



# Blacksmiths of Central Texas

President's Corner

October 2010

## Thanks, Everyone!

*A Very Good Year*

This is my final monthly column as President of Balcones Forge. We will hold Board of Directors Elections at our October meeting and the new board will then appoint our next President. My sincere hope is that you will give that shiny new President the same effort and enthusiasm that you have given me this year!

We have had a wonderfully successful year with a lot of changes and adjustments. At the beginning of the year, members asked for more actual, hands-on blacksmithing and we have certainly done that! We forged hot iron at most of our meetings this year, giving the public some pretty good shows in the process. In addition, we had a terrific pair of demos, featuring Gordon Williams and Dan Smith. Both were very well attended and we managed to promote the craft and our organization to a lot of new folks as well as enjoying ourselves.

The Board of Directors is already at work on a fine program for our Bluebonnet Demo next April. We will be forging iron for the Pioneer Museum, Zilker Gardens, Mission Espada, the Rockdale Train Depot, and our newest success, "Up the Chisholm Trail" cattle drive for the Williamson Museum. In addition we have planned a joint meeting with the Houston Area Blacksmiths Association at Alan, Jeff and Carlton Lee's Steep Hollow Forgeworks in Bryan, Texas this February. It promises to be a big show with lots of fancy forging and work on the BIG hammer! The Lees have really raised the bar on blacksmithing in Central Texas and it will be interesting to see what they have up their sleeves for this demo! Check out their work at [steephollowforgeworks.com](http://steephollowforgeworks.com).

A successful year like this only happens because of TEAMWORK. No single person can make Balcones Forge a great success by themselves, no matter how hard they work. Our officers put out a fine effort this year and I am grateful for that. However, our biggest effort this year came from our Balcones members. We



### Officers

#### President

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210/566-1028

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**Rudy Billings**

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512/461-7375

#### Secretary

**Jim Elliot**

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512/863-4482



### Editor

**Vince Herod**

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512/253-6045



*President's Corner*  
*continued from page 1*

had good attendance and lots of enthusiasm at our meetings and a serious push by many members to do a lot more iron forg-

ing and to learn more about the craft. That's why we're here!

The heart of a fine program is interesting meetings and we have a good one lined up for this month in Llano. Bob Pheil has built a big fan club for himself through his unrelenting pursuit of true excellence in craftsmanship. And every year, Bob makes time to show us another facet of his process in building the awesome high-end iron and mesquite creations that are making him famous. Don't miss this chance to see Bob's latest masterpiece and to join in the annual debate over which barbeque place in Llano is really "best in the world"!

John Crouchet, President

### **NEW ADDRESS**

Please note that we have FINALLY moved into the 21st century and now have DSL. What a wonderful change....so, change our email address to the following, or we won't be able to "hear" from you.

blpheil@verizon.net

Thanks!

Bob and Lisa Pheil  
Pheil Forges, Inc.  
Llano, Texas

IGNORE the e-mail address on the map! *Editor*

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### **GOT A TWITCH?**

The Trade Item this month is a twitch. Yep, Jerry came up with another fun and interesting project. Try your hand at creating one.

There are several examples on pages 10 & 11.

And remember, you gotta make one to take one!

### **SECRETARY'S REPORT**



San Gabriel Park, Georgetown, TX Sept 18, 2010 Elizabeth Brim will not be able to demonstrate for us this spring. Discussion followed regarding lining up demonstrators further in advance, perhaps two to three years. Jerry Darnell was suggested (but was also unavailable).

Board of Directors elections will be held in October. If you are not there you could wind up as President or Secretary. Let's have a good turn out.

The November 27th meeting is to be held at the train station in Rockdale.

The December meeting is to be in Boerne. The date will have to be decided as the last Saturday is Christmas.

The January meeting may be at George Craig's shop in San Antonio. More on this later as details develop.

In February the meeting will be held at the Lee Brother's shop in Bryan.

The trade item for September was a scythe anvil and there were several good examples. Henry Stone's work was an absolute work of art and has been donated to the auction. We appreciate the endeavors and hope for even more for the October item, a twitch. A twitch is a device made to make horses behave in a more docile manner. One wonders if they can be adapted for human applications, just a thought. See Jerry's example photos and get to hammering. See ya at Bob's!

Jim Elliot, Secretary



### **MEETING INFO**

October 30 - 9:30 AM  
Pheil Forge - Llano  
200 Post Oak Drive, Llano, TX

Directions: From Hwy 71, take County Road 152 west at the stoplight. Go 1.7 miles from the stop light and Post Oak Drive veers off to the left. Pheil Forges home/shop is the ninth home on the left.



### **ANNUAL ELECTIONS**

October is the month for annual elections for Balcones Forge. Our By-laws state that the membership elects the members of the Board and the Board comes to a consensus regarding Officers.

What do you want from the organization? What are you willing to contribute to make those goals happen? Is it time to step up to the plate? These are questions every member should ask themselves.

Come to the October meeting and make your voice a part of the discussion. Bob Phiel always has a GREAT demonstration and the food in Llano ain't bad either!



Cowgirls singers, visitors from the Ukraine and lots of other fun at the September meeting of Balcones Forge





Photos by Vince Herod and Helen Wise





## Friederick Cross Necklaces

by Doug Merkel

Here is an item that is a good seller at craft fairs and a fast demo. You can do all the time consuming work back at the shop and have sets ready to forge on site. Pre-cut your stock to the measurements as shown in the chart. Note that the cuts overlap, this overlap will make the open diamond in the center of the cross. Length '1' will be the left and right cross arms, the section from '2' to '3' will be the top of the cross and the section from '2' to '4' becomes the bottom of the cross. Forms small rings out of 1/8 inch brass or nickel silver rods by cold wrapping it around a 5/16 inch rod and cutting rings off as needed. A 20 inch piece of leather strap is used for the neck piece.

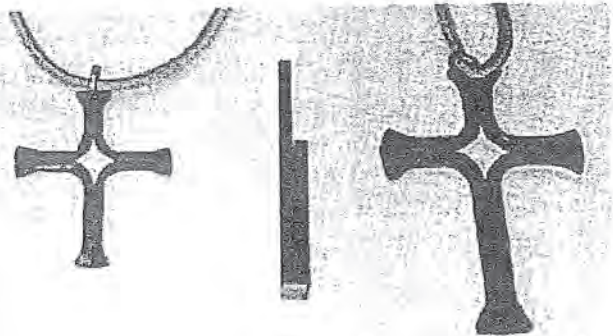
Heat the stock in the forge and strive for a very even heat in the section where the cuts overlap. Do this next part all in one heat. .. push the two side arms down on the hardy to spread, grab the cross top with a second pair of tongs and spread it away from the long bottom of the cross, use your hammer, the edge of the anvil and top of the anvil to fully open and flatten the cross. A lot to do in one heat but it can be done. Really impresses the crowd.

If you do need a second heat be sure you get it even so that all the bends in the center of the cross look the same. You can use the pritchel hole to make sure that the arms are even and that the top matches the bottom. Heat each end and use the cross pein to decorate each of the four ends. The metal will be thin enough to cold punch a hole in the top or you can drill a hole to match your ring. Wire brush the cross, may be even a little gypsy gold, apply a wax finish, insert one of the small rings you made,

thread in a strip of leather and sell it.

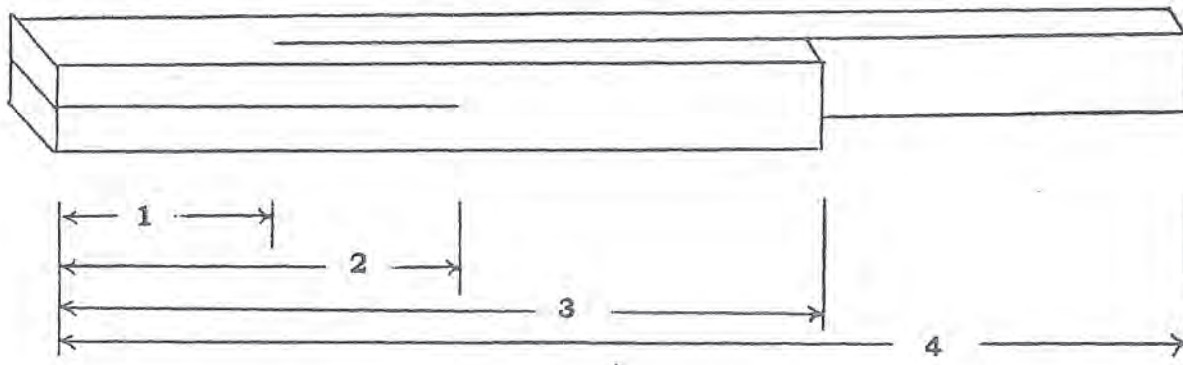
This small project that can be done at demos to keep the interest of your audience. You end up with a nice little item in a short amount of time if you do all your cutting of the stock back at the shop.

Get it Hot, Hit it Hard, Quit when it's Done!  
Doug Merkel



### Friederick Cross, Necklaces

	<u>3/8 square</u>	<u>1/4 square</u>
1	7/8	11/16
2	1 7/8	1
3	2 3/16	1 11/16
4	3 1/2	2 11/16





These are just a few examples of the many stamps from around the world that have paid tribute to balcksmiths.

Poland (left)

Viet Nam (lower left)

Belgium (lower right)





## ANVILS Vulcan



Cast gray iron body, tool steel face and horn, fully warranted.

Nos. ....	5	10
Weight each, lbs. ....	50	100
Size face, ins. ....	8½x3	12½x3½
Length, ins. ....	14½	20½
Height, ins. ....	7½	9½
Hardie hole, ins. ....	¾	¾
Pritchel hole, ins. ....	7/16	¼
Each .....	\$51.25	\$78.25

Nos. ....	13	15
Weight each, lbs. ....	130	150
Size face, ins. ....	13½x3¾	14½x4
Length, ins. ....	21½	22¾
Height, ins. ....	10¾	11¾
Hardie hole, ins. ....	1	1
Pritchel hole, ins. ....	9/16	9/16
Each .....	\$93.50	\$103.00

Nos. ....	17½	20
Weight each, lbs. ....	175	200
Size face, ins. ....	15½x4½	16x4½
Length, ins. ....	24¾	25¾
Height, ins. ....	11¾	12¾
Hardie hole, ins. ....	1	1½
Pritchel hole, ins. ....	9/16	9/16
Each .....	\$123.25	\$135.00

Nos. ....	25
Weight each, lbs. ....	350
Size face, ins. ....	17½x4½
Length, ins. ....	27¾
Height, ins. ....	13
Hardie hole, ins. ....	1½
Pritchel hole, ins. ....	9/16
Each .....	\$163.00
Loose	

## Columbian Bench



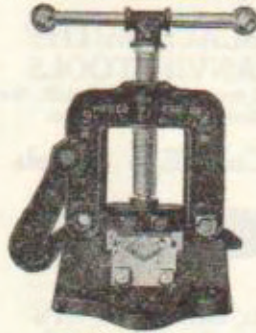
### WITH CUT-OFF TOOL

Made of shock-resisting "Kromiron" castings, and has a broad, tough face. Equipped with a steel cut-off tool, heat treated and hardened. Face size 3x6 inches, 3 inch horn. Base size 4x5½ inches. For home, dentists, jewelers, etc.

No. 9A—Wt. ea., 9 lbs. .... Each \$5.50  
Six in a case.

## VICES Hinged Pipe

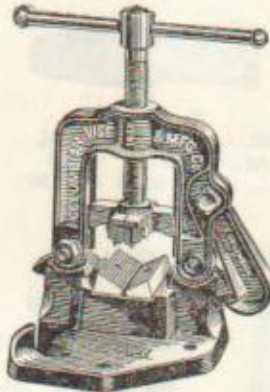
Malleable iron frame and base, black japanned; steel screw and handle: hardened and tempered tool steel jaws.



### STANDARD

Pipe Wt.

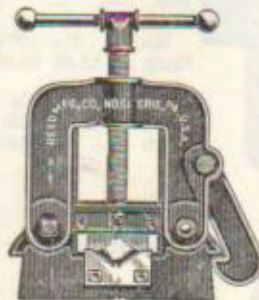
No. ....	capacity, ins.	ea., lbs.	Each
16X	¼ to 1½	5	\$15.75
Loose.			



### LONG JAW

Lower jaws reversible. Threaded lock nut on end of screw allows take up for wear. Automatic take up keeps these vises from getting loose or sloppy from wear.

No. ....	Pipe capacity, ins.	Wt. ea., lbs.	Each
160	¼ to 2	9	\$18.50
161	¼ to 2½	11	21.90
162	¼ to 3½	19	33.25
163	¼ to 4½	26	43.20
Loose.			

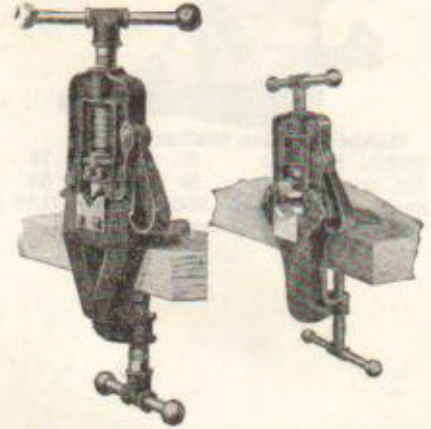


### EXTRA HEAVY

These vises are for the very heaviest class of work.

No. ....	Pipe capacity, ins.	Wt. ea., lbs.	Each
164X	¼ to 6	49	\$ 97.50
165X	1 to 8	81	198.00
166X	1½ to 8	163	290.00
Loose.			

## VICES Hinged Pipe



Nos. 100 & 11      No. 10

### REED'S CLAMP KIT

Japanned malleable iron frame and base. Clamps to bench or post. Hardened tool steel jaws, No. 10 has long jaws.

No. ....	Pipe Capacity, inches	Clamp opens, inches	Wt. ea., lbs.	Each
100	¼ to 1½	2	7½	\$22.30
10	¼ to 2	4¼	12	24.75
11	¼ to 2½	3	14	30.00
Loose.				



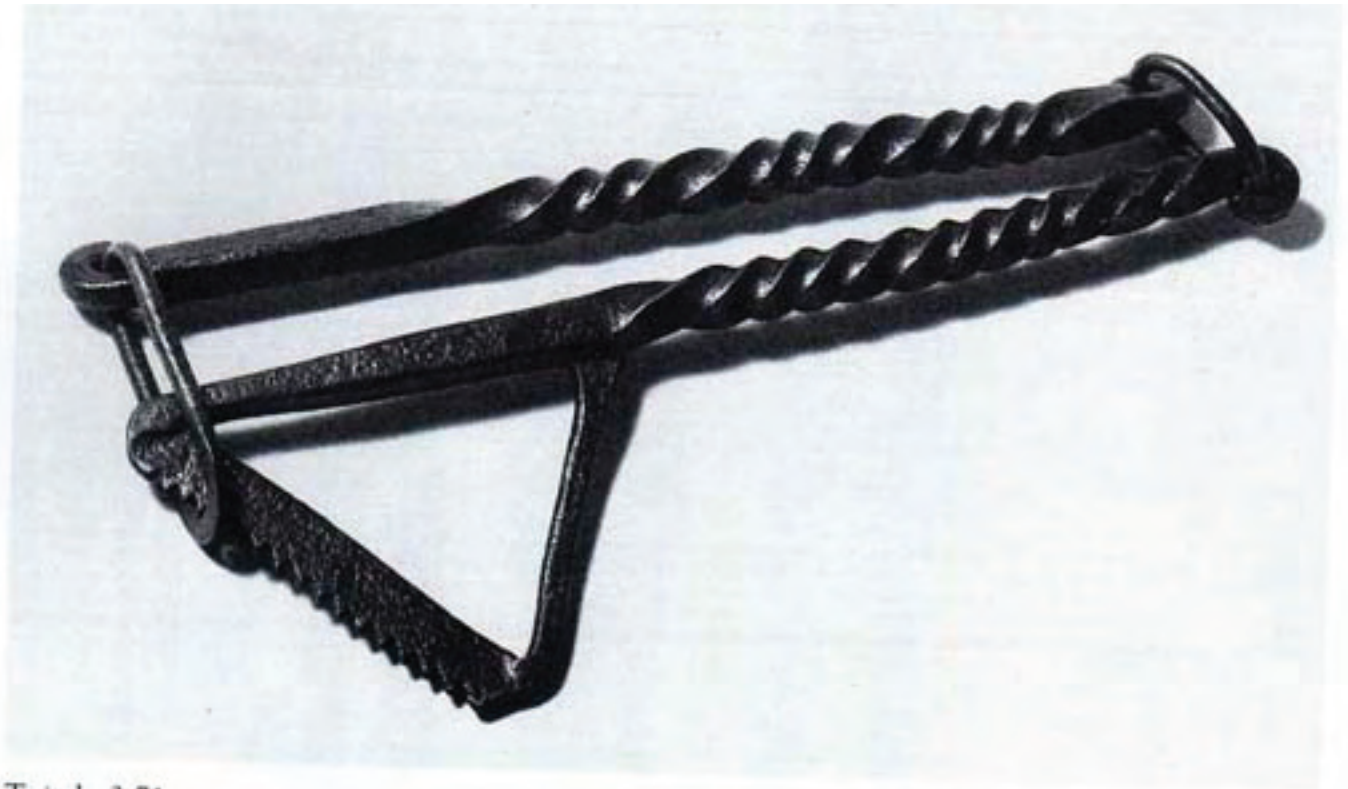
### LITCO

Long, one-piece removable grooved steel jaws. Self-locking latch.

No. ....	Pipe Capacity, ins.	Wt. ea., lbs.	Each
LT-51	¼ to 1¼	3½	\$5.40
LT-52	¼ to 2	5¼	6.50
LT-53	¼ to 2½	8½	9.75
One in a box			



WWW.BALCONESFORGE.ORG



**Twitch, 3-71**

*The device is clamped tightly over the horse's lip, making any significant movement quite painful. This was sometimes used by a farrier or veterinarian to keep an unruly horse under control. 12x4*

**twitch** (tw ch)

v. twitched, twitch·ing, twitch·es

v.tr.

To draw, pull, or move suddenly and sharply; jerk: I twitched my fishing line.

v.intr.

1. To move jerkily or spasmodically. See Synonyms at jerk1.

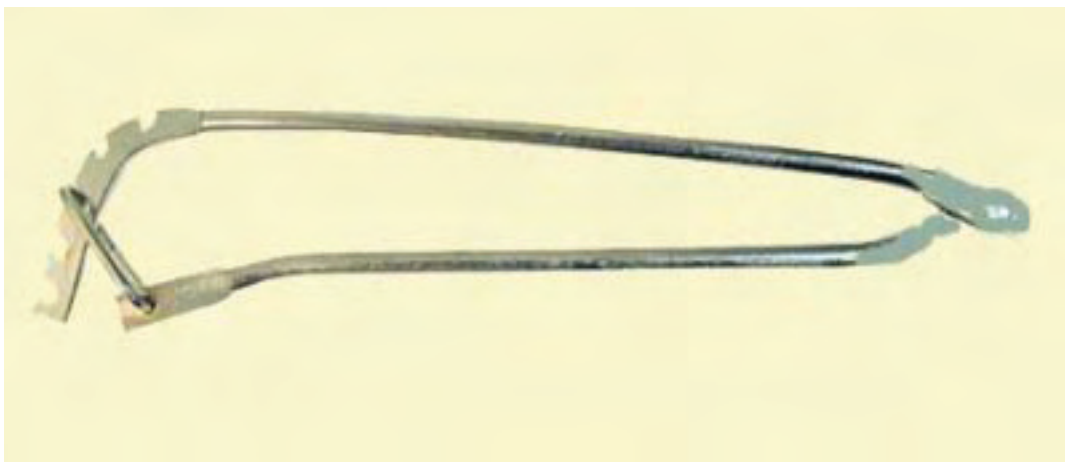
2. To ache sharply from time to time; twinge.

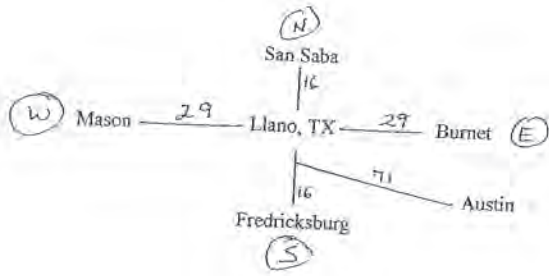
n.

1. A sudden involuntary or spasmodic muscular movement: a twitch of the eye.

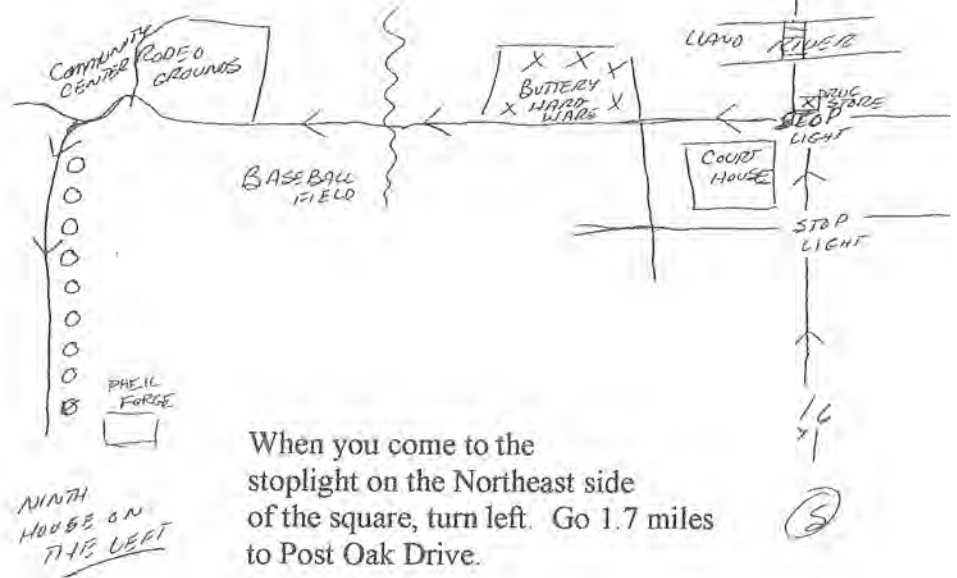
2. A sudden pulling; a tug: The fish gave my line a twitch.

**3. A looped cord used to restrain a horse by tightening it around the animal's upper lip.**





Pheil Forge  
 200 Post Oak Drive  
 Llano, TX 78643  
 915-247-1370  
 bpheil@tstar.net



When you come to the stoplight on the Northeast side of the square, turn left. Go 1.7 miles to Post Oak Drive.

Return Service Requested

Vincent Herod  
 Spotted Dog Forge  
 166 Granite Road  
 Paige, TX 78659-4922