

# Metal Daisy

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My wife loves flowers. When she suggested that we ought to replace the drapes on our front door, I volunteered to make a curtain rod with flower finials. Figure 1 depicts one of the finials, it is modeled after a design we saw on a garden gate in Germany. The bloom on the gate was welded to the stem, something I wanted to avoid. This turned out to be an interesting challenge.



Figure 1: Metal daisy

For materials, you need a 9" garden spike and a 4"x 4" piece of sheet metal, about 1/8" thick. Figure 3 shows the pattern that you need to cut (reduced by about 25% so that it fits on this page.) It helps to round out the space between the petals with an angle grinder. Once cut, you are ready to forge the bloom into shape. Begin by progressively flattening the petals. This will give the edges a more delicate appearance and will widen the petals. This step will also close up the space between the petals.

A cross-peen hammer will do as a fuller for putting the patterns into the petals. Since our swage block does not have the appropriate form, we used a slightly rotten stump as our swage block and a large ball-peen hammer as our fuller to form the cup in the center of the bloom. (Tex

came up with this idea.) You are now ready to gently bend the petals. Punch or drill a hole in the center of the bloom ensuring that the spike fits snugly.



Figure 2: Upset stem

Attaching the stem to the bloom took several attempts. In one of them, I cut the spike head and formed a tendon. While this worked, the resulting head was much smaller than the original spike head and was out of proportion with the bloom.

I ended up cutting the spike about 3/4" from the head and ground down the remaining shank so that I could cut a 1/4 coarse thread onto it. I upset the cut end of the spike, drilled a hole in it and tapped it. Not my favorite solution, but it works. The result can be seen in figure 2.

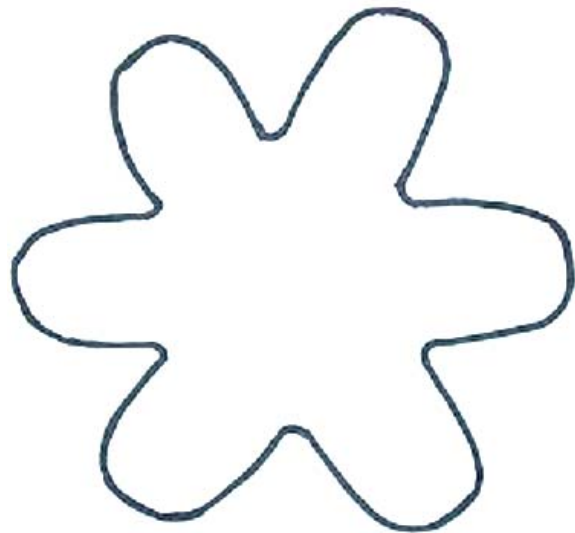


Figure 3: Bloom pattern (reduced by 25%)