

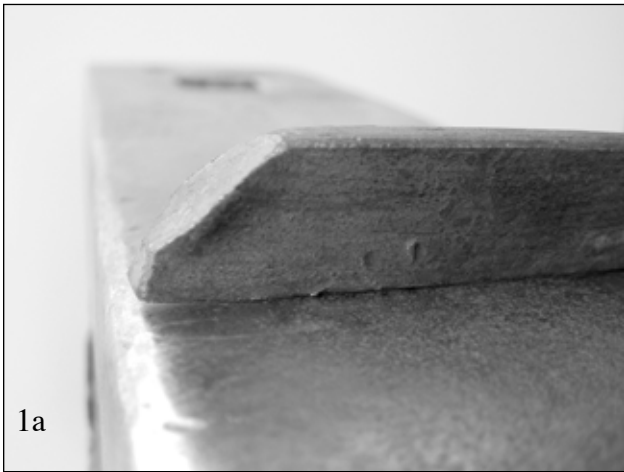
The Beveled Leaf Scroll.

Article to suport ABANA's National Curriculum
Mark Aspery 2011

This scroll is found in the grill project of
ABANA's national curriculum.

The ABANA grill project calls for water leaves
to be added to each scroll about 5 inches from the
scroll tip. This article will concentrate on mak-
ing the scroll end and turning the simple scroll. A
future Hammer's Blow article will focus upon the
turning of the scroll/leaf combination.

Forge a short point on the end of the bar. The
taper will be flat on one side and curved on the
other. Thin the point down as it adds to the effect.
Try to keep the taper no longer than the width of
the parent bar-stock. Step 1 - 1-C below.

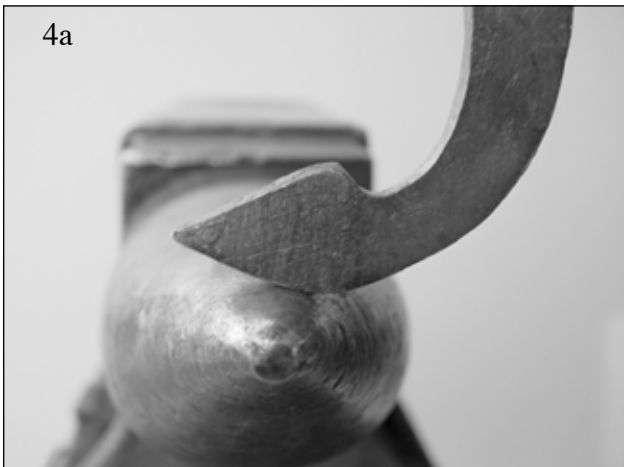


Next, define the leaf by forging a set transition.
Shown is a half faced blow over the offside edge
of the anvil, but this could equally be forged
over the bick to produce a slower transition. The
important thing to remember here is to keep the
leaf short; perhaps the width of the bar stock. The
leaf may look a little small after this move, but the
leaf will, dare I say, "grow" during the beveling
process. Steps 2 through 2B.





After defining the leaf, the bar needs to be bent through approximately 90-degrees. Keep this bend short, within an inch to an inch and a half, just behind the leaf. Step 3 through 3B below. These type of scroll are one sided, there are two of each within the grill. If you place the leaf on the anvil with the bend going to the left, you will forge a left branching scroll and of course visa versa. The example shown is for a left branching scroll.



At this time the leaf portion of the scroll needs to be blown back. This can be done later with a pair of scrolling tongs, but you run the risk of gauling the leaf with the tongs. Step 4 through 4B. Decide on the direction of your scroll and using a ball-faced hammer, chamfer the edges.

Note that chamfering the outside edge will tighten the bend while chamfering the inside edge will open it. It would be nice if, after chamfering, the bend were returned to its original position. Step 5 through 5B show the bevel.



In order to better understand how to scroll this type of scroll, get a piece of cardboard (a breakfast cereal box will do nicely) and draw the outline of your forged scroll on the cardboard. Cut the cardboard scroll out with a pair of scissors.

Holding the cardboard in one hand between the thumb and forefinger, start about halfway down the leaf and make a bend 90-degess perpendicular to the center line of the leaf. Feed out about 1/4-inch and do the same thing again. Continue this along the entire scroll.

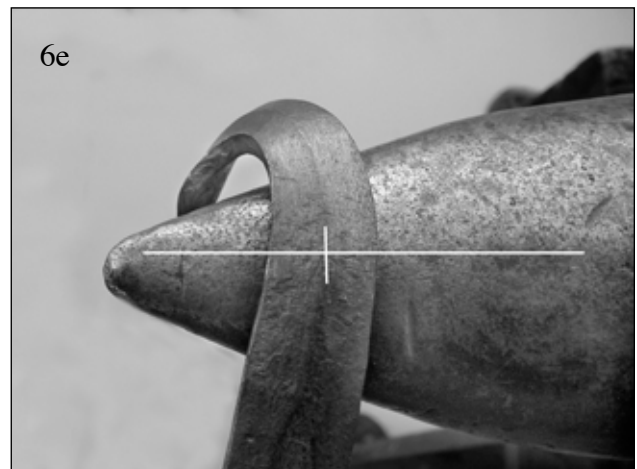
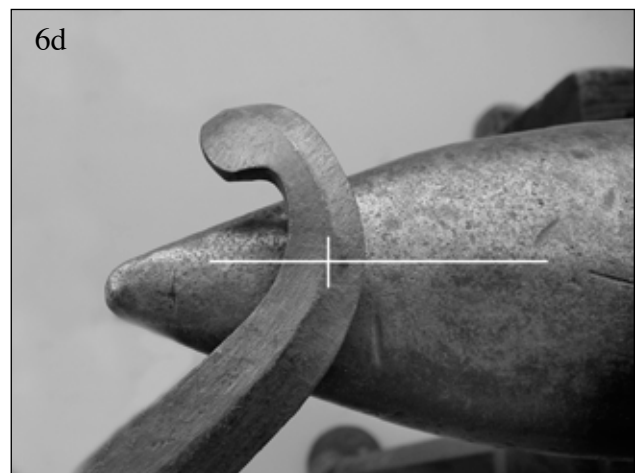
You should find that the leaf and the bend have made a slow 90-degree turn and are now resting in line with the rest of the scroll. That knowledge helps you when you go to the anvil.

You can turn these scrolls off the side of the face of the anvil if you didn't need the clearance for the turning leaf.

As such, we turn these scrolls on the end of the bick as it allows us the clearance that we need for the turning leaf and scroll.

As you feed the leaf and scroll over the bick, make sure that you keep the centerline of the scroll 90-degrees to the centerline of the bick.

I like to use a small leather mallet here in order to protect the bevel line. Step 6 through 6e

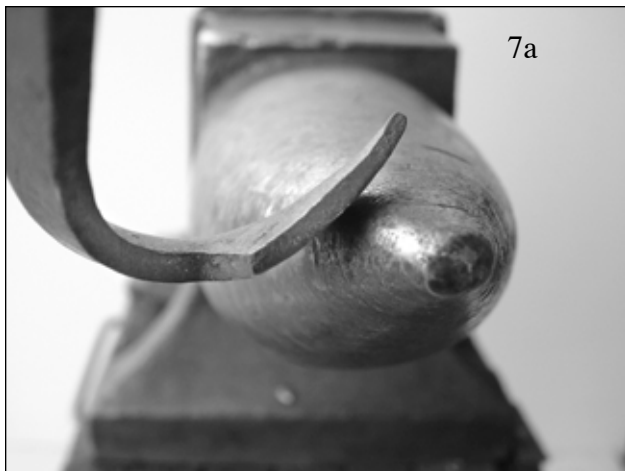
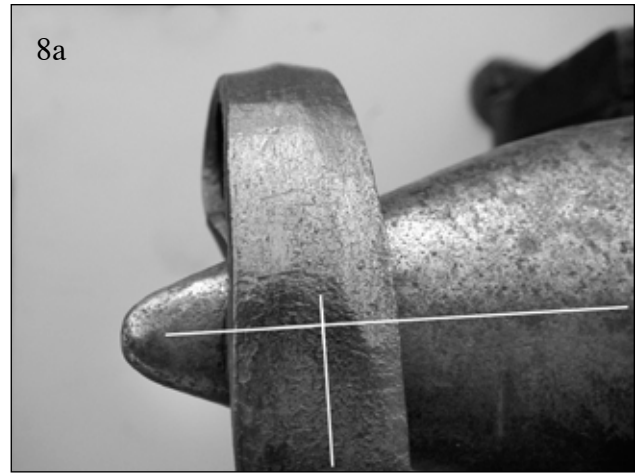


Before you turn the complete scroll, stop and bend the tip of the leaf back in the other direction.

This move can sometimes cause a bit of frustration. Rest the leaf on the end of the bick and make sure that you do not move the hand holding the scroll as you bend the leaf.

Moving your hand now can cause the scroll to open rather than the tip of the leaf to bend. If you are having problems, consider quenching the bend of the scroll up to 1/4 way up the leaf and then give it a go. Step 7 and 7 B

Re-heat the scroll and continue to bend. At some point you may want to continue scrolling using either a dog wrench and horns or with a pair of scrolling tongs. Step 8 with 8 b showing the point at which the use of scrolling forks (dog wrench) and tongs can become useful.



The 'C' Scroll above used slightly longer leaves than the process previously described.

The ABANA grill has a water leaf welded to each scroll about 5 or so inches from the tip of the scroll. This does add to the degree of difficulty in turning the scroll, making it a more tool intensive process.