

Saltfork Craftsmen Artist-Blacksmith Association

November 2011

Conference Special



Teresa Gabrish with the “Peoples Choice” Winner at the 2011 SCABA Conference. This piece was created using an amethyst cathedral a copper cross and rose vine. It has LED lights installed in the base to add accent lighting that shines up through the crystals.

President's Notes

Gerald Franklin



Our 15th Annual Conference is behind us now and again, it proved to be a real winner. We were treated to fine demonstrations by Mark Aspery and Brent Bailey, both from California. They really worked hard to put on a good show for the attendees and if you missed the conference you missed an excellent learning experience. In addition to the fine demonstrators, we were joined by several vendors who brought a good assortment of smithing supplies, books, and, of course, tools. Tailgating was excellent. I don't think I've seen more different tailgaters offering as much stuff as we had this year.

Participation in the toolbox raffle, Iron-in-the Hat raffle, and the auctions was impressive and represented a good level of support for the club.

Tammy Cowart, our Registrar reported a total of 121 separate registrations and many more individual attendees for the conference. I feel that these numbers reflect the quality of the demonstrators and the hospitality provided by the conference volunteers. I want to thank all the members who put out so much effort in making this event the success that it was and I want to thank all of you who came to the conference to visit and to learn.

We made some presentations at lunch on Saturday to recognize the efforts of some of the individuals who make Saltfork what it is. Dan Cowart presented a gift certificate from Pieh Tool Co. to Charlie McDevitt of Comanche, OK for winning the T-Shirt design contest.



We did a re-presentation of the award presented to Mike George at the last Saltfork picnic recognizing his over sixteen years of service on the Board of Directors and as Secretary-Treasurer during that period. The first plaque presented was the wrong size. This is one award that was just as good for me the second time around as it was the first time. Thanks again, Mike for your years of hard work.

The last award presented was a new award called the Mike George Award for Meritorious Service. This is an award that is presented without any schedule associated with it to a person who has provided the club with outstanding service. Mike graciously agreed to allow us to use his name on the award and I can think of no name more appropriate. The very first Mike George Award for Meritorious Service was presented to Diana Davis. The citation reads as follows:



The Mike George Award for Meritorious Service

is presented to DIANA DAVIS for her constant and multi-talented service to the organization. In her over fifteen years of Saltfork membership, Diana has unselfishly provided her talents, leadership, and hard work to improve the club. Her efforts have been instrumental to making the association a success and serve as an example to all members.

Given this day, October 15, 2011 by the Saltfork Board of Directors.

Just as I can think of no more appropriate name for the award, I can think of no more appropriate recipient for the first award. It will be tough to come up with a deserving candidate for a subsequent award who matches the height of the bar that Diana has set. Thanks again, Diana for your years of service to Saltfork.



SOUTH CENTRAL REGIONAL PAGE

Meeting dates

January 21, 2012

Host:
Phone #

February 18, 2012

Host: Gerald Franklin
Phone #: 580-252-6002
Trade item: feather

March 17, 2012

Host:
Phone #
Trade Item:
Lunch:

April, 2011 (ANNUAL PICNIC)?

Host:
Phone #

May 19, 2012

Host:
Phone #
Trade item:

June 16, 2012

Host:
Trade items
Lunch:

July 21, 2012

Host:
Phone #
Trade item:

August 18, 2012

Host:
Phone #
Trade item:

Sept. 15, 2012

Host:
Phone #:
Trade item:

October 21-21, 2012
SCABA Conf. Perry, Okla.

November 19, 2011
Host: Bill and Diana Davis
Phone #: 580-549-6824
Trade item: basic blacksmithing project (see notes)

December 17 2011
Host: Gerald Franklin
Trade item; Wall hook

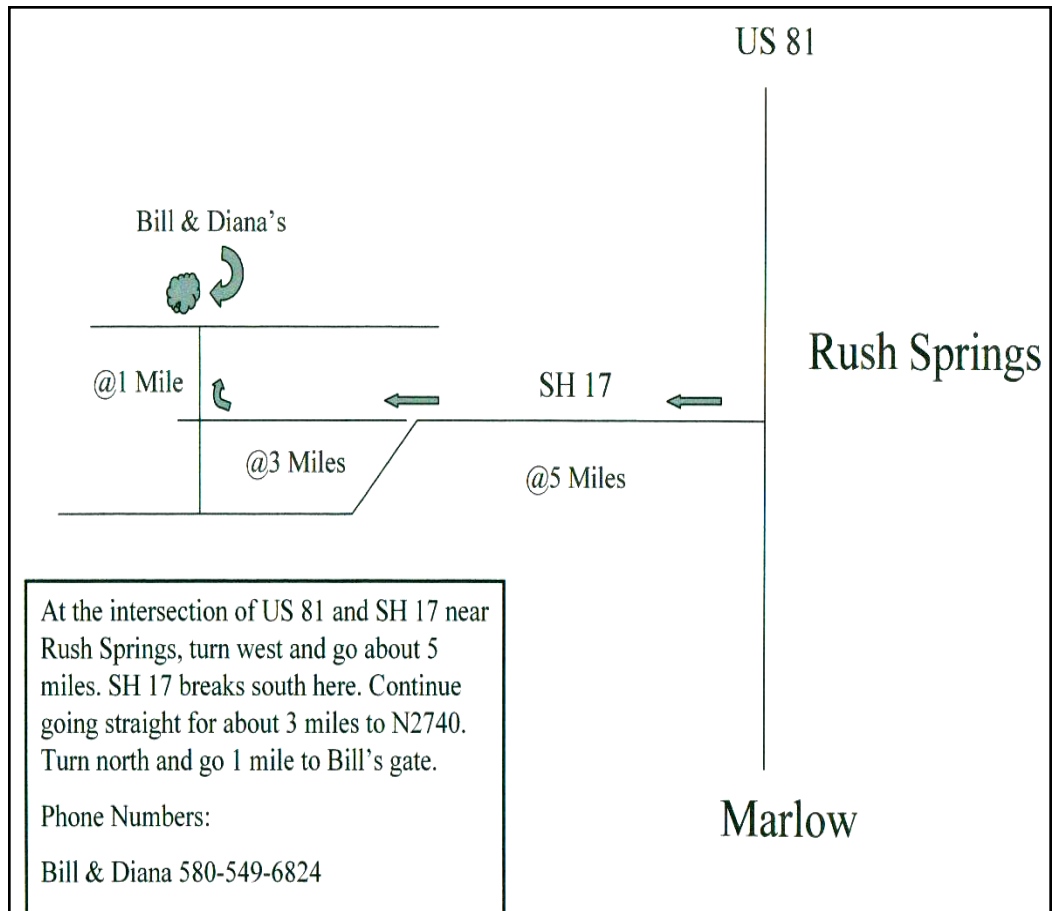
Meeting Notes:

No meeting in Oct. due to conference....

Next meeting will be at Bill and Diana Davis home west of Rush Springs in November. The trade item is any item that includes at least 3 of the following basic skills:

Taper
Twist
Scroll/curl
90 degree bend
Rivet

Lunch will be provided.



NORTH EAST REGIONAL PAGE

Meeting dates:

January 14, 2012

Host: Bill Kendall
Phone # 918-742-7836
Lunch: Sack lunch or on own

February 11, 2012

Host:
Phone#
Trade item.

March 10, 2012

Host:
Trade items:

April 14, 2012

Host:
Trade items:

May 12, 2012

Host:
Phone #:
Trade item;

June 9, 2012

Host:
Phone #
Trade item:

July 14, 2012

Host:
Phone #
Trade item;

August 11, 2012

Host:
Phone#
Trade item

Sept. 8, 2012

Host:
Phone #
Trade item:

October 20-21 2012 State conference

November 12, 2011

Host: Matt Goyer
Phone # 918-272-8424
Trade item: Christmas tree ornament

December 10, 2011

Host: Charlie McGee
Phone #: 918-245-7279
Trade item: ladle

No meeting in October.

Next meeting will be at Matt Goyers place near Owasso, Okla.

The meal will be provided. Matt plans to serve smoked meat. Bring a side dish to help out.

The trade item is a Christmas tree ornament.

Directions to Matt Goyer's place

Exit hwy 169 at 96th N and go east to 177th St. east Ave. (Approx. 3 miles).

Turn right on 177th St. and travel approximately 1/2 mile (up a slight hill). Take the 1st Right. (onto 90th N) We are the 3rd house on the left.

Address: 17578 E. 90th St. N

918-272-8424

Bring your equipment and enjoy the day.

NORTH WEST REGIONAL PAGE

January 28, 2012

Host:
Phone#
Trade item;

February 25th, 2012

Host:
Phone #

March 24, 2012

Host: Eddie Horton
Phone #:
Trade item; Campfire Tool
Location; Fort Supply

April 28, 2012

Host: Tom Nelson
Phone #
Trade item:
Lunch: Sack lunch or on own

May 26, 2012

Host:
Phone #

June 23, 2012

Host:
Phone #:
Trade item;

July 28, 2012

Host:
Phone #:
Trade item:

August 25, 2012

Host:
Phone #:

Sept. 22, 2012

Host:
Phone #:
Trade item;

October 20-21 2012 State conference

November 26, 2011

Host: Ron Lehenbauer
At Fairview
Lunch: Sack lunch or on own

December 24, 2011 Merry Christmas

Chuck Wagon Cook off.

On Saturday the 1st of October SCABA members were invited to a Chuck Wagon Cook off in Nowata at the First Church of God. The weather was great and the food was even better. We had lots of interest and sold several items mostly crosses if we didn't give them to the kids. As you can see in the pictures there was lots of fun. There was an auction, hay rides and booths to buy things from Jacob even had an artist draw his picture while he was working.

Day Cowart



SOUTH EAST REGIONAL PAGES

January 7th 2012

Host:
Phone:

February 7, 2012

Host: Eddie Horton (Ft. Towson)
Phone #: 580-873-2634
Trade item: Heart

March 4, 2012

Host: Eddie Horton (Ft. Towson)
Phone #: 580-873-2634
Trade item: Leaf or Flower

April 7, 2012

Host:
Phone #:

May 5, 2012

Host:
Phone #
Trade item:

June 2, 2012

Host:
Trade item

July 7, 2012

Host:
Phone #:

August 4, 2012

Host:
Phone #:
Trade item:

Sept. 1, 2012

Host:
Phone

October 20-21, 2012

SCABA Conference

November 5, 2011

Host: Eddie Horton at Peter Conser Historic home
SW of Heavener, Ok
Phone #:

December 3, 2011

Host:

November meeting for the SE region will be hosted by Eddie Horton at the Historic Peter Conser home SW of Heavener Ok. Lunch will be Dutch oven cooked. Contact Eddie for more information at 580-873-2601.

Better late than never....

August meeting report.

The August Southeast Regional meeting was Hosted by Bill Phillips and held at his ranch near Indianola. It was a sunny and warm day but turnout was light. I figured the fish were biting. Those in attendance were Bill Phillips, Frank Dean, Ed McCormack, Hugh Harden, Ronnie Smith, Mike Smith, Doyle Smith, Cecil Craig, Ken Taylor and I. The trade item was something with a rabbit head. Several were brought or made on site. All were unique and one of a kind and of course not made in China or distributed by Wal-Mart. Bill served up some great barbecue beef and beans. We had watermelon, cantaloupe, chocolate chip cookies and a bunch of other goodies. Cecil Craig and Kenneth Taylor forked over a twenty dollar bill to join Saltfork Craftsmen. **Welcome aboard Cecil and Ken !** Both of these guys are into gunsmithing, knives and other forms of metal work.

Gerald Brostek, Saltfork Craftsman



FORGING

A

FULL SIZE WHITETAIL DEER ANTLER



Acknowledgements

Last spring I attended a class by Rick Jay on forging a 1/3 scale set of antlers at John C. Campbell Folk School. Rick is a good teacher and I thoroughly enjoyed the class. It is my intent to pass this knowledge on to the best of my ability. I have done as most of us have done and have adapted Ricks teaching to suit my own style and ways of doing things. The techniques I use are not the only way to make antlers and I hope you can take what I have written and derive from it what you need in order to achieve the goal of making realistic antlers.

Required Materials

*14" Of 1 ½" Mild steel round bar stock

36" Of 1" Mild steel round bar stock

18" of ¾" Mild steel round bar stock

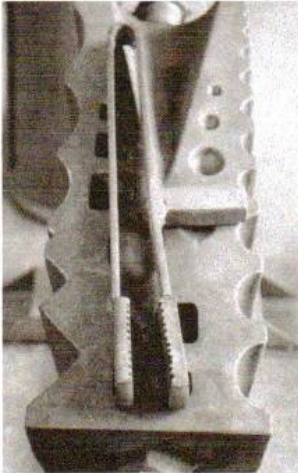
*Note - If you are making a full set you will need to double the material. Also forge both antlers at the same time, I find this to be a lot easier when bending and shaping.

Required Tools

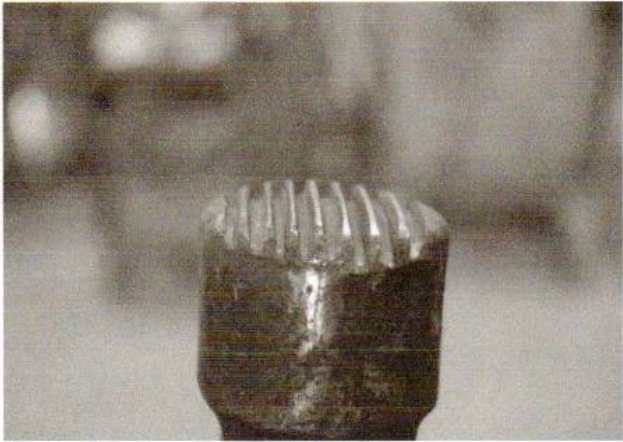
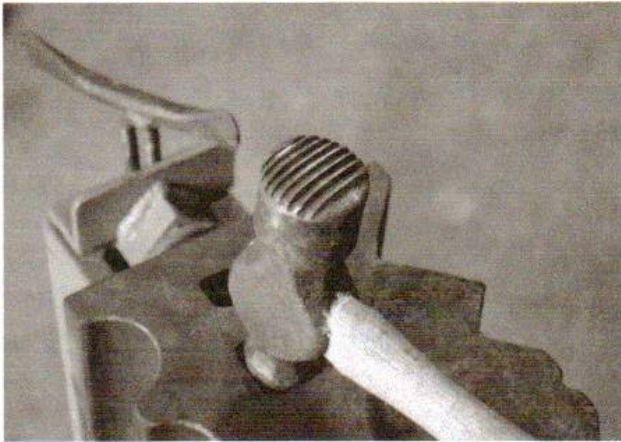
Power Hammer

Mig Welder

Texturing swage



Texturing hammer



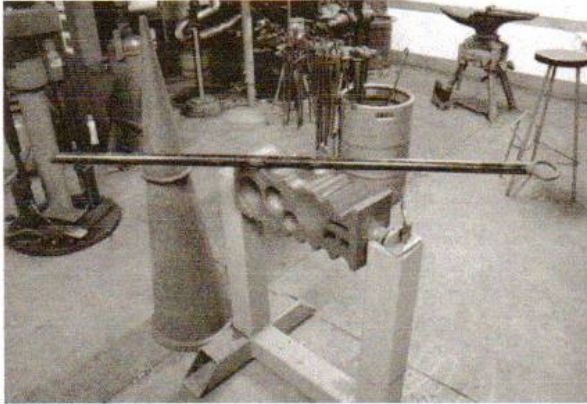
Die Grinder

Dremel tool with cut off wheels

Flap wheels

4 1/2" grinder

Bending tool (Long piece of 1" pipe)



Mount fixture



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Let's start with the tooling.

I make my texturing swage from sections of Jack hammer bits forged down to 1/2" thick then air cooled. The spring is plain 1" x 1/4" mild steel. I pre-heated the tool steel prior to welding it on to the spring. The serrations are cut with a cut-off wheel on a 4 1/2" grinder.

The texturing hammer is a modified flea market ball peen. The serrations were cut with the same cut-off wheel. I did not anneal the head or remove the handle.

The bender - The best thing I have found to bend these with is a piece of sch. 40 1" pipe about 4' long. Take the business end and flare it a little and grind it smooth so it won't mark up the antler. I welded a ring on mine so I can hang it on the wall out of the way.

The mounting jig - Is a piece of 2" x 2" x 3/8 angle 11" long with a 2" notch cut out of the center of one side and then bent over and welded. I weld the main beam to it and clamp it in the vise to make a solid base for bending. You may not need this but it helps me to visualize the proper angle as I am bending the main beam and the tines.

A quick note on vises. In my shop I have bolted my vises and anvil stands to the floor. I have better things to do with my time than chase either across the shop.

Forging the Main Beam & Tines

Cut a 14" length of 1 1/2" mild steel round stock

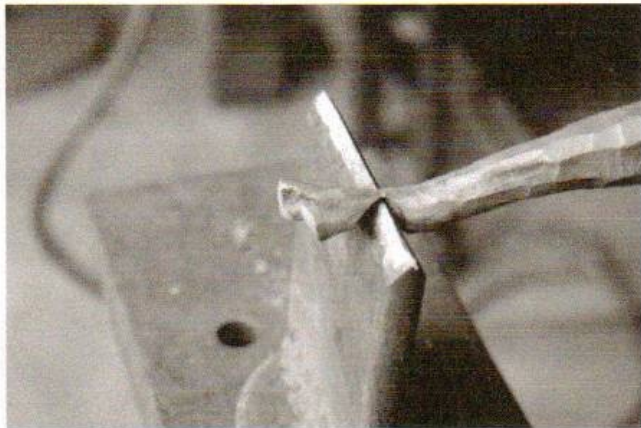
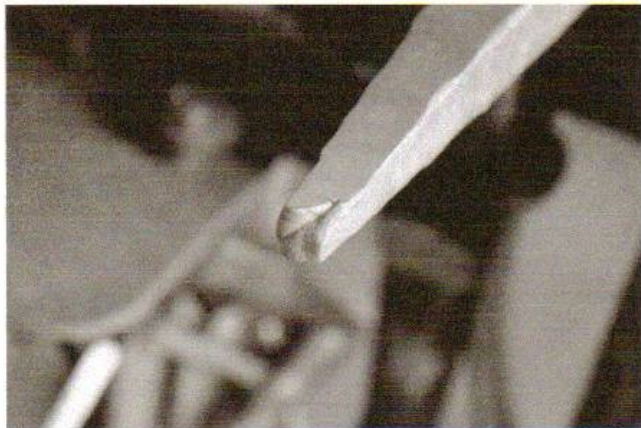
Weld a handle on one end. I use 18" of either 1/2" or 3/4" scrap round or square bar stock.



Draw a long taper starting 4" from the handled end tapering to 1/4" for a finished length of 24"

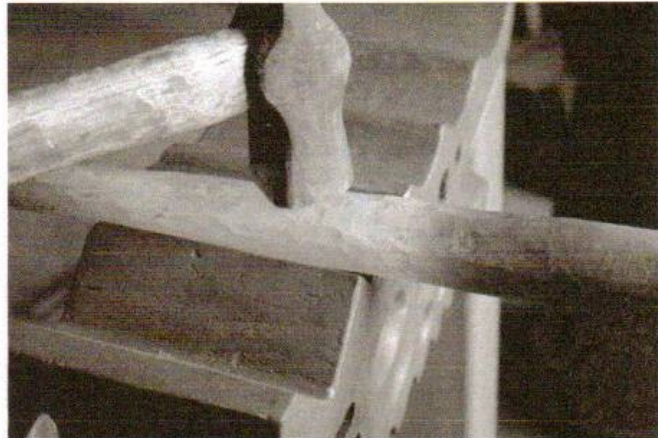
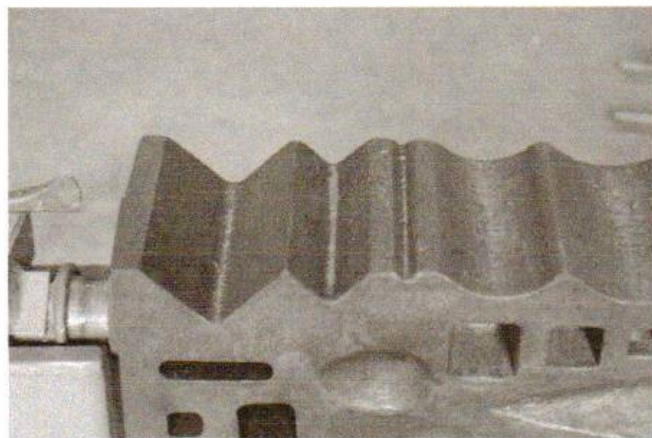


I always get fish lips on the end of the bar so I allow for cutting approximately 1 1/2" off the end to eliminate the fish lips. Otherwise the end of you antler will split and crack as you work it.

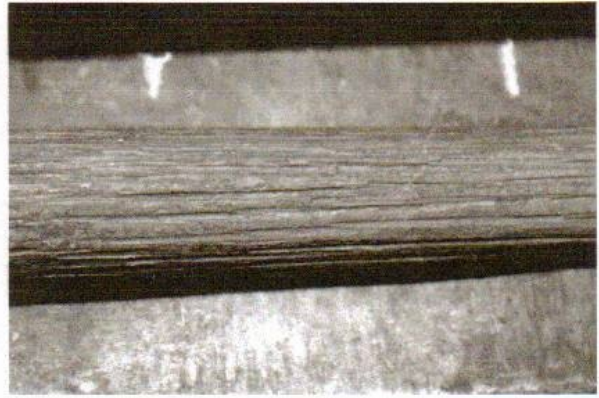
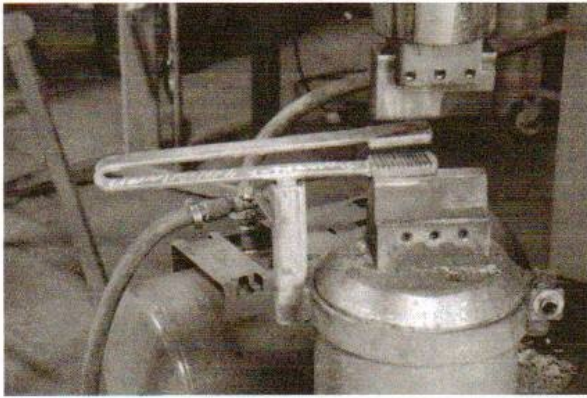


No two antlers are alike. I always like to have one to copy. Some antler main beams are oval and some are triangular to oval.

For this antler we will use a V swage block and starting just past the beginning of the taper I will set it down in the vee to give it a slight triangular shape. Mark the top of your handle so you keep track of the top flat. Once you are about 2 thirds of the way down the length then transition to a slight oval. The top of the oval runs in line with the top flat of the triangle.



Place the texturing swage in the power hammer. Heat the full length of the antler and then pull it through the swage. Do not rotate it until you have textured to within 2" of the full length. Do not try to texture the very end in the swage as it will destroy it. Rotate the antler push it back to the base of the horn and pull it through again. Continue until the whole antler except the last 2 inches or so is textured.



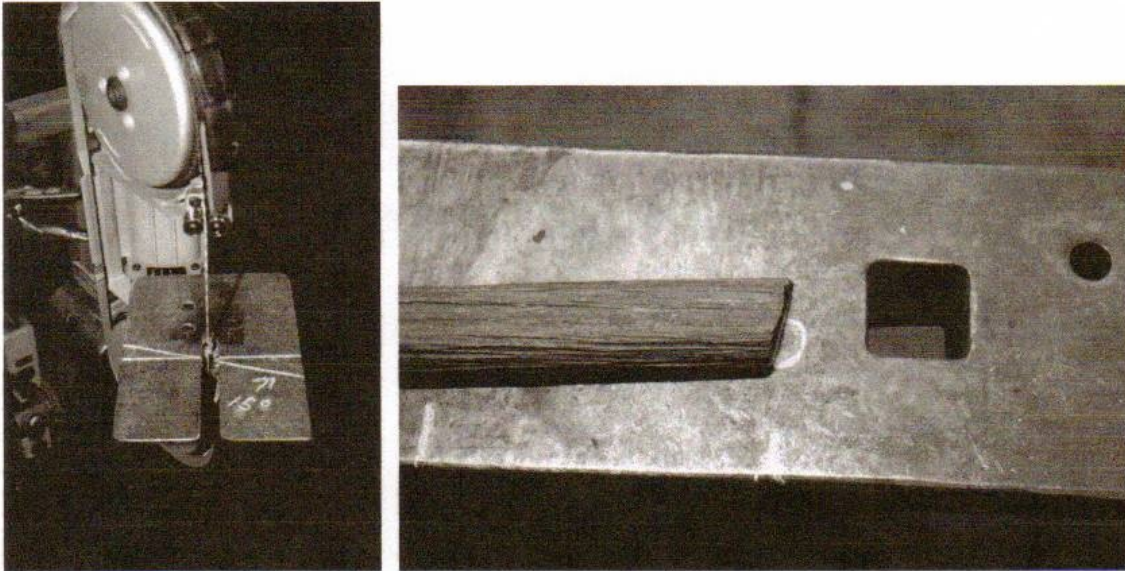
Reheat and use the texturing hand hammer to texture the last 2".

Set the main beam aside for now.

Take a heat on one end of the 1" stock, taper the last 2" (width of my hammer dies) to 1/4" in a 4 to 4 1/2" taper. Make a mark 9-1/2" from the end of the taper and forge this length to an oval shape. Texture in the same manner as you did the main beam using the hand texturing hammer for the last 2".



Set the chop saw vise for 15 degrees or make a 15 degree line on the band saw table and cut a 9 ¼" length.

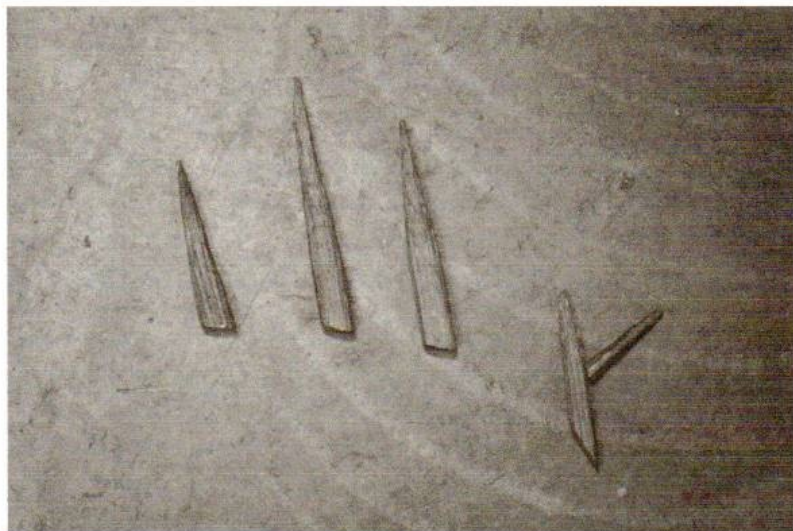


Forge 2 more in the same manner and cut at 8 ¼" and 6".

Set these aside also.

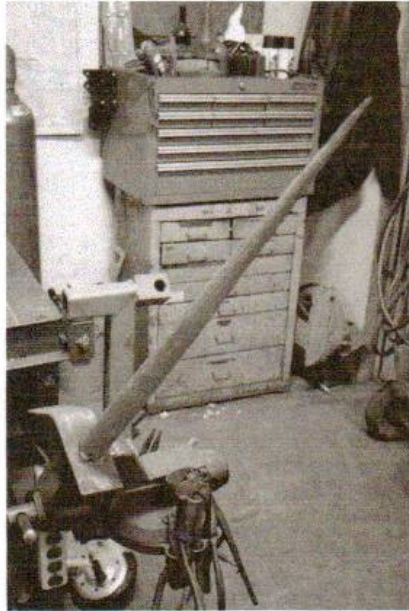
Take a heat on one end of the ¾" stock, taper the last 2" (width of my hammer dies) to ¼" in a 4 to 4 ½" taper. Make a mark 5" from the end of the taper and forge this length to an oval shape. Texture in the same manner as you did the main beam using the hand texturing hammer for the last 2". Cut off at 4 ½" on a 30 degree angle.

Take another heat on the bar and forge another taper same as the last. Cut it off at 3 ½" on a 30 degree angle also. Your tines should look similar to the ones pictured below.

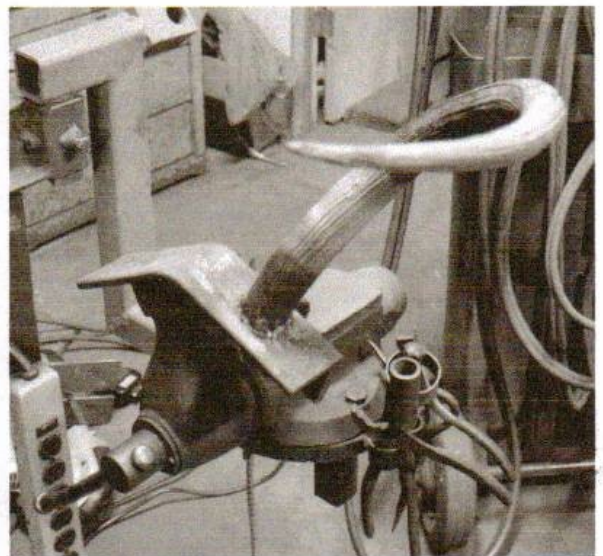


Welding & Shaping the Antler

Place the mounting jig in the vise, cut the handle off of the antler and weld the antler base to the jig at approximately the same angle it would come off of the skull. Be sure to have the top flat of your triangle (remember your triangle?) facing the 9 o'clock position. That way your triangle and oval should be in the right position as you bend it around. The triangle Vee should be pointing down and the flats of your oval should be on the sides as you bend it around



Now fire up the rose bud, slip the bending pipe over the main beam, Heat and bend the main beam to match the original.



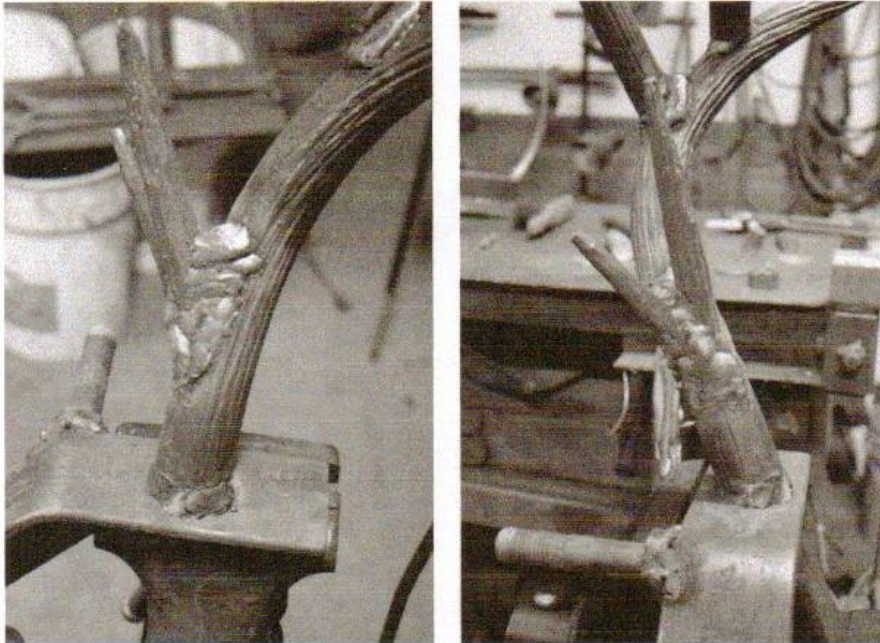
I take my tine spacing measurements of the antler from tip back to base. For this antler the spacing is tip to center of 1 = 9 ½", center of 1 to center of 2 = 4", center of 2 to center of 3 = 3", center of 3 to inside of 4 = 5".



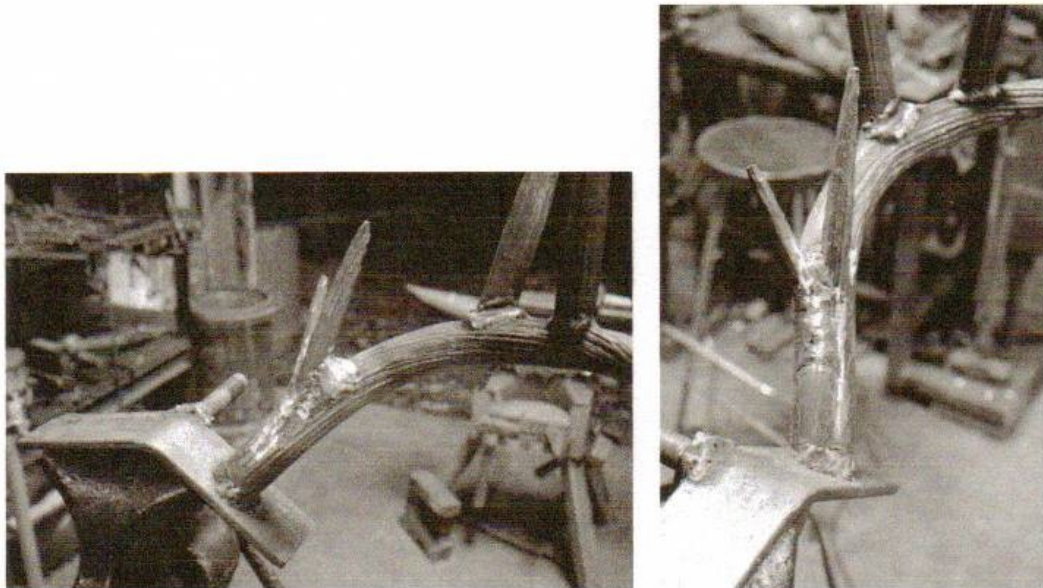
Take a Sharpie and mark the centerlines on the main beam. Take a good look at the original antler, hold the first tine in place and pay close attention to the angle long ways with the beam. Also notice that the tines do not all sit in a row on top, they tend to twist round the main beam as they go. Tack the tines in place and adjust as necessary.



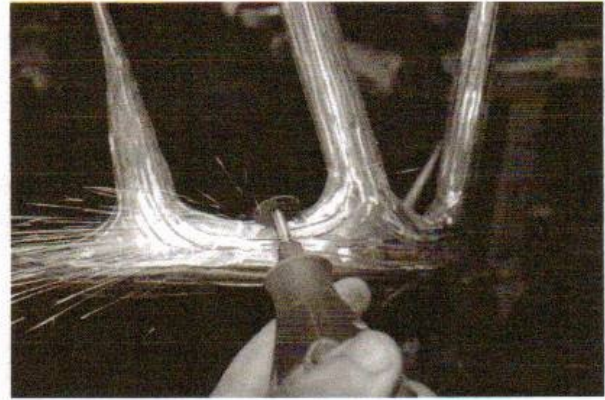
Step back and make sure you have the spacing and angles to your liking. Once you are satisfied weld them up. Look at how the original blends in both ways and try to copy the flow as you weld them up. A little time and forethought here will save you a lot of grinding.



Now the real fun begins. Take the 4 1/2" grinder and the die grinder and start grinding and blending the welds in so they flow nicely. You will probably have to do the weld up/grind down several times to get the look you want. Finish with flap wheels, small sanding drums.



Once you have the welds blended in to suit you take the dremel tool with cut off wheels and start matching the texture on the main beam with the texture on the tines. Don't cut too deep and once again try to make it flow from one to the other.



Next come up 1" to 1 ½" from the base and start building up the Boss with the mig welder, try to get the boss at the same angle as the original. In order to get the brow tine and the boss to flow together you will probably have to build up the girth of the tine between the two with weld metal.

Step away and take a scrap piece of round stock at least 12" long and get a good heat on it (orange to yellow) and texture the length of it all the way around. This is your practice piece to give you a chance to get the bead technique right prior to welding the beads on the bottom third of the antlers.

Do not change the setting of the welder from what you've been welding with. DO NOT turn the welding gas off. Use your normal settings and move the gun away from the work and run up and down quickly. Don't worry about all the sticky wires poking out we'll take care of those in a minute.

Practice and adjust YOUR speed and distance until you get the look you are after.

Now about those pesky, pokey wires... Fire up the torch, pass it over the test piece and watch them melt away:<) no more pesky, pokey wires.

You are now ready to apply the beads to your antler. Notice on the original the vast majority of the beads are on the bottom 1/3 of the antler.



Finishing Touches, Now it's time to pay attention to detail. Notice the texture on the antlers is more pronounced the closer to the base of each tine. I take a flap wheel or sanding disk and sand the ends of the tines to smooth them out a bit. I also look to see if the tines on the original are pointed, rounded or flattened a bit and make them match the original.

If you are making a shed cut the antler off directly below the boss and then dimple the cut with a center punch or an air chisel with a pointed bit.



If you are making a full rack trace out your mount, shape it and then cut the antlers off at the base of the mounting jig. Pay close attention to the angle you weld them to the skull, this is always the hard part for me.

Hopefully you now have an antler or rack that looks something like these.



I hope you have found this helpful to you,

John Bennett

Artist Blacksmith

2011 SCABA Conference get going...

Friday morning, October 14th is here ready or not. It time to travel to Perry Oklahoma to start setting up for the conference. The truck is full and I am sure I forgot something but maybe it won't be missed. This is our 15th year to hold a conference and our 5th year to be a Perry. The facilities are great. We are able to utilize 2 buildings and a reasonable large parking lot for the tailgating area. Ron Lehenbauer is change with setting up the tailgating area. He lets me place my few items on a table of his and then I off to get things going in the ladies building.

Pat, Dan, Tracy and Tammy Cowart have already got the registration set up so I pass off a few things more for them and find me some strong guys to help set up tables and chairs for the classes and meals.

Before long items start coming in for the conference and gallery. This club has some very talented artist and they bring some very unique items for us to view.

The Guys are having a slower time getting started. They are waiting for the teaching trailer that contains the forges and other equipment needed to set up the two forging stations. But the tool box has arrived and Amy Pieh is here to set up her store. She has brought lots of books and other hand tools.



Humming bird and flower
by:



Titled: "Looking for my feet"
By:



Set up is starting to get finalized and Bill Kendall has been nice enough to provide the set up crew with the evening meal of Chili with fixings and peach cobbler for desert.



As soon as the meal was over the Board of Directors retired to the women's building for a meeting. Results of meeting will be in next months newsletter. With meeting adjourned it was down to final preparations and lock up for the night.

Saturday morning..for this editor started at 3:00 AM. Which is when I am typing this article. More coffee PLEASE...

Order for the day is to get all the nice donations entered for the auction and continue to set up the gallery. The family classes with get started with the copper rose pendant. Conference registration is up this year with approximately 60 preregistered and another 60+ to get registered. It makes for a busy hour for the ladies at the registration desk.

Blacksmithing demonstrations got started on schedule as well as the ladies classes. We wish we could get more of the ladies interested in the classes but there seemed to be a good response anyway. As you can see I need to change the name of the classes from ladies to Family because anyone is welcome to attend the classes. We were glad that Ron joined the class because his first hand knowledge of working with thin metals added to the learning experience for everyone. Cheryl Carrothers taught a Ztangles class that I signed up for but didn't get to try my hand at. But I picked up the supplies and will see what I can do.

Mecca Wait taught a jewelry class also. We Tried to have a selection of things to interest the members. If you have a suggestion for next year, contact Carol Doner and let her know.

Our meals were provided by Stagecoach BBQ. They were excellent as usual.



Demonstrations:

We had two very talented demonstrators this year with Mark Aspery and Brent Bailey. The forging started at about 8:00 on Saturday and allowing for the much needed periods of rest and relaxation, ended at 4:00 P.M. on Sunday afternoon. Both demonstrators kept their audiences taking notes and asking questions throughout both days.

Auction:

This year we had 81 items donated to the auction. Some of them came from the John Burns estate. We also had some demo pieces from last year that were finished up on Sunday after the auction. This year those Sunday demo pieces will be auctioned off at the end of the demonstrations on Sunday so we don't have to store them a whole year. This is our last year to have HO as our auctioneer and he will be hard to replace. Gerald Franklin presented HO and his wife with "Thank You" gifts. HO was presented with a cross made by Gerald Brostek and his wife received a rose pendant and earrings made by Teresa Gabrish.

The auction is always a lot of fun and the items donated are some of the nicest examples of workmanship.



Tool Box.

The tool box this year was made by Don Garner and the hinges by Byron Doner. There was a super nice assortment of tools donated by the membership.



The drawing was held after the evening meal on Saturday right before the auction was to begin. We didn't sell as many chances as we have in years past but we still had a nice showing of support for the project.

Bill Kendall was the project chairperson and he set up the drawing for the lucky name. He asked for three people that DID NOT have any tickets in the box to come forward. Jan Kendall, Cheryl Carothers and Teresa Gabrish were the three ladies that would, through a process of selection, draw out the lucky name.

First up was Jan Kendall who pulled out a double handful of tickets that were then placed into another box. Those tickets were shaken up and Cheryl Carothers was then asked to pull out a single handful of tickets that were placed into an empty box and shaken up. Teresa Gabrish then was asked to pull out one ticket. The winning name was Carol D. Perry of Oklahoma City.



Gallery:

We had a lot of nice items placed in the gallery this year. They were all fine examples of workmanship and all deserved to be mentioned. The conference committee and Gallery workers appreciate everyone bringing their work up for us to enjoy.



I apologize if your item is not pictured. Some came in after I made the rounds taking pictures. But there was a nice lamp by Mike George and a beautiful painted saw blade, some roses and a fire place screen and other items I am sure I am forgetting but I appreciate every one of them. This year we had our "People Choice Award" again and it was presented to Teresa Gabrish for her Lighted Amatheth Cathedral covered with copper roses with a copper cross as the center piece. (Picture on front cover.)

Iron-N-Hat..

Bryon Doner was in charge of the Iron-N-hat drawings this year and there looked to be a nice selection of items to choose from. He had several ladies helping him through out both days and that helped him a lot as he was also the coffee goddess again this year. We kept him busy keeping coffee and snacks ready in both buildings.

The ladies that were selling tickets were Carol Doner, Chuyleeporn Seigrist and Ann Seigrist (?). The ladies did a great job of selling the tickets and then drawing out the lucky numbers.



Vendors:

Along with Pieh tools, we also had several other vendors come and set up. These vendors add a lot to the conference experience because they bring goods that we might be able to find locally. And when they bring them to us we save on shipping cost and get to look and handle them which you can't do over the internet or phone. I know that I bought things that I would not have if I had not had the opportunity to look at them and see the potential in their use. Rodger Degner brought his videos again this year. I can't remember all of them but hope they come back again next year because I plan to save up for a new hammer.



Turn out the lights, the party's over....

As soon as the last person left from eating lunch. I started getting the chairs and tables put back up on the racks. With the help of two of the men that were still hanging around in the ladies building, we had the building ready to lock up in a about an hour. With one building down we started on the other one. While some of the men worked to load the forging equipment out the back, some of the rest of us started on gathering the trash up and sweeping and mopping the floors.

I would like to thank all the members who stayed after the final demonstrations were finished to help clean up and get all the equipment loaded back into the proper trailers and headed home. It is easy after a long day or two of watching demonstrations to just get up and load your goodies up and head for home with no thought as the ones that spent hours getting everything set up on Friday and now are facing hours of tearing down time before they are able to go home. I can't name everyone that stayed to help even for a little while but they know who they were and I just wanted them to know that we were very appreciative of their help with the table, chairs and other equipment that had to be put or loaded up.

Diana Davis