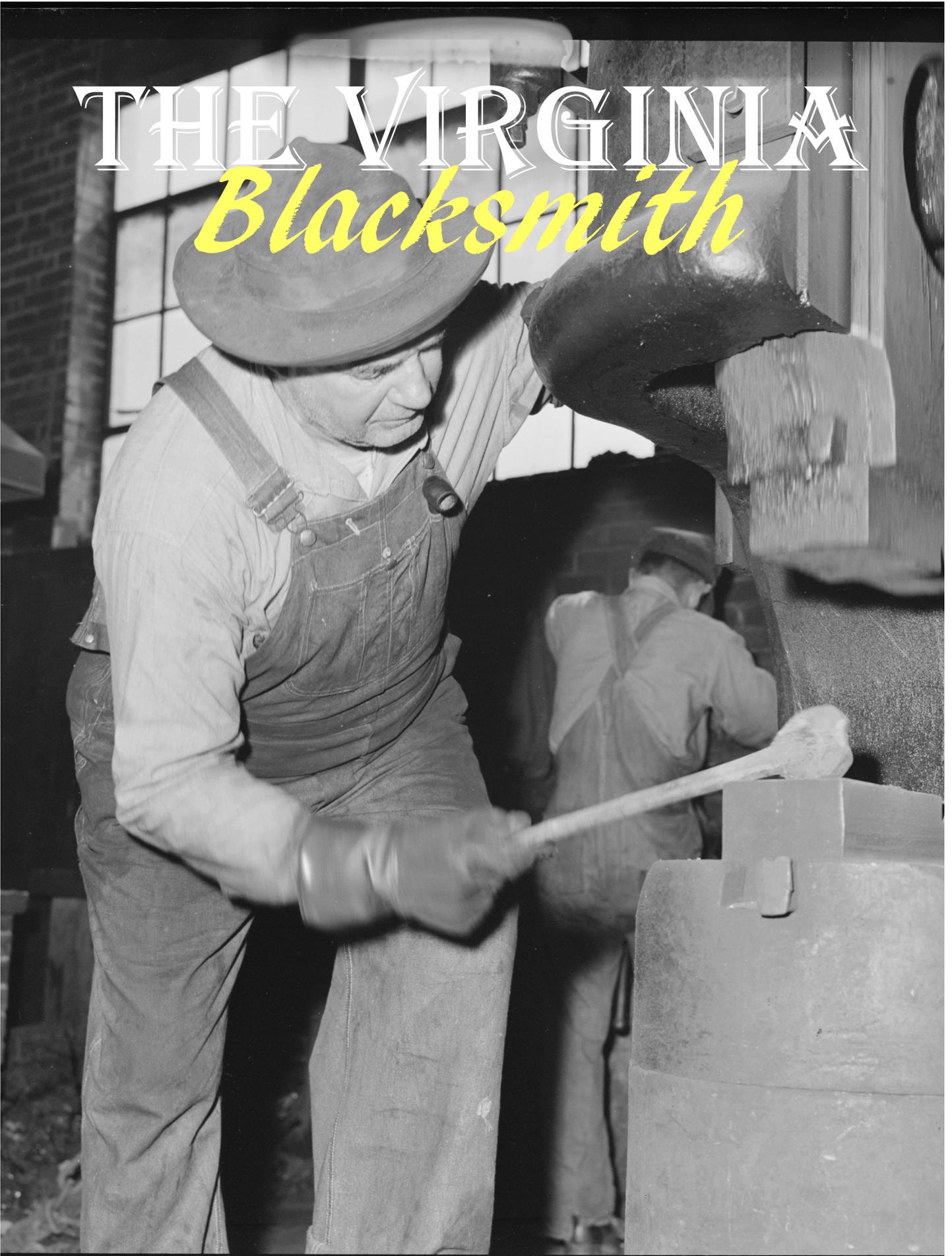


# THE VIRGINIA *Blacksmith*



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## Disclaimer

Blacksmithing is a lot of fun, but comes with inherent dangers. All members, demonstrators, and guests are responsible for using appropriate safety equipment and for using safe working methods. Minors must be accompanied by a parent or responsible adult.

The Southwest Virginia Blacksmith Guild, Central Virginia Blacksmith Guild, their officers, members, demonstrators, guests, hosts, writers, and the editor disclaim responsibility for any damages, injuries, or destruction of property as a result of the use of any information published in this newsletter or demonstrated at workshops, meetings, or conferences.

Every effort is made to insure the accuracy and the safety of information provided, but the use of any material is solely at the user's own risk.

Attendees at organization functions and classes consent to the use of their images in publications, social media and web pages of the Southwest Virginia Blacksmith Guild and/or Central Virginia Blacksmith Guild.

Unless otherwise noted, all content is available for use by nonprofit blacksmithing and metalsmithing groups, provided the source is cited.

## On the Cover

Blacksmith using hammer to shape piece of heated iron, The Pocahontas Corporation, Mines 33 - 34, Bishop, Tazewell County, Virginia August 27, 1946

Source: National Archives and Record Administration



## Coming Events

**November 10 - 9 am - 1 pm**

CVBG November Meeting

Keith Hicks' shop

17910 Stage Rd., Barhamsville

**November 18 - 2 - 4 pm**

SWVABG November Meeting

Great Road Craft Guild

1812 Big Spring Dr; Elliston

**December 8 - 9 am - 1 pm**

CVBG December Meeting and Holiday Party

Paradise Garage

14 S. Allen St.; Richmond

**December 16 - 2 - 4 pm**

SWVABG December Meeting

Great Road Craft Guild

1812 Big Spring Dr; Elliston

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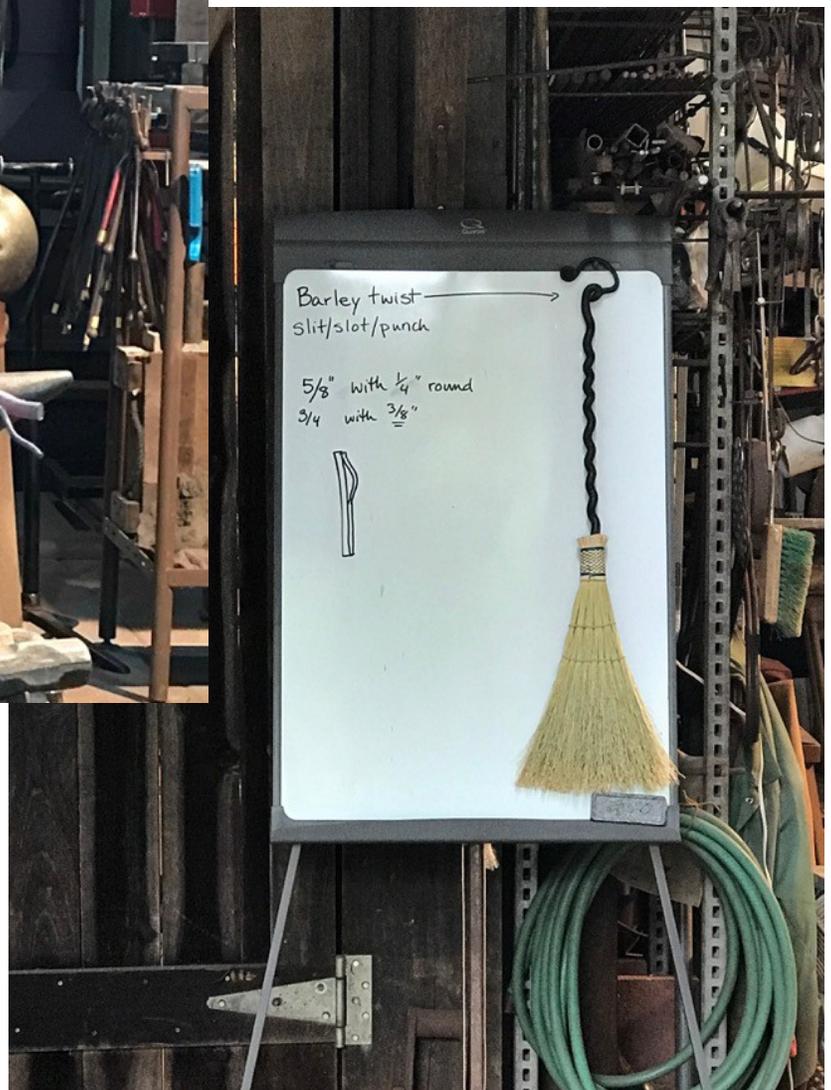
# Barley Twist Broom Handle and More

with Caitlin Morris of Ms. Caitlin's School of Blacksmithing

(CVBG August Demonstrator at Bruce Manson's Shop) by Erin Mitchell

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## “What are we? ...LAZY BLACKSMITHS!”

This was, for me, the greatest educational moment of Caitlin Morris’s demonstration.

As odd as that may sound, even the most muscular of hammer wielding smiths should strive for laziness. I really enjoyed her perspective on this:

“If you’re trying to muscle your way through the steel you’re putting too much effort into it. I respect it, I understand that you’re a strong human being. The flip side to it is that if I can do it without expending nearly that much energy I’m going to prefer that. Less energy means I don’t get tired as quickly.”

Ms. Caitlin demonstrated and emphasized how a simplified thought process and proper technique can allow for the most effective use of energy. She breaks it down to a simple outline for blacksmithing. Laziness is doing things in the lowest energy form (plenty of heat, proper tool use, body awareness). This means you can forge longer without tiring. A longer period to work inevitably means more mistakes will be made. The only thing to do with all these mistakes during this long period of work is learn how to fix them (and then how to avoid them). End result is you get better at blacksmithing if you’re lazy!

### Barley Twist Broom Handle

This demonstration utilized a Grizzly Industrial Benchtop Bending System. The twist can also be performed with only a vice and wrench but may not have the same uniform spiral. To begin, tack weld the ends of the 1/4in round (sacrificial steel) at each end of the 5/8in length (broom handle). Heat the steel rods. The forge was only deep enough to heat half the length at one time so the heating and twisting process occurs and repeats.



Once heat fully penetrates the larger diameter rod, lock into bending system or vice. With fluid motion count the number of twists to your preferred spiral appearance, unlock, heat the opposite side and repeat.

On the second twist the metal moved more quickly at it’s hottest point and created a tighter spiral. Bruce was able to knock out a few small bends that occurred during twisting with a light hammer blow. A third round of heating and twisting was used to more closely match the two halves.

The welds can now be cut off and the thinner stock untwisted and removed from the thick. The removed piece may be reused, however this process will have thinned it by stretching during the twist. Photo compares original sacrificial steel size to the twisted, stretched and removed sacrificed piece.





Twisting process



Taper and punch for bristle attachment



Taper for handle

Now one end of the handle piece can be tapered, flattened a bit, and a hole punched for the broom bristle end. A 1:5 ratio is the general rule to stay within when working the metal, meaning keep one unit of thickness to less than 5 units of height. This will maintain control of the metal's movement without allowing it to fold on itself.

"T" for TUMBLE - 90 degree turns, alternate between strikes

"E" for EDGE - work on the edge of anvil surface to allow the hammer clearance

"A" for ANGLE - an even point will be created when the angles where the hammer meets the metal vs. where the anvil meets the metal are equal

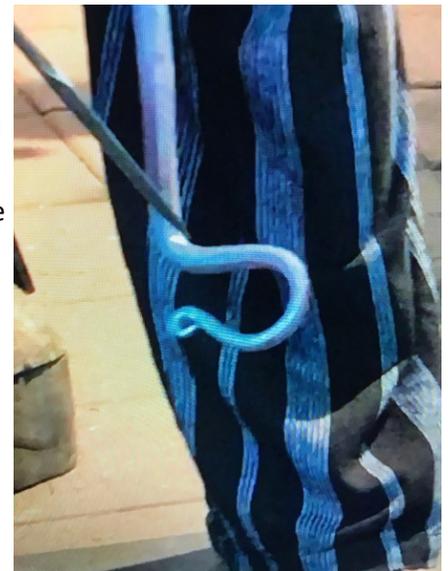
For the handle end, taper the metal to a long point with TEA in mind. Thin the tip and curl in the point.

To bend a rounded handle, measure approximately 6 inches from the curled tip and mark. Spot heat the area under the focused heat of the burner. Place the metal in a vice and hammer to a 90 degree angle. The 6 inch length can be heated but cool the elbow bend and scrolled tip. Use the anvil's horn to work this length into a circle and use the face of the anvil to coax out any bowing.

Then all that's left to do is finish and seal the metal, and of course, make the broom (but that is for another class).

Ms. Caitlin started out looking for a hobby and a distraction from the monotony of her desk job. It was as easy as writing a list before lunch of all the things she wanted to learn and tapping the "Sort Alphabetically" function in Excel. Her childhood memories of decorative metalwork in her parent's European travel photographs set Blacksmithing on that list and it shot right to the top once she pressed the button.

"I haven't made it past the B's yet by the way" she's said.



## The Making of a Damascus Knife

By Matthew Hanvey

I went to Carson's shop [Carson Sams—ed.] to learn how to make Damascus. We used bandsaw blade (scrap that I got from work), 1075, and 15N20 (nickel) to make a stack of metal. I first had to cut the bandsaw into 12 strips, about 6" long each. Then I cut a 13" piece of 1075 in half, and 12" piece of nickel in half. Once all pieces were cut they have to be sanded until shiny metal shows. After all pieces are prepped that have to be welded together in order of: 3 bandsaw/nickel/2 bandsaw/1075/2 bandsaw/nickel//2 bandsaw/1075/3 bandsaw. That gives us 16 layers to start with. You want to clamp the stack tightly to have as little gap between the layers as possible. You want to weld by having straight lines across the layers and space each weld about 0.5" apart. Once the back of the stack has been mig welded you need to grind down the other sides until all layers are even,



re-clamp, and weld the opposite side. The block will be cut in half and save one side in case a mistake is made. Weld on a small square stock piece for a holding handle. Spray both with pb blaster to prevent rust. You want the forge to get up to high heat before putting in the one you want to weld. Once the forge is hot put in the block with the layers vertical, rotate often for even heat. Let it get warm then start fluxing (borax) it, mainly on the sides to get between the layers. Heat and brush off the flux then put on new flux

a couple times, while trying to keep an even heat on the metal. Then let soak in the fire to get to welding temp know exactly where you are going and how you are doing it before pulling it out of the fire for the first forge weld. I used a power hammer to stick the weld, then reflux and heat again, make sure to scrap off all old flux to see if there are any blisters in the layers. I sadly got a blister, but we ground that section down two layers until the blister is gone and flux that area and keep going back to the power hammer. Once you are sure the weld is solid you want to re-square up your piece and lengthen it. Then mark halfway and we cut down most of the block, leaving enough material so we can fold it over and not have to do more mig welding. You want to then clean the sides that will fold in together and heat up and bring in close so not much gap. Flux and clean a couple of times then go back to the power hammer and weld them, now we have 32 layers. Then you want to work the flats and sides, to make sure

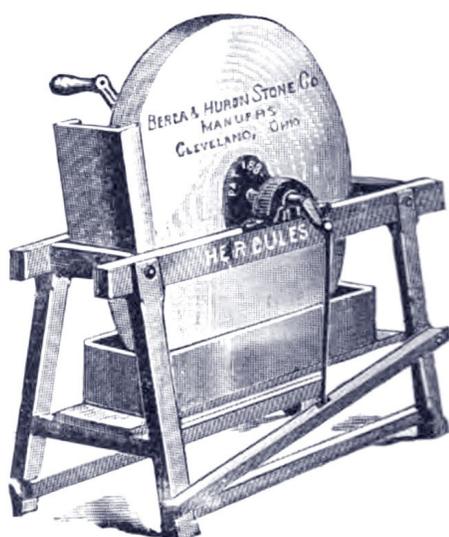


the weld is fully secure and to lengthen the material. To make the tang, go in about 2" from the attached bar, you want a rectangular taper but also taper the flats some also. Then you can cut off the extra bar and form the tip of the blade. Now the rest of the work is done on the anvil. After you have the tip you want to go to the anvil and bend the side opposite where you want the bevel, because as you put in the bevel the back will curve. After doing a heat or two of putting in the bevel you want to curve it again to straighten it out. As you are working the bevel you want to leave a space of about 1.5" from the tang alone. Keep working the blade until close to desired shape, then you want to anneal it for the grinding work. After the grinding work and



you are happy with the shape you want to harden and temper the blade. To harden you want to bring it up to nonmagnetic then quench the bevel first in oil once it goes down to black

heat put the whole blade in oil. For the temper put it in an oven at 450 degrees for 1.5 - 2 hours checking it for the temper colors. I took it out of the oven at a bronze and a little bit of purple color. Then we clamped the blade with the tang sticking out so we use the vise as a heat sink and want to heat the tang until all the colors run towards the blade. After that we do the hand sanding up to 400 grit, using pb blaster as lubricant. Finally, we etch the blade after we clean off all oil and dirt we put it in acid to sit for 1 hour and then it was put in a bath of boiling baking soda and water for about 10 minutes.



Matthew Hanvey was the winner of CVBG's scholarship. This article fulfills one of the requirements for scholarship winners—to write an article about their class for the newsletter.

If you'd like to try for the next CVBG scholarship, see the application on page 11.

## GRINDSTONES

of all sizes, mounted and unmounted.

The Cleveland Stone Co., Cleveland, O.

R. 35, Wilshire Bldg.



# Central Virginia Blacksmith Guild

*Celebrating 20 years! - 1998 - 2018*

1600 Valley Rd., Richmond

cvbgboard@gmail.com

## 2018 Board of Directors

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814-769-9464

### Vice President

Julian Cook, Jr.

### Treasurer

Bruce Manson

### Secretary

Tom Chenoweth

### Communications Director

Bob Pennington

### Librarian

Cory Goff

## Meetings

2nd Saturday of the month - 9 am - 1 pm

## In the News

### In Memoriam

It is with heavy hearts that we report that long-time CVBG member Richard Robins passed away September 17 as a result of injuries sustained in a motorcycle accident. Our thoughts and prayers are with his family.

### Iron in the Hat

Just a quick reminder, if you donate a handcrafted item to Iron in the Hat, you'll receive 1 free Iron in the Hat ticket.

### Gift Exchange

Our guild gift exchange item this year will be - cooking utensils! Can't wait to see everyone's forks, spoons, spatulas etc. at Paradise Garage on December 8!

### Elections and Scholarships

Still looking for candidates for the CVBG board elections! This is **your** guild - step up and take a leadership role! Contact one of the current board members for information.

Starting on page 6, you'll find an article by Matthew Hanvey about a class in Damascus knifemaking he took this summer. Winning the CVBG scholarship last year helped make this happen! We'll award our 2019 scholarship at the December meeting; if you're eligible, there's still time to apply. Eligible applicants must be members in good standing of CVBG who have attended several meetings in the past year. Find the application on page 11!



CVBG on the web

[www.cvbg.org](http://www.cvbg.org) • [facebook.com/cvblacksmith/](https://facebook.com/cvblacksmith/)  
[zazzle.com/cvbgstore](https://zazzle.com/cvbgstore)

## November CVBG Meeting at Keith Hicks' Shop

Directions to 17910 Stage Rd., Barhamsville

### From Richmond:

- Take I-64 East to VA-33 towards West Point, Exit 220
- Take VA-33E to 2.6 miles, turn right onto VA-30E
- Take VA-30E 3.8 miles, turn right towards State Rt 632. Almost immediately, turn right again onto State Rt 632. Your destination will be on the right.



Tredegar Ironworks

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## December CVBG Meeting at Paradise Garage

Directions to 14 S. Allen St., Richmond

### From the North and West:

- I-64 E/I-95 S to exit 76B—Belvidere.
- Use the middle lane to turn left onto W. Leigh St.
- In 400 feet, turn right onto N. Belvidere St.
- In a half mile, turn right onto W. Main St.
- In .8 miles, turn left onto S. Allen St. Paradise Garage will be on your right. Park on the street.

### From the South:

- I-95 N to exit 74A—Downtown Expressway (VA-195— this is a toll road.)
- Exit onto Parkwood Ave towards Meadow St.
- In 236 feet, turn right onto Meadow St.
- In 300 feet, turn right onto W. Cary St.
- 1/10 of a mile, turn left onto Allen Ave. Park on the street.

Remembering Richard Robins



## CVBG Scholarship Application – 2019

Each year, CVBG awards a scholarship of up to \$500 to a member to be used for a blacksmithing or related class, or to attend a blacksmithing conference or seminar. The scholarship must be used within 1 year of its being awarded; in certain circumstances this deadline may be extended. Scholarship recipients agree to demonstrate what they've learned at a CVBG meeting within a year of their class, and to write an article about the class for the newsletter. Scholarship winners will also head up next year's scholarship committee. One scholarship will be awarded at the December 2018 meeting.

Eligible applicants are members in good standing with the Guild who have attended several meetings within the last year. If you meet these requirements and would like to apply, please complete the application below and **MAIL** to:

CVBG  
2390 Yarnell Road  
Henrico, VA 23231  
ATTN: Scholarship

Name:

Phone:

Email:

Years in the Guild:

How will you use the scholarship?

# Southwest Virginia Blacksmith Guild

swvabg@gmail.com

Serving Roanoke, Bedford, Blacksburg, Christiansburg, and all of southwestern Virginia

## 2018 Board of Directors

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Joshua Langfitt

### Vice President

Eric Collins

### Treasurer

Henry Bryant

### Secretaries

Gabrielle Judy and Matt Heffernan

Find us on  
Facebook!

[www.swvabg.org](http://www.swvabg.org)



Doug Connel's vise

## Meetings

3rd Sunday of the month - 2 - 4 pm

Meetings are held at either:

Great Road Craft Guild

1812 Big Spring Dr.

Elliston, VA 24087

Or

Historic Smithfield Plantation

1000 Smithfield Plantation Rd.

Blacksburg, VA 24060

(completely surrounded by the Virginia Tech campus)

## In the News

### Happy News!

Congratulations! to Matt Heffernan and Gabrielle Judy on the announcement of their engagement! Wishing you both a lifetime of joy!



Robert Jaeger's Hummingbird

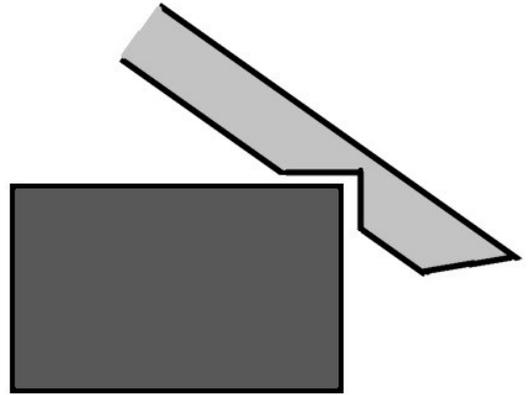
## Forging a Tasting Ladle

This was one of my first projects when I started blacksmithing in the last century, and one of the early lessons in our Blacksmith Boot Camp class. It's a great way to start thinking in 3 dimensions, and helps build hammer control.

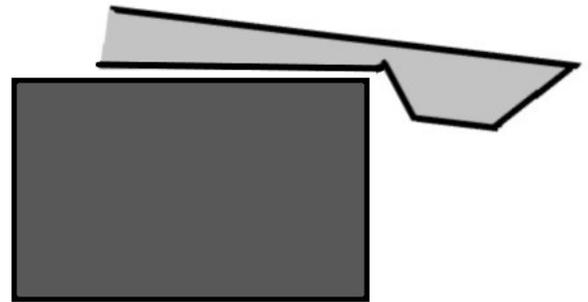
Start with a 6" piece of 1/2" square stock. Upset a blunt taper on 1 end.



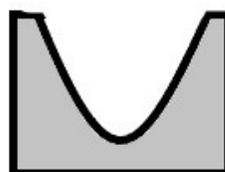
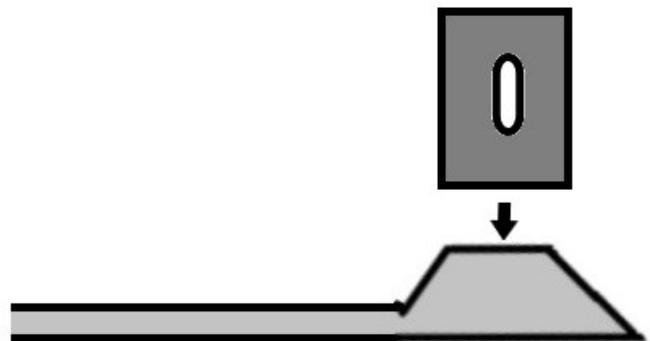
Turn the piece over. Drive the piece into the anvil, at an angle, to form a complementary taper about 1 1/4" - 1 1/2" back from the first taper.



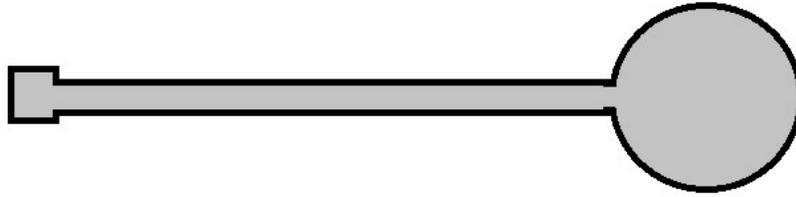
Drop your tong hand down, then hammer the back taper shallower. Work this down to make the handle (you can leave a "blob" at the opposite end for a bean or hanger, if you like.)



Flip the spoon over, and use the pien of the hammer to start spreading the blank for the bowl. Concentrate the blows in the center of the "bowl mass" to establish the depth.

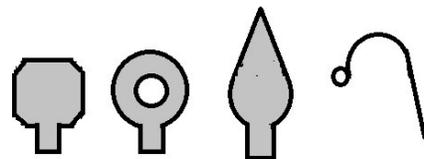
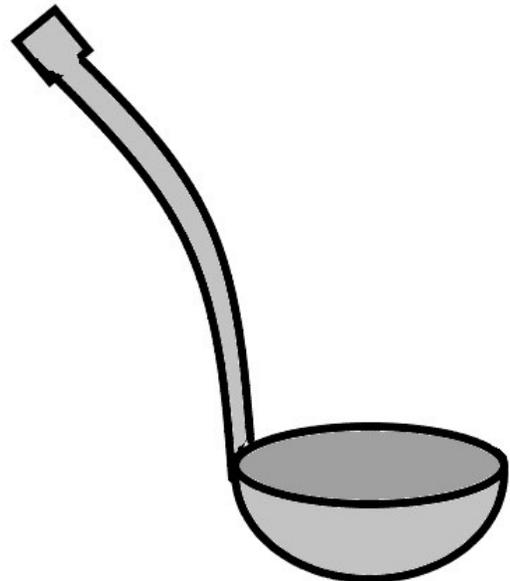


Spread the rest of the mass to form the “bowl blank.” Use the pisen of the hammer. Try to do this not by moving the hammer from side to side, but by hammering the same area on the anvil, moving the piece beneath it. Try rotating the blank under the hammer, with the center of the bowl being the pivot point as you move the blank around. Be careful to avoid any cold shunts. You’ll end up with something like this.



From here on, you’re essentially forging sheet metal, so monitor your heats closely to avoid burning. Using a ball pisen, sink the bowl in a swage. If you don’t have a swage, carve or hammer a circular depression into a piece of hardwood (preferably end grain.) It won’t last as long, but will work just fine. Curve the handle into a graceful arc, making the ladle, well, ladle-like.

Then there’s the matter of what to do with the finial (the end opposite of the bowl.) There are a lot of options. You could simply file down the corners, making it into a faceted ball. Those look quite elegant. You could hammer in the corners to make a ball, then take it even further, flatten the ball and punch a hole in it. One of my favorite ways to treat this is to draw it to a point, then spread to make a leaf or flame shape. Scroll the leaf over to make a hanging hook. Some students forego the blob on the end altogether, just drawing the handle to a point then forging a hook. There are thousands of other things you can do. Come up with something cool, and surprise us!



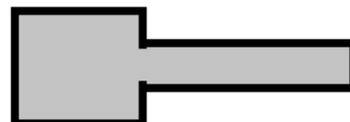
# No Rivet Required

## *Forging the 1-piece Spatula*

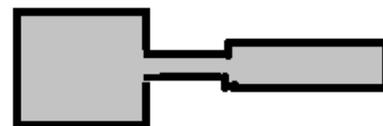
At some point, almost all of us have or will decide to forge out some cooking utensils. So we'll forge out a beautiful handle, leave a flat spot, punch (or more likely, drill) a couple holes, then rivet on a blade and call it a spatula (or a bowl to a ladle, etc.) There's absolutely nothing wrong with this approach! It gets the job done, often with satisfying results. You'll find plenty of historic examples where this is the exact approach was taken. It's completely legitimate. But...

We're blacksmiths. We move hot iron with hammer and anvil and we know we don't have to go down this path. That you can make the same—or better—spatula from one piece of steel. And that by doing so, we build our skills to be applied to a future project.

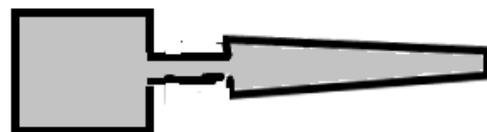
Start with a piece of 1/4" x 1 1/2" or 1 1/4" flat bar. Working over the horn, draw out a long nub, about 3/4" wide and 9-10" long. This will become the handle.



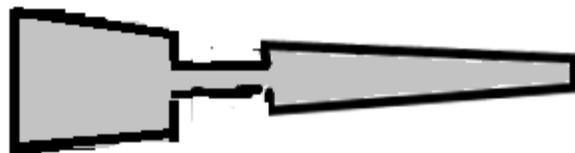
Again over the horn, neck down about 3" of the handle, nearest to the parent stock until it's about 3/8" dia. Knock the corners off this section, then round (or, don't round. The faceted look is pretty, too.)



Forge a slight taper on the "wide" part of the handle, so that the part closest to the parent stock is wider than the end of the handle. (Taper in illustration is exaggerated; make it less severe.) Forge a simple hook on the end (see *Forging a Flesh Fork* in the Sept. issue.) Slightly bevel the edges of the handle.



Cut the spatula from the parent, leaving about 2" of the parent stock to become the blade. Slightly taper the blade so that the part closer to the handle is narrower than the part farther away. It will look like a truncated pyramid.



Using the pisen, draw out the blade of the spatula. Start by concentrating on the center to establish the final thickness (about as thick as half a chainsaw bar,) then draw out from there to the sides. Once you're satisfied with the width, take a couple heats and, using the pisen again, draw out more length for the blade. Remember, you're essentially forging sheet metal at this point, so watch your heats! Finish by planishing out the hammer marks in the blade at a low heat.



Clamp the blade in the vise, and bend it about 30—35 degrees from the handle. Curve the handle into a graceful arc. Clean up the edges with a file; finish with mineral oil.



# VIRGINIA INSTITUTE OF BLACKSMITHING

200 W. 12th St., Waynesboro, VA 434-960-9718 [vablacksmithing.org](http://vablacksmithing.org)

## Dec 8—9 — Build a Hatchet

Build your own hatchet! This course will cover forge welding, lamination, mechanical joining, and tool making. A handle will be provided so students can leave with a complete tool. This course is suitable for the ambitious novice or the experienced beginner.

## Dec 15—16 — Blacksmith's Knife

Learn to forge a knife in this two day, blacksmithing centered, knife making class! The first day, you will start on the forge and anvil where you'll be shown how to shape a knife blank with the hammer and anvil. The second day will be spent shaping and honing the knife blank on knife grinders into a sharpened tool. You will be provided with oak handle scales and copper pins to complete your knife. The goal is for you to leave with a finished, working knife. *This is NOT an ABS class!*

## Dec 29 —30—Build a Spear

Make a spear head. This is a beginning level course suitable for the novice and up. There will be a lot of hot forge work in this class. A dowel will be provided for each spear head.

## Jan 7—18 — ABS Intro to Bladesmithing with Scott McGhee

## Jan 12—13 — Build a Shield

## Jan 19—20 — Blacksmith's Knife—Chopper

## Jan 26—27 — Build a Hatchet

## Feb 9—10 — Pattern Welded Damascus

## Feb 16—17 — Firetools for the Home

## Feb 23—24 — Build a Hatchet

Visit [vablacksmithing.org](http://vablacksmithing.org) for more information!

## **Coming Soon to the Banton-Smith Center!**

### **January 19 & 20 - 9 a.m. to 5 p.m. - Blacksmith Boot Camp** CVBG Members - \$200

Basic training for blacksmiths! You'll make several projects for the home, kitchen and workshop, all while being introduced to many of the most common techniques used in blacksmithing: drawing, upsetting, bending, cutting and punching, heat treating and forge welding. And you'll have fun doing it!

#### **Other Sessions of Blacksmith Boot Camp:**

May 4 & 5 • July 20 & 21 • Oct 19 & 20

### **February 10 - 10 a.m - 2 p.m. - Introduction to Blacksmithing** CVBG Members - \$25

Always wanted to try blacksmithing? Here's your chance! The class will cover the tools of the trade, safety, and basic techniques. This will be a hands-on class; everyone will go home with a completed project! CVBG members, your tuition will be applied to your 2019 guild dues.

#### **Other Sessions of Introduction to Blacksmithing:**

May 18 • Aug 17 • Nov 16

### **March 16 & 17 - 9 a.m. - 5 p.m. - Smithing Made Simple** CVBG Members - \$200

With Caitlin Morris

Discover the magic of moving hot metal! Learn the basic skills through simple and practical projects. Individualized instruction will help you feel strong, confident, and comfortable in the workshop. Open to all skill levels and abilities.

### **April 6 & 7 - 9 a.m. - 5 p.m. - Forged Fashion with Ellen Durkan** CVBG Members - \$200

Class will focus on making something wearable. We will go over various forging, forming, riveting techniques. We will discuss design ideas and how to complete them, feel free to come with a design in mind or just sort it out as you learn new techniques and how to apply them. Class welcomes both beginners and advanced students.

### **June 22 & 23 - 9 a.m. - 5 p.m. - Creative Caffeine w/Caitlin Morris** CVBG Members - \$200

Get inspired! Focus on design, learn new techniques, and take your existing skills to the next level through a series of creative challenges based around a simple, functional project. Geared towards students with some experience, but all skill levels are welcome!

## **Banton-Smith Center for Blacksmith & Metal Arts**

1600 Valley Road, Richmond

*New events are added all the time! For more information on these or any other Banton-Smith Center events, visit [facebook.com/BantonSmithCenter](https://facebook.com/BantonSmithCenter), or contact Jerry at [bantonsmith.center@gmail.com](mailto:bantonsmith.center@gmail.com) or 540.872.3729*

### Banton-Smith Center Wish List

Thinking about downsizing, or upgrading? The Banton-Smith Center is the perfect place to give your old tools new life. We gladly accept donations and loans of tools and equipment in good working order. Here's a few specific things we're looking for:

- Porta-band
- Press
- Plasma Cutter
- 2 X 72 Belt Grinder
- Gas Saver for Oxy-Acetylene torch
- Tongs. We always need tongs. ALWAYS.
- 4" or 4 1/2" angle grinders
- Variable speed buffer
- Anvils
- Forges

Thanks for thinking of us!



"RR Spike Knife" by Nick Rossi. Blade is 1084, forge welded to a HC marked railroad spike handle

## CVBG Membership Application

Name:	H#	M#
Street:	Email:	
City:	State:	ZIP:
Are you willing to host a CVBG gathering?	Yes___ No___	ABANA Member Yes___ No___
Are you willing to demonstrate for a CVBG gathering?	Yes___ No___	
Suggestions for CVBG demonstrations: _____ _____		
Are you a: Professional___ Hobbyist___ Just interested___ Other_____		
<b>Central Virginia Blacksmith Guild Liability Release Form</b> <p>I, the undersigned, realizing the potential hazards involved in the craft of blacksmithing, will not hold the Central Virginia Blacksmith Guild, it's officers, demonstrator(s), or host(s) responsible in the event of any accident or injury incurred during an association function or at any time a sponsored activity concerning blacksmithing or metalworking is occurring. I am aware of the requirement to wear safety glasses during association demonstrations and will do so. I am aware also of the possibility of hearing damage due to the nature of the craft and accept the responsibility of taking the necessary steps to protect my hearing. It will be my responsibility to inform any family member or guest that I may bring to a demonstration of these potential dangers and advise them of all necessary precautions.</p>		
Signature _____		Date _____
<b>RETURN COMPLETED FORM TO-</b> CVBG Karen Smart 2705 Buckhorn Hills Maidens, VA 23102		<b>DUES= \$25</b>

## SWVABG Membership Application

Name:	Home#	Cell#:
Street:	Email:	
City:	State:	Zip:
<b>Southwest Virginia Blacksmith Guild Liability Release Form</b> <p>I, the undersigned, realizing the potential hazards involved in the craft of blacksmithing, will not hold the Southwest Virginia Blacksmith Guild, it's officers, demonstrator(s), or host(s) responsible in the event of any accident or injury incurred during an association function or at any time a sponsored activity concerning blacksmithing or metalworking is occurring. I am aware of the requirement to wear safety glasses during association demonstrations and will do so. I am aware also of the possibility of hearing damage due to the nature of the craft and accept the responsibility of taking the necessary steps to protect my hearing. It will be my responsibility to inform any family member or guest that I may bring to a demonstration of these potential dangers and advise them of all necessary precautions.</p>		
Signature _____		Date _____
<b>RETURN COMPLETED FORM TO-</b> SWVABG 6585 Stoneskeep Lane Elliston, VA 24087	<b>DUES= \$5</b> make check payable to Henry Bryant	

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