

# Saltfork Craftsmen Artist-Blacksmith Association

May 2012



Teresa Gabrish and Byron Donor get all dressed up to go to the fair. Norman's Medieval Fair was the place to be March 30– April 1 2012.

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

President: Gerald Brostek                    918-687-1927  
205 N. Anthony  
Muskogee, Ok. 74402  
Gerald.brostek@sbcglobal.net

Vice-President/events:                    580-688-3555  
David Seigrist  
P.O. Box 163 Hollis, Ok 73550  
dseigrist2004@yahoo.com

Sec-Treas. Dan Cowart                    918-440-0653  
10380 N. 4010 Road  
Wann, Ok 74083  
ddcowart@gmail.com

Director/Editor: Diana Davis            580-549-6824  
23966 NE Wolf Rd.  
Fletcher, Ok 73541  
Diana.copperrose@gmail.com

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

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

Director: Don Garner                    580-661-2607  
23713 E. 860. Rd  
Thomas Ok. 73669

**Assignments:**

Webmaster:  
Dodie O'Bryan  
Pawnee, Ok  
scout@skally.net

Workshop Coordinator:  
Gerald Franklin                    580-467-8667  
Rt. 3 Box 2391, Duncan, Ok 73533  
franklin@myrhinomail.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.

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

**Notes from the Editor:**

The club has made some minor changes in the slate of officers this year. Gerald Franklin stepped down as President after serving the club in that capacity for several years. Under Gerald's leadership the club opened many new opportunity to educate the public about not only blacksmithing but the many other crafts demonstrated by club members.

Gerald Brostek was elected to the president position by unanimous vote. Gerald has already served one term on the board and also as co-chair of the annual conference. I feel that Gerald Brostek will help the club continue to grow and fulfill its mission towards educating the public.

As a newly elected board members, I look forward to working with the other board members and our new President.

The board had a quick meeting after the lunch break at the picnic to take care of some pressing club business. You can check out the minutes in this newsletter.

Again this year Byron Doner and myself are in charge of organizing the demonstrators for the State Fair. If you demoed last year please let me know about any changes that we need to make in the set-up of the forges. If I don't hear from anyone I will assume that everything is to be set up the same as last year. Those that demonstrated last year will have first choice of the days and times. As soon as I have the dates they will be posted and a signup sheet started.

***I would like to thank Ken Donor for the many photographs used in the newsletters each month.***

Until next month, have a safe time at the forge.  
Editor, Diana Davis

## Prez. Notes...

The annual State meeting and picnic held at Byron and Carol Donor's place was a fun filled day of visiting with folks from the far reaches of our membership range. We had a good turnout and enjoyed a great meal. The tailgating area was abuzz with folks looking over and dickering for items for sale or trade.



We received several decorative nails to add to the 2012 nail board. This nail board will be auctioned or raffled at our annual Conference in October and some lucky member will be able to display it in their home or shop. Thanks to all who contributed a nail. We still have time for you to make one if you haven't done so before the conference. If you have already made one and want to make another please do so as we have room for many more.

As for the nail making contest we held at the picnic, once Tracy Cowart broke the ice and became the first contestant, several followed working against the clock to create their three best nails in the allotted time. Diana Davis rounded up some ladies to be the judges and a winner was selected. Larry Urban was declared the winner and received an engraved plaque and \$20 Saltfork Gift Cert. I think all who entered as well as those watching enjoyed this fun filled contest. We were to have a second contest for who could make the most nails in an allotted time but the sun was in the west and the day growing short. Perhaps next year we will do it again. Most of the contestants used Byron's neat little induction heater. This machine will turn a 3" section of 1/4" stock a bright orange in a few seconds. Many of us old folks were amazed.

While the men were forging nails the ladies were learning the art of fold forming from Jewelry instructor Teresa Gabrish. They learned that with a little hammering and annealing and a few clips here and there they could turn out a one of a kind copper leaf. They could then add that to an existing piece of jewelry. After lunch they were introduced to PMC clay and each got to make charms from a 9 gram package. Once dry the clay was fired with a torch. Properly fired the clay becomes .999 pure silver. They were able to make between 4 and 6 nickel size charms. The Charms were decorated before firing by using rubber stamps.

We would like to thank everyone that helped out with the meal by bring a dish/desert, beverage or other type of food. It helped to made the meal complete.



## SOUTH CENTRAL REGIONAL PAGE

### Meeting dates

#### January 21, 2012

Host: Byron Donor

Phone #

Trade item: heart candleholder

#### February 18, 2012

Host: Gerald Franklin

Phone #: 580-252-6002

Trade item: feather

#### March 17, 2012

Host: Bob McKelvin

Phone #

Trade Item: pitchfork with three tines

Lunch: Hot Sandwich, bring a side dish/desert

#### April, 2012 (ANNUAL PICNIC)

Host: Byron Donor

Norman, Ok.

#### May 19, 2012

Host: Linda Morefield

Phone #

Trade item:

#### June 16, 2012

Host: Larry Mills

Trade items anything with three scrolls

Lunch: provided, bring a side dish

#### July 21, 2012

Host: Richard Simpson

Phone # 405-344-7413

Trade item: Campfire tool

#### August 18, 2012

Host: Charles McDevitt

Phone # 580-439-8931

Trade item: something from a horse shoe

#### Sept. 15, 2012

Host:

Phone #:

Trade item:

#### October 20-21, 2012

SCABA Conf. Perry, Okla.

#### November 17, 2012

Host: Bill and Diana Davis

Phone #: 580-549-6824

Trade item:

#### December 15 2012

Host:

Trade item;

Phone:



### Blacksmith picnic at the Donor's

We want to thank everyone that came to our home/shop for the Statewide Free Family Picnic. We appreciate all of the food that was donated for the hamburger/dog picnic lunch. We also want to thank rusty and josh for grilling and Megan for assisting with everything. Byron and I had a great time visiting with everyone. We heard the women's classes and Men's nail contest were great! Congratulations to Larry Urban for winning the nail contest.

Thank you all for bearing with our construction zones. We were glad to see your families; i.e. lots of wives that we don't always see. We had 60+ sign in, so our best guess is 70? Maybe next year we'll hit 100.

We had missed the Hadicks but never dreamed they were at the hospital spending their last hours with Brahk's wife Charity. Our hearts go out to the whole Black/Hadick family.

Byron and Carol Donor





## NORTH EAST REGION

### Meeting dates:

#### **January 14, 2012**

Host: Bill Kendall  
Phone # 918-742-7836  
Trade item: ladle  
Lunch: provided, (possibly chili), bring a side/desert

#### **February 11, 2012**

Host: Gary Gloden  
Phone# 918-321-5015  
Trade item. leaf  
Lunch: provided, bring a side dish or dessert

#### **March 10, 2012**

Host: Dan Cowart  
Phone: 918-440-0653  
Trade items: spoon, fork or knife  
Lunch: provided, bring a side dish

#### **April 14, 2012**

Host: Omar Reed at Fort Gibson  
Phone: 918-478-4088  
Trade items: cooking item  
Lunch: provided, bring a side dish

#### **May 12, 2012**

Host: Ed. McCormack  
Phone #: 918-733-9844  
Trade item; something made from horseshoe  
Lunch: provided, bring a side dish

#### **June 9, 2012**

Host: Mike Krukoski  
Phone # 918-789-2484 or cell 636-297-0329  
Trade item:  
Lunch: supplied, bring a side dish

#### **July 14, 2012**

Host:  
Phone #  
Trade item;  
Lunch:

#### **August 11, 2012**

Host:  
Phone#  
Trade item  
Lunch:

#### **Sept. 8, 2012**

Host: James Maberry  
Phone # 918-440-0653  
Trade item: something with a leaf on it  
Lunch: supplied, bring a side dish

#### **October 20-21 2012**

##### **State conference**

#### **November 10, 2012**

Host: Matt Goyer  
Phone # 918-272-8424  
Trade item:  
Lunch: lunch provided, bring a side dish

#### **December 8, 2012**

Host: Charlie McGee  
Phone # 918-245-7279, cell 918-639-8779  
Trade item: ladle  
Lunch: provided, bring a side dish

## NORTH WEST REGION

#### **January 28, 2012**

Host: Ron Lehenbauer  
Phone#  
Trade item; punch/chisel/tool for shop in Fairview

#### **February 25th, 2012**

Host: Mandell Greteman  
Phone #  
Trade item: eye punch

#### **March 24, 2012**

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

#### **April 28, 2012**

Host: Tom Nelson (held in Perry at the  
Phone #  
Trade item:  
Lunch: Sack lunch or on own

#### **May 26, 2012**

Host: Fred Voss  
Phone #  
Chisholm trail museum in Kingfisher

#### **June 23, 2012**

Host: Gary Seigrist  
Phone #:  
Trade item; something made from horseshoe

#### **July 28, 2012**

Host: Don Garner  
Phone #:  
Trade item: Hardy tool  
Fairview shop

#### **August 25, 2012**

Host: Bob Kennemer  
Phone #:  
Trade item: cooking Utensil

#### **Sept. 22, 2012**

Host: Ron Lehenbauer  
Fairview Threshing Bee  
Trade item;

#### **October 20-21 2012**

##### **State conference**

#### **November 24th 2012**

Host: Roy Bell  
Lunch:  
Trade item: bell

#### **December 22, 2012**

Merry Christmas

## SOUTH EAST REGION

### January 7th 2012

Host; Bill Phillips

Phone:

Lunch: provided, bring side/desert

Trade item: steak turner

### February 4, 2012

Host: Eddie Horton ( Ft. Towson)

Phone #: 580-873-2634

Trade item: Heart

### March 3, 2012

Host: Eddie Horton (Ft. Towson)

Phone #: 580-873-2634

Trade item: Leaf or Flower

### April 7, 2012

Host:

Phone #:

Lunch:

Trade item:

### May 5, 2012

Host: Bill Phillips

Phone #

Lunch: provided, bring side/desert

Trade item: spoon

### June 2, 2012

Host: Ronnie Smith

Phone:

Lunch: provided, bring side/desert

Trade item: critter

### July 7, 2012

Host:

Phone #:

Lunch:

Trade item:

### August 4, 2012

Host: Eddie Horton (Fort Towson)

Phone #:

Lunch: Mr. Wallace Dutch oven cooking

Trade item:

### Sept. 1, 2012

Host: Bill Phillips

Phone:

Lunch: provided, bring side/desert

Trade item; knife

### October 20-21, 2012

SCABA Conference

### November 3, 2012

Host:

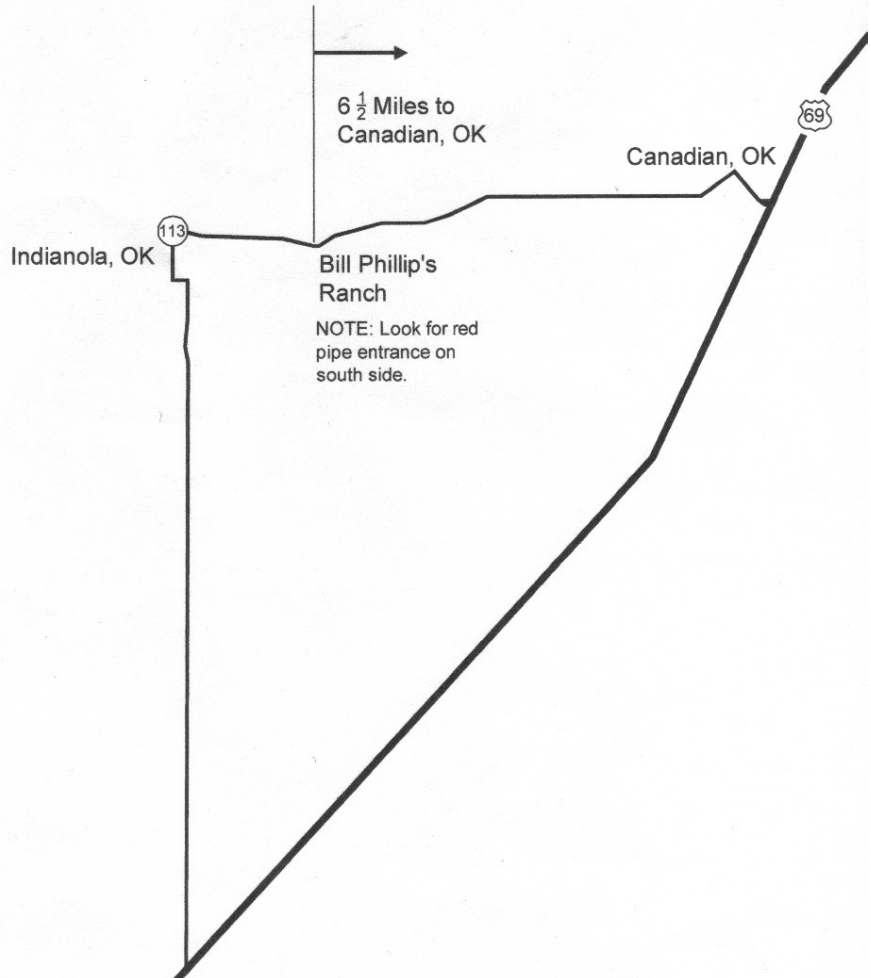
Phone #:

### December 1, 2012

Host:

There was no meeting in the SE region in April.

May meeting will be at Bill Phillips Ranch (see map) Lunch is provided, bring a side dish. Trade item is a spoon.



Teresa Gabrish is offering a rose making class on May 26th.

It will be held at Arrowhead Supply

330 SW 28th Street

Oklahoma City, Ok

Cost is \$45.00 for copper, Sterling Silver is extra

For more information contact Teresa Gabrish at

405-795-8982

## North East Regional meeting in April

Hosted by Omar Reed at Fort Gibson.  
Report by Gerald Brostek

The Ne meeting at Fort Gibson had a light turnout. The threatening Sky's apparently kept most near shelter, we were able to do a bit of smithing till 11am when the rain cme. We had lunch inside one of the log buildings and headed for the house soon after. Brandon Jackson of Tulsa came by and decided to join the club.

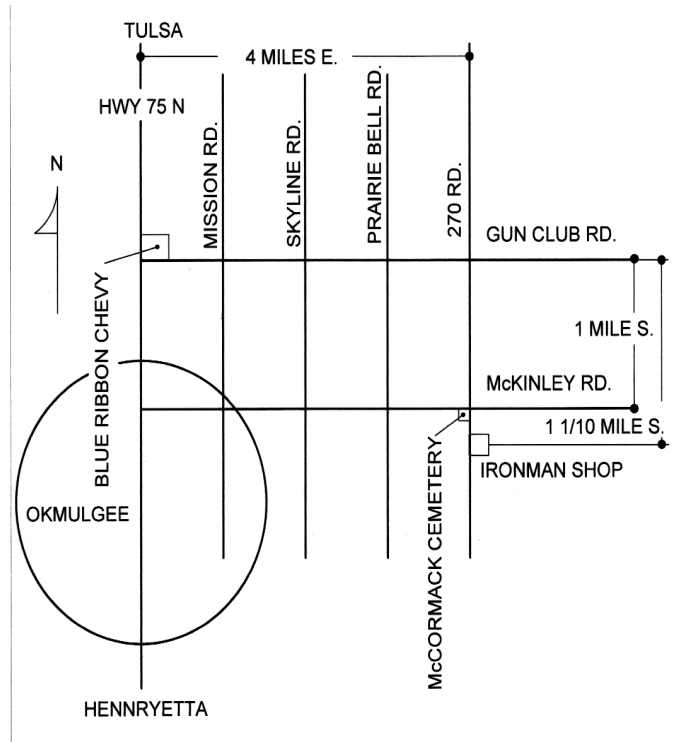


## North East Regional meeting in May

Hosted by Ed McCormack at his home/shop in Okmulgee, Ok. (See map for directions)

Ed is providing lunch but bring a side dish to help out.

He has chosen something made from a horse shoe. If you need more info. 918-7339844



I featured these two young men on the front of the April newsletter but failed to get their names mentioned. I am sorry for that but here they are. Pictured are Joshua and Jacob Hodges. "1st timers"



## Demo opportunities:

- ◆ June 2nd, Eddie Horton and Mark Hamill are demo-ing for the Hugo Homecoming in front for the Old Frisco Depot. Everyone is welcome to come by and help out. Usually have a good turnout.
- ◆ Pawnee Bill's Wild West Show held annually the last 3 weekends in June at the Ranch Site museum. Located on the west edge of Pawnee, Ok. Saltfork has had a blacksmith or two every weekend at the event for many years. It is a fun place to demo as well as enjoy the side and main shows. Smiths can bring their own forges and tools, there is a good place to spread out in the shade just outside the old Pawnee Bill Ranch blacksmith shop. The original shop is open for our use as well. Bring a portable box fan if you plan to use the shop forge. You will need to bring your own project steel and coal for the day. Come join the fun on Saturday June 16, 23, or 30.

The museum contacts for the event are Erin or Ronnie Brown [ebrown@okhistory.org](mailto:ebrown@okhistory.org) or 918-762-2513

The Saltfork Craftsmen were well represented during the Medieval Fair that is held each year in Norman, Okla. There were 5 forges going all three days of the Fair. Each year that the Saltfork Medieval Smiths have worked for the King they have more recruits come to participate. I'm not sure how many smiths worked this fair but it would be safe to say that there were at least 10-12 smiths. And that doesn't count the number of members like myself that stopped by to shout "Good Morrow" to all. The Medieval Smiths will be at the Muskogee Castle each weekend in May so stop by if you get the chance and bid them a "Good Den".



## Norman Medieval Fair March 30,31, April 1

On Thursday afternoon, March 29, a gathering of members of Saltfork converged on Reeves Park to set up for demonstrations at the 36th annual Norman Medieval Fair. After some initial miscommunication as to what we did or did not need to do and what we could or could not do, (Thanks very much to Norman Council woman Linda Lockett for straightening that out for us) we hit the ground running and didn't slow down



from before 9:00 am until after 7:00 pm on all three days of the fair. This was the first time for Teresa Gabrish and Chuck Ogden to demo at a medieval or renaissance event and they both took to it very well. To list all of our members who worked alongside or Terry Jenkins and Byron Donor to make this a fun and enlightening event would fill an article. Likewise to list the members who visited us during the fair, would be quite long. Some came to encourage, others to see what we were doing, and some came for the chance to give a little good natured harassment. We were glad to see and talk with everyone. For those of us who have done this event in the past, it was an opportunity to visit with friends that we haven't seen in a while. For the newcomers, it was a chance to meet new people and share our skills and ability with a lot of people that we might not meet otherwise. (In three days, about 400,000 people attend the Norman Medieval Fair each year) members made everything from tent stakes, to beautifully decorated mirrors, railroad spike knives, to roses. Jim Stubbs was honored by the king and the court of the fair for the work that he did making small swords from duplex nails for the kids last year. Several people asked about our organization and asked about attending meetings and joining Saltfork. Many people stopped to thank us for showing the wide variety of things made by blacksmith and the amount of labor that went into the things that many of us take for granted. The general consensus was that it was a lot of fun for everyone and we and the staff of the Norman Medieval Fair look forward to doing it again next year.

Steven Knisely



## More demo-ing around the state

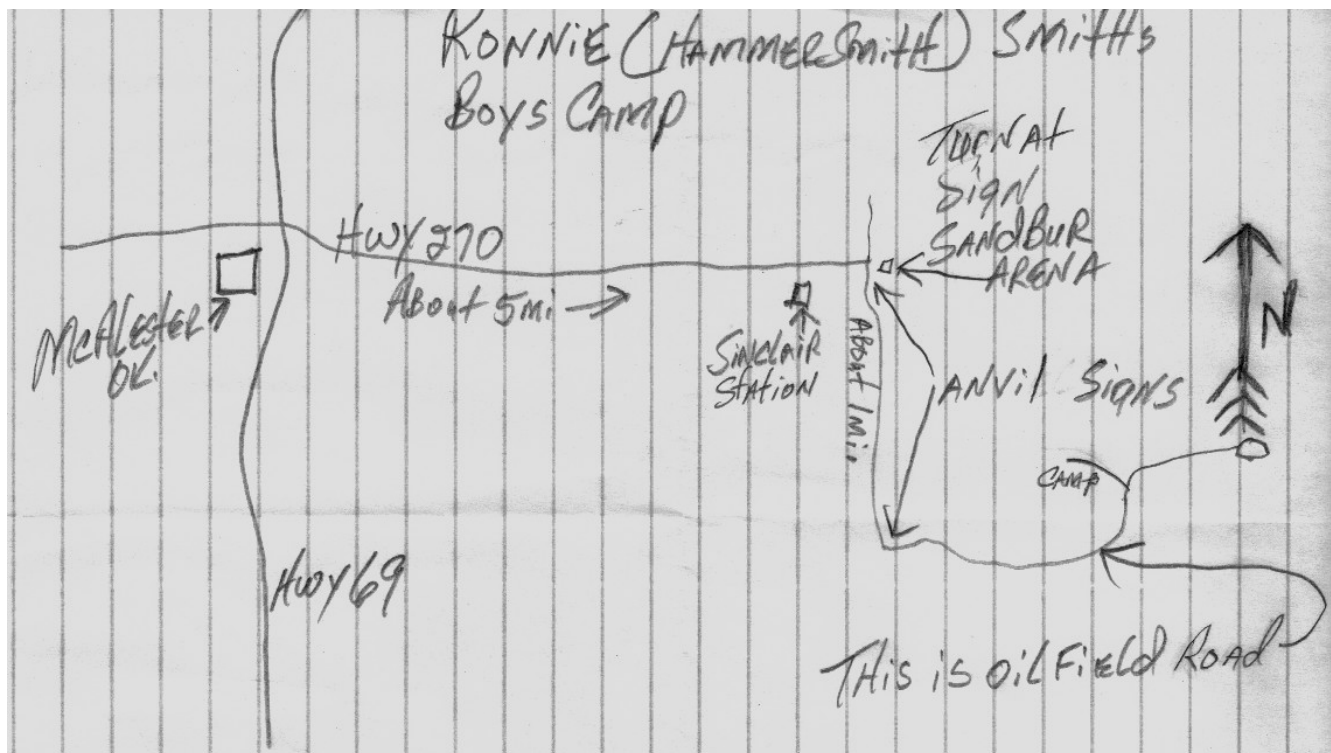
### *From Fred Voss..*

First I did the living history day for school kids at the kingfisher Chisholm Trail Museum on Friday, they had 500 kids registered to come. We had a good crowd and very good weather. (Sorry not picture).

On Saturday I was out at Williams' Scout Camp for the day. Went up Friday night to set up. They too had around 500 scouts registered to show up. We had a good storm on Friday night with around 2 plus inches of rain with wind and thunder around two in the morning. The day turned out very well and we had a good crowd almost all day. Nick Mingus, a new member of the Saltfork Craftsmen came by and used the forge for awhile. Was a welcome relief as I got to walk around and see the other things going on. All in all it was a good weekend.



Map/directions to meeting for the SE region on June 2nd.





# The Ring Thing

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By Paul Novorolsky

## [UMBA Scholarship payback article: part 3 of 3]

Tooling: Swages, Punches and Drifts

In this last article in this series, I describe the forging of the remaining tools created for The Ring Thing. The previous articles described how to make the ring itself, swages, punches and drifts. This will describe the remaining tools, a bolster, scrolling (dog) wrenches, a frustum of a cone, and chainmaker's swage.

### Bolster

A small, square-holed bolster was made to support the stock while drifting the square holes. This is more of a concern with the holes punched in the round stock, where this is less material to support it than with the holes in the square bar. Nonetheless, the bolster is useful for both pieces.

The size of the bolster must be slightly larger than the size of the square drift, so that it can pass through the bolster without interference. This amounts to "3 increments of oversize" when the bolster cools. From the previous article, we said that the drift is 2 increments over-sized, so the bolster needs to be an additional increment to allow for a non-binding fit around the drift, plus an additional amount to accommodate the contraction upon cooling.

So if the square drift is slightly oversized when first forge (before filing), it can be used to drift the bolster before it is filed to its final dimension. Some additional filing may be necessary on the bolster, but this will get you close.

We started the bolster by drilling a  $\frac{1}{2}$ " square hole in a piece of  $\frac{1}{4}$ " plate, approximately 3"x3". Then the oversized square drift is used to drift the hole. Take care to get the corners of the drift aligned so that the corners are closely aligned to the horizontal and vertical axes, as this will make it easier to line up the close-fitting bolster during use, while the hole is obscured from view. Relieve the edges on the hole in the drift to further avoid any binding as the bolster aligns with the drift.

### Scrolling Wrenches

The scrolling wrenches we made are also described in "Mastering The Fundamentals of Blacksmithing", and a video of the process can also be found on YouTube. I'll describe them here, as the YouTube demo leaves out the calculations and dimensions. The book devotes an entire chapter to this process, so this is quite abridged. Nonetheless, I believe this description, together with the YouTube video will be sufficient to produce these wrenches.

Begin with a 24" length of  $\frac{3}{8}$ " x 1" bar. This should be enough material to make 2 wrenches, one from each end. The "fork" end is formed first, and we need to determine the amount of material to isolate.

In Figure 1, the top representation shows the dimensions of the finished product. The working end is forged down to  $\frac{7}{16}$ " x  $\frac{1}{2}$ " before bending. We will calculate the volume of material needed for that component. The total length of  $\frac{7}{16}$ " by  $\frac{1}{2}$ " material,

$$1 \frac{3}{8} + \frac{1}{2} + \frac{1}{2} = 2 \frac{3}{8}$$

which is from "Point P" to the end of the bar, is:

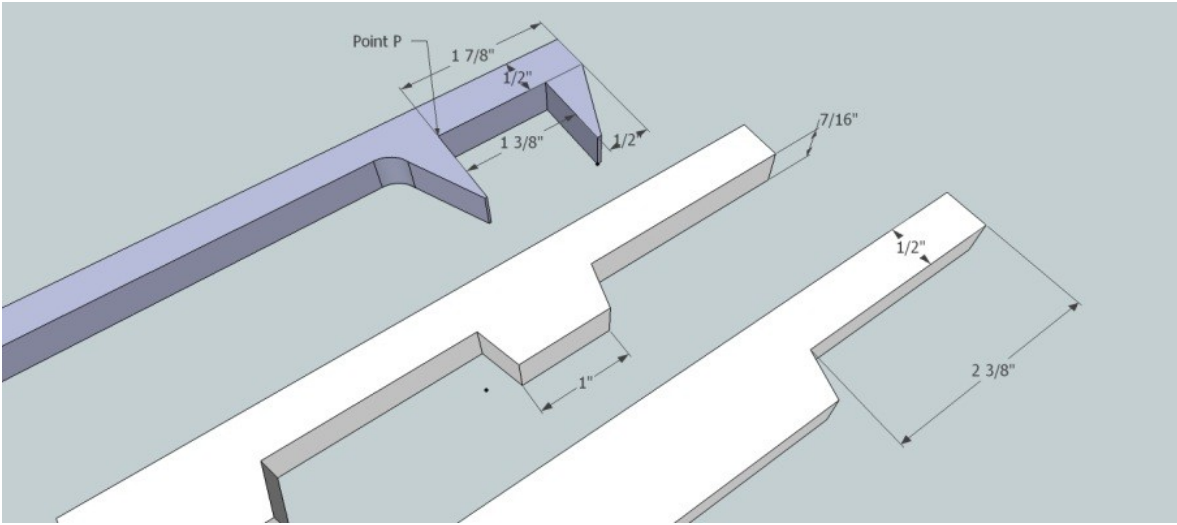


Figure  $1 \frac{3}{8} + \frac{1}{2} + \frac{1}{2} = 2 \frac{3}{8}$

$2 \frac{3}{8} * \frac{7}{16} * \frac{1}{2} = \frac{133}{256} = 0.519 \text{ in}^3$

Multiply that by the area of the cross section:

$2 \frac{3}{8} * \frac{7}{16} * \frac{1}{2} = \frac{133}{256} = 0.519 \text{ in}^3$

to determine how long of a section of the 3/8" x 1" stock to use, divide that by

$.519 \div .375 = 1.384$  or a little over 1 3/8".

3/8" x 1" (3/8 sq in). So you have

or a li

ttle over 1 3/8". I

used 1/2" because it was easy to mark and forge and "close enough" here.

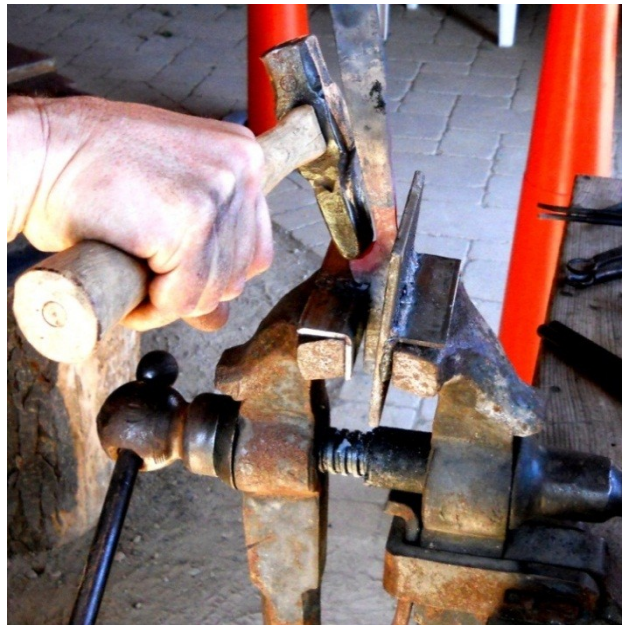


Figure 2

So lay about 1 1/2" on the anvil, take a couple of half-faced blows and draw out the isolated material to approximately 7/16" x 1/2" and about 2 3/8" long. It should look like the far right/bottom representation in Figure 1. Next lay about 1" of the unforged stock off the far side of the anvil, and forge it down so it is similar to the piece in the center.

Figure 2 shows forging the inside tine using a fuller (I'm left handed, so my hammer is in the other hand.) When doing this, a vise insert is used. The insert is made up of a piece of angle iron on the front jaw, and a backing plate

welded to another piece of angle on the back jaw. The backing plate supports the work piece while using the fuller to forge down the isolated blob into a tine.

Be sure to dress the tine as work progresses so that the inside corner and edge are always tight against the front jaw insert. Otherwise you run the risk of a cold shut here. Once the first tine is forged, draw the far end to a taper about 1" long. Then relieve the edges with a file while you can still get at them. Reheat the end, quench the tip, and forge an upset square corner for the end tine. Use a small piece of stock as a set hammer to dress the bottom of the "U" in the fork.

## Cones

The rings are shaped around a frustum of a cone. A frustum is a truncated cone, in this case with the "top" removed. The use of a truncated hollow cone makes it easier to use the dog wrenches to pull the ring around cone. In addition, the small cone segment then allows cutting channels into the sides to accommodate the bar it passes through.

The top of the cone must be small enough to allow the ring to slide over, and the slope will accommodate any differences in size of the ring. For this exercise, we make a cone that is about 3" outside diameter at the top and about 4" inches at the bottom. The diameter of the ring is about 3 5/8" at its center, which makes the inside diameter roughly 3 1/4", so it should easily fit easily over the top of the ring.

To calculate the material for the ring, we will start with the midpoint of the outside surface of the cone, which will be a 3 1/2" diameter circle. Then to account for the compression of the inner surface and stretch of the outer surface, we will calculate based on the center of the material. Since the material is 1/4" thick, we subtract 1/8" from each side of the diameter (or 1/4") to arrive at an effective diameter of 3 1/4".

The circumference is  $\pi * diameter$ . We'll approximate by using 3 for pi, making the length of material needed 9 3/4". In order to shape the cone, the top diameter must be shorter than the bottom diameter. This can be achieved by first bending the stock the hard way. The inside edge will become the top of the cone, and the outside edge will become the bottom edge.

Next, draw the layout for the cone. This is done by setting up 2 parallel lines, separated by a distance that matches the width of the stock. In this case 2 1/4". A center line is then drawn. From the center line, make a mark at half the small diameter of the cone on the top line. In this case, we mark at 1 1/2". Similarly, mark the bottom line at the radius of the larger dimension, which is 2". Now use a straight edge that connects those two marks, and continue that line until it meets the centerline.

Take a length of string and a pencil or soapstone and using the intersection of the centerline and the line you just drew as the pivot point, measure off an arc to each point where the centerline intersects the parallel lines, and sweep an arc so your sketch looks something like the right side of Figure 3. This is now the arc to which you will forge your cone segment.

As in the other components, there is a video of this procedure on YouTube.

Remember that, as the arc is formed, the inside edge will be compressed and "push out", and the outside edge will be stretched and the corners "pulled in". So, to keep the end "in line" with the radius, we pre-deform the ends so that after they move, they are in line with the center point. This is done by upsetting the inside edge, and then walking that taper to the outside edge

Take a good heat along one end of the bar, and hold it on the anvil so the long edges are horizontal, one above the other, and perpendicular to the far edge of the anvil. Now upset that corner along the long edge about 3/8", so that the length of that edge is now about 9 1/8". (No need to measure that 9 1/8, I only added that so it is clear which direction you are forging.) Dress the flat of the bar to maintain control, but there is no need to flatten the upset. We'll just leave that on the inside of the cone. Walk that upset to the near corner so that it forms an even taper.

Repeat this process on the other side. Be sure that both upset ends are on the same long edge of the bar! Also, try to move the upset to the same face, so that will become the inside of the cone.

Next, take a good heat over about 1/3 of the bar. Again place it on edge on the anvil, with the length of the bar horizontal and perpendicular to the far edge. Keep the far end on the anvil while you lift your tong hand so that the bottom edge of the bar is about 3/8" above the center of the anvil, and strike the top of the bar a short distance nearer the tongs, driving this gap onto the face of the anvil. Repeat this



process while feeding the bar away from yourself, and you should get a reasonable curve. Reverse the bar end for end and repeat so the entire bar has an even curve. Check the bar against your layout. If you overshoot the curve and make it too tight, remember that you have effectively upset the inside circumference of the bar, and you can forge that edge back down a bit, which will stretch it and straighten the bar slightly.

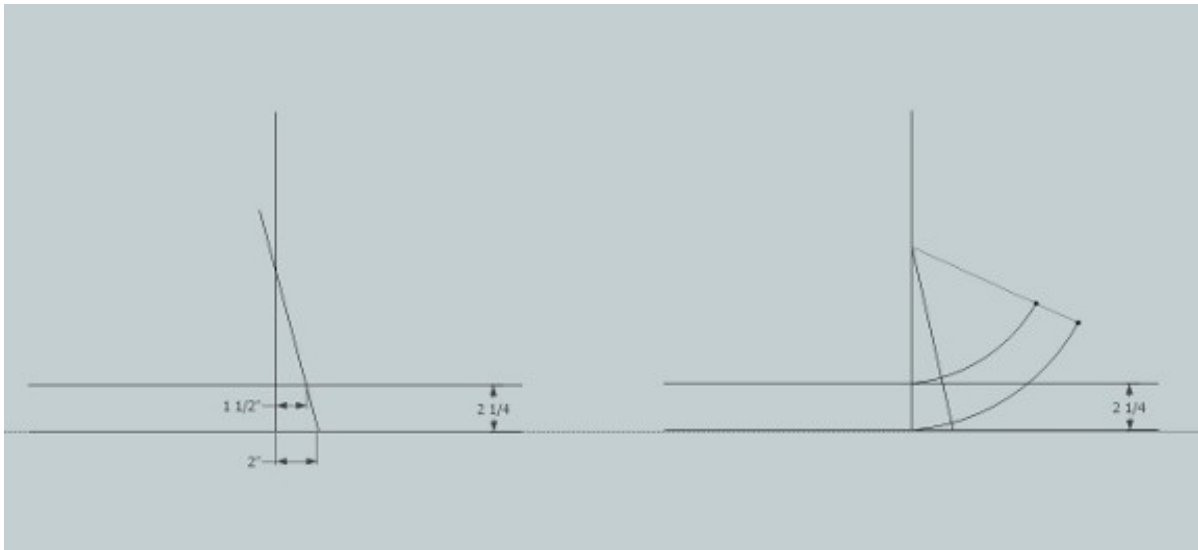


Figure 3

The next step will be to roll the bar into a cone. But before we do that, we need to pre-distort the shape once again. As the cone is rolled up, the inside surface will be compressed, and outside surface stretched. This will result in cupping. To avoid this, the bar must be “pre cupped” in the opposite direction. Heat the bar, and using a shallow swage, or possibly a log stump, forge the bar to create a shallow depression along the length, with the concave side on what will be the inside of the cone.

Once this is complete, take a good heat, and repeat the process used to bend the bar the “hard way”, but this time bend it the easy way, with the concave surface from the previous step on the inside. This step is a little tricky, as you are basically shaping a circle freehand. To make the process less daunting, I found it helpful to draw a circle of the appropriate size on the layout drawing and test the piece against that. This helps make it easier to see where the adjustments need to be made. A pair of hoop tongs (Figure 4) is also helpful in forging the cone, as it can then be held securely while shaping around the horn or on the face of the anvil.



Figure 4 Hoop Tongs

Dress the cone as needed during the forging process and correct any deformities early. A small gap at the joint of the 2 edges is acceptable for this cone as we will be cutting clearance slots for the pass through bar. We used a plasma cutter to hurry things along in the class, but given my lack of experience with that tool, I think the cleanup consumed any time savings the cutting may have provided. Cutting with a hacksaw would certainly be adequate, and for me, preferred.

Before cutting the slots, weld the cone onto a base, and add a short piece of steel angle or tube to the base so that the cone can be held in a vise or anvil hardy hole.

There are 2 slots cut into the cone, 180 degrees from each other. The slots are about 3/4" wide, and about 2" or more deep. These recesses will accommodate the square bar while the ring is formed around it.

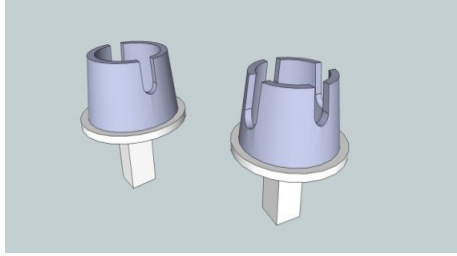


Figure 5

A second cone is also needed. This should be the same size, but have 4 slots. The second pair of slots will be perpendicular to the first. This will be used to true up the ring and re-drift the holes in the ring after it is welded. The first question is, "why not just use the cone on the right, and not make two?". The problem with using the second cone to initially bend the ring is, the additional holes make it difficult to anchor the dog wrenches as there is too much open space. Having 2 cones makes this much easier.

## Chainmaker's Swage

A simple swage is made to simplify the welding of the ring. This is similar to a chain maker's swage. It consists for a 10" length of 1" square bar, bent to 90° in the hardy hole. The length of material within the hardy hole is about 2". Once you have this bend, with the long end of the bar laying on the face of the anvil, forge a 1/2" round half round into it. The half-round must be arched so that as the ring lays across it, the center of the ring is supported, but the arch of the ring is not galled by the edges of the swage. This concludes my summary of the class. I hope I explained everything in a way that is easily understood. If you have questions, feel free to get in touch with me via the UMBA website. I think we all learned a lot on the way to making the ring thing. Mark Aspery explains things in a way I find very easy to understand. With some luck, I passed on some of the knowledge I gained.

### S/C regional meeting in June

**Host:** Larry Mills  
**Place:** Chestnut Forge  
**Address:** 3510 Charleston Rd, Norman, OK  
**Phone:** 405-401-9739  
**Date:** 16 June  
**Time:** 8:00-4:00

**It's Freeeee**  
Some S7 and 5160 to be given away

**Pastries and Fruit available in AM, Lunch at 12 contact Linda to help with the side dishes**  
**Nonparticipants may want to bring Lawn Chairs.**

**Activities**  
Open Forging all day  
Demonstration with hands on instruction morning and afternoon  
**Best Scroll Competition**  
**Tailgating encouraged**  
**Iron-in-the-hat proceeds go to the club scholarship fund.**  
**Trade Item, anything with 3 scrolls**

#### **Hot News**

Klingspor Abrasives Rep. will be onsite with 2x72 belts of various grits and other abrasives available to try

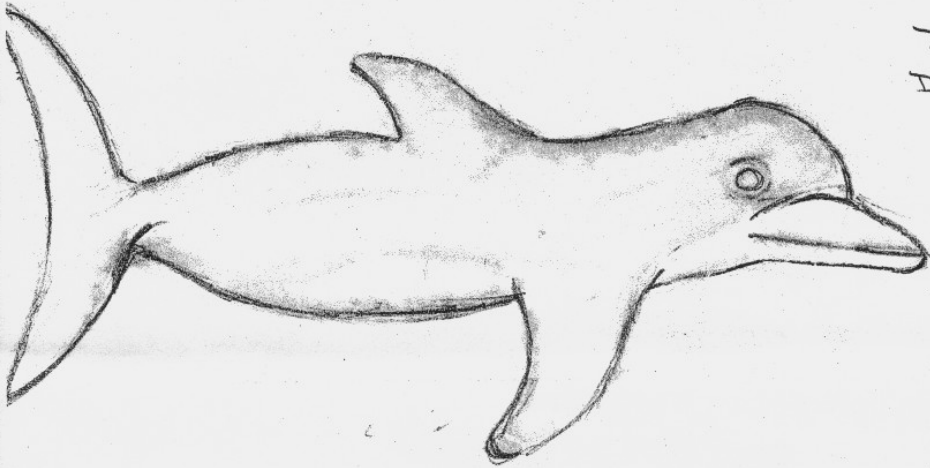
**We are opening a gallery and are interested in displaying your work**

# FLAT ONE SIDED DOLFIN

DATE: 6-18-11

DESIGN BY: BILL EPPS

DRAWN BY: MARCO, GARCIA



## MATERIAL NEEDED

1/4" x 1" FLAT STOCK

LONG ENOUGH TO HOLD ONTO

2 LB CROSS PEN HAMMER

ANVIL

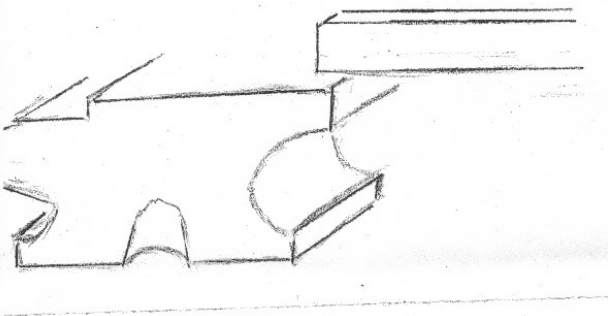
BALL PUNCH AKA BLOB PUNCH

EYE PUNCH

HOT CUTTER

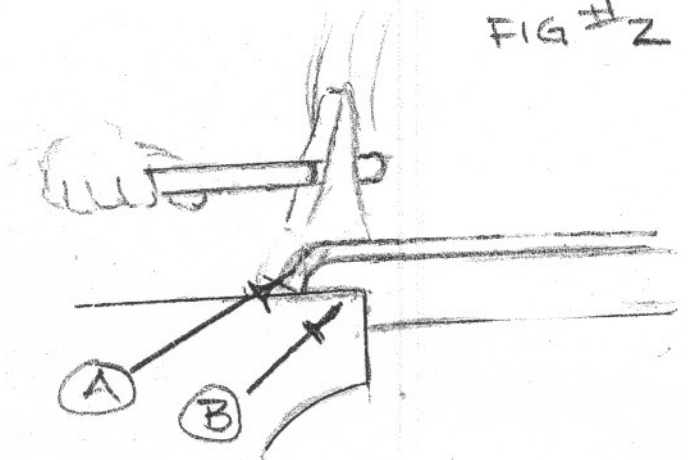
BUTCHER PUNCH

FIG #1

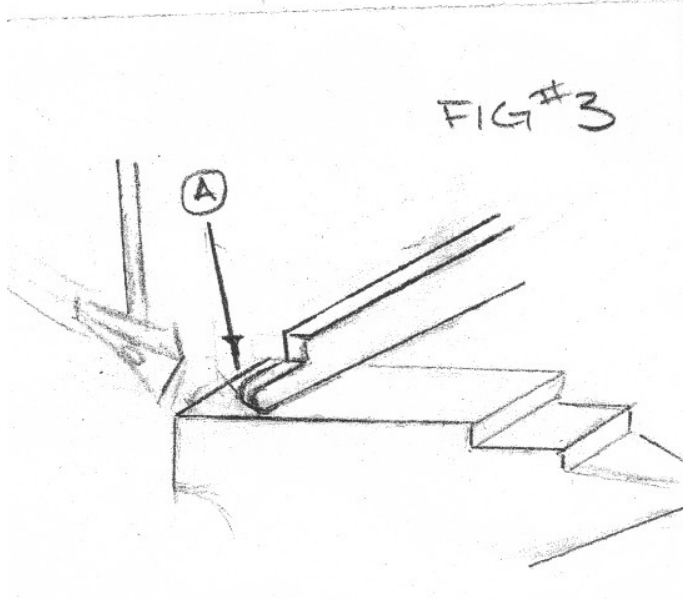


Start with a pc of 1/4 x 1" flat bar long enough to hold on to.

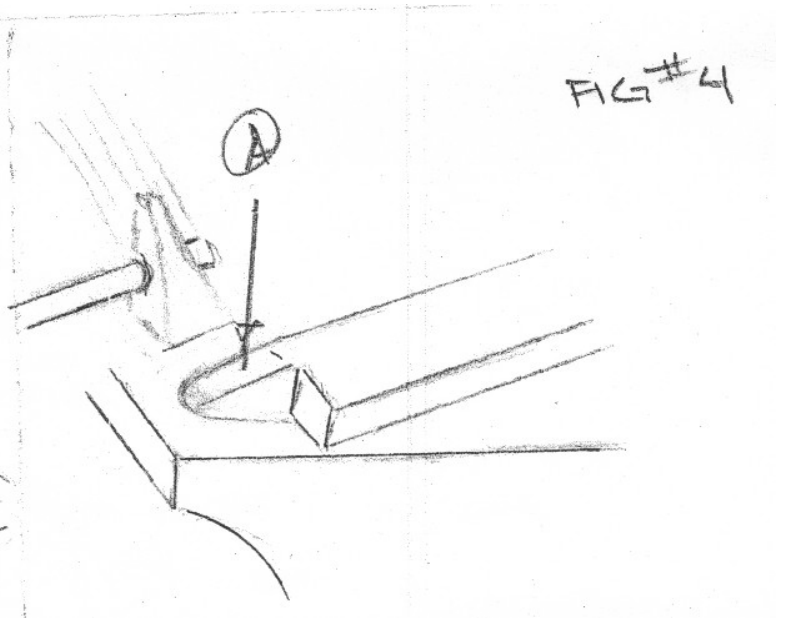
FIG #2



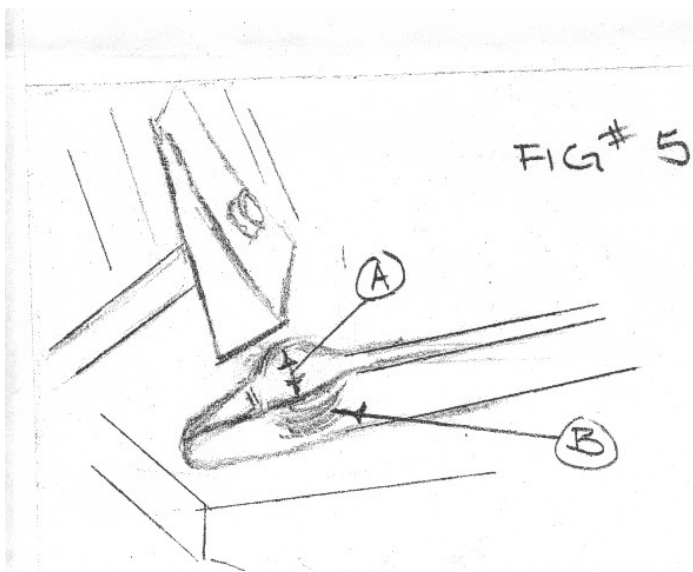
Set down about 1/8" back to start forming the nose of the dolphin



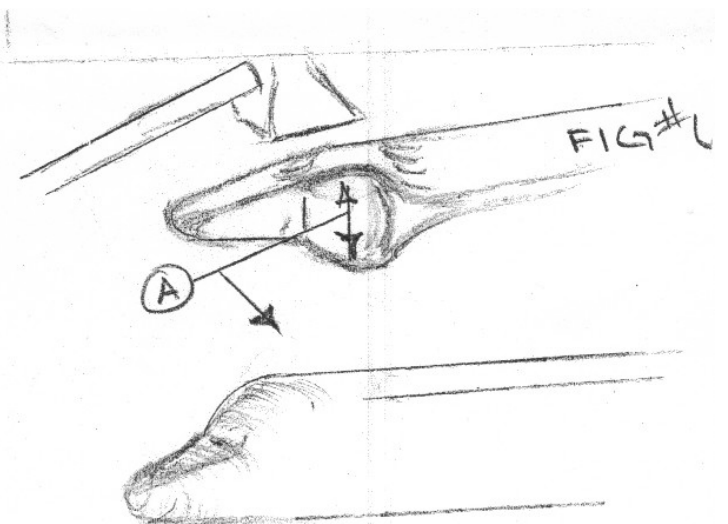
Round up and taper the nose shaping with the hammer and file as needed



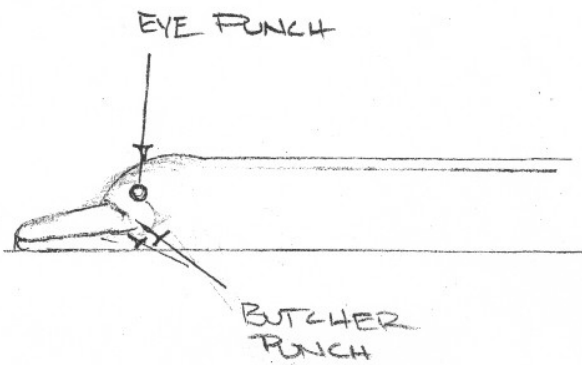
Refine and form the snout



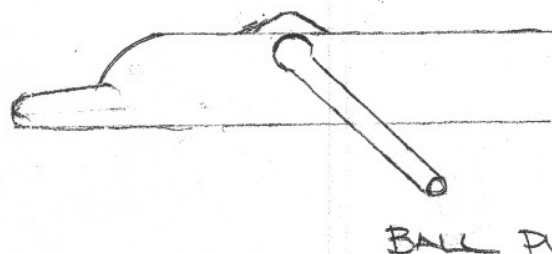
Drive the top corner into itself at a 45 degree angle allow the sides to swell out.



Lay flat on anvil then flatten swells out back to the 1/4" thickness this will generate the radius for the top of the head



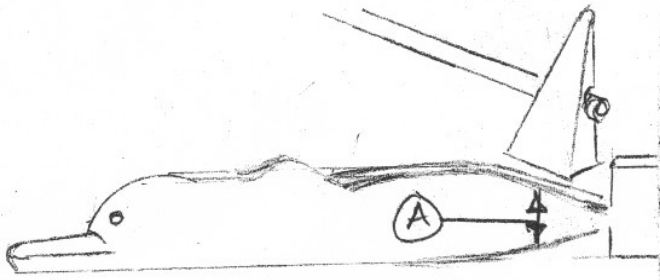
Make the eye using the eye punch also cut the line forming the mouth, make a line at the back of the nose to form definition to the head



On the back side using a ball punch upset enough material to form the top fin

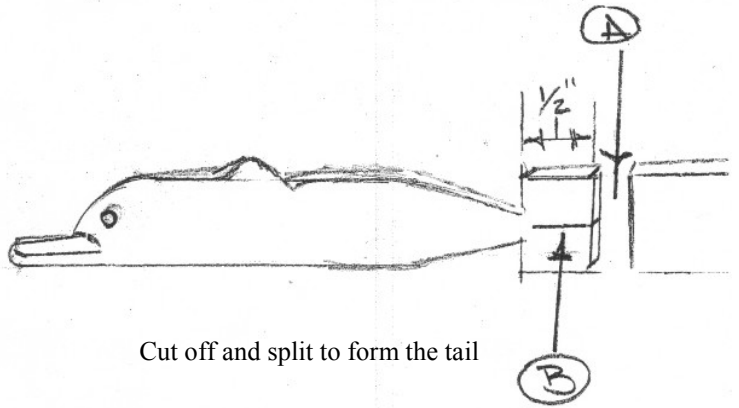


FIG # 9



Taper the body keeping the thickness even leaving the part that will become the tail full size.

FIG # 10



Cut off and split to form the tail

Fig #11

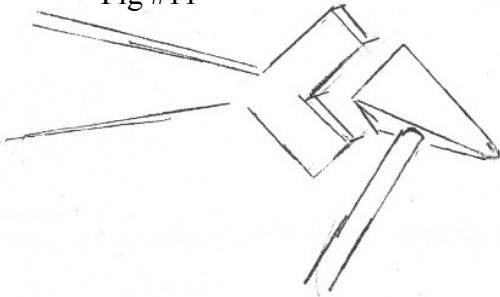
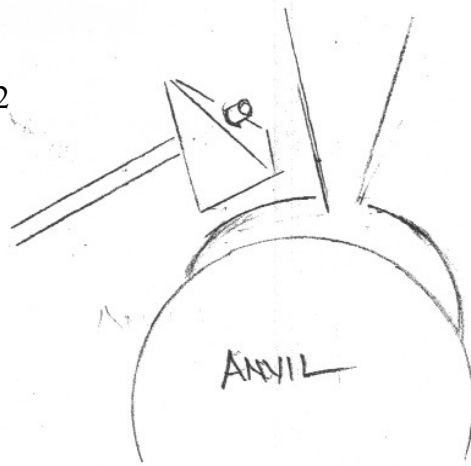
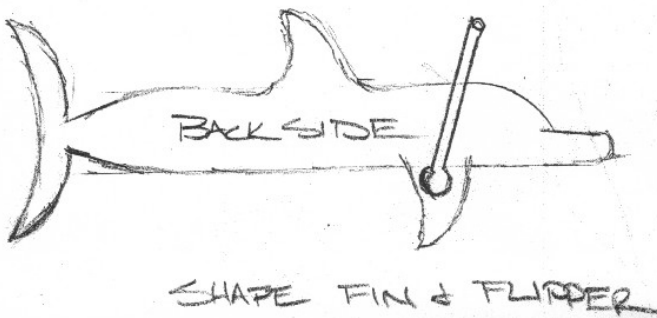


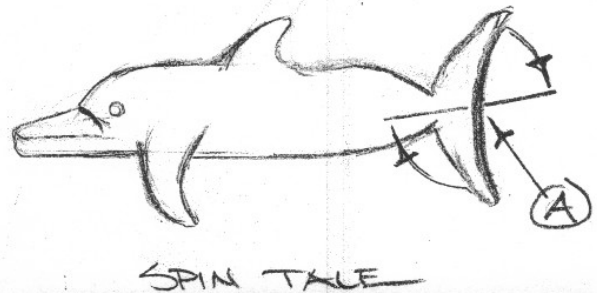
Fig #12



Take a good heat and open up the split then shape the dolphins tail

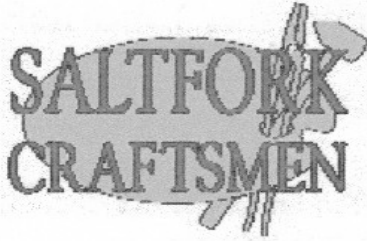


Take a good heat then ball punch on the back side to form the flippers, then finish shaping the top fin.



Take a good heat on the tail end of the body then twist the tail 90 degrees. Back to the anvil to flatten out the twist. Wire brush and apply finish.

Try it just for the fun, your friend Bill Epps



Saltfork Craftsmen Artists-Blacksmiths Association  
Scholarship & Grants Committee  
1227 Fourth Street  
Alva, OK 73717  
[www.scaba.abana-chapter.com](http://www.scaba.abana-chapter.com) 08 – 16 - 2002

## The Saltfork Scholarships / Grants Program and Application:

Since founding in March of 1995, the Saltfork Craftsmen ABA has been committed to high quality educational opportunities for our members and our region. The purpose of the Saltfork Craftsmen ABA Scholarship / Grants Program is to provide Club Members with financial assistance toward that end.

The Scholarship / Grants Program will provide funding each year to aid in increasing skills and abilities through participation in schools, conferences, or special classes. The total amount of funding and the distribution limit per person / application will be set annually at the First Board / Trustees Meeting. Unused monies will be rolled over for use the following year.

Because the Saltfork Craftsmen ABA desires to promote and sustain an interest in blacksmithing and other crafts, funding is available to interested blacksmiths, blacksmith educators, other craftsmen, and other craft educators at all skill levels – novice to journeyman.

## Requirements for Selection of Scholarship / Grant Funding:

- 1) The applicant must be an active member of the Saltfork Craftsmen ABA for at least one year – 12 consecutive calendar months. The applicant must have attended at least 4 general or area Saltfork meetings in the past 12 months.
- 2) The applied for conference, school, or class must be deemed to also be of benefit to other members of the Saltfork Craftsmen ABA by the Scholarship / Grant Committee. The school, class, or conference is not limited to just blacksmithing.
- 3) As long as funding is available, applications will be considered once each quarter of the calendar year at the Saltfork Board / Trustees meetings.
- 4) Should there be more applications than there is money available in the Scholarship / Grant fund, applicants will be selected by drawing of names and the funds divided by the Scholarship / Grant Committee.
- 5) Recipients of previous Scholarship or Grant awards are not eligible to submit another application for two years after the completion of the conference, school, or class and fulfillment of the Applicants Responsibilities listed below.

## Applicant's Responsibilities for Selection of Funding:

As a condition of receiving Saltfork Craftsmen ABA Scholarship / Grant funding, all recipients are required to share the results of their learning with other Saltfork members. The recipient is further encouraged to share this learning with other ABANA Chapters and / or ABANA proper.

The recipient will fulfill this responsibility by at least two of the following forms of presentation:

- 1) A public demonstration, lecture, or organized workshop at a General Meeting of the Saltfork Craftsmen ABA covering what was learned in the class or conference.
- 2) The submission of an article for the Saltfork Newsletter and / or ABANA or other artist-blacksmith association newsletter or related publication.
- 3) Making and donating an item for the Annual Conference "iron in the hat" or other Saltfork Auction. The item should be from the class or conference. Money received from this item, if auctioned, will be added to the Scholarship / Grant Program account.

The fulfillment of the Applicant's Responsibilities, as listed above, must be completed within 6 calendar months after the course of study is completed.

The Saltfork Craftsmen ABA Scholarships / Grants Committee will have the final say as to whether the requirements are deemed as being met.

### Saltfork Craftsmen ABA Scholarship / Grant Application Form

[Please type or print all application data clearly]

Name: \_\_\_\_\_

Address: \_\_\_\_\_  
\_\_\_\_\_

City, State, Zip Code: \_\_\_\_\_

Member of Saltfork since: Month, Day, Year \_\_\_\_\_

Telephone: Home \_\_\_\_\_ Work \_\_\_\_\_

E-mail: \_\_\_\_\_

Have you applied for Saltfork Craftsmen ABA Scholarship / Grant Funding in the past?

Yes \_\_\_\_\_ No \_\_\_\_\_. If Yes, date you applied: \_\_\_\_\_

Results of that application \_\_\_\_\_

Describe the School, Conference, Workshop, or Class for which you are seeking Saltfork funding. List the location, dates, and published cost. If known, list whom the instructor(s) will be. Attach a Conference, Workshop, School, or Class flyer (or copy) if possible. State how you plan to fulfill the Applicant's Responsibilities. Use the back of this sheet and additional paper as necessary.

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_



# ABANA

## 2012 CONFERENCE

### RAPID CITY, SOUTH DAKOTA

### JULY 18-21, 2012

### DEMONSTRATORS

**Signed Demonstrators as of 9-15-11**

- Ed Caffrey - ABS Master Knife Maker
- Ed Fowler - ABS Master Knife Maker
- Kirk Rexroat - ABS Master Knife Maker
- Jill Turman - Female Artist / Blacksmith
- Becky Little - Female Artist / Blacksmith
- Brian Brazeal - Traditional / Sculptural
- Lyle Wynn - Brian's Helper / Blacksmith
- Lee Sauder - Smelt
- Steve Mankowski - Smelt
- Shel Browder - Smelt
- Pete Renzetti - POMM
- Tom Latane - POMM
- Michael McCarty - POMM
- Tina Chisena - POMM
- Carl Close Jr - POMM
- Punzo Family - Coppersmiths
- 6 members from the Punzo-Angel Family from Mexico

**More to come!**  
**See You In Rapid City!**

SCABA members, if you can't attend this years ABANA conference but would still like a chance at the iron-n-the-hat items, you can purchase tickets from the SCABA Editor. Gerald Franklin passed the tickets on to me when he stepped down. The tickets are \$1.00 each and all you have to do is see me at a meeting or mail your money to me along with your information. I will mail you back the ticket stub. But Hurry you only have until June 10th. Tickets and money Must be back to ABANA by June 20th.

We do have members that will be attending and if you are a lucky winner it might be possible to negotiate with one of them to bring back your prize.



Mr. Affiliate President

SALTFORK ART. BLKSMTHS ASSOC.  
 President, Gerald Franklin  
 Rt 3 Box 239-J  
 Duncan, OK 73533

October 1<sup>st</sup>, 2011

Dear President:

Exciting news for those local affiliate chapter members unable to attend the July 2012 Rapid City, S.D. conference. We have found a way for them to participate in the three fabulous Iron-In-The-Hat drawings. The super drawings will consist of the following items:

- √ Tire Hammer by Mark & Mindy Gardner
- √ BAM Box Filled With "Signature Tools"
- √ NIMBA Titan 120 lbs Anvil by Nimba Anvils

Participants do not have to be present to win. At the winners' request, shipping arrangements (paid by winner) will be made.

As you are aware, all proceeds from the Iron-In-The-Hat are used by ABANA for Affiliate member scholarships.

# Minutes

Saltfork Craftsmen Board of Director's Meeting  
April 21, 2012

The first meeting of 2012 was held at the SCABA picnic at Byron Doner's home in Norman Ok. The meeting was called to order by David Seigrist Vice-President at 1:30 pm. Members present were Gerald Brostek, Dan Cowart, Byron Doner, Gerald Franklin, Bill Kendall, David Seigrist and Diana Davis.

First on the agenda was the result of the election for Board of Trustees also known as the (Board of Directors or BOD). Thirty one ballots were returned to Secretary/Treasurer Dan Cowart.

Dan Cowart received 31 votes

David Seigrist received 31 votes

Diana Davis received 30 votes

Ron Lehenbauer received 1 vote

The new BOD now consists of Gerald Brostek, Dan Cowart, Byron Doner, Bill Kendall, David Seigrist and Diana Davis. The new Board got busy and elected officers. Dan Cowart nominated Gerald Brostek for President and Bill Kendall seconded, Diana Davis was nominated for President by David Seigrist and seconded by Gerald Brostek but Diana Davis declined saying she had more to do now and being new to the board would like to pass at this time, the BOD accepted it. Gerald was elected President. Next Dan Cowart nominated David Seigrist for Vice-President and was seconded by Byron Doner. David was elected by the BOD. Dan Cowart was nominated for Secretary/Treasurer by David Seigrist and seconded by Gerald Brostek and was elected. The results are:

President: Gerald Brostek

Vice-President: David Seigrist

Secretary/Treasurer: Dan Cowart

Dan Cowart will contact Arvest Bank and make the necessary changes. Dan Cowart, Gerald Brostek and David Seigrist will be able to write checks.

The BOD next discussed the State of Oklahoma Fair in Oklahoma City. The BOD decided to participate and Diana Davis was placed in charge because of her past experience.

The BOD is looking for members to help with the conference in Perry this year. We decided to try and find some help in Co-Chairing this event.

Someone brought up the fact that we need an auctioneer for the conference and Diana Davis volunteered to contact David Lowery in Texas and see if he would be interested.

The next item on the agenda was getting someone to act as Workshop Coordinator. Gerald Franklin had done it in the past and it was recommended that we get him to continue. The BOD agreed and Gerald Brostek will contact Gerald Franklin and see if he would continue.

The Scholarship Committee was next and no definite action was taken at this time.

Dan Cowart requested that the BOD let him go to a class on "Constant Contact". This is software that allows him to contact through mass E-mails the members of the club that have E-mails. The BOD approved the class for \$199.00.

Mike George asked to rent a trailer to take swage blocks and cones to take to ABANA. He will sell what he can and then turn the trailer in. Board Approved.

Dan Cowart was also put in charge getting some decals put on the trailers that would take off the addresses and phone numbers of the old S/T and replace them with the club's Internet address Saltforkcraftsment.org.

The meeting was adjourned at 2:30 pm.

The next BOD meeting was not set.

## Workshop Schedule 2012

Gerald Franklin

The 2012 workshop schedule has been fleshed out. Take a look at the following list and mark your calendar for any workshops that you think you may want to attend. Enrollment will open on the 10<sup>th</sup> of the same month the workshop is being held. Complete enrollment information will appear in the newsletter the month before the workshop is scheduled.

March 31, 2012—**Basic Blacksmithing Workshop** at Elk City in the Route 66 Museum Blacksmith shop. Instructors are Don Garner and Dorvan Ivey. Cost is \$20.00 which includes materials and lunch. Sign up open immediately. Contact Bob Kennemer to register. 580-799-1878 or 580-225-3361

March 31, 2012 – **Basic Blacksmithing Workshop** at Bill Kendall’s shop in Tulsa. Instructors will be Bill Kendall and Dan Cowart. Enrollment opens at **NOON on March 10**. Email Dan Cowart (ddcowart@gmail.com) then to get your name on the list. You may also call Dan at 918-440-0653. Again, you won’t be able to enroll before **NOON on March 10**. Cost: \$20.

⇒ June 30, 2012 – **Decorative Punch Workshop at Gerald Franklin’s shop near Duncan, OK. Learn to make and use various punches and chisels to enhance your work. This is a “cold shop” workshop with no forge work. Class size will be limited to ten students. To give everyone a chance to get the word about the class, enrollment will not be taken before 12 noon on June 5th. Enroll by emailing Gerald Franking at franklin@myrhinomail.com or by calling 580-467-8667 Cost is \$10. which includes materials and lunch.**

September 29, 2012 – **Veining Hammer Workshop** at the Major County Historical Society’s shop in Fairview, OK. Mike George will guide you through forging a veining hammer for use in repousse’ and leaf work. Enrollment info will be in the August and September newsletters. Cost: TBA.

This page will be in each newsletter as a reminder of the workshops that are available to the membership. Please take note of the locations, registrations times and cost for each.



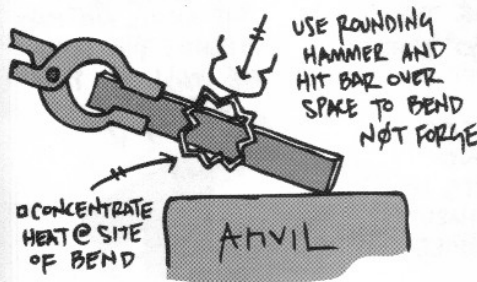
# DANIEL BECK ARTICLE

## The LEAFING JIG

FOR USE WITH THE LEAFING HAMMER IN MAKING THE WATER LEAF

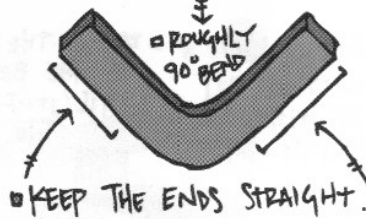
BEGIN WITH 6" OF  $\frac{3}{8}$ " x 1" FLAT BAR FOR THE YOKE.

1 START BY BENDING BAR THE HARD WAY IN THE CENTER OF THE 6" PIECE.

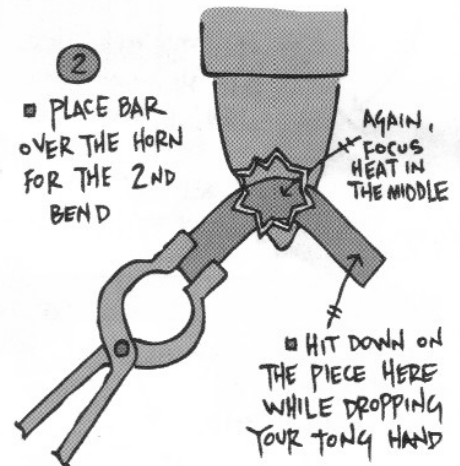


USE ROUNDING HAMMER AND HIT BAR OVER SPACE TO BEND NOT FORGE

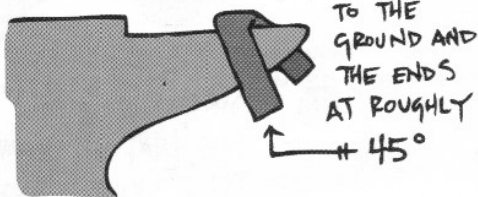
★ RESULTING SHAPE SHOULD LOOK LIKE THIS.



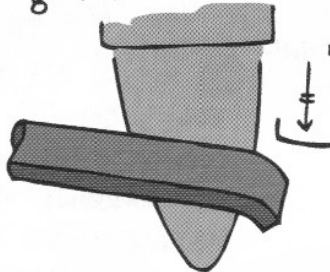
2 PLACE BAR OVER THE HORN FOR THE 2ND BEND



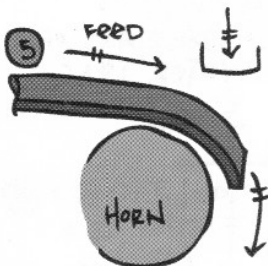
3 THE RESULT IS A COMPOUND BEND WITH THE BOTTOM OF THE YOKE PERPENDICULAR TO THE GROUND AND THE ENDS AT ROUGHLY 45°



4 TO MAKE THE RING, START WITH 11" OF  $\frac{3}{8}$ " x 1" FLAT BAR.

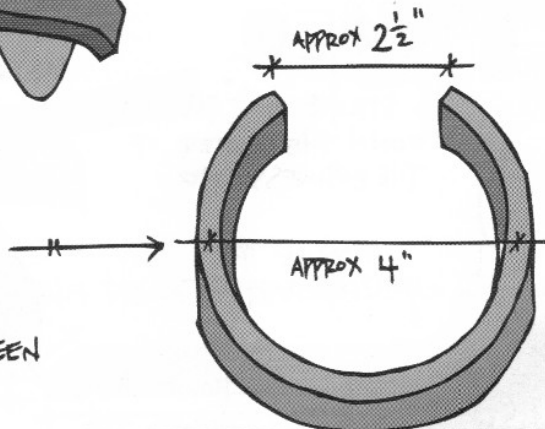


START CURVING THE RING @ THE END OF THE BAR OVER THE HORN.



CONTINUE FEEDING THE BAR OVER THE HORN, HAMMERING IN THE SAME SPOT FOR AN EVEN ARC.

6 CONTINUE SHAPING THE RING IN THIS WAY UNTIL YOU HAVE A CIRCLE WITH ABOUT A 4" DIAMETER WITH A 2 1/2" GAP IN BETWEEN



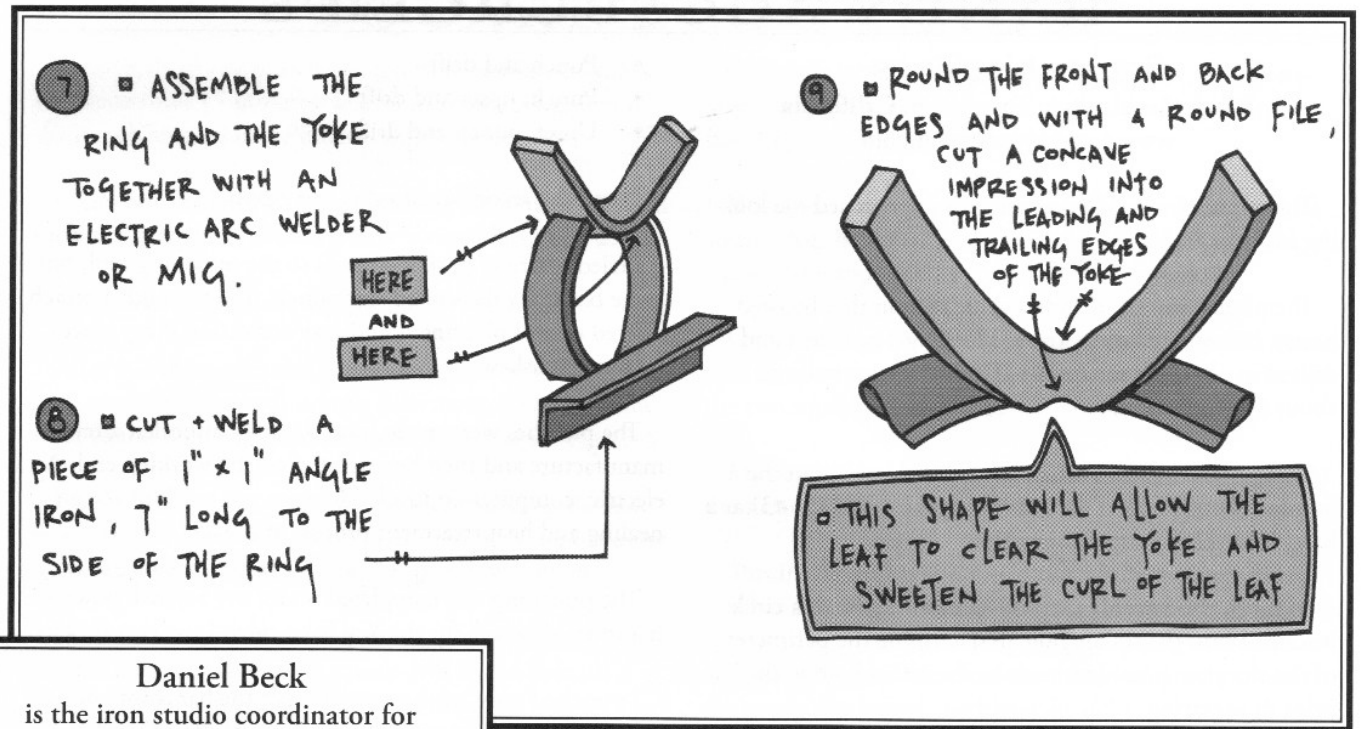
# DANIEL BECK ARTICLE

7 ■ ASSEMBLE THE RING AND THE YOKE TOGETHER WITH AN ELECTRIC ARC WELDER OR MIG.

8 ■ CUT + WELD A PIECE OF 1" x 1" ANGLE IRON, 7" LONG TO THE SIDE OF THE RING

9 ■ ROUND THE FRONT AND BACK EDGES AND WITH A ROUND FILE, CUT A CONCAVE IMPRESSION INTO THE LEADING AND TRAILING EDGES OF THE YOKE

THIS SHAPE WILL ALLOW THE LEAF TO CLEAR THE YOKE AND SWEETEN THE CURL OF THE LEAF



Daniel Beck  
is the iron studio coordinator for  
Penland School of Crafts



## Off the Web...

To whom it may concern.

My name is Mark Myers and I had the privilege of coordinating our Boy Scout district's annual Camporee. The Camporee was held at Slippery Falls Scout Ranch in Tishamingo, Okla. On April 13th thru 15th.

I contacted Steven Knisely, a blacksmith with Saltfork Craftsmen, who was very happy to attend and put on a blacksmith demonstration for the scouts. Our theme this year was "Out of the Past" and Steve was able to share a lot of history and knowledge with the youth and adults.

We had over 200 youth and adults registered for the event. Unfortunately Norman, which is in the middle of our district, was hit by a tornado on Friday the 13th and a large portion of the scouts did not attend. We had around 60 attendees and everyone enjoyed Steve's talks and demonstrations.

Steve is a very generous person and many of the attendees left with an item he had made. The scoutmaster's that attended each received a steak turner made by either Steve or myself.

Mark Myers  
Camporee Coordinator  
Sooner District  
BSA

## SCABA Shop and Swap

### For Sale:

6" round nosed pliers (great for putting scrolls on small items) \$5.00 each. Brooms tied, \$25.00 on your handle  
Contact Diana Davis at [Diana.copperrose@gmail.com](mailto:Diana.copperrose@gmail.com)

### For Sale:

24"(wide) x 1"(thick) Ceramic fiber blanket (similar to Kao-wool) \$1.00 per inch of length. Twisted solid cable 1/2" diameter \$2.00 per ft.

Contact Larry Roderick at 940-237-2814

### 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 pile is located in Douglas, OK.** If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of \$10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence the \$10 charge. You may opt to load your own coal without using Tom's loader. The coal can be weighed out at the Douglas Coop Elevator scales. Contact Tom Nelson (580-862-7691) to make arrangements to pick up a load. Do not call Tom after 9 PM!! Bring your own containers and shovels. Payment for the coal (\$.07 per pound) should be made directly to the Saltfork Treasurer.

**NE Region coal location: Charlie McGee** has coal to sell. He lives in the Skiatook, Oklahoma area. His contact information is:

[littleironworks@gmail.com](mailto:littleironworks@gmail.com) or (home) 918-245-7279 or (cell) 918-639-8779



Show pride in your organization by displaying one of our tags on your vehicle. We still have the Saltfork Tags on sale while supplies last. You

can order one for \$5.00 each. Contact the editor for more info.

We have coffee cups for \$9.00 and We just got in a new shipment of caps for \$10.00. We have "Fat head" hats for those having trouble finding a hat to fit.

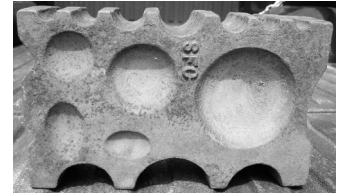
Please note that due to increases in cost we have had to raise our prices on the swage blocks.

SCABA swage blocks

\$100.00 plus shipping to members. (1st block)

\$120.00 plus shipping to non-members

Contact Bill Kendall for more information



SCABA Floor Cones are now available from Bill Kendall, Byron Donor and Gerald Franklin. The price is \$200 plus shipping and handling.

### For Sale:

One 50# "Transition Style", Little Giant Power Hammer, In excellent condition. We are currently using it in our shop. It comes complete, ready to run with two sets of dies. \$3750.00 fob Alva Okla. Pictures available on request.

Mike George at 580-829-1968 or [George.purchasing@yahoo.com](mailto:George.purchasing@yahoo.com)

# SCABA membership application

New \_\_\_\_\_ Renewal \_\_\_\_\_

January 1 2012—March 31— 201\_\_

Please accept my application

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

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

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

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ ZIP \_\_\_\_\_

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

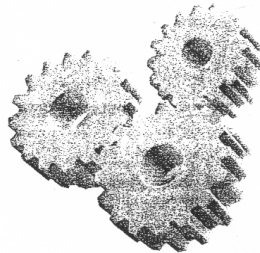
E-Mail \_\_\_\_\_ ABANA Member?  Yes  No

I have enclosed \$20.00 (per year ) for dues to March 30, 201\_\_

Signed \_\_\_\_\_

Return to: Saltfork Craftsmen Membership, Diana Davis 23966 NE Wolf Rd. Fletcher, Okla. 73541

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FOR MORE INFORMATION CONTACT:

DAVID KING (405)348-0476 OR BOB PADDACK (405)634-8353  
(405)426-0476



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