

Now and Then
Newsletter of the Shenandoah Valley Blacksmith Guild
January 2017

Inside: Club Information Meeting Notes General Notes Items of Interest	Editor's Notes: Another year for Blacksmithing classes and events has begun. Try to attend at least one event of another Blacksmith Guild, they are a great place to make new friends and get new ideas. Ray and I hope that your year goes better than the last half of ours. May you be blessed with a Happy New Year! SusanPlank.svbgeditor@gmail.com
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Club Information

2017 SVBG Board of Directors

At the December 14th SVBG Monthly Meeting, the attendees voted to keep the SVBG Board of Directors the same for 2017. I am not sure if that was a vote of confidence for last year's board or if just nobody wanted to step up and try something new. Thanks to last year's SVBG Board of Directors work making ours a great local guild! If you are a new attendee or even an old attendee that may wonder why something is being done a certain way or just have questions, please feel free to speak up and ask questions during the "meeting" portion or our monthly meetings. Below you will find contact information if you have questions that need answering during the month.

President...Dewey Baker contact preference through email: chevy38truck@gmail.com
or message him on Facebook by typing in Dewey Baker and messaging him;
if you must contact him by phone only call between 8 am & 8 pm at (540) 421-5510; He is
unable to be reached by phone on Monday evenings between 7 & 9 pm for Boy Scout Meetings
and the 1st and 2nd Tuesday evenings between 7 & 9 pm for Ruritan Meetings

Shop Master...Everette Burkholder (540) 879-9260

Secretary/Treasurer...Karen Robertson (434) 989-2206 email: ksrobertson7@gmail.com

Librarian...Daniel Burkholder (540) 879-9260

Safety Officer...Matt Williams (910) 465-0463 email: stonecrestforge@gmail.com

Web Master...Darrell Gilman email: web.svbg.darrell@gmail.com

Photographer...Dirk Gold email: dirkgold@gmail.com

Coal Manager...Ed Fleming email: flemishfoke@hotmail.com

Facebook Administrators... Drew Alexander email: magicdrew88@gmail.com
Dale Morse email: vulkanschmiede@yahoo.com

Newsletter Editor...Susan Plank (540) 896-1232 email: SusanPlank.svbgeditor@gmail.com

Guild Master - Virginia Institute of Blacksmithing, Dale Morse (434) 960-9718
email: vulkanschmiede@yahoo.com

More SVBG Information can be located at...

The Shenandoah Valley Blacksmith Guild website can be located on the internet at
<http://svbg.squarespace.com>

and

On Facebook, like us at Shenandoah Valley Blacksmithing Guild

Club Information - Continued

2017 SVBG Calendar of Events

Please take a look at your calendar and see when it will fit in your schedule to do a demonstration at our SVBG monthly meeting. As you can see, there are still lots of months to choose from for your special demonstration. Your demonstration can be simple or complex, we have all levels of skill in our guild. A mentor can be found if you feel you need a little guidance to boost your self esteem while demoing. Dewey Baker or Karen Robertson will have the demonstrator sign up sheet available at each meeting.

January	<u>12th Monthly Meeting</u> - Dewey Baker demonstrates “Friederick Cross Key Fob”
February	<u>9th Monthly Meeting</u> - Bill Fox demonstrates “to be announced later” <u>25th Boone Pasture Party</u> held in Louisa, Virginia - You must pre-register with Karen Robertson at our SVBG February 9th meeting if you plan to attend
March	<u>9th Monthly Meeting</u> - 1 demonstrated needed <u>31st Greater Shenandoah Valley Knife Show</u> begins at Rockingham County Fairgrounds
April	<u>1st and 2nd Greater Shenandoah Valley Knife Show</u> continues at Rockingham County Fairgrounds <u>13th Monthly Meeting</u> - Beginner and Mentor Night - 3 demonstrators needed 1. [Redacted] 2. [Redacted] 3. [Redacted] <u>21st, 22nd & 23rd Blacksmith Guild of the Potomac 2017 Spring Fling</u> will have two daytime demonstrators - Kim Thomas and Williamsburg Gunsmith, Richard Sullivan; and an evening crucible melt demonstration by Josh Fikentscher. NOTE: new location this year at Fredrick County Fairgrounds located at 155 Fairgrounds Road in Clear Brook, VA 22624
May	<u>11th Monthly Meeting</u> - 1 demonstrator needed <u>20th & 21st Blacksmith Guild of Central Maryland 29th Annual Blacksmith Days</u> will have three demonstrators - Nathan Robertson, Jackpine Forge [tool making], Rob “Deker” Dekelbaum [Pattern Welded Steel and Bladesmithing], Jacob Selmer [Forging Sheet and Armor] held at the Carroll County Farm Museum located in Westminster, MD
June	<u>8th Monthly Meeting</u> - 1 demonstrator needed <u>17th Central Virginia Blacksmith Guild annual festival of iron and wine, “Hammerstock,”</u> will be held at Grayhaven Winery located at 4675 East Gray Fox Circle in Gum Springs, VA
July	<u>13th Monthly Meeting</u> - Ray Plank demonstrates “Farrier Rasp Snake”
August	<u>10th Monthly Meeting</u> - 1 demonstrator needed <u>14th through 19th Rockingham County Fair</u>
September	<u>14th Monthly Meeting</u> - Beginner and mentor Night - 3 demonstrators needed 1. [Redacted] 2. [Redacted] 3. [Redacted]
October	<u>12th Monthly meeting</u> - 1 demonstrator needed
November	<u>9th Monthly Meeting</u> - 1 demonstrator needed
December	<u>14th Monthly Meeting</u> - 1 demonstrator needed

Alternate:

Club Information - Continued**Just some SVBG Reminders....**

by Susan Plank

SVBG Monthly Meeting Parking

SVBG Monthly Meeting close up parking in the Burkholder Buggy Shop parking lot is for handicapped persons or if you have heavy and/or multiple items to unload. Parking for the rest of us is available across the street in the paved parking lot just past the Burkholder's driveway. You will turn right onto Stonecroft Drive (Road 1225) like you would be going into *SOUTHBREEZE Estates*. Just past the *SOUTHBREEZE Estates* sign, take an immediate right into the parking lot. Thank you for your cooperation!

SVBG Annual Membership Dues

If you haven't already taken care of this, it's time to renew your Shenandoah Valley Blacksmith Guild Membership. If you have not paid your annual dues for 2017 yet, please see Karen Robertson at the SVBG January 2017 Monthly Meeting. For visitors and occasional attendees there is no charge for meetings. The cost for SVBG annual membership from January through December 2017 is \$15.00. Membership dues can be paid with cash or with a check made out to SVBG. Thanks for supporting your guild!

SVBG Name Tags

The new attendees have mentioned to me that it is nice to be able to put a name to a face. Thanks for wearing your SVBG name tags at our SVBG Monthly Meetings. If you are a regular and see someone without a name tag, introduce yourself and show them where the "visitor" name tags are. In the past few months, we have seen a lot of new faces and some old faces returning to our SVBG Monthly Meetings and Summer Events. Thanks for continuing to let people know who you are!

Blacksmithing is dangerous. There is fire, hot metal, flying metal slag, grinding dust, heavy iron, power hammers, power tools, etc. You may also be welding, which is dangerous. If you use any wood in your work, even more dangers arise. **Please be aware of the risks and take appropriate precautions!**

Word from the President

Happy New Year! Boy Scout Troop 52 Mount Sidney is looking for people who are interested in assisting in scouting. You may have great memories of scouting or have just always wanted to help kids, there are many opportunities to become involved. This scout troop has boys ranging from ages 12 and up. They meet every Monday night at the Scout Hut in Mount Sidney. This scouting troop works on merit badges and about once a month they camp. You could assist as a blacksmith mentor, for example, on the Metalworking Merit Badge which includes working with copper, tin and blacksmithing. You could volunteer while they are camping because you especially like to hike, have knowledge to share about trees and leaves, are good at orientating, or just like to cook outdoors. You can get involved as much or as little as your time allows. Contact SVBG President...Dewey Baker through email at chevy38truck@gmail.com or message him on Facebook by typing in Dewey Baker and messaging him; if you contact him by phone only call between 8 am & 8 pm at (540) 421-5510; He is unable to be reached by phone on Monday evenings between 7 pm & 9 pm for Boy Scout Meetings and the 1st and 2nd Tuesday evenings between 7 pm & 9 pm for Ruritan Meetings. Scouting is a great way to touch a child's life!

Meeting Notes

SVBG July 2016 Monthly Meeting
E. Daniel Burkholder, Jr. demonstrated
"The Makings of a Copper Skimmer"
article by E. Daniel Burkholder, Jr.
photos by Dirk Gold and Susan Plank

The skimmers that I make started out their life as a piece of copper water pipe. I use recycled pipe because it can often be picked up from the local plumber's junk pile and is therefore much cheaper than buying new sheet stock. Also, copper can be worked cold which is a real advantage when sinking it into the swage. I generally make a 7.25" diameter skimmer, so a 3" pipe, split lengthwise and flattened out, yields a sheet of copper about 9" wide. (2" pipe will yield about 6.5" and the wall thickness seems to be the same as 3"). [see No. 1]



No. 1

I begin by splitting a piece of pipe lengthwise (at the seam if possible) and bring it to a dull red heat in the gas forge. Taking care to avoid the scalding steam, quench the pipe in the slack tub to anneal it, then open it up and flatten on the anvil with a wooden mallet. [see No. 2] This generally leaves a somewhat dirty surface which can be cleaned with a fine wire brush or random orbital sander.



No. 2

Find what will be the center of the disk and mark with a center punch. Using a compass, mark the outside diameter and carefully cut to shape with a band saw or tin shears. [see Nos. 3 & 4]



No. 3



No. 4

Now, lay out the desired hole patten, center punch, and drill 1/16" holes. [see Nos. 5, 6 & 7]



No. 5



No. 6



No. 7

These holes will need to be enlarged later, but if they are made the correct size now they will deform in the process of sinking the ladle.
lay out the desired hole patten

Meeting Notes - Continued

E. Daniel Burkholder, Jr. demonstrated "The Makings of a Copper Skimmer"- Continued

The disk is now ready to be sunk in the mold, which, of course, means that first there must be a mold. If a cast iron swage block is at hand with the proper size depression, that is the end of the problem, if not, a mold can be made from a wooden block. [see No. 8] I made my own from a 3" thick block of end-grain hickory which was first turned to a 10" diameter on the wood lathe. I then laid this disk face down on the table saw directly on top of the blade (which was not running and had been lowered beneath the table).



No. 8

With the saw fence on the right side of the wooden swage block, and an extra block clamped to the saw fence between the blade and the in-feed side of the table, turn on the saw, **(with the blade still beneath the saw table)**. Now slowly raise the blade about 1/8" **with the saw running**, and rotate the swage block, which is nestled securely in the corner of the fence and the auxiliary block, one full revolution. Continue to raise the saw blade in 1/8" increments, with the saw running, and rotate the swage block until a depression approximately 1 1/4" deep and 7 1/4" across has been carved into the face of the wooden disk. And, Presto, the mold is ready to be used. I added a square post on the bottom of mine that fits in the hardy hole of the anvil or vise to hold it steady while in use. **(Use great care while making the depression on the table saw.)**

Now, I repeat, the disk is ready to be sunk in the mold. [see No. 9] Lay the copper disk on the wooden swage block, and using a hammer with a rounded face (although not as pointed as a ball peen) start about 1 1/2" in from the outer edge and pound the disk down into the swage block. [see Nos. 10, 11 & 12]



No. 9



No. 10



No. 11



No. 12

If the outer edge begins to form a wrinkle, stop immediately and work it out because a wrinkle that is allowed to go too far before attending **cannot be removed**. [see No. 11] Continue to work the copper disk until the hammer blows have a solid sound indicating that the entire surface has been fully seated into the swage block. [see No. 13]



No. 13

At this point I enlarge the holes to their proper size, generally 3/16", but they can be either larger or smaller depending on the application. After drilling the holes, they should be slightly counter sunk to relieve the sharp corners.

Even if the copper disk was perfectly round at the beginning, the swaging process likely caused some distortion and sighting over the top edge of the skimmer reveals a wavy rim. [see No. 13]

Meeting Notes - Continued

E. Daniel Burkholder, Jr. demonstrated "The Makings of a Copper Skimmer"- Continued

This can be flattened by turning the skimmer face down on a 6" wide belt sander. However, the upside-down skimmer is a bit tricky to hold so I insert a 3/16" by 1 1/2" stove bolt in the center hole and put a nut on the outside which serves as a handle. [see Nos. 14, 15 & 16]



No. 14



No. 15



No. 16

Once the outer rim is flat, remove any burrs and sand the inside and outside surfaces with 220 grit sandpaper (a random orbital sander works well for this) followed by a soft, power wire brush which will give it a nice luster.

Of course, no skimmer is complete without an appropriate handle. There are many ways to do this, most of which will give the opportunity for some real forge-time. [see Nos. 17 & 18] I have found that a 7" diameter bowl with a 26" long handle yields a well-proportioned tool. One of the skimmers pictured has a one-piece steel handle that is historically accurate and the other one is a copy of an old tool with a combination wood-and-steel handle.



No. 17



No. 18

Meeting Notes - Continued

E. Daniel Burkholder, Jr. demonstrated "The Makings of a Copper Skimmer"- Continued

While it takes somewhat more work to make the wooden handle style, it is by far the most attractive. The metal part of the handle can either be forged from a piece of 3/8" x 1" steel or fabricated from three pieces. If fabricated, I use 1/8" x 1" that is folded in the center to mount the wooden handle, 3/8" square bar for the center section, and a piece of 1/8" sheet metal to join the handle to the bowl. The handle and bowl are fastened together with three copper rivets, while the wooden and metal handle parts are joined with countersunk steel rivets. [see Nos. 19, 20, 21 & 22]



No. 19



No. 20

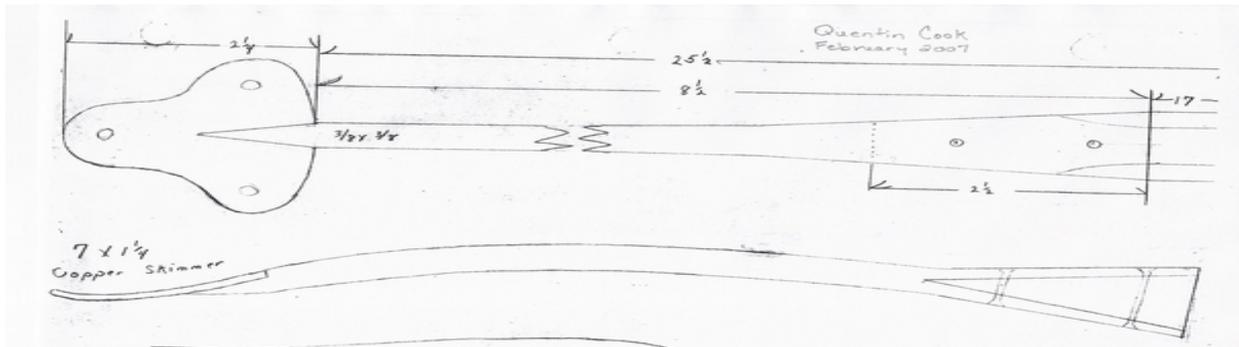


No. 21



No. 22

Drawing below shows further technical details of the handle and bowl and the wooden and metal handle. (Drawing is not to scale). I generally use Tiger Maple for the octagonal wooden handle and stain it a rich-looking, dark red.

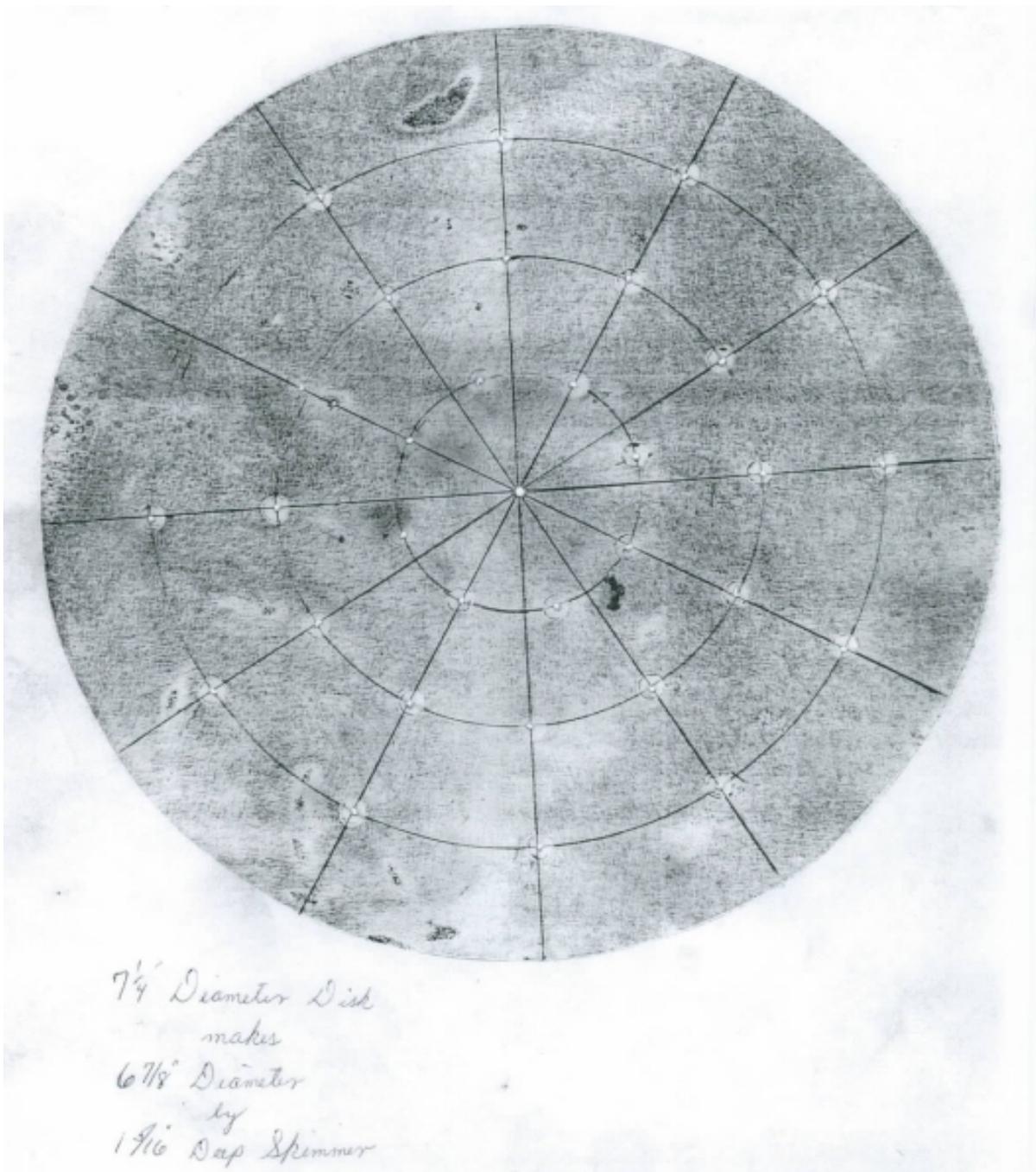


On the next page you will find a drawing of the desired hole patten lay out mentioned on page 4 in paragraph 3 and pictured being used in No. 5. (Drawing is not to scale.)

While this does not cover every aspect of skimmer-making, hopefully there is sufficient information here to inspire you to try it for yourself. Happy hammering!

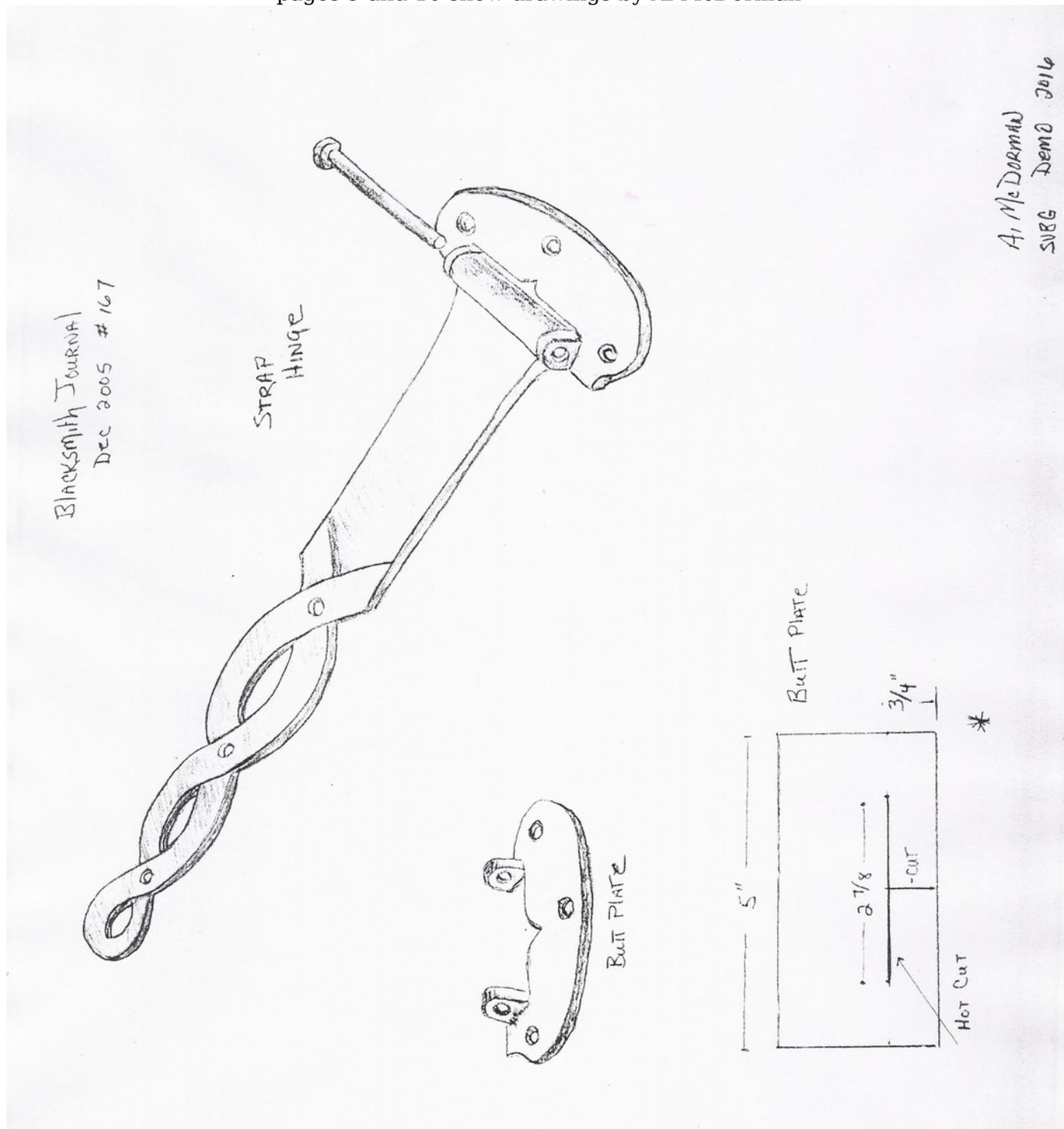
Meeting Notes - Continued

E. Daniel Burkholder, Jr. demonstrated "The Makings of a Copper Skimmer"- Continued



Meeting Notes - Continued

SVBG November 2016 Monthly Meeting
Al McDorman demonstrated "Braided Hinge Strap"
pages 9 and 10 show drawings by Al McDorman

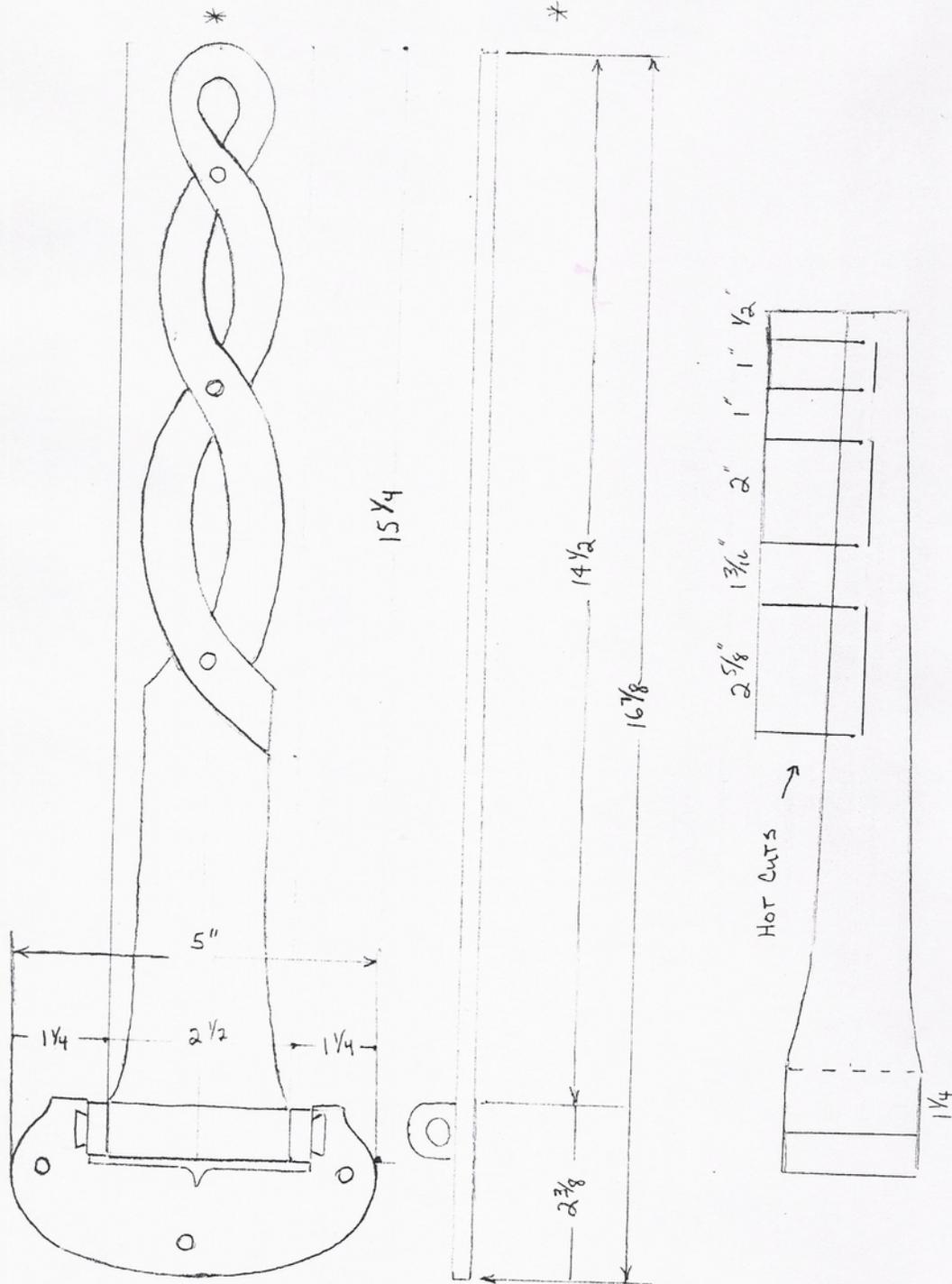


Meeting Notes - Continued

SVBG November 2016 Monthly Meeting
Al McDorman demonstrated "Braided Hinge Strap" - Continued

Al McDorman DEMO
Nov 2016 SVBG

STRAP HINGE
Approx 1/2 Scale *



BLACKSMITHS JOURNAL
#167 Dec 2004

Meeting Notes - Continued

SVBG January 2017 Monthly Meeting
Dewey Baker demonstrates "Frederick Cross Key Fob"
pages 11 and 12 give demonstration directions



Sketch Book

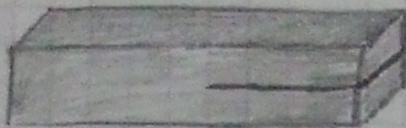
By Diana

Frederick Cross key Fob

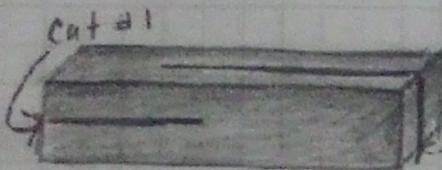


Start with 2 1/2 inches of 3/8 square

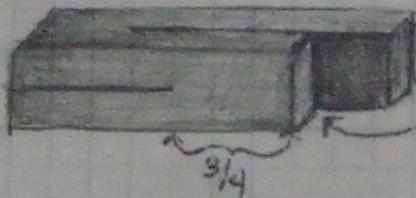
Next - use a saw to make the following cuts:



Cut #1 - 1" Long



Cut #2 - 1 3/4" long



Cut #3 - Cut 3/4" off one of the longest legs. This leaves a 1" long leg that will become the top of the cross.

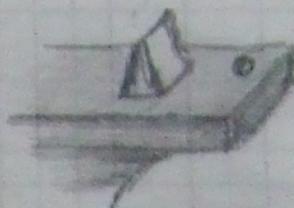
The two cuts should overlap 1/4". When opened, this overlap forms the diamond shaped hole in the center of the cross.

This preparation work is done COLD, now you are ready to get it HOT.

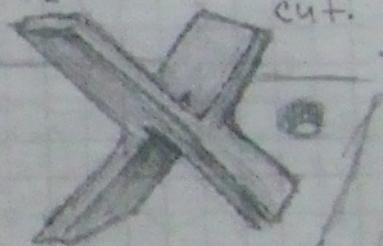
Meeting Notes - Continued

Dewey Baker demonstrates "Friederick Cross Key Fob" - Continued

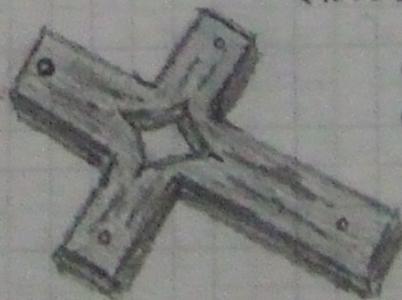
While you are waiting for your metal to heat.
★ Place a slitting chisel in a vice or
a hot cut in hardie



When metal is hot,
Grasp with tongs
being careful not
to close slits.
hook cut on edge
of slitting chisel,
and pry open each
cut.



When both slits have been opened
about 45 to 60°, use your tongs to
hold onto one leg and carefully flatten the
cross on the anvil.



Add any texturing
on cross and then drill or
punch a hole for key
Ring.

General Notes

Virginia Institute of Blacksmithing
has Certification Program in Blacksmithing



Virginia Institute of Blacksmithing's Certification Program to train interested students in the art of architectural and ornamental metalwork at a professional level. Students who complete the one year program will gain the knowledge and skills in blacksmithing so that they are qualified to work for and continue their training with a professional blacksmith.

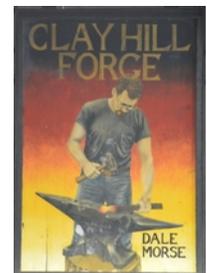
For a student who likes to work with their hands and be creative; learning a trade in the art of traditional blacksmithing might be the perfect journey to take.

Students who possess mechanical aptitude and visualization skills (the ability to look at a 2 dimensional drawing then see it in 3 dimension) are best suited for the Certification Program.

The course is divided into 12 workshops starting with an introduction to blacksmithing safety, techniques and shop etiquette to conceiving, drawing and producing a project of the students own conception. Topics including introduction to business management and accounting, zoning and building codes and other helpful topics are also covered in the program. Online micro business management courses may be recommended by the instructor.



The Certificate Program is taught by **Dale Morse**. Dale has over 35 years of experience in traditional blacksmithing, is the co-founder of the Virginia Institute of Blacksmithing and proprietor of *Clay Hill Forge*, an artisan blacksmithing company specializing in architectural and ornamental ironwork.



[above information located at <http://vablacksmithing.org/certification-program-in-blacksmithing/>]

Items of Interest

Blacksmith classes:



STRIKE WHILE THE IRON IS HOT!

1. Our SVBG Guild Master, **Dale Morse**, at *Virginia Institute of Blacksmithing* located at 200 West 12th Street in Waynesboro, Virginia 22980 has various classes. This is a tentative schedule for 2017. The schedule is subject to change. For any questions regarding classes, call (434) 960-9718 or email him through info@vablacksmithing.org

January - 7 - 8 BSMTH 105: Certification Course
 14 - 15 BSMTH 111: Certification Course
 21 - 22 Beginning Blacksmithing - Build a Helmet
 21 Metalsmithing - Torch Fired Enamels
 28 - 29 Beginning blacksmithing - Wall Mounted Pot Rack
 28 - 29 Metalsmithing - Intro to Metalsmithing and Forged Jewelry

February - 4 - 5 BSMTH 106: Certification Course
 11 - 12 BSMTH 112: Certification Course
 18 - 19 New Beginning Blacksmithing - Re-enactors class
 18 - 19 Metalsmithing - Intro to Silver Soldering and Cabochon Stone Setting
 25 - 26 Beginning Blacksmithing - Build a Shield
 25 - 26 Metalsmithing - Small Boxes and Hinges

March - 4 - 5 BSMTH 107: Certification Course
 11 - 12 New Beginning Blacksmithing - Leaves, twists, and other Embellishments
 18 - 19 Private Class
 25 - 26 Beginning Blacksmithing - Build a Hatchet (CLASS FULL)

April - 1 - 2 BSMTH 108: Certification Course
 8 - 9 Beginning Blacksmithing: Hook Rack and Candlestick
 15 - 16 Beginning Blacksmithing: Tips and Tricks of the Anvil
 22 - 23 TBD
 29 - 30 Beginning Blacksmithing: Build a Spear

2. **Phil Travis'**, *Dragon's Breath Forge*, blacksmith classes have not been set yet. Check in our SVBG April Newsletter for his blacksmith class information.

