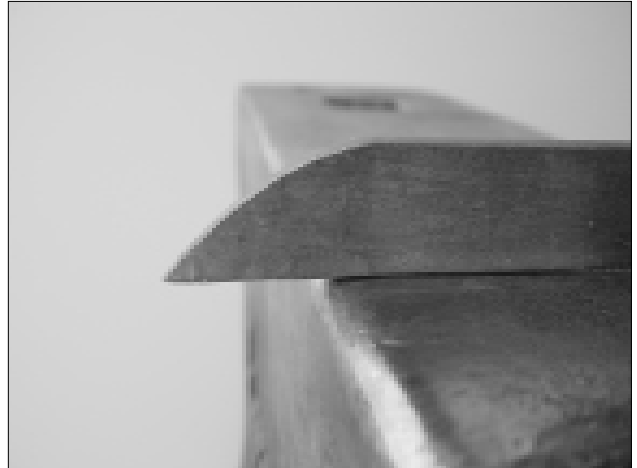


The Beveled Leaf Scroll.
Mark Aspery School of Blacksmithing.
www.markaspery.net
Concept article only (Not finished)
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I find this scroll to be one of the most pleasing of the scroll ends. It does have a few steps to its manufacture, but the result is worth the effort. Forge a short point on the end of the bar. The taper will be flat on one side and curved on the other. I also thin the point down a little as it adds to the effect. Try to keep the taper fairly short, not much longer than the width of the parent bar-stock. Step 1 through Step 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.



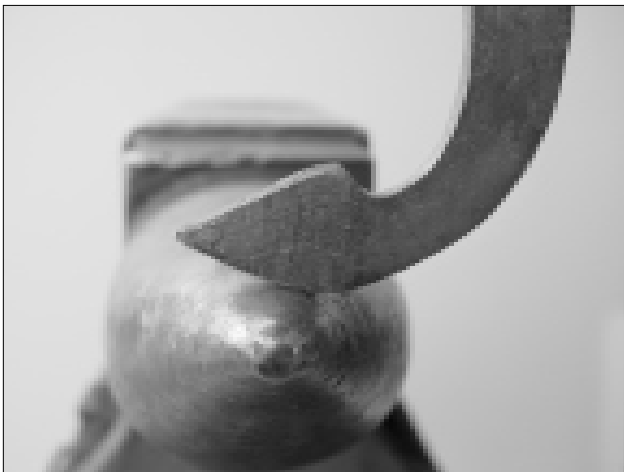
After defining the leaf, the bar needs to be bent through approximately 90-degrees. Keep this bend short, within an inch to an inch and a half, just behind the leaf. Step 3 through 3B below.





These type of scroll are one sided, and a decision must be made as to which way the scroll will turn. 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.

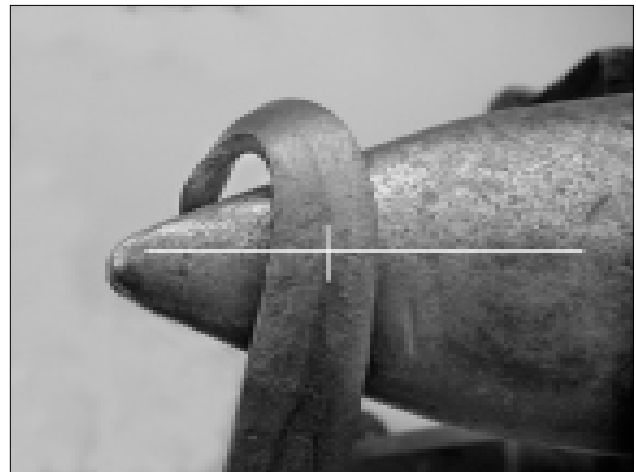
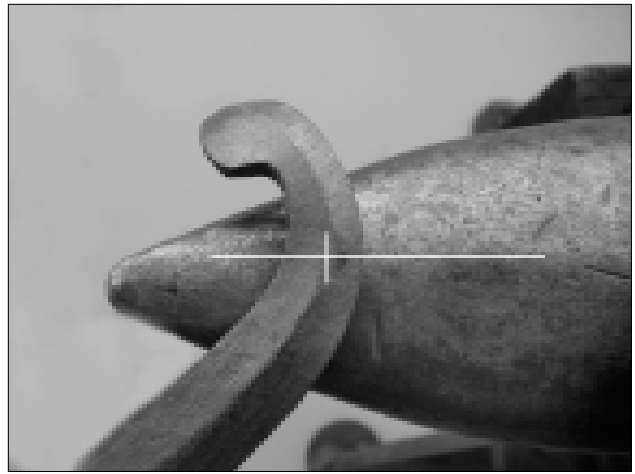


And now to the scrolling part. In order to better understand how to scroll this type of scroll, get a piece of cardboard (a breakfast cereal box will do nicely) and draw the outline of your forged scroll on the cardboard. Cut the cardboard scroll out with a pair of scissors.

Holding the cardboard in one hand between the thumb and forefinger, start about halfway down the leaf and make a bend 90-degess to the center-line of the leaf. Feed out about 1/4-inch and do the same thing. 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 line of the adjoining-bevels. Step 6 through 6F



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

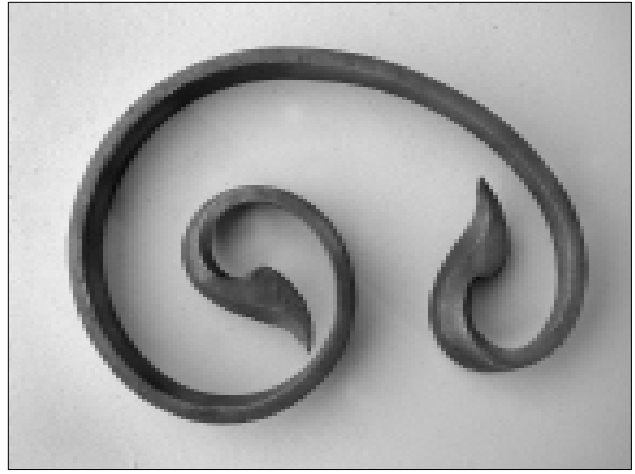


Step 7

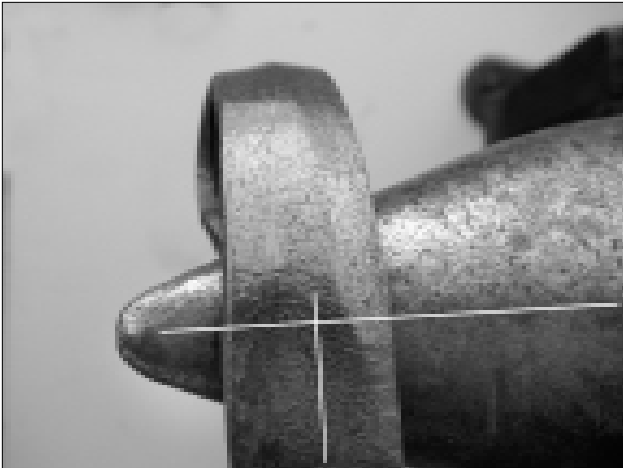


Step 7 B

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.



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



Step 6 F



Result of step 6