

Saltfork Craftsmen Artist-Blacksmith Association

February 2010



Mark Galloway with his wolf paw decorative punch that he made at JC Banks meeting.

**Saltfork Craftsmen
Artist-Blacksmith Association
Officers and Directors**

President: Gerald Franklin 580-467-8667
Rt. 3 Box 239J, Duncan, Ok 73533
franklin@myrhinomail.com

Vice-President/events: Bill Davis 580-549-6824
23966 NE Wolf Rd
Fletcher, Okla. 73541
lazyassforge@hughes.net

Sec-Treas. Mike George 580-327-5235
1227 4th St. Alva, Ok. 73717
mike-marideth@sbcglobal.net

Director/website: JC Banks 580-482-3209
16007 S. CR 206 Altus, Ok. 73521
jc.banks@okstate.edu

Director: Byron Doner 405-650-7520
6520 Alameda, Norman Okla.
byrondoner@earthlink.net

Director/swage blocks: Bill Kendall 918-742-7836
1756 E. 59th St Tulsa Ok. 74105
wwkendall@aol.com

Director: Richard Dyer 918-582-5065
1119 S Birmingham Pl. Tulsa, Ok. 74104
irondyer@aol.com

Assignments:

Editor: Diana Davis 580-549-6824
23966 NE Wolf Rd Fletcher, Ok 73541
Diana-copperrose@hughes.net

Librarian
Bill Malsom 918-440-4318
21450 N. 4020 Rd. Bartlesville, Ok 74006
billmalsom@hotmail.com
918-440-4318

Workshop Coordinator
David Seigrist 580-688-3555
dseigrist2004@yahoo.com

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.

Material from this newsletter may be freely copied without permission for non-profit purposes. Please credit the author and this publication.

Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org

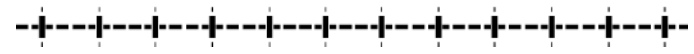
Trading Post

For Sale:
5/8in. Round 1045 stock in 12 ft. lengths. Price is .50/ft. contact Ron Lehenbauer at therusty anvil@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



Wanted:
Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or Mike-Marideth@sbcglobal.net



For Sale:
50# New Style Little Giant Power hammer. Rebuilt late 2009. \$3500,00 Contact Bill Davis at 580-549-6824

Quench Oil. Gerald Franklin has McMaster-Carr 11 second quench oil for sale. Price is \$15 per gal or 5 gal for \$70. Bring your container (and money) to Gerald's meeting on Feb 20 for an early chance at some quality quench oil.

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

Feb

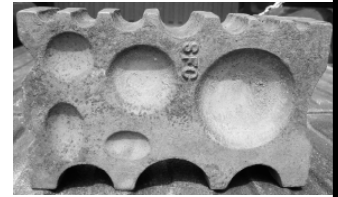
SE Regional meeting (Feb 6th) Hosted by Eddie Horton at the Fort Towson Historical Site. Meal will be provided. Bring something sweet to finish out the meal. Directions: On highway 70 (about 15 miles east of Hugo or 30 miles west of Idabel) will be a blue sign for Fort Towson Historical site and signs for blacksmith workshop. Turn left and site is 3/4 mile North from intersection. Depending on the weather.. Workshop will be either under the pavilion or inside the sites shop. For more information you can call John Davis at 580-873-2634 or email at jdavis@okhistory.org

NE Regional meeting (Feb 13th) hosted by Bill Kendall. Trade items is a heart because the next day is Valentines Day. For lunch we can go to Ci Ci Pizza (dutch treat) or on your own.

S/C Regional meeting (Feb 20th) Hosted by Gerald Franklin at his shop east of Duncan. Lunch is provided. The trade item is any riveted item. Map in back of newsletter.

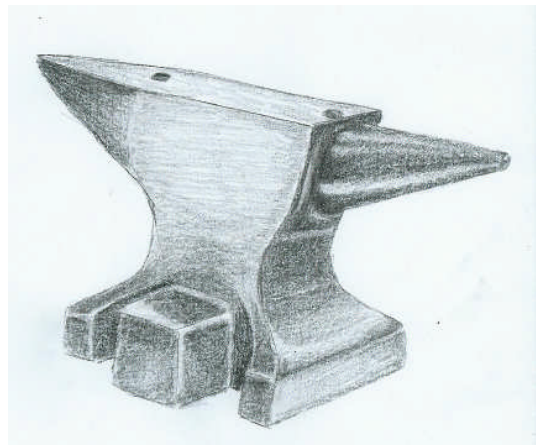
NW Regional meeting (Feb27th) Hosted by Mandell Greteman at his shop in Foss Okla. Lunch provided bring a desert if you wish. Take Exit 53 off I-40 at Foss. Go North 1 1/2 miles to main st. Turn (L) and go 2 blocks to Mandell's house. Trade items is any tool.

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

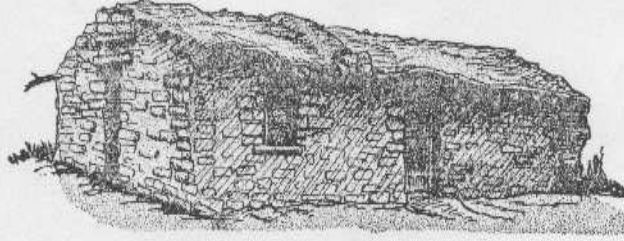


We are now about 30 days into 2010. Below is a list of challenges for you. Lets all see how many of them we can do. Several of them have time limits so start on them today.

1. Pay your dues before March 30th.
2. Vote your ballet for SCABA directors.
3. Sign up to host a meeting is 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.



Major County Historical Society



Fairview, Okla. 73737

November 30, 2009

Saltfork Craftsmen Artist Blacksmith Assoc. Inc.
1227 Fourth Street
Alva, Oklahoma 73717-1227

Mike George,

Trust all is well and that the upcoming Christmas season brings you and yours good cheers.

In reading your October newsletter. I notice the North West Regional meetings are held at different places every month. We here at the Major County Historical Society are inviting you and the Saltfork Craftsmen Club to meet here on ours grounds for one of your spring meeting. We have a gentleman who wants to feed your group a chuck wagon style meal. Sometime March, April or May 2010. The Blacksmith shop, museum, conference room, and inside restrooms will be open for you clubs convince.

Please consider us for one of your spring meetings. You can contact the museum office at 850-227-2265 Ask for Lynda or email us at lrag@pldi.net.

Sincerely,

Major County Historical Board

North East Regional meeting..

The NE regional meeting was hosted by Gary Gloden.

There was a pretty good turn out for the meeting. The trade Item was anything made at the meeting.



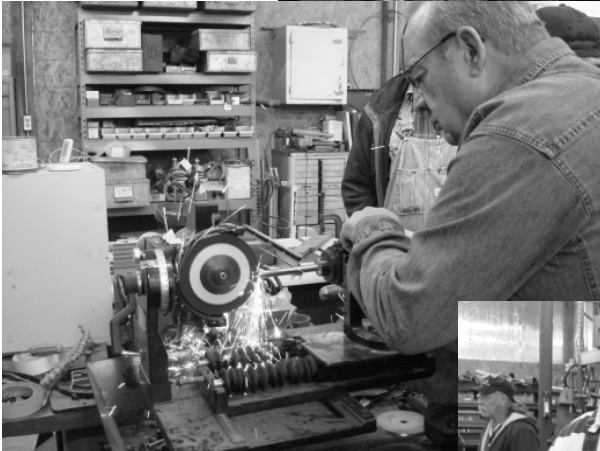
Home made vice. →
Will fit in the hardy hole of
your anvil.



South/Central meeting

The S/C meeting was hosted by JC Banks at his home in Altus, Ok. There were about 30 members that showed up for the meeting. The winners for who came the farthest went to Jim White and Terry Farquar who rode together from Texas. The trade items was a decorative punch. JC had lots of stock so that if you didn't get a chance to make one before the meeting you could get some help making one for the trade items and one to take home with you. We had a great lunch and returned to making more punches. Bill and Byron played around with

the largest folding knife I think I have ever seen. We are sure going to miss having meetings at JC's when he moves to Colorado. He has such neat tools to play with. ↓



We used this one to cut lines in the ends of the rods. It allowed you to



index the rod 30° at a time. Great for laying out the petals for flowers, etc.



This wolf paw punch was made by Mark Galloway. It was his first attempt at making a decorative punch.

Calendar of events....

The year is just getting underway and many of you will be asked by your local organizations to do demonstrations. We need to know about these events. We have a lot of members that would like to do some public demonstrations but don't know how to get started or who to contact. Everyone could use some help at these event because it makes for a long day to demo by yourself. Many events are repeated year after year but they sometimes change the dates so even though the events has been listed in the newsletter in the past, please send in the information to me and we will get it in the newsletter and on the web site. Send your events to Diana-copperrose@hughes.net

Because of Easter falling on the first weekend of April the Medieval fair in Norman will be held on the last weekend of March. Contact Terry Jenkins for more info.

Muskogee fair is held every weekend in May. You can get more info about any of the Medieval fairs from Terry Jenkins at teesox@aol.com

Trade items

Each month the meeting host have trouble deciding what to do for a trade item. Below is a list of potential trade items.

Letter Opener	Candle holder	Door Knocker
Small hand vice	nail header	yard art
Door pull	gate latch	hinge
Spoon	fork	knife
Miniature Log tongs	napkin rings (4)	fireplace poker
BBQ tool	ice cream scoop	flower
Fishing pole holder	something made from horseshoe	boot scraper
Something with a heart	animal head	decorative punch
Something made from a RR spike	trivet	leaf
Blacksmith traveler	nail	wall hook
Tongs	hardy tool	bell
Cross	feather	bottle opener
Nut cracker	wizard	hand shovel
Rug beater	flint striker	hack saw
Vase or vessel	Sheppard's hook	trammel hook
Scrolling jig	bending fork	spring fuller
Something made from a file	something riveted	
Maybe you can think of something else....		

Max and I want to THANK the Saltfork Craftsmen Club for bringing all the beautiful works of art to the auction on Sunday, Dec. 13, 2009. Some of you may not know that the auction alone brought in \$3000.00. God has blessed us with your love, your support, and prayers for our family during Max's illness. Our whole family prays that God will bless each and everyone of you. To those of you who have worked on our house a "Great Big Thanks". So many people have given you some of the nicest complements on your efforts. We do Appreciate each of you.. We hope you had the very best Christmas and a Happy New Year!!

Love.. Max & Ann Scrudder

President's Notes

Gerald Franklin

We have a couple of big events on the near horizon – in March we have the election of members to serve on the Board of Directors and the annual statewide meeting/picnic is scheduled for April. We have some good candidates who have already agreed to having their names on this year's ballot and if you would like to have your name added to the ballot, contact our Secretary/Treasurer, Mike George soon. The ballot will be mailed out in the March newsletter. So when you get the ballot, fill it out and mail it in for goodness sake! In past years, we have only had about thirty ballots returned. With a membership of well over 200 people to get such a small number of ballots cast is poor to say the least, so take this opportunity to support the club in a way that will take very little of your time.

The Board of Directors will meet on Feb 20 to discuss plans for the annual picnic. If you have some ideas about something that you'd like to see or do at the picnic, pass your thought on to one of the board members.

Last month I included a few reminders. As I look over the list now, I see that several items that are still appropriate with just a little bit of updating. So:

- **Pay your dues.** Memberships expire on March 30 and newsletters will stop for those who haven't renewed their memberships.
- **Remember your tongs.** Three Kings Day, January 6th was the agreed upon delivery date for the participants in the Christmas Tong Exchange to deliver tongs. If you haven't delivered your tongs yet, do it now. Please don't put your exchange partner in an uncomfortable situation by having to ASK that you send your tongs.
- **Schedule a meeting.** Diana Davis keeps the 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.
- **ABANA Conference.** The 2010 ABANA Conference will be held in Memphis in June. This is one of the closest locations to Oklahoma in recent years. Register early for a price break.

One last thing: The staff at the Ft Towson Historic Site, near Hugo, has agreed to host a meeting on February 6. We have been trying to generate more interest and membership in the southeast corner of the state for quite some time so come down and help wave the SCABA flag. Also, it would be a good opportunity for you to see a neat part of Oklahoma history. Directions and meeting details are in this newsletter

FARM WEEK

March 13-21, 2010



We need your organization at the zoo!

- What:** Farm Week—events for kids of all ages
- When:** Sat. March 13 through Sun., March 21 during the zoo's public hours. This is during spring break for most public schools.
- Where:** Tulsa Zoo, centered around the Contact Yard (petting area). The venue will be outside but can provide some shelter, and electricity will be available.
- Why:** To highlight the farming, ranching and rural lifestyle for our kids.
- What we need:** people & organizations for demos, products, exhibits, information booths, etc. for as much time as you can spare. While not a "trade show", you are welcome to advertise your organization.

To reserve a spot for your organization at Farm Week:
 Contact Paul Louderback @ 918-669-6249 or
 Plouderback@cityoftulsa.org
Spots are limited!



DURING FARM WEEK 2009, THE TULSA ZOO HAD 53,000 VISITORS DURING THE NINE DAY PERIOD.



THIS WOULD BE GREAT EXPOSURE (AND PR) FOR YOUR ORGANIZATION AND YOUR TRADE.



OUR GOALS ARE: EDUCATION, FUN, AND RAISING AWARENESS OF THE RURAL/COUNTRY LIFESTYLE.



COMMITMENT: ALL NINE DAYS OR JUST ONE...WHATEVER YOU CAN SWING.



WOODCARVERS, CANDLE MAKERS, SOAP MAKERS, BASKET WEAVERS, FARMERS, CHEESE-MAKERS, SILVERSMITHS, POTTERS, GARDENERS, HORSE TACK DEMO, BLUE-GRASS BANDS, CLOGGERS, ROPERS,.....ANYTHING RURAL OR COUNTRY! PLEASE



CONTACT US SO YOU CAN TAKE ADVANTAGE OF THIS GREAT OPPORTUNITY.



Christmas tong exchange.

This year there were 11 participants in the Christmas Tong exchange. Not only did Saltfork members participate but there were some participants from other groups.



This pair of tongs were made by James Allcorn from Paris Texas. Not sure who they were sent to.



This pair was made by Mark Williams of Snow Hill, MD



This pair was made by Nathan Robertson and was being sent to David Seigrist

More tong for the exchange...



These tongs were made by Jim Carothers and are being sent to Steve Parker

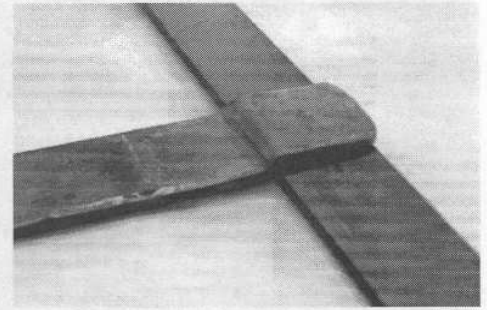
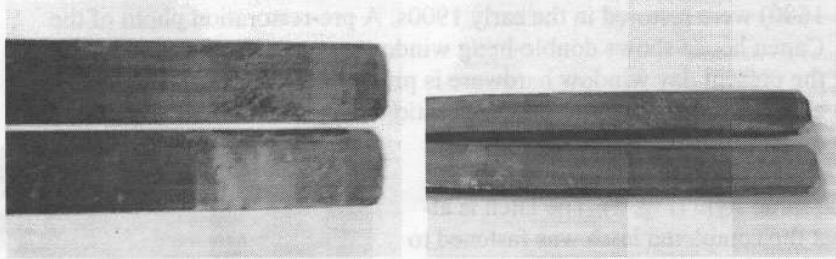


These tongs were made by Gerald Franklin and are being sent to Nathan Robertson

This is just 5 of the 11 sets of tongs that were made for the Christmas tong exchange. This is our second year to do this and it had grown larger each year. These are all nice tongs and Saltfork wishes to thank everyone that took part.

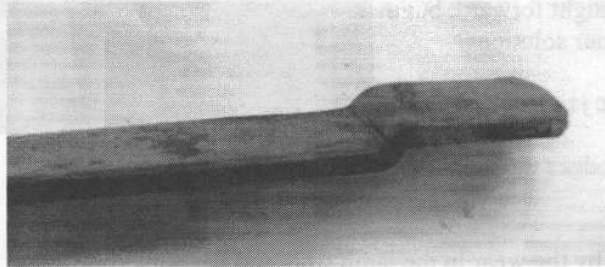
Quick Offset tool: Leigh Morrell

Here is a handy, but quick, tool which is a real time saver for creating offsets. I am not sure who I saw this from, but it is not new and the credit is due elsewhere. For this one I quickly grabbed two pieces of 3/16" X 1 1/4" off the rack for a 3/16 thickness offset,

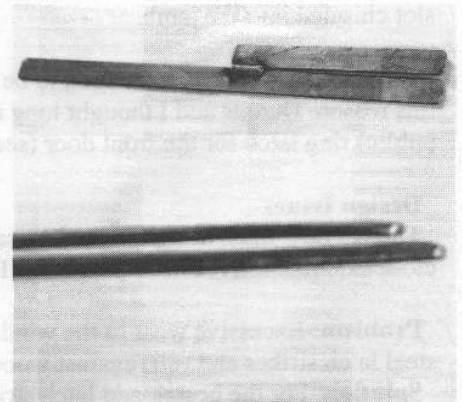


set a space between the two just shy of the dimension of material to be offset, in this case also 3/16", then weld up both sides. Then slightly offset both

bars to allow the forging material to pass between the bars created. Under the power hammer, this operation takes generally no more than two hits. I think the pictures are self explanatory. Make one up and try it out. If you have bean style keepers to make for thumb latches, make up the offsets first, then bean out the ends, making quick work of a keeper.

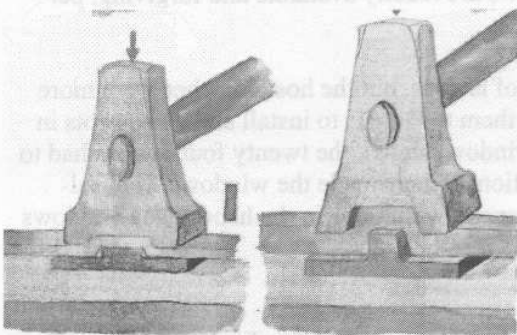
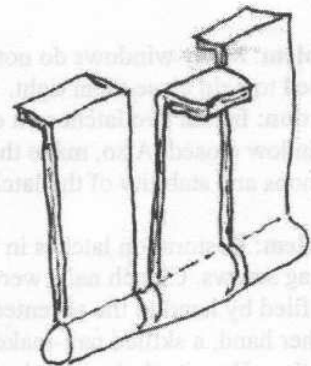


Fred adds: Such a tool could be used under a treadle hammer, too.



David Court once showed us a 3 leaved version for creating double offsets using your vise. I think it looked something like this:

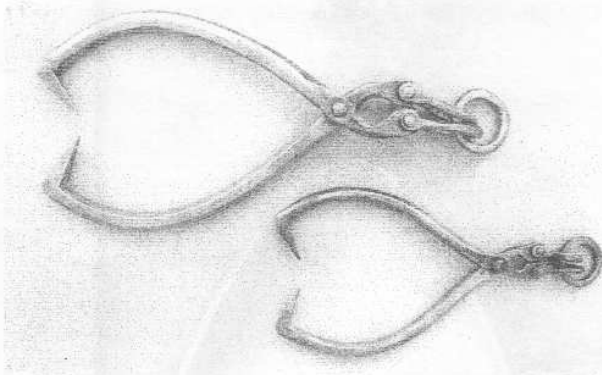
The important thing is to remember to provide the clearances, that Leigh mentions, based on the material being formed. Insufficient clearances will act as a shear, cut into and weaken the material being offset. Close bends like this can be frustrating to a beginner but taking the time to make the proper tool will bring its own reward.



Otto Schmirler's "*Werk und Werkzeug des Kunstschmieds*" shows large offsets being formed by special set tools. This book is one you should be "saving up for" because its color drawings explain so much of how decorative iron was created and is timeless in its easy to understand lessons.

Miniature Log Tongs

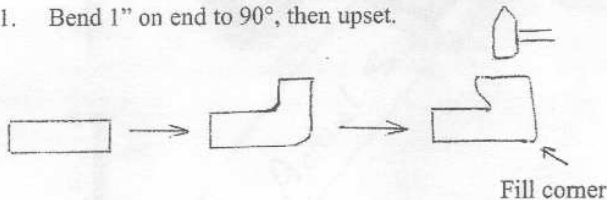
By Steve Anderson, a MABA member



Tongs 1/3 Scale

Material: 20-1/2" of 1/2" square stock

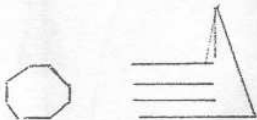
1. Bend 1" on end to 90°, then upset.



2. Forge the point.



3. While hot, forge heated end to octagon.

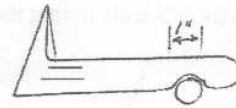


4. Quench and repeat on the other end, then cut in center to make two pieces.

5. Taper cut ends to 2/3 thickness and round end.

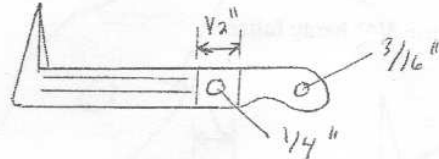


6. Over the horn, fuller the side opposite of the point.



* rotate to forge fullered area to octagon.

7. Forge the rest of the tong to an octagon shape, leaving 1/2" square for the pivot.

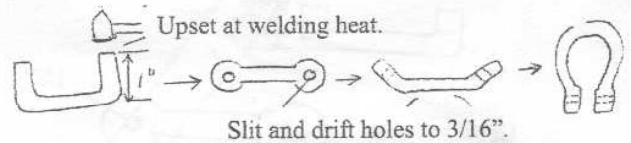


8. Slit and drift the holes.

9. File to clean octagon lines, then bend to shape placing a rivet in the 1/4" hole to prevent distortion. Use a wooden mallet.

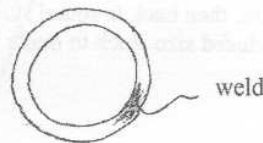
Clevis

Material: 2 pieces: 4-3/4" of 9/32" or 1/4" round stock.



Ring

Material: 5-1/4" of 5/16" round stock.



Assembly

1. Clean all holes with drill.
2. Cut 7/8" length of 1/4" round stock to be used as a temporary blind rivet so the two tong halves can be clamped at the pivot point in a vice. Use a wooden mallet to adjust and align the tong halves.



3. Remove the temporary 1/4" round stock and replace it with a 1/4" rivet at the pivot. Leave two times the diameter of the rivet to form a good round head.
4. Rivet clevises with 3/16" rivets remembering to insert the ring. Again use two times the diameter of the rivet for the head.
5. Apply finish of your choice.

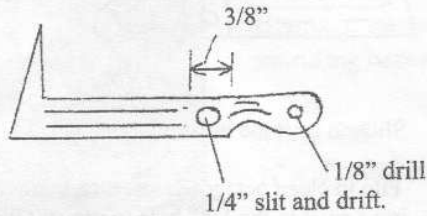
Tongs 1/4 Scale

Use the forging instructions for 1/3 scale noting the changes below.

Tongs

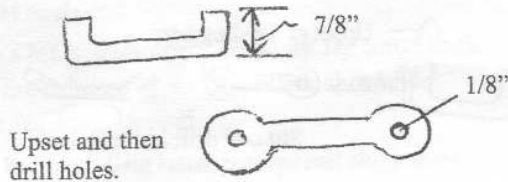
Material: 15-3/8" of 3/8" square stock.

1. Bend 7/8" on end to forge point.
6. To fuller, use 3/4" hardy fuller.
8. Holes:



Clevis

Material: 2 pieces: 3-1/2" of 1/8" round stock.
Bend cold in vice.



Ring

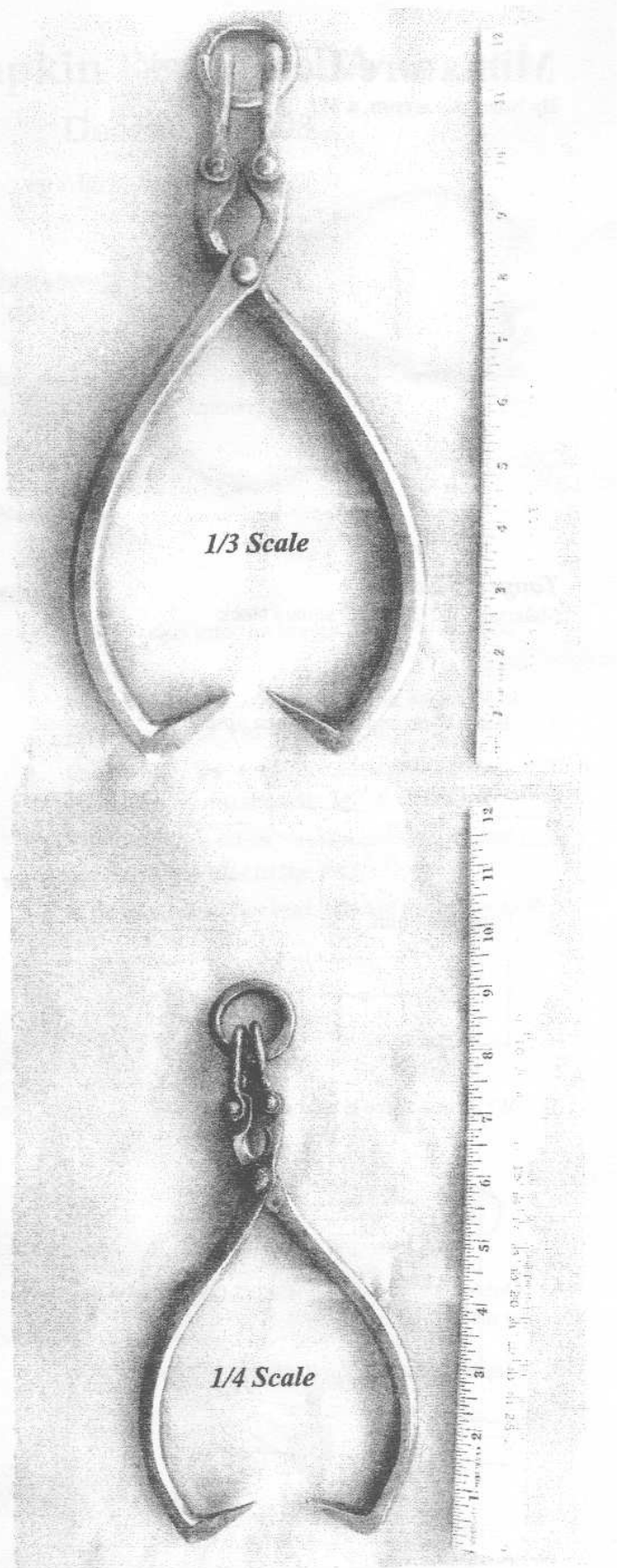
Forge 1/4" round stock square, then back to round stock, to reduce the size. Use 4" of reduced size stock to make the ring.

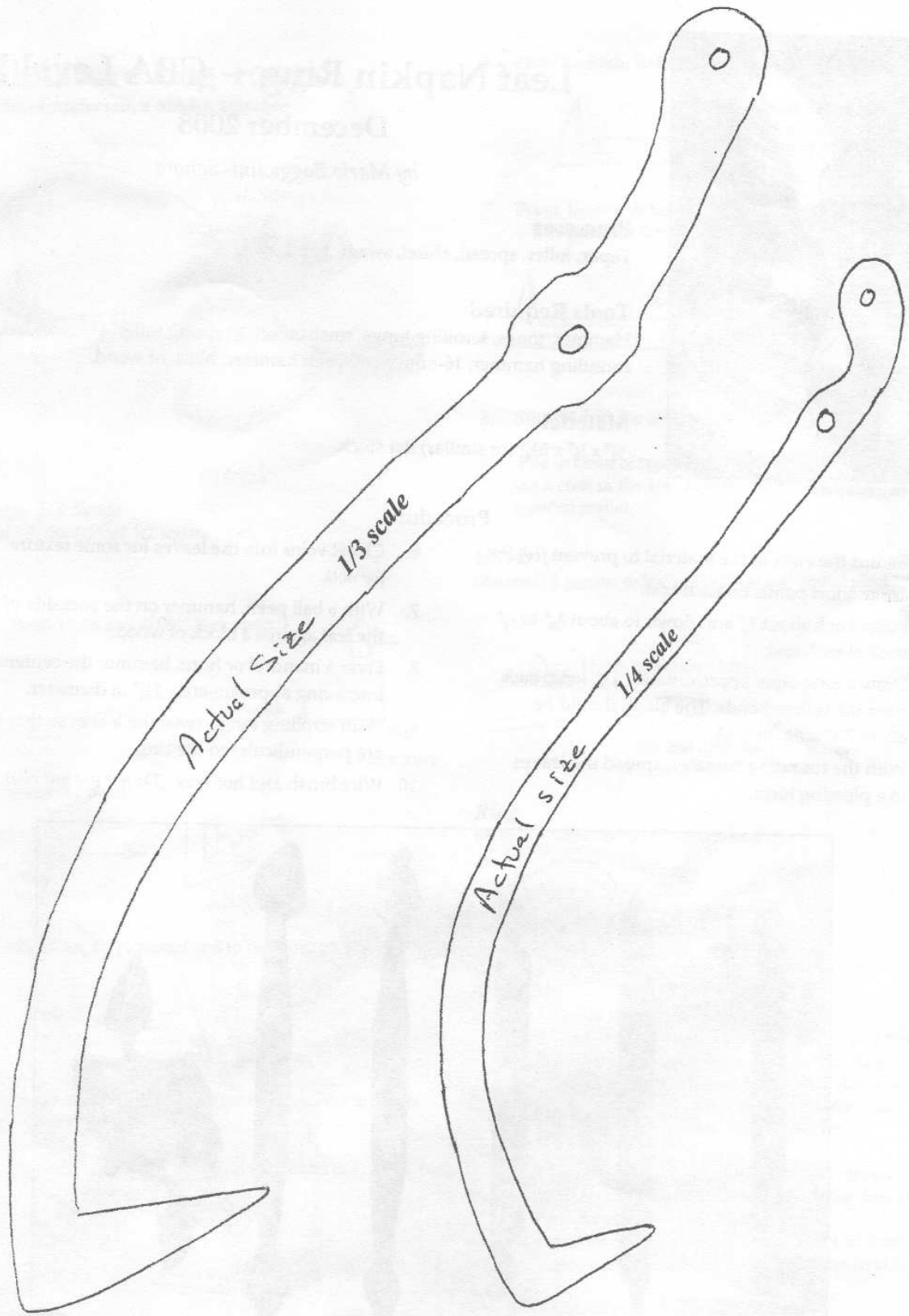
Assembly

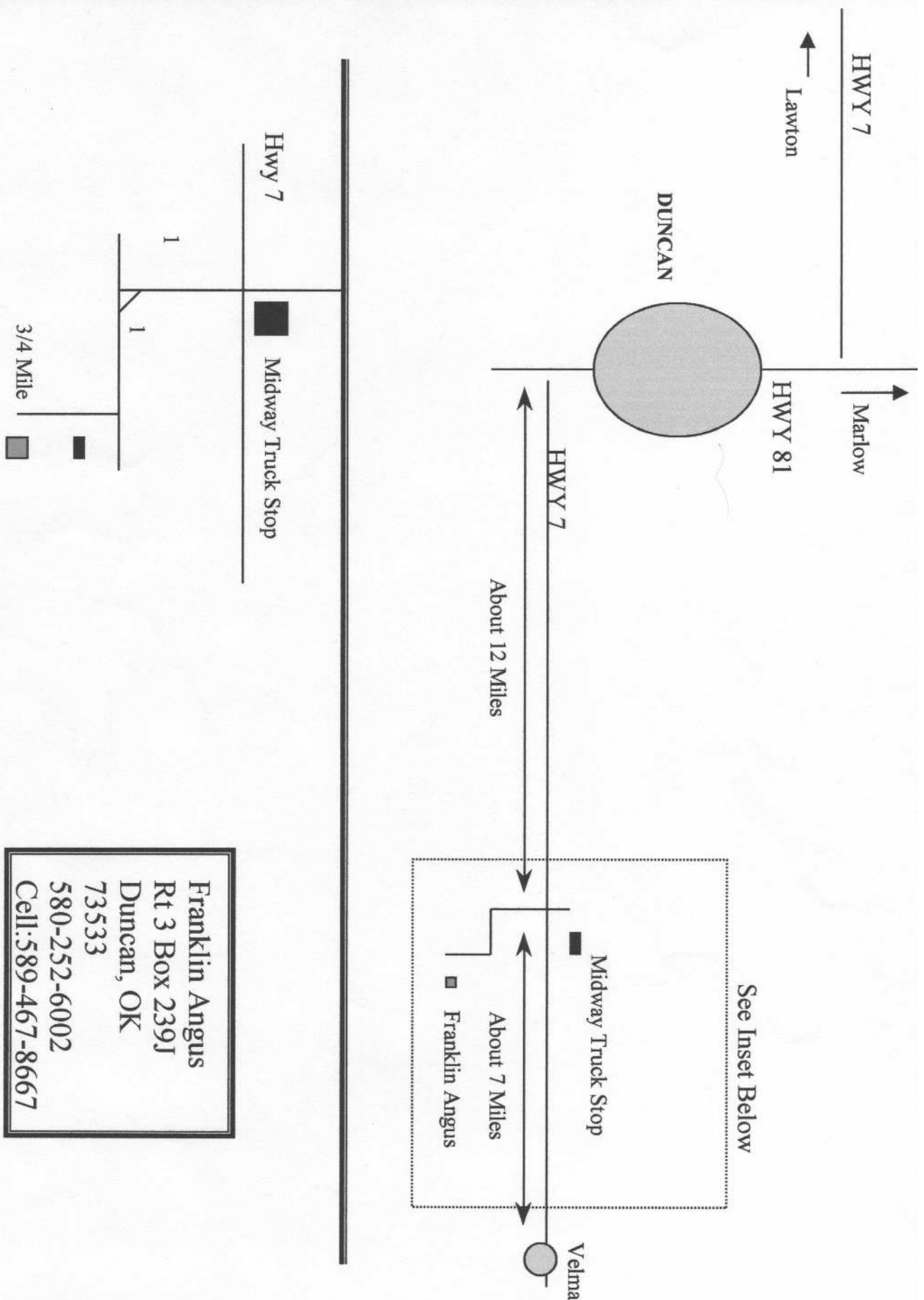
2. Cut 5/8" length of 1/4" round stock to be used as a temporary blind rivet so the two tong halves can be clamped at the pivot point in a vice. Use a wooden mallet to adjust and align the tong halves.



3. Reduce diameter of the rivet head on a 1/4" rivet.
Remove the temporary 1/4" round stock and replace it with the modified 1/4" rivet at the pivot. Leave two times the diameter of the rivet to form a good round head.
4. Rivet clevises with 1/8" rivets remembering to insert the ring. Again use two times the diameter of the rivet for the head.







Franklin Angus
 Rt 3 Box 239J
 Duncan, OK
 73533
 580-252-6002
 Cell:589-467-8667

NORTH EAST MEETING DATES

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

February 13, 2010
Host: Bill Kendall
Trade item. A heart

March 13, 2010
Host: Dan Cowart
Trade items: a 4 leaf clover or something

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 9, 2010
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 23, 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: a riveted item

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:

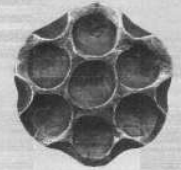
November 6, 2010
Host: open
Phone #:

December 4, 2010
Host:
Phone #



Decorative Bolts & Rivets

by Paul Mills, Victoria, Australia



Forge my own bolts and rivets? "Why would I want to do that?" you ask. While it's true that ordinary bolts and rivets are readily available, this utilitarian joinery can be used as decorative elements in your forge work.

Decorative bolts and rivets can add a special finishing touch to your handcrafted metalwork and set your work above all those around it. Surely a few nice decorative bolt heads would look better holding your hand-forged hinges onto the doors of St. Paul's Cathedral than a handful of hex bolts from the local hardware.

It is one of those things that look great, especially to the lay person, without being overly complex to achieve. All of the decorative effects seen here were created with just a few simple tools. The number of patterns and designs you can create is limited only by your mind and ability to make your own tools. As a smith, making the tools is something you can easily do, so why not try your hand at a few fancy bolts or rivets?

Tools Required

Heading Bolster

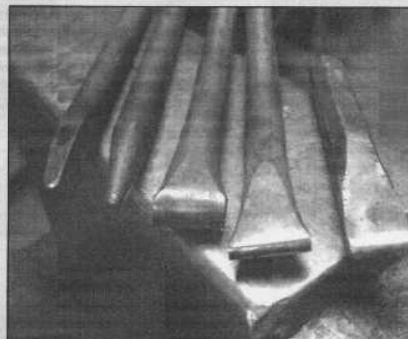
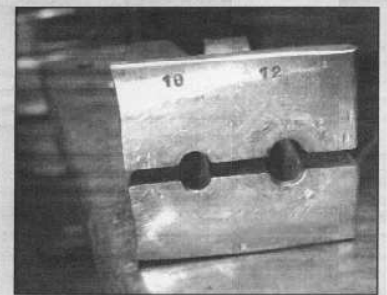
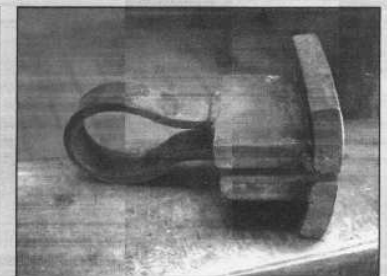
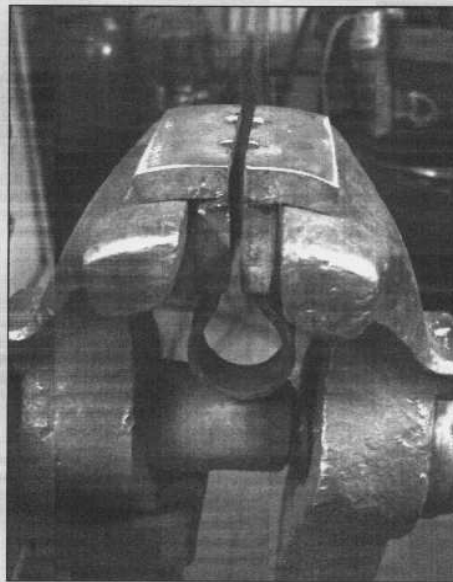
The one I have made is a spring-type bolster for mounting in a vice. You can also use a simple piece of plate steel with holes drilled in it to fit the size stock for your bolts/rivets for use on the anvil. **Hint:** Drill the holes on the centerline of the block and then cut the block along the centerline.

Chisels and Punches

These are largely dependent on the design you are trying to achieve: straight cut, half-round, eye punches, teardrop, fullers, etc. The size

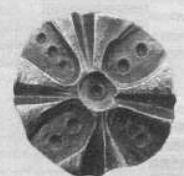
of the tools depends on the size of your work. You can easily get away with just a few tools if you work on the same scale each time. If your tools are made from good material and properly heat-treated, they will last you a lifetime, so look after them – keep the job hot and the tool cool!

The following can be said for all forging projects: You must have a clear plan of the job you are going to produce and the steps required to produce it before lighting your fire – at the very least a well thought out plan and design in your head but preferably a clearly drawn design on paper, preferably to scale.



Having a full-size drawing enables you to check your available tooling and to establish, well before the time comes to hit hot metal, if you need to make any more tools or jigs to produce the job.

Remember: Work smarter, not harder.





Creating Decorative Bolts & Rivets



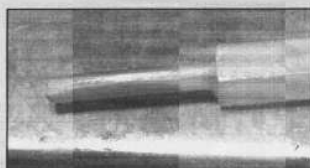
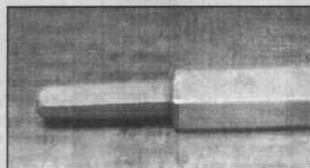
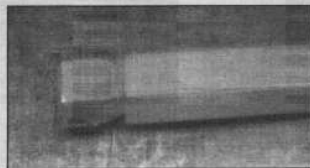
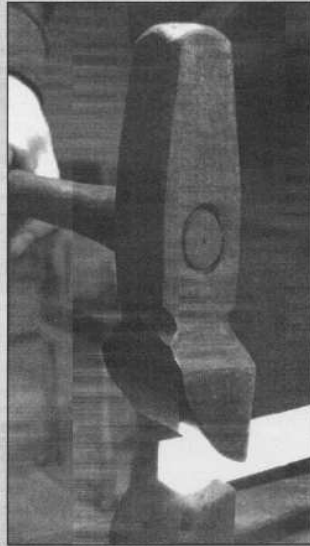
Method 1

Square Heads

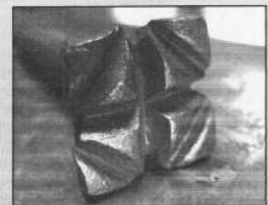
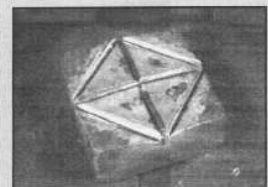
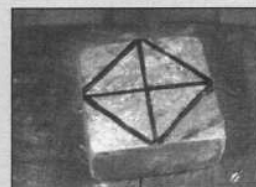
shown is 20mm square bar

Note well: All forging operations should be carried out at a high forging heat (yellow/orange).

1. Forge shoulder on the end of a bar using side-set or butcher tool. Be careful not to cut too deeply into tenon.
2. Draw out tenon to form the bolt shank. Forge square, then round, then swage to size. Ensure the shank is same size along its entire length. Check the shank for size in your heading bolster.
3. Cut off enough material to form the bolt-head required. This can be done using the cut-off Hardy, hot-set, cut-off saw, etc. With care, you can create a pyramid effect on the head of the bolt using the hardy by carefully cutting from all four sides equally.
4. Take a heat on the head section and drop the bolt into the heading bolster and forge to the desired thickness.
5. Remove bolt and refine shape of head on anvil. Forge head to desired shape.
6. Repeat steps 4 and 5 until desired shape and size are achieved. Leave bolt to cool. *(Time to make another!)*
7. Once cooled, lay out your design on the head of the bolt.



8. With the cooled bolt in the heading bolster, use the punches and chisels required for your design to mark the design on the bolt head, following your layout. This creates data marks that will enable you to follow your design accurately when the bolt-head is at forging temperature.
9. Take a heat on the bolt head only and drop it into the heading bolster. Follow your layout marks carefully, and chisel your design into the bolt head. Depending on the complexity of your design, this may take a number of heats. Remember to keep the job hot and your punches and chisels cool!
10. Once forging is complete, wire-brush the bolt and leave it to cool. Ensure there is minimal scale on the shank of the bolt as this will foul the thread-cutting dies when finishing your bolt. *(This is not as critical when making rivets.)*





Creating Decorative Bolts & Rivets



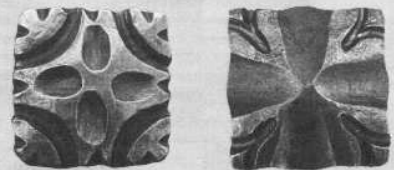
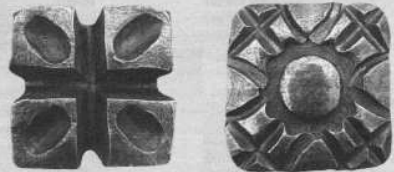
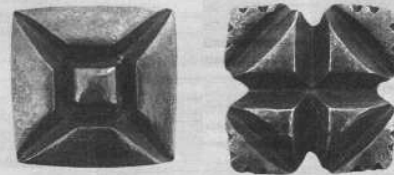
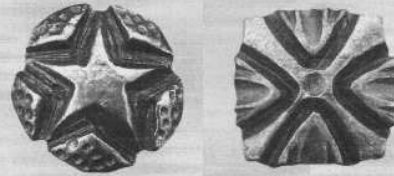
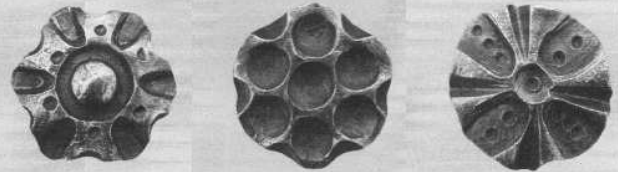
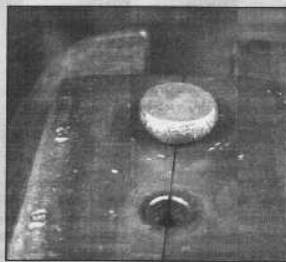
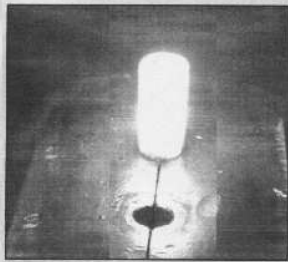
Method 2

Round Heads

(shown is 20mm round bar)

1. Take a short (40mm) heat on the end of the bar and drop into the heading bolster, leaving approximately 30mm protruding. This will give you a bolt head of about 25 x 25 x 5mm in size.
2. Forge the head down evenly, check for alignment and correct on the anvil if necessary.
3. Repeat steps 1 and 2 until desired shape and size are achieved. Leave bolt to cool.
(Time to make another!)

Follow procedures from Method 1, Step 7 to complete your decorative bolt/rivet. ♣



**LEARN HOW TO MAKE YOUR
LITTLE GIANT POWER HAMMER
WORK HARDER THAN EVER!**

Please join us March 19-21, 2010 for our annual Little Giant Rebuilding Seminar!

This class was first taught by our good friend Fred Caylor of Zionsville, Indiana. We carry on his tradition of teaching how to make Little Giants run well and hit hard.

This 2 ½ day class is a hands-on format. You will help transform a 25 LB Little Giant hammer from functional but sloppy condition into a well tuned, quiet, hard working hammer. Sid Suedmeier, owner of Little Giant, will share all his knowledge and experience gained from working with Fred and from 19 years of repairing and rebuilding Little Giants.

An old style 25 LB Little Giant will be rebuilt during the class, and a new style machine will be on hand to demonstrate proper assembly and adjustment of both styles.

The class is held in our shop in historical Nebraska City, Nebraska. The city has a wide variety of cafes, outlets (including Pendleton Woolen Mills), antique and gift shops, orchards, wineries and museums.

**IF YOU HAVE A LITTLE GIANT, THIS
CLASS IS FOR YOU!**

No experience is required to attend this class. Past students have ranged from age 15 to 90, and from all walks of life. Anyone who wants to learn will benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop.

If you are in the market to buy a power hammer, this class will make you an educated shopper. If you already own a Little Giant, or any other brand of power hammer, this class will teach you how to get the best performance possible.

The class costs \$95, refundable up to 7 days prior to the class; advance registration is required. We limit the class to 25 participants. The class starts at 9 AM sharp on Friday, and usually ends by Saturday evening. The schedule runs Sunday until noon in case we encounter any exceptional problems in rebuilding, and to answer remaining questions.

When we receive your registration, we will send you a city map, along with travel and hotel information.

Airports are located in Omaha (45 miles north), Lincoln (50 miles west) and Kansas City (125 miles south).

2010 REGISTRATION

Name: _____

Business name: _____

Address: _____

Telephone: _____

Email address: _____

PAYMENT

- Check enclosed
- Visa
- MasterCard
- Discover
- American Express
- Number: _____
- Expiration Date: _____

POWER HAMMER INFO

Brand: _____

Size: _____

Serial Number: _____

Please call or email if you have any questions, or prefer to register by phone. You can reach us at 402.873.6603 or Sid@LittleGiantHammer.com
Little Giant is located at 420 4th Corso, Nebraska City, NE 68410.

Saltfork Craftsmen

Artist-Blacksmith Association
Membership Application
April 2010 thru March 2011

Please accept my application

Date: _____

First Name _____ Last Name _____

Married? ___ Yes ___ No Spouses Name _____

Address _____

City _____ State _____ ZIP _____

Home Phone (____) _____ Work Phone (____) _____

E-Mail _____ ABANA Member? ___ Yes ___ No

I have enclosed \$20.00 for dues to March 30, 2011



ABANA

Name: _____

Email: _____

Address: _____

www url: _____

City: _____

Phone: _____

State: _____ Zip: _____

Fax: _____

Country: _____

TYPE OF MEMBERSHIP:

CREDIT CARD INFORMATION:

NEW MEMBER

RENEWAL

VISA Mastercard Expiration Date: _____

Regular - \$55.00

Contributing-\$100.00

Card Number: _____
Submit check, money order -U.S. Banks only, or by credit card:

Student- \$45.00

Library-\$45.00

Senior (65+) \$50.00

Foreign-\$65.00

ABANA Chapter Affiliation: _____

PO Box 3425

Knoxville, TN 37927-3425

Phone: 865.546.7733 Fax: 865.215.9964

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.
1227 Fourth Street
Alva, Okla. 73717-1227

U.S. POSTAGE PAID
STERLING, OKLA
NONPROFIT
ORGANIZATION
73567

Address Service Requested



Pay your dues by March 30

