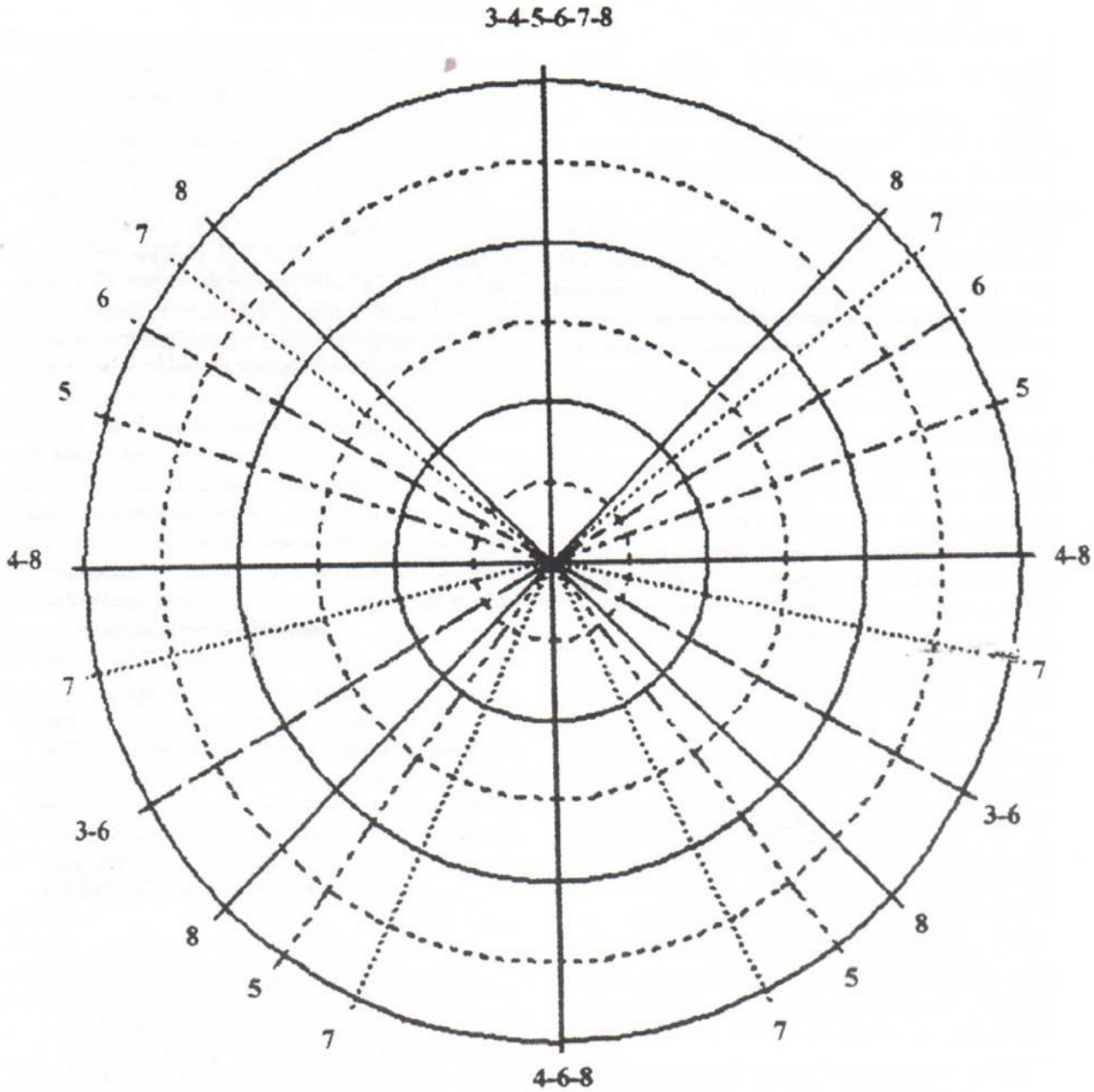








Circle Divider



To divide a circle into a given number of parts, connect all points marked with that number. For instance, to divide a bowl or flower into 5 segments, center it on the template and mark at every line that has a 5. Photocopy and enlarge – scribe arcs and lines onto sheet metal (steel, brass or copper) for more permanent template.

From Tidewater Blacksmith's Guild

Infinitely Adjustable Vise Jaw Spacer

by Michael Wollowski

This article originally appeared in Indiana Blacksmithing Association *Forge Fire Newsletter* - June 2012]

In the photo below, you see an infinitely adjustable vise jaw spacer. I saw a vise jaw spacer that Clay Spencer made and wanted to build one for myself. His looked like a three dimensional cross and had six useable sizes. In the process of figuring out how to build it, I was wondering whether one could build one with more than six widths. After rejecting several designs, the idea of a circular wedge hit me. It provides infi-

nitely many widths and affords extreme ease of adjustment: just turn the wedge to the desired size. Next, I had to solve the problem of how to hold it in the vise. Again, several ideas were rejected when the magnet occurred to me as the best option. It has several benefits: it moves with the vise jaws, it holds the spacer in its dialed-in position and when you are done with it, just place the magnet and wedge on the post.



The wedge is made from a 5" piece of 3/4" mild steel, forged into an 8" long wedge. The wedge tapers gradually to about 1/16" thick. When bending the wedge into a circle, it helps to

bend the thick side first. The magnet is about 2" long and can be purchased at Harbor Freight.

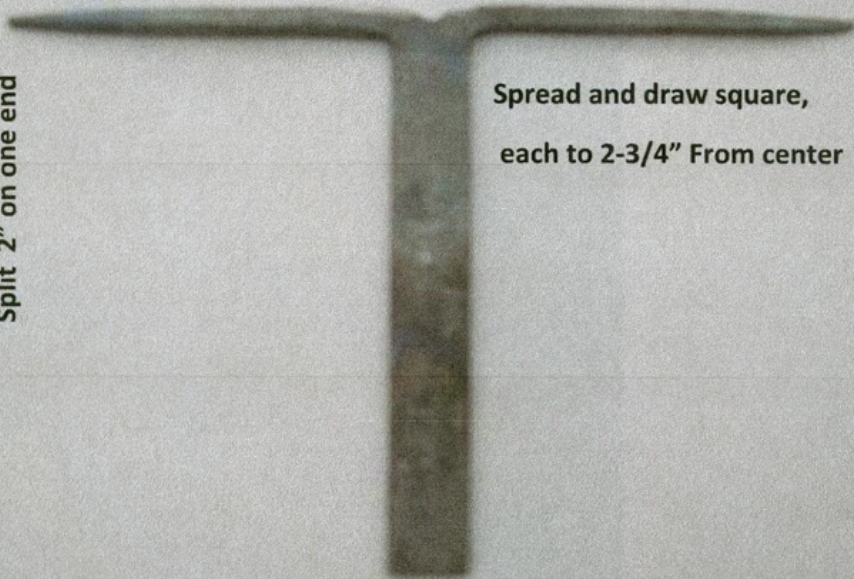
Mason Jar Mug

Inspired by Steve Anderson & The California Blacksmiths

3/16"x3/4"x 7"



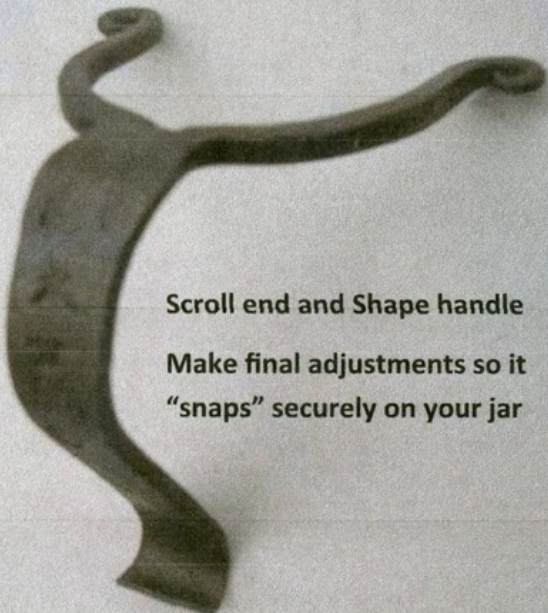
Split 2" on one end



Spread and draw square, each to 2-3/4" From center



Form to 2-5/8" Dia. semicircle



Scroll end and Shape handle
Make final adjustments so it "snaps" securely on your jar



Brentwood North, Feb. 23rd 2013

Fred Mikkelsen



BLACKSMITH FESTIVAL

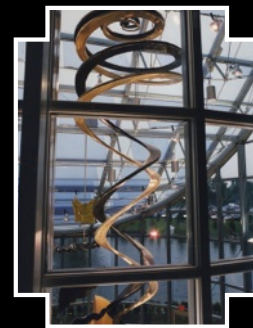
Spruce Pine Main Street is proud to partner with the Toe River Arts Council and Penland School of Crafts for the annual Fire on the Mountain Blacksmith Festival 2014

April 26th, 2014 • 10 am to 4 pm downtown Spruce Pine



Scott Lankton

This year's Master Blacksmith, Scott Lankton, received his B.F.A. from Western Michigan University in 1978. He opened his own studio in 1979. In 1985 he went to Aachen, Germany and received his Diploma at The International Teaching Center for Metal Design, where he apprenticed under Manfred Bredohl. Today he works as a studio artist, mostly creating sculptures and doing architectural commissions such as stair railings, gates, furniture, and kitchen racks in steel and bronze. Recent projects include 180 feet of dogwood motif railing in steel and bronze, forging handguns into artwork, and a large hanging sculpture for a cancer center.



ABOVE: "Duality"
A Double Helix
Hanging Sculpture of
Bronze and Iron

LEFT: Console Table

Blacksmiths Mike Rossi and Andy Dohner will also be at the main demonstration tent throughout the day.

Blacksmiths will be selling their wares and be doing demonstrations at their individual booths.

Also on hand will be blacksmith tool vendors selling forges, tongs, hand-held hammers and power hammers..

Penland School is sponsoring the Hands-On Tent where, with assistance from an experienced blacksmith, people of all ages can try their hand at the art of blacksmithing.

Free Demonstrations on Saturday:

10 am – Andy Dohner • 11:30 am – Scott Lankton • 1 pm – Mike Rossi
2:30 pm – Scott Lankton will finish out the festival downtown

A Pig Roast will start at Penland School at 6:15 pm (by advance reservation please – 828-765-7942)

Interested parties are also welcome to stay for the free lecture at 8 pm Saturday night by our Master Blacksmith, Scott Lankton, who will be sharing his work and experience with the audience.

Check out the 20 iron finials designed by blacksmiths for Spruce Pine's downtown signage, on display at the Toe River Arts Council! The Blacksmith Artist Exhibit will also be on display through the end of the festival. This is always full of extraordinary works of art, so don't miss it!

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Hammers



Spring Swages

AACB BLACKSMITH CONFERENCE

May 16 & 17, 2014 Murfreesboro, TN

www.appalachianblacksmiths.org

www.facebook.com/pages/AACB-2014-Blacksmith-Conference

Register *online* with PayPal/credit card!

● **MAIN DEMONSTRATORS** ●

Brian Brazeal: Tool Maker, Artist
Elmer Roush: Lock Making, Viking Ax

—— **MINI DEMOS** ——

Dave Smucker: Metallurgy / Heat Treatment
Lonnie Farmer: Frying Pan Forging
Broadus Weatherall: Cowboy Hat, Cross, Door Pull
Mike Rose: Layout & Design
John Williams: Joe Humble Door Knocker, Stories
Gary Bowman/Jason Bivens: Knife Handle Making



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NC Whisper Momma w/Open End Ports



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Quarterly Meeting at Oak Hill Iron

Saturday, March 22
9am until about 4pm

3308 Frank Whisnant Road
Morganton, NC 28655

The featured demonstrator will be noted farrier and artist blacksmith

Tom Willoughby

from Crown Point, Indiana.



Come to Oak Hill Iron in Morganton to enjoy their fantastic hospitality & facilities.

Remember to bring something for Iron-in-the-Hat to support the NC ABANA scholarship program.



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Local Group Meetings

Triad Area Blacksmiths (Winston-Salem, NC)

Marshall Swaringen
marshall@swaringen.com (336) 998-7827

1st Tuesday at 6:30PM for demos
 3rd Saturday at 9AM for business and all day forging
 Dixie Fairgrounds, Winston Salem, NC

Southern Foothills Blacksmiths (Mooresville, NC)

Steve Barringer
steve@powerhammerschool.com (704) 660-1560

2nd Sunday each month

Triangle Blacksmith Guild (Raleigh - Durham, NC)

Randy Stoltz
rhstoltz@gmail.com (919) 481-9263

1st Saturday in even # months at various locations

Brasstown Blacksmiths (Brasstown, NC)

Paul Garrett
pdg86@hotmail.com (828) 835-8441

1st Tuesday in even # months; 5 to 8 PM

Wilkes Teaching Forge (WTF) (Millers Creek, NC)

Lyle Wheeler
chairmakr@yahoo.com (336) 838-2284

2nd Tuesday of each month, 7:00 PM

Blue Ridge Student Blacksmith Guild (Flat Rock, NC)

John Matthews
john.knox.matthews@gmail.com (828) 645-2109

You are welcomed to attend any of the local group meetings.
 Please contact the host to confirm date, time and location.

NC ABANA Meetings

1st Quarter 2014 – March 22, 9 am

Oak Hill Iron
 Morganton

2nd Quarter 2014 – June 28

Yesterday Village Dixie Classic Fairgrounds
 Gate 9, 27th Street
 Winston-Salem

3rd Quarter 2014 – September 13

Raleigh-Durham Area

4th Quarter 2014 – November 1

John C Campbell Folkschool
 Brasstown

Other Events

Fire on the Mountain – April 26, 10-4

Spruce Pine, NC
<http://downtownsprucepine.com/Festivals.html>

AACB Conference – May 16-17

Murfreesboro, TN
<http://www.appalachianblacksmiths.org/aacb-conference/>

Dixie Classic Fair

Winston-Salem, NC
 October 3 - October 12, 2014
www.dcfair.com

North Carolina State Fair

Raleigh, NC
 October 16-26, 2014
www.ncstatefair.org

For the most current meeting and event information go to the NC ABANA website,

ncabana.org

North Carolina Artist-Blacksmith's Association of North America



THE HOT IRON SPARKLE

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First Quarter Meeting of NC ABANA

March 22nd - 9 am

Oak Hill Iron

3308 Frank Whisnant Road

Morganton, NC

Featured demonstrator Tom Willoughby of Crown Point, IN

Bring something for Iron-in-the-Hat!

Lunch provided courtesy of Big Blu Hammer

