

# Saltfork Craftsmen Artist-Blacksmith Association

December 2009



Tom Nelson demonstrating how to shrink the rim of a wagon wheel during his meeting on November 28th

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Artist-Blacksmith Association  
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The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization of amateur and professional artist and craftsmen, publishes this newsletter monthly. Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

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**Visit our Saltfork Craftsmen Website:**  
[www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org)

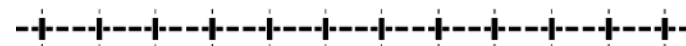
**Trading Post**

**For Sale:**  
5/8in. Round 1045 stock in 12 ft. lengths. Price is .50/ft. contact Ron Lehenbauer at [therustyanvil@yahoo.com](mailto:therustyanvil@yahoo.com) or call 580-554-1126 to order. Delivery can be made at the Conference. I can have it cut into 1ft or 6ft pcs to haul. 1-foot pcs will be a bit extra for the cuts. This is great metal for punches or chisels.

Army surplus round nosed pliers that make good scroll pliers for small items. They are 6" long \$5.00 each plus shipping. I also tie brooms on your handle or mine. \$20.00 plus shipping. Diana Davis 580-549-6824 or [Diana-copperrose@hughes.net](mailto:Diana-copperrose@hughes.net)



**Wanted:**  
Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or o [Mike-Marideth@sbcglobal.net](mailto:Mike-Marideth@sbcglobal.net)



## Club Coal

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces. The coal is \$140.00/ton or .07 /pound to members. **No sales to non-members.**

### NW Region coal location:

Bring your own containers. Contact Tom Nelson at 1-580-862-7691 to make arrangements to pick up a load. **DO NOT CALL AFTER 9 P.M.** If you make arrangement well in advance, Tom can load your truck or trailer with his skid steer loader. Otherwise you will need to bring a shovel. The coal can be weighed out at the Douglas Coop Elevator scales.

**NE Region coal location:** Dan Cowart also has coal to sell. He can be contacted at ddcowart@gmail.com or CowartPat@gmail.com

*Send your ads to the Editor by the 20th of each month. Ads will run for 60 days.*

## MEETING SCHEDULE

### Dec.

#### SE Regional meeting (Dec 5th) Open

**NE Regional meeting (Dec 12th)** Hosted by Charlie McGee

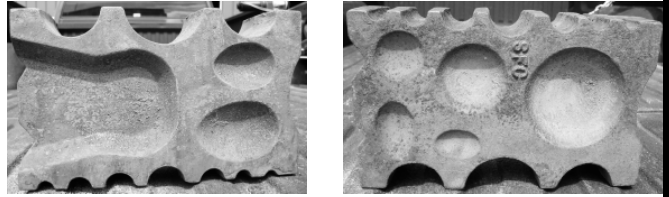
Directions; 12 miles north of Sand Springs on Hwy 97 to end of road. Then turn Left (W) and go about 2 miles. House located on Right (N) side of road. Come through gate and shop is located behind the house. If you need better directions call 918-245-7279

**S/C Regional meeting (Dec19th)** Hosted by Kent and Anelia Hadick at their home in Oklahoma city. Meal will be provided but bring a side dish. The trade item is anything you would be pleased to receive for Christmas. Please bring it wrapped. **NO GAG GIFTS** This doesn't have to be a forged item but it would be nice. Anelia plans to play *Dirty Santa* so come and enjoy the day. Map and directions are located in this newsletter.

**NW Regional meeting (Dec 26th)**

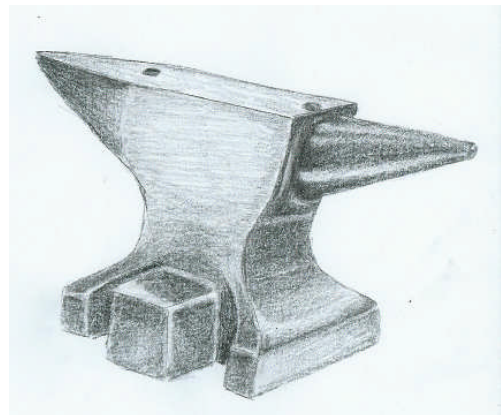
***Merry Christmas and Happy New Year.***

New shipment of swage blocks now in. \$80. plus shipping to members. \$100.00 plus shipping to non-members. Contact Bill Kendall for more information



**This year is almost over and it is time to start getting ready for 2010. Here is a list of things to do in 2010. See how many of these things you can get do.**

1. Pay your dues before March 30th.
2. Vote your ballot for SCABA directors.
3. Sign up to host a meeting in your region
4. Attend the State Picnic in April.
5. Attend a workshop or class
  - A. Suggest a workshop that you would like to attend.
  - B. Volunteer to teach a workshop
6. Make several items to place in conference gallery.
7. Make and donate items for the conference auction.
8. Sign up for a conference committee.



## President's Notes

Gerald Franklin

I open this installation of the President's Notes with disappointing news. Our good friend, mentor, fellow smith, and long time Saltfork member Max Scudder is very ill. He has been diagnosed with cancer. He has been going down hill for several months but the cancer diagnosis was a shock to most of us. Please remember Max and his family in your thoughts and prayers.

After an outstanding conference in October, twelve of us treated ourselves to an excellent repousse' workshop taught by nationally know repousse' artists, Mark and Mindy Gardner in early November. A write-up of this event is located elsewhere in this newsletter, so "read all about it" there. We have been fortunate this past year to have had several good workshops made available to our members. We will continue to hold workshops in 2010. They haven't been scheduled yet, so there is time to get your preferences in to our workshop coordinator, David Seigrist, so he can add your subject to his list.

We are well into the holiday season now and again this year we will hold our Christmas Tong Exchange. Sign up with coordinator Jim Carothers early so that you can set aside plenty of time to make your tongs. This was a fun program last year for the fourteen of us who participated. This year we are looking forward to even more exchangers.

The Board of Directors met at Dan and Pat Cowart's place on November 14 and we got a good bit of club business taken care of. Thanks to Dan and Pat for putting up with us for the afternoon.

The end of the year also means that Diana Davis is putting together a calendar to schedule the 2010 regional meetings. She runs this list on a first come, first served basis so if you have a particular date in mind that you would like to schedule, let Diana know. Hosting a meeting is lots of fun and it can be a lot of work. But it can be done in a simple fashion as well. Just arrange a pavilion at a local park, ask folks to bring their forge and a sack lunch, and you are on the way to being a meeting host. If you live in town, don't bother with having folks bring their lunch, just go to the local hamburger joint so folks can buy their own lunch. The important thing is to get the smiths together because, in addition to the good food and fellowship, these meetings are where most of our individual teaching and learning takes place.

May your clinkers break into dust and your tools never rust.

# Minutes

Saltfork Craftsmen Board of Director's Meeting  
Nov 14, 2009

The meeting was called to order at 1:02 PM at the home of Dan and Pat Cowart near Dewey, OK. Board members present were Richard Dyer, Bill Kendall, Bill Davis, J.C. Banks, and Gerald Franklin. Absent board members were Mike George and Byron Doner. Other members present were: Diana Davis, David Seigrist, Dan Cowart, Tammy Cowart, Pat Cowart, Tracy Cowart, and Bill Malsom.

- Treasurer's Report: The report was submitted in writing several days before the meeting. President Gerald Franklin distributed copies of the report to the board for review and discussion.
- Conferences:
  - 2009 Conference: Conference Co-Chairs J.C. Banks and Dan Cowart discussed the 2009 conference, which was very successful. We had over 100 people register for the conference.
  - Plans for 2010 Conference: This conference is scheduled for October 16-17, 2010 at the Noble County Fairgrounds in Perry, OK. Conference Co-Chairs will be Dan Cowart and David Seigrist. Demonstrators will be Darryl Nelson from Washington and Gordon Williams from Arizona. The fairgrounds have been booked for these dates. We did not have T-shirts for the 2009 conference and Dan Cowart will work out a design and source for shirts for the 2010 conference. Gerald Franklin is to find a source for caps with the Saltfork logo.
  - 2011 Demonstrators: A committee consisting of Bill Davis and David Seigrist will begin the search for 2011 demonstrators.
- State Fair: We will ask for input from prospective demonstrators concerning whether we want to support the 2010 OK State Fair. (Action: Franklin)
- Cone Mandrel Project: Jim Carothers reports that we have a cost effective bid for cone mandrels from a foundry in San Antonio and he is waiting for another bid from a foundry in Pryor. We already have a bid from Harris Patterns in the amount of \$5900 for a pattern and core box. The board voted to procure a pattern and core box that is compatible with the foundry that we select to pour the cones. Motion: Davis, Second: Banks. Carried.
- Board Candidates: The election to replace three current board members whose terms expire in 2010 will be held in March. The current list of candidates includes Dan Cowart, David Seigrist and Gerald Franklin. Anyone who wants to be considered for the board in the March election should notify the club Secretary.
- Swage Block Status: Bill Kendall reports that the current swage block inventory is adequate to fill projected orders until spring. He continues to look for a source of shipping boxes.
- Teaching Trailer Excess: Bill Davis reported that there are several items of equipment that are not needed in the teaching trailer. Some of these items could possibly have been donated. An attempt will be made to give a donor the chance to re-claim any items they are entitled to. Items not claimed will be either donated to museums or sold.
- Quench Oil: The board agreed that the club should buy a quantity of quench oil for sale to members. Bill Davis will identify a source and prices.
- State Meeting/Picnic: The board decided to re-schedule the event to April instead of May. Byron Doner was asked telephonically to check on availability of the Cleveland County Fairgrounds (Norman) for an April event.
- Plaque Project: The board discussed a plaque award project proposed by Mike George. It was decided to procure the plaque. Motion: Banks, Second: Kendall. Carried. Action: Franklin.
- The next BOD meeting was scheduled for February 20, 2010 at the S/C meeting site.
- Adjournment: The meeting was adjourned at 3:25 PM.

## Conference Evaluation Comments

Gerald Franklin

The following comments were compiled from the written section of Conference Evaluation Forms completed at the 2009 Saltfork Conference. These written comments are in response to the question: "What would you change for next year's conference?" The notations in Italics following some of the comments are my remarks.

### Comments:

- Change nothing except have "sideline" conversations taken outside of the demo areas, please. *(I got this comment verbally from other folks as well. We all need to remember that we paid money to hear the demonstrators talk and that our own personal conversations are distractions to those who came to learn. Most of us were raised better.)*
- Auxiliary heat would be nice on cold mornings. Publishing the class agenda would be good; i.e. what subjects would be covered. *(Actually, I had copies of the class schedule ready to post around the arena but when I saw that our Registrar had included individual copies in the registration packets, I didn't hang them up. Perhaps we should have had both.)*
- Very good, change nothing.
- Flies are a BAD problem. *(In spite of the fact that we are set up in a livestock facility, we do need to do a better job of "fly management.")* A U.S. map on the wall so that we can "dot" or "push-pin" our home location to visualize where we all came from. *(This is an excellent idea and we'll certainly try to remember this for future conferences.)* On nametags, it would help if we had our hometown listed, too. *(We used to do this. I'm not sure why we quit doing it but I agree, it would be nice to resume doing it.)* Open forge for Friday night & Sat night after "formal festivities". *(We could probably do this if we had a volunteer to take charge of shutting things down after forging is over...any takers?)* T-shirts with current demonstrators...just don't order so many that you can't sale [sic] them all. *(We've done this in the past, too. We just didn't get around to it this year. We'll do better.)*
- Keep the weather the same and everything would be just fine ... Nathan Robertson.
- **Encourage attendees to come to meals promptly. There were times when the catering staff had already started breaking down the serving line when "stragglers" showed up to be fed.**
- Feed the Set-up Crew first on Friday night. Solicit donations from others if food is available and they want to eat. *(We generally have a donation can set out for the Friday night meal and most people (set up crew and others as well) put a little something in the can to help the club pay for the meal. While we don't turn anybody away, it would be best if the set-up crew ate before the latecomers. I just don't think we could or should separate the two groups. I'd like to add that for the past few years, Bill Kendall has volunteered to feed us on Friday night with dessert support from J.C. Banks. Both of these guys have done an excellent job after putting in a pretty rough day as part of the set-up crew. Thanks are in order for Bill and J.C.)*
- Very good set-up and excellent management and execution – food was very good.
- As usual, the women's craft classes were outstanding – kudos to the teachers.
- **Make sure Korny wins the toolbox ... signed Annomommnus [sic].** *(What the heck's a "Korny?)*
- **Add T-shirts.** *(See above.)*
- You all do an excellent job. Demonstrators all always informative – meals are great and everyone is social. Had a great time. This.
- Directions on how to get here from the hiway for the new people coming. *(We do need to do a better job of this.)*

- [Change] Nothing.

- Larger gallery. Use of wall space for hanging items. Overall not bad. *(The individual items are very good but we'd like to have more items in the gallery. Perhaps earlier and more extensive encouragement for folks to get stuff ready to display would get us more gallery entries.)* I believe the group should set up a Face Book Group Page. It would be easier to show work and what is happening with Saltfork Craftsmen ... Dustin Sypher.

- Do latches, hinges, doorknockers and other more mechanical type demonstrations.

**The club gave a thank you gift to the caretaker of the fairground for all his help that he has given to the club over the years. This is the card he sent to the club.**



# Saltfork Repousse' Workshop is a Success

Gerald Franklin

The club hosted a repousse' workshop on November 6-9, 2009 for a group of twelve Saltfork members. The instructors were Mark and Mindy Gardner from Farmer City, Illinois. David Seigrist set everything up by contacting Mark and Mindy months ago so that they could fit the trip into their busy schedule. J.C. Banks offered up the OSU Southwest Research & Extension Center Maintenance Facility near Altus for the event. This is a very nice facility for such an event as it is large enough to pull trucks and trailers into the shop for loading and unloading. There is enough floor space so that we could spread out the workstations, grinding equipment, and finishing areas so that we weren't working on top of each other.

Mark and Mindy are very accomplished repousse' artists and they teach several classes around the country each year. They are in demand from schools such as the John C. Campbell Folk School and other noted smithing institutions and we are fortunate that David was able to line them up for a trip to Oklahoma.

They didn't travel light. Their load of thirteen treadle hammers, an assortment of tool grinders, student notebooks, various tools, tool steel and sheet metal for the class was impressive. J.C. had his skid steer on site for the loading and unloading which sped things up quite a bit. When students showed up on Friday morning we were greeted with our individual treadle hammers ready to go to work.

Our first task was to learn to make tooling to use under the treadle hammer. Mark uses S-7 for the majority of his (and Mindy's) tooling. He brought enough for each student to make a set of seven basic tools. The majority of the morning was taken up with forging, grinding and polishing this tooling. I might add that as the class progressed, many of us found that we needed an additional tool for a particular task and Mark was very helpful in guiding us through this process as well.

After we finished our tooling, Mindy took over and demonstrated her techniques on a large Oak leaf. We were then cut loose to go to our hammers and get busy ourselves. Most of us had never done any repousse' work but it surprised me how the group fell in on the job with little troubles. Don't get me wrong, it's not easy work. But with guidance from Mark and Mindy, we were all able to turn out pretty good leaves on our first try. After we were through with our leaves, Mindy shared some of the techniques that she uses to put the finish on her individual work.

With the Oak leaf finished, we got a tutorial on a feather and then it was back to the treadle hammer for another tap-tap-tap session. Again, with good help, it's surprising how a bunch of rookies can turn out a pretty good-looking product on their first try. Then, just when we thought that we were "getting good" at this, Mindy turned us loose to design and forge a project of our own. We found out that it was pretty easy to bite off more than you could chew. Eventually, though, we were able to turn out some pretty good stuff. Our last project was a Ginkgo leaf. This was a neat project, also, because they are differently patterned leaves so it is hard to go wrong.

We finished up on Monday afternoon. Mark had a much lighter load going back to Illinois since six of our students bought treadle hammers. He was also not hauling as much tool steel back either because we pretty well wiped out his stock.

This was a really good workshop and we all owe David and J.C. our thanks for making it a good learning experience by doing all the hard work associated with setting up and hosting such an event. We were able to get a quality course at literally a fraction of the cost of taking it at one of the schools where the Gardners teach.





## North East Regional meeting

It was a cold and wet day spent at Dan Cowarts place in Wann, Okla. But despite the weather we had a nice time. David Seigrist did some forging while the rest of us watched. Bill did some forging on a forge that was set up outside.

We had a very good lunch of brisquet with all the fixings. Pat made some great muffins and I have included the recipe in this newsletter.

There was board meeting after lunch and you can read the minutes to see what club business was covered. Meeting adjourned about 4:00 p.m.




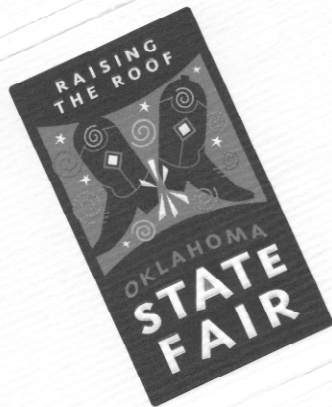
*Recipes to remember*

Title: Pecan Pie Mini Muffins

1 cup packed brown sugar  
1/2 cup all-purpose flour  
1 cup Chopped Pecans  
mix to combine  
2/3 cup butter (no substitutes) melted  
2 eggs, beaten  
Combine mix well. Stir into dry mixture.  
Fill greased & floured or paper-lined mini-muffin cups 2/3 full. BAKE at 350° for 20 to 25 minutes. Remove immediately to cool.  
Yield about 2-1/2 dozen.

Received From:





Dear Gerald and Diana,

Thank you so very, very much for providing the Blacksmithing demonstrations for the Centennial Frontier Experience. They really made our attraction more complete!

As a token of our appreciation, I have enclosed the 2009 Oklahoma State Fair Medallion. I hope you will consider working with us again next year.

On behalf of Amanda Putnam and myself, thank you again for everything you contributed to make the Oklahoma State Fair and CFE a huge success!

Sincerely,  
Melinda



Gerald received this from Melinda shortly after the ending of the fair. She included one of the bronze medallions given to fair participants. I will get both framed along with pictures take during the fair ready by the picnic in April.

Diana

Mark your calendars for this years State Picnic. We have moved it up one month. It will be held on **April 17th** at the fairground in Norman. We will be working up a menu. The club will be doing the meat but we will be needing side dishes and deserts. If you wish to help, get a hold of Diana Davis or Carol Doner. We will also be planning other activities for the day, If you have any suggestions let us know. We would like to see a lot of tailgating and forging contests. Suggestions for ladies activities or demos are needed. Let us know asap. We don't want this to be a last minute process.

Diana Davis, 580-549-6824 or [Diana-copperrose@hughes.net](mailto:Diana-copperrose@hughes.net)

Carol Doner, 405-329-5635 or [byrondoner@earthlink.net](mailto:byrondoner@earthlink.net)

## NORTH EAST MEETING DATES

January 9, 2010  
Host: Gary Gloden  
Phone #  
Trade item; something made at meeting

February 13, 2010  
Host:  
Phone #

March 13, 2010  
Host:  
Phone #

April 10, 2010  
STATE PICNIC MONTH

May 8 2010  
Host:  
Phone #:

June 12, 2010  
Host:  
Phone #:  
Trade item:

July 10, 2010  
Host:  
Phone #:

August 14, 2010  
Host:  
Phone#  
Trade item

Sept. 11, 2010  
Host:  
Phone #:  
Trade item

October  
Host:  
Phone#

November 13, 2010  
Host:  
Phone #:

December 11, 2010  
Host: Charlie McGee  
Phone #: 918-245-7279  
Trade item: angel

## NORTH WEST MEETING DATES

January 23, 2010  
Host: Charlie Todd  
Phone# 580-242-0105  
Trade item; anything forged

February 27th, 2010  
Host: Mandell Greteman  
Phone # 580-515-1292  
Trade item; tool

March 27, 2010  
Host: Mike George  
Phone #: 580-327-5235  
Trade item; Flower

April 24, 2010  
STATE PICNIC MONTH

May 22, 2010  
Host: Gary Seigris  
Phone #:580-225-3007  
Trade item: hardy tool

June 26, 2010  
Host: Ron Lehenbauer  
Phone #:580-758-1126  
Trade item; something western

July 24, 2010  
Host:  
Phone #:

August 28, 2010  
Host:  
Phone #:

Sept. 25, 2010  
Host: Gary Seigris (Elk city)  
Phone #: 580-225-3007  
Trade item; something from a horseshoe

October 16-17, 2010  
Host:  
Phone #.

November 27, 2010  
Host: Tom Nelson  
Phone #: 580-862-7691

December 25, 2010  
**Merry Christmas**

## SOUTH CENTRAL MEETING DATES

January 16, 2010  
Host: JC Banks  
Phone # 580-482-3209  
Trade item:

February 20, 2009  
Host: Gerald Franklin  
Phone #: 580-252-6002  
Trade item: boot scraper

March 20, 2010  
Host:  
Phone #

**April 17, 2010**  
**STATE PICNIC NORMAN OK**

May 15, 2010  
Host:  
Phone #  
Trade item:

June 19, 2010  
Host:  
Phone #:

July 17, 2010  
Host:  
Phone #:

August 21, 2010  
Host:  
Phone #:

Sept. 18, 2010  
Host:  
Phone #:

**October 16-17, 2010**  
**Host: : SCABA Conference Perry, Okla.**

November 20, 2010  
Host: Bill and Diana Davis  
Phone #: 580-549-6824  
Trade item: door knocker

December 18 2010  
Host:  
Phone #:

## SOUTH EAST MEETING DATES

January 2, 2010  
Host:  
Phone #:

February 6 2010  
Host: Eddie Horton  
Phone #: 580-513-8370

March 6, 2010  
Host:  
Phone #:

April 3, 2010  
State Picnic Month

May 1, 2010  
Host:  
Phone #

June 5 2010  
Host:  
Phone #:

July 3, 2010  
Host:  
Phone #:

August 7, 2010  
Host:  
Phone #:

Sept. 4, 2010  
Host:  
Phone

October 2, 2010  
Host:  
Phone:

November 6, 2010  
Host: open  
Phone #:

December 4, 2010  
Host:  
Phone #

## South/Central meeting

Bill and Diana Davis hosted the meeting of the S/C region for November again this year. We couldn't have asked for a better day for the meeting. Allan Hamm was the first to arrive coming in from Texas. We also had Frank Sheldon, Page Thomas and Terry Farquhar also up from Texas. There were around 40 to 45 present during the day.

The trade item was a flower and there were several to choose from. JC also brought some of the items done at the latest workshop that was held at Altus.



Leaves and cotton made at the repousse' workshop held in Altus.



Trade item made by Bill Davis and drawn by Allan Hamm

We had a great lunch with lots of good desserts to finish up with. After lunch everyone got back to the forging and visiting with everyone. Before you knew it everyone started drifting home.



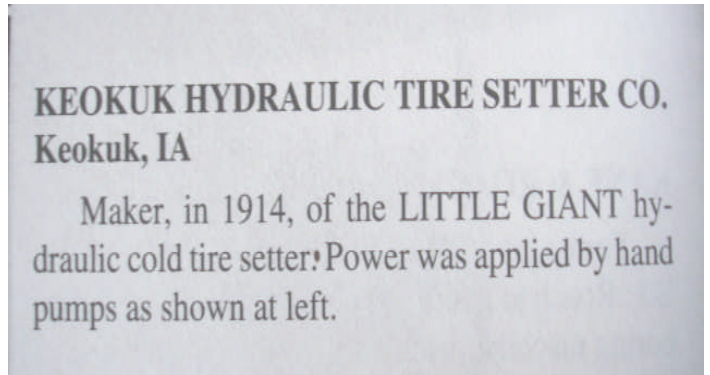
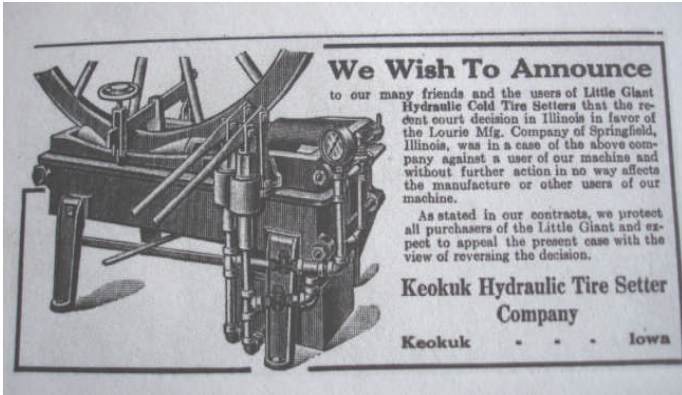
Tulip made by Jerry Cathy during the repousse' workshop



Trade item made by Gerald Franklin and drawn by Bill Davis

## Northwest regional meeting

Tom Nelson hosted the meeting for the NW region. It always falls right after Thanksgiving but there was still a good turnout for the meeting. Tom showed us how to shrink a tire using a hydraulic shrinker that was made in 1914. He used the shrinker to do three points around the rim of the wheel. The overall shrinkage was about 3/8 of an inch. In 1914 this was a great



improvement over the old method of having to heat shrink the rim.



Ron Lehenbauer set up his forge just outside the door and forged a couple knives from horseshoes and made a chili pepper from some small tubing. Tom also did some forging earlier. He showed how to make a cross from some square Tubing.

We took the opportunity while up there to get some coal.



Remember to tell potential new members that coal is only sold to members and that Mike needs to receive their membership dues prior to them going and getting coal from any of the clubs locations.

The meeting started to break up about 1;30.

## Getting ready for a workshop...

By the time you get the newsletter, a workshop on joinery taught by Mark Asprey will be well underway. It will start on Nov 30th and go for a week. It is being held at Gerald Franklins place. There are five students and they will be making tools and learning how to use them to complete a project that was designed by Mark to help each student to understand the how to use each tool to form a different type of joint.



Bill Davis and Gerald Franklin cutting some of the different size stock that will be needed by the students to make the tools for the class.

Mark Asprey working on making some of the tools that he will be expecting the students to make.

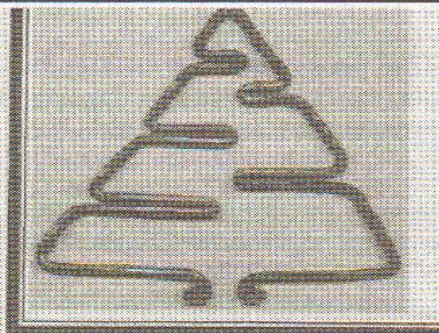


Students enrolled in this class are Gerald Franklin, Bill Davis, Byron Doner, David Seigrist and JC Banks.

### *Map and directions to Anelia Hadicks*

Take I-40 to Douglas Exit. go North to 29th. Take 29th east to Westminster Rd. Take Westminster south to Newey. Take Newey west to 10818





## **Christmas Tree Bell**

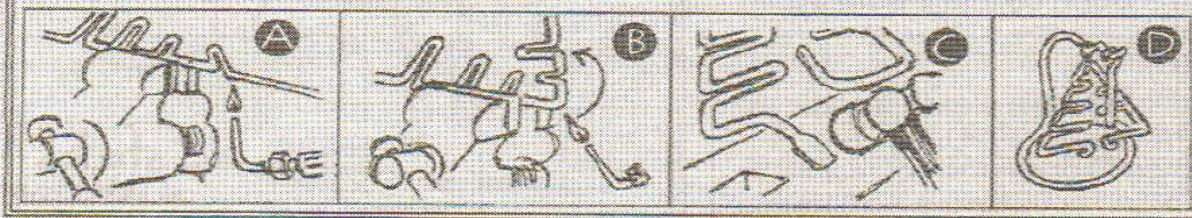
from  
**North Texas Blacksmith Assoc**

*Submitted by Ned Digh*

This bell may be made (see directions with drawings below) from 3/16" round stock, 48" long. It is best to isolate the heat for the tight triple bends with a Oxygen/Acetylene torch in order to get the proper angles. A better musical sound is produced if the bends do not touch. Start with the triple bends on one side, saving the center single bend, the two lower single bends and end scrolls for last. This allows putting the long shape into a forge. And, it is also easier to hold and maneuver. Hammer marks may be added after all of the triple bends are completed. After the five triple bends are aligned, bend the center single bend. Then measure for the final single bends on the bottom. Hack saw off the excess and twist the ends out. Heat the tips with a torch, hammer the ends flat and twist the scroll ends with needle nosed pliers. For a more melodious sound, place the triangle into the forge, heat to red and quench in water. While still at black heat, brush with brass brush to give brass highlights. The triangle uses about 39", which allows a 8" hand clangor to be made from the remainder.

A stand may be made from another section of the same stock. Twist a cobra like shape to hold the triangle and clangor. (See drawing "D" below.) For best sound quality, hang the triangle on the stand with a sturdy wire.

1. Place a mark approx. 19 1/2" from end of stock.
2. From mark, measure length of first leg and begin bending of triple bends on one half of triangle.
3. Flip the unit around and repeat for the remaining triple bends. See "A".
4. Add hammer marks.
5. Bend center single bend. See "B".
6. Heat the complete shape, place on anvil and square up.
7. Measure and bend the two lower single bends.
8. Trim excess and twist out lower sections.
9. Hammer ends flat, see "C", twist end scrolls with pliers. Twist ends back into alignment with triangle.
10. Heat and quench.



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September - October 2003

Blacksmith Association of Missouri

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# A Holly Candleholder

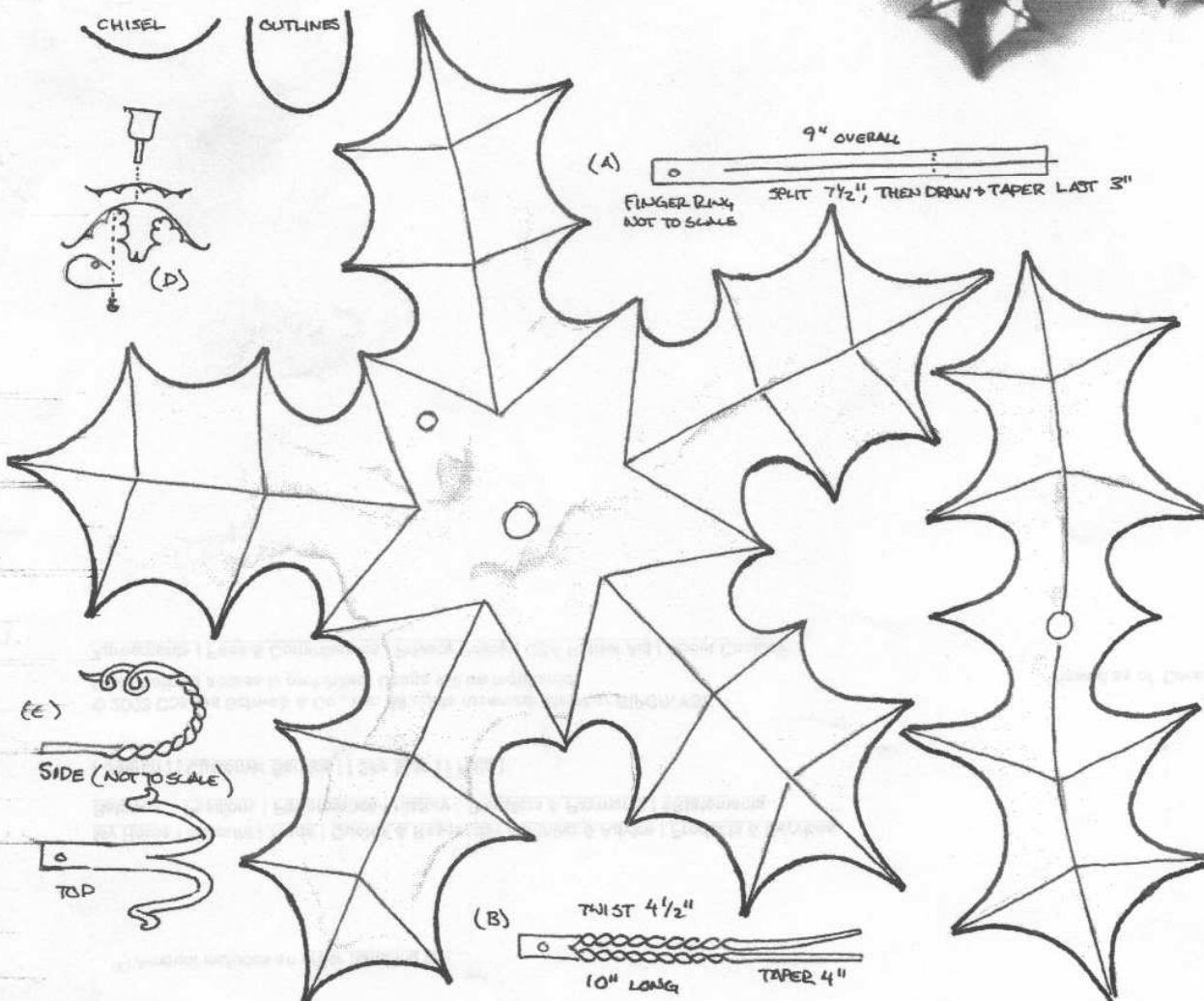
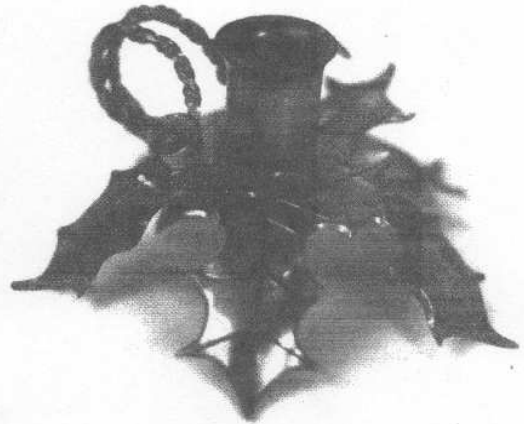
Designed by Gary Scasbrick, written by  
Brian Gilbert

*Here's a simple project that I wrote about a couple of years back in the Appalachian Area Chapter newsletter. Even though it's been around the chapter newsletters for awhile and you may have already seen it, it's such a neat little design that I couldn't resist printing it again. Christmas will be here sooner than you think, and this would make the perfect gift for someone special!*

A good friend Gary Scasbrick designed these neat little holly candleholders a few years ago. It's made mostly from sheet steel, cut with curved chisels he forged from jackhammer bits. (For more on curved chisels, see the Spring issue of the *Hammer's Blow*, Vol 8 #2.) Note that the pattern below is reduced a bit. Enlarge it about 20% on a xerox machine for best results.

The candle cup is made from a piece of 3/4" pipe, fullered

down. Leave a long stem on the base of the pipe to use as a rivet to hold the piece together, and please don't use galvanized pipe... nasty fumes! The unique double-finger ring is made from a piece of 1/8" x 1/2", split, tapered, and twisted, and riveted to the large leaf. Dish the leaves in a swedge block or over a stump, then heat and brush with a brass brush to give it a golden color.



# Holiday Candle Holder

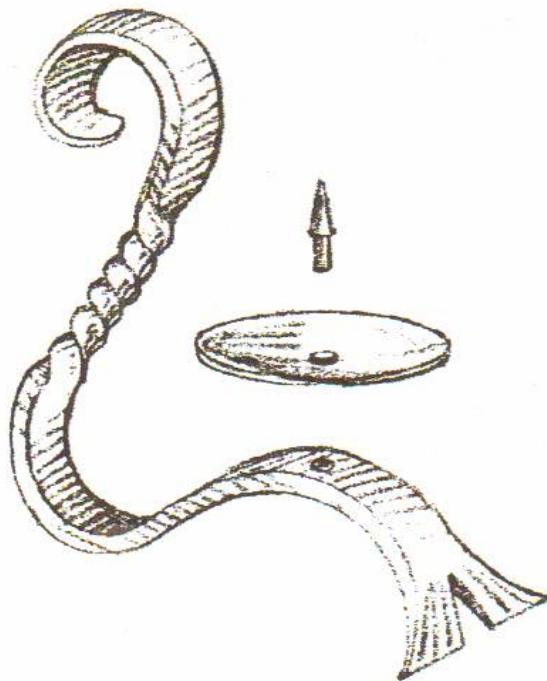
Step 1 - Using a 1/4" x 1" x 18" piece, forge a 4" section square and taper at both ends of square section 4" from one end.

Step 2 - Draw out the handle end thinner and wider to form a slightly pointed shape. Forge the handle shaping concave, lengthwise.

Step 3 - Twist the square section evenly, leaving the handle and the bulk of the bar in one plane.

Step 4 - Cut a 2" split in the other end. Spread wider and thinner with the cross peen. Leave the peen marks showing to give it character.

Step 5 - Spread the feet and curve the whole piece as shown. The handle will curve back under with the concave side underneath.



Step 6 - Forge the pin from a 1/4" round rod and put a 3/16" tenon on the end, about 1/2" long. At this small size, it is just about as easy to file it to a tenon.

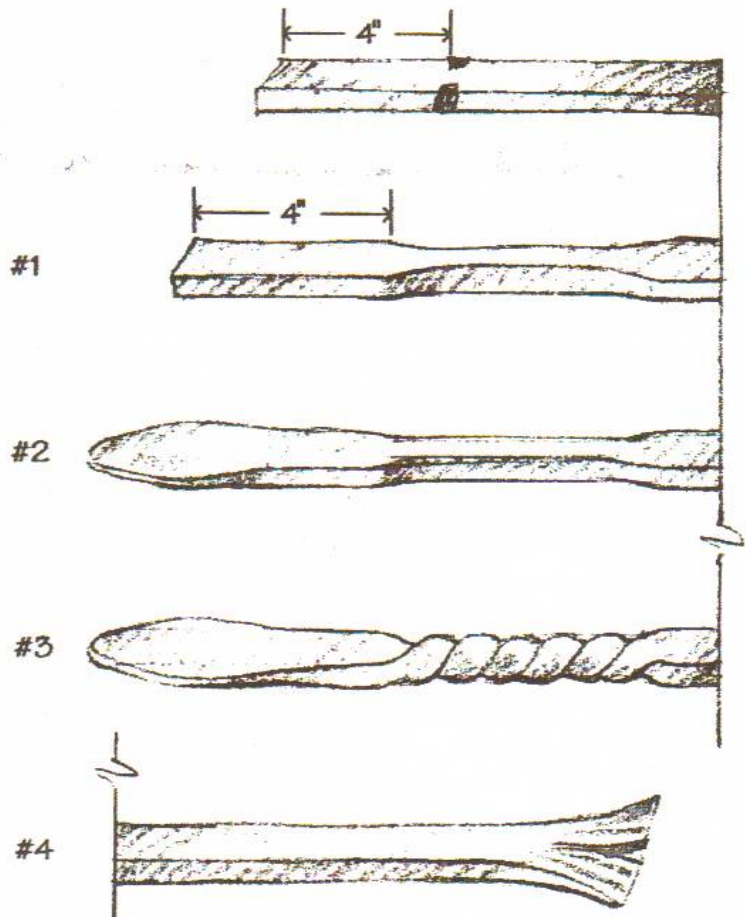
Step 7 - Cut a 4" circle from 1/8" plate and drill a 3/16" hole in the center.

Step 8 - Upset the edge of the plate to add a little depth to the wax tray. This can be done over the end of a piece of 3" pipe. Turn up the edge just enough to look nice.

Step 9 - Center the plate on the legs and mark the spot for the hole and drill to receive the tenon. It is easier to get the tray level after the legs are curved and the tray upset and drilled.

Step 10 - Rivet the bottom of the pin in the holes to attach the tray.

Step 11 - Finish by sanding lightly and applying floor wax or some other clear finish. ☺



# Saltfork Craftsmen

Artist-Blacksmith Association  
Membership Application  
April 2009 thru March 2010

Please accept my application

Date: \_\_\_\_\_

First Name \_\_\_\_\_ Last Name \_\_\_\_\_

Married?  Yes  No Spouses Name \_\_\_\_\_

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Home Phone (\_\_\_\_) \_\_\_\_\_ Work Phone (\_\_\_\_) \_\_\_\_\_

E-Mail \_\_\_\_\_ ABANA Member?  Yes  No

I have enclosed \$20.00 for dues to March 30, 2010

Signed \_\_\_\_\_

Return to: Saltfork Craftsmen, 1227 Fourth St. Alva, Ok 73717



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