

# A ROSE DOOR KNOCKER

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### Material needed:

- Item #1 1/2 x 3/16 x 15 inches
- Item #2 1/2 x 1/2 x 1-3/4 inches
- Item #3 1/2 x 1/2 x 3/8
- Item #4 A Disc of 18 gauge x 2-1/8 Dia.
- Item #5 A Disc of 18 gauge x 2-3/8 Dia.
- Item #6 A Disc of 18 gauge x 2-5/8 Dia.
- Item #7 A Double headed "Staging" nail
- Item #8 2 #8d nails
- Item #9 1/8 x 2 x 10 to 12" long

### Procedure:

Step #1 - Flatten one end of Item #1 to a fan shape keeping taper uniform. *See figure 1 at right*

Step #2 - on other end of above piece, turn on edge and forge flat 1/8 thick x 1/2" wide (length unimportant), but flat must be 90 degrees from rest of bar. Scroll fan end into spiral and drill 3/16 hole through the flat on other end. *See figure 2 at right.*

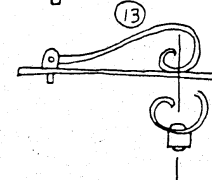
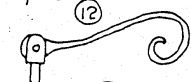
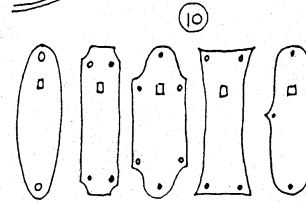
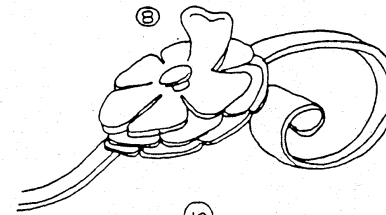
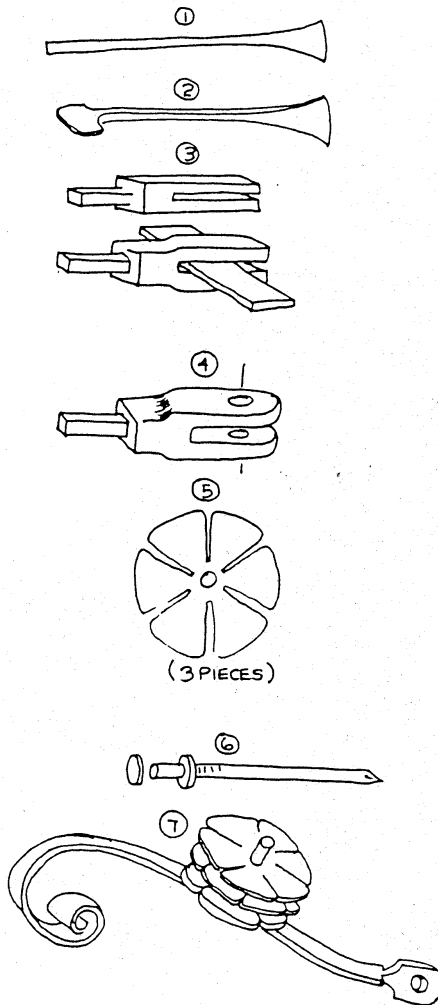
Step #3 - On a piece of 1/2 square (to make Item #2), forge a 1/4" tenon. Cut off at 1 3/4" (excluding tenon length). Saw a slot in the end 3/4" deep, heat and spread, forge over 1/8" stock to form *Figure 3 at right*. Drill 9/64 in center of split.

Step #4 - Mark center of Item #3 and drill with 9/64 hole. *See figure 4 at right.*

Step #5 - Mark discs (items #4,5, and 6) in 6 equal segments and drill center with 3/16 hole. Snip or saw to within 1/4" of the hole. Round corners of each segment with snips or file. *See figure 5 at right.*

Step #6 - Cut top head from Staging nail. Center punch center of scroll and drill 3/16" hole. Place the nail in the hole, measure for length to cut the nail for use as a rivet

Step #7 - With cuts in the discs staggered, place them on the top part of nail and form rivet head on both ends of the nail. *See figure 7 at right.*



Step #8 - With an acetylene torch or carefully in the forge so as not to burn the thin discs, heat them and bend each petal of the top disc upward with needle nose pliers. Carefully bend each disc segment into a natural, cup shaped, rose petal. Repeat the process with the center then the lower disk. *See figure 8 at left.*

Step #9 - Check the rivet for tightness and rest if necessary.

Step #10 - Lay out a pleasing design on the base plate (Item #9 in the materials list). *See figure 10 for examples.* Mark, center punch, and drill the mounting holes in the back plate. Decorate as desired with hammer texture, engraving, beveling or what ever you find attractive.

Step #11 - Punch a 1/4" square hole in the backing plate near the top center of the plate leaving at least the length of the scrolled piece from the hole to the bottom edge of the backing plate. *See figure 11 at left.*

Step #12 - Take the split and tenoned piece made in Step #3, and rivet it in place on the scroll.

Step #13 - Place the scroll on the back plate and mark the point on the scroll where it contacts the back plate. Drill a hole in the scroll at the mark and using a #8 nit with the head on the inside of the scroll, rivet the small block (Item # to it.

Step #14 - Clamp top of scroll in vice and rivet the tenon in the hole in the back plate.

Step #15 - Cleanup as necessary with a file and apply finish of your choice.

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An Example of this project from IronFlower Forge