

# Saltfork Craftsmen Artist-Blacksmith Association

December 2013



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Artist-Blacksmith Association  
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Editors notes...

I don't have a lot this month to talk about. Just hope everyone has a safe and happy Holiday Season. I will start again in the January Newsletter pestering you to host meeting and pay your dues. For now, Charlie asked me to share this email with everyone.

Charlie Groom Charlie@macselectricsupply.com  
To: Diana.copperrose@gmail.com

SALTFORK FRIENDS:

GOD HAS BLESSED ME WITH SO MANY FRIENDS. THERE ARE SOME ACTS OF KINDNESS THAT WORDS CAN'T EXPRESS. THIS IS ONE OF THOSE TIMES. IT IS VERY HUMBLING AND I HAVE A GREAT AMOUNT OF GRATITUDE FOR ALL OF YOU. I WANT TO THANK EVERYONE WHO MADE THINGS FOR THE AUCTION AND TO EVERYONE WHO BOUGHT THOSE ITEMS. BUT MOST OF ALL I WANT TO THANK EVERYONE FOR THEIR PRAYERS. I HAVE MY SURGERY SCHEDULED FOR DEC. 2. YOUR ACT OF KINDNESS ENCOURAGES ME THAT HOPEFULLY SOMEDAY I WILL BE ABLE TO PASS THIS ACT OF KINDNESS ON TO SOMEONE ELSE IN NEED. THANKS AGAIN.

LOVE AND PRAYERS, CHARLIE GROOM

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)

## December Presidents' notes.



Due to Thanksgiving Holidays, the newsletter had to be done early this time before the printing folks closed down, so their people could also have some days off. Because to this, I've got less time to think of things to whine about. Probably better for y'all and me.

We've had three get-togethers at my house on Friday nights so far. To say the least they've been hectic, but they have been fun. It seems each person has a different agenda he's trying to accomplish and the way my shop is organized we have been running over each other quite a bit. Hopefully as the new wears off, things will calm down a little bit and we will be more productive. I think also, our scrap rate should go down. We get started around 3:00PM in the afternoon, and everyone is welcome. Come on over and play!

I had a good time at the meeting at Bob and Shirley's McKelvin's place. (SC Regional meeting) I had taken Bob a sack of coke that I'd bought at Nature Farms Ferrier Supply in Norman. (\$26.50 for 50 lbs) After assuring him it was nearly impossible to get lit, Bob proved me wrong by using his cigarette butts soaked in charcoal lighter method.

The ferriers that I saw using Coke, lit it with a weed burners. I had tried it using kindling and failed. The reason for using coke is that it's virtually smokeless. I'm hoping to get our demonstrators to use it at the conference to fight the smoke problem.

Merry Christmas to all! And please remember those who are less fortunate than yourselves. Babbling Byron

Thanks,

Byron Doner

(Korny)

## REGIONAL MEETINGS:

### December Regional meetings...

- \* SE Regional meeting (Dec 7th) Open
- \* NE Regional meeting (Dec 14th) Open
- \* SC Regional meeting (Dec 21st) will be hosted by Ricky Vardell at his home and shop at 103 W. Main in Temple Okla. Trade item will be a forged 3/4" open end wrench. Instructions for a forged wrench can be found in "Practical Blacksmithing vol. III. On page 38 and 39. *You can find this book online as a pdf and can print off the pages. If you don't have internet we have tried to provide some of the information for you in the Nov. newsletter.* Lunch provided but bring a side dish to help out.
- \* NW Regional meeting (Dec 28th) Open

### January 2014 Regional meetings...

- ⇒ SE Regional meeting (Jan 04,) open
- ⇒ NE Regional meeting (Jan 11) will be hosted by Bill Kendall at his shop in Tulsa.
- ⇒ SC Regional meeting (Jan 18) will be hosted by Gerald Franklin at his shop east of Duncan, Ok. His trade item is a candle holder. Lunch is provided but bring a side dish to help out. There will be a map in the January newsletter but if you need to contact him here is his info...franklin@myrhinomail.com or 580-467-8667
- ⇒ NW Regional meeting (Jan 25) will be hosted by Dorvan Ivy at the Route 66 museum blacksmith shop in Elk City, Ok. His trade item is something with a leaf. Lunch is provided but bring a side dish to help out.

### February Regional meetings...

- ◆ SE Regional meeting (Feb 01) Open
- ◆ NE Regional meeting (Feb 08) will be hosted by Gary Gloden at his shop at 16606 S. 97th W. Ave in Sapulpa, Ok. His trade item is "Horseshoe art". Lunch is provided but bring a side dish to help out.
- ◆ SC Regional meeting (Feb 15) will be hosted by JJ McGill at the Murry Co. Antique Tractor Grounds (map will be in February newsletter) JJ McGill is working with the Boy Scouts this weekend and would like all the help he can get. The boys are on a quest to kill zombies and need to learn to make anything that they can use to defeat them. This is your opportunity to bring out your inner child and use your imagination to FORGE ahead and help the Boy Scouts defeat the Zombies. You can contact JJ at jjmcgill88@yahoo.com for more information. The trade item is a knife or weapon. Lunch is provided.
- ◆ NW Regional meeting (Feb 22) will be hosted by Gary Seigrist at the Route 66 Museum in Elk City, Ok. The trade item is a "Grill tool". Lunch is provided but bring a side dish to help out.

## Dutch Ovens and Blacksmithing get together for a day...

I am sending you several photos of events that David Knight and myself have participated in. These first 2 photos are from a church Chuck Wagon Cook off in Nowata, Okla. on October 5th. This is a free event hosted by the First Church of God in Nowata. They take the opportunity yearly to cook and minister to the community through food, crafts and trades.



The next three photos are from the Chuck Wagon Cook-off at the 75th Anniversary of Will Rogers Days in Claremore, Ok. On November 2nd. We started the day at 7:30 AM and smithed until 5:00 PM. There were 100's in attendance, exact numbers are unknown. The event was televised on News channel 2 in Tulsa showing the Cook-Off teams as well as Saltfork Blacksmiths. We made and sold numerous items at the event and were able to spread the word about blacksmithing to many. We thoroughly enjoyed both events and look forward to participating next year.

Thanks..James Maberry



## Regional meeting reports..

Due to the early printing some reports did not get to me in time to print. They will be printed in next months newsletter if received.

SE Regional meeting reports not received.

NE Regional meeting was canceled.

SC Regional meeting was hosted by Bob and Shirley McKelvin at their home west of Rush Springs, Okla. They had approximately 27 members and friends for lunch. Gerald Franklin had a forge going with members enjoying his forging and stories through out the morning and again after lunch. He forged several items while explaining techniques and answering questions from the watchers.



Teresa Gabrish also was set up working with her copper wire. Her work always draws lots of lookers.

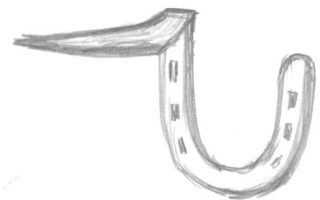


Bob's trade items was a shovel and he asked for everyone to try to use the form on our swage block. He had some nice shovels show up for the item swap.

Ricky Vardell brought a top tool that he made to go along with the swage block to help form the shovel. (with his permission) I have put a copy of his design in this newsletter. Bob had 9 shovels in the item swap. I think everyone was happy with the one they took home.



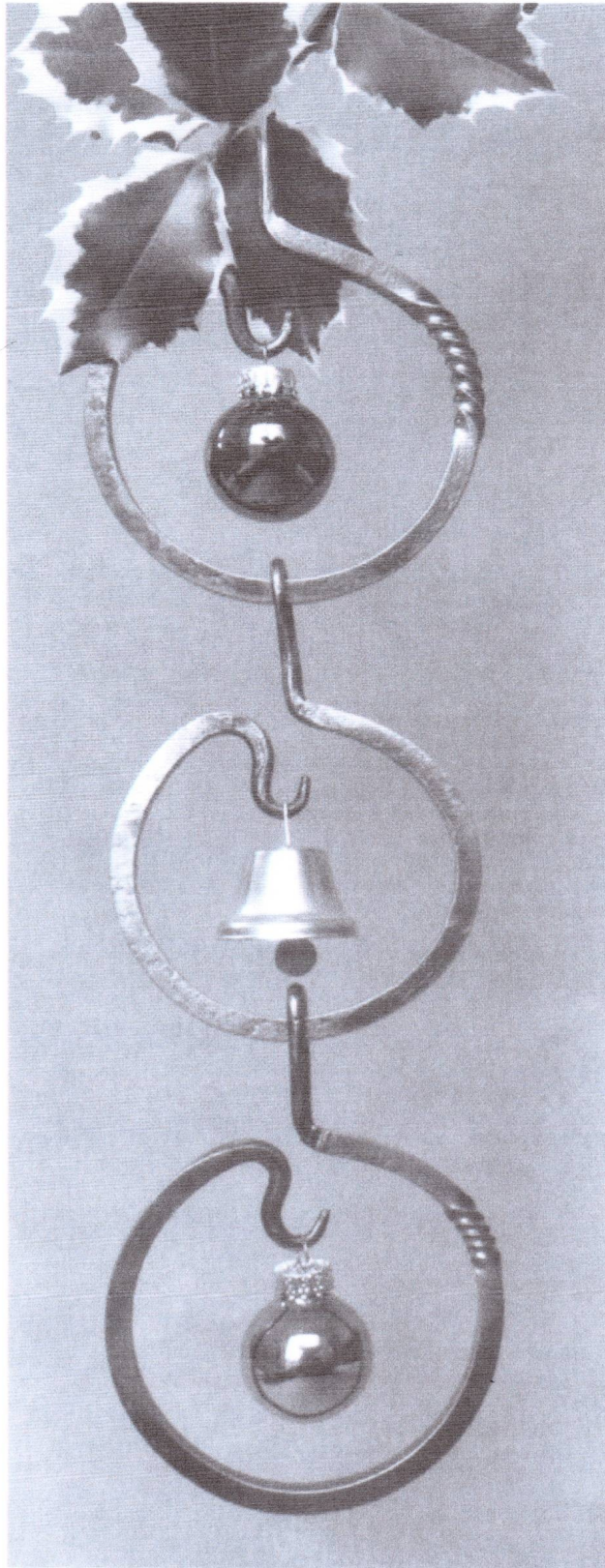
Another project that Bob had going was making coat hooks from horseshoes, for the local Cowboy Church. It was a fairly simple design. You draw out and taper one of the heels of the shoe and then folded it over with a twist to form a 90 degree angle to the rest of the shoe. It made a drive in hook. Just need to remember to fold it over so you can miss the other side of shoe when using a hammer. There were a couple of guys that made some for Bob.



I had to leave early but had a good time while there and want to thank Bob and Shirley for hosting a second meeting this year. We always have a good time at their place.

Diana

NW Regional meeting held after this newsletter goes to print..

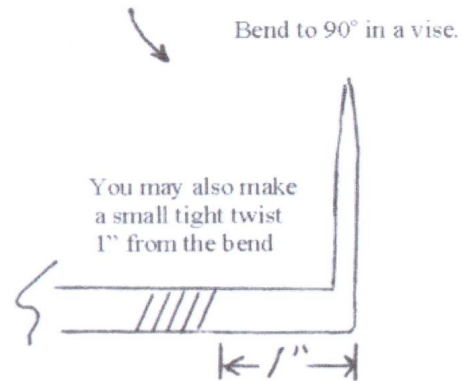
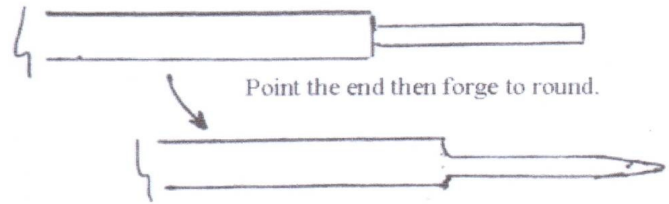


# Christmas Ornament Hanger

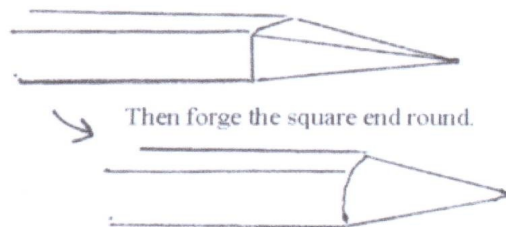
By Steve Anderson,  
a MABA member

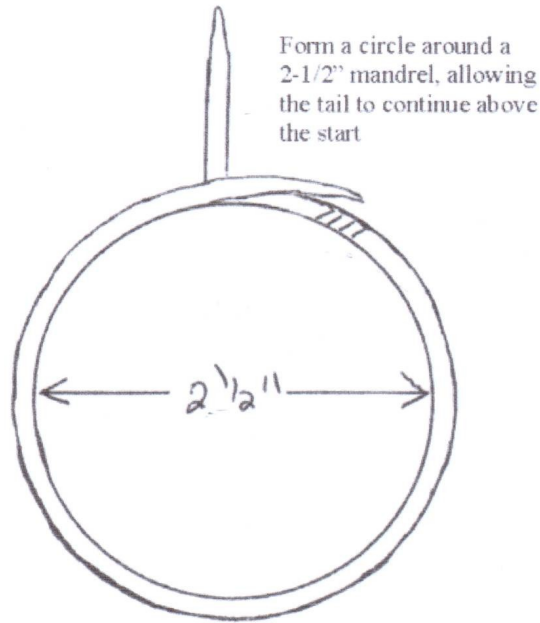
Stock: 3/16" square x 9-3/4"

Starting 1-1/4" from the end, forge to 1/8" square.



Forge a long square taper starting 1" from the other end.

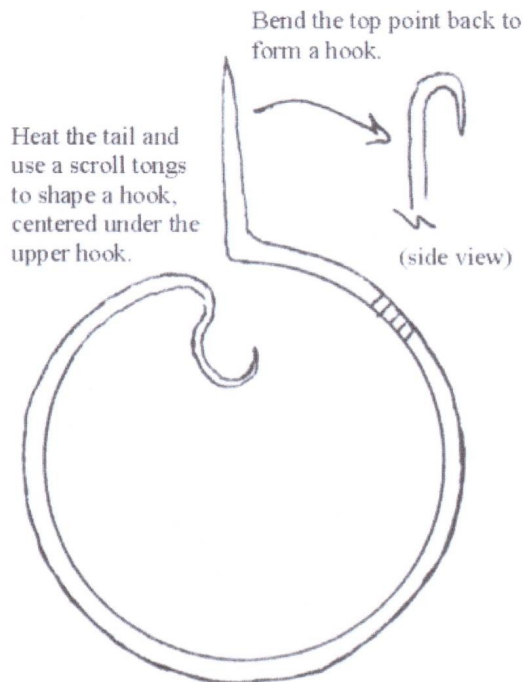




Form a circle around a 2-1/2" mandrel, allowing the tail to continue above the start

Editor's note: When Steve Anderson sent us a sample of the ornament hangers with his article for the newsletter, we knew the large 3-1/2" diameter hanger would be perfect for a chip carved ornament made by my cousin, Dick Baker.

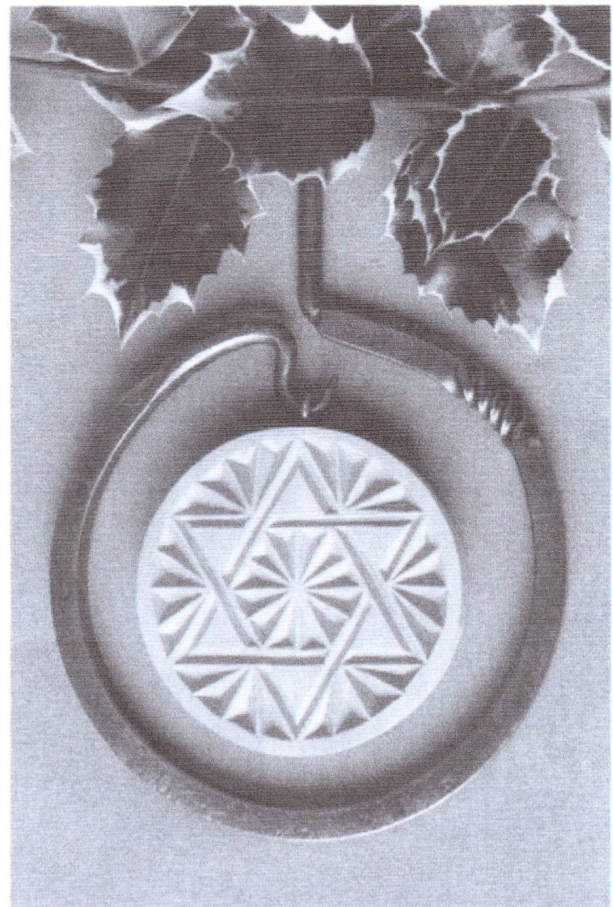
We hope you enjoy making these hangers to accent your special ornaments. Happy Holidays!



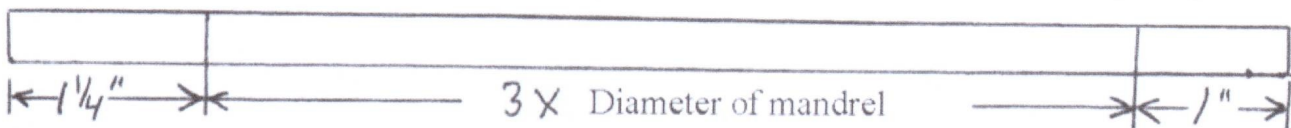
Bend the top point back to form a hook.

Heat the tail and use a scroll tongs to shape a hook, centered under the upper hook.

(side view)



To finish, use hot wax or use a wire wheel and a clear coat to finish. Using a brass brush is optional. For a different size mandrel, use the dimensions below, you may want to go up to 1/4" square stock for larger hangers.

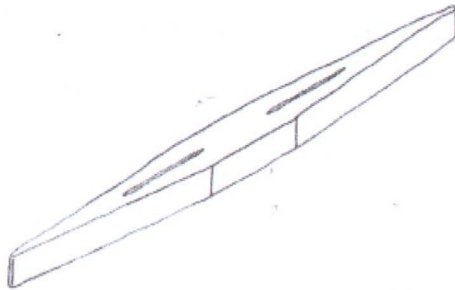




# Reindeer Shoe tree ornament

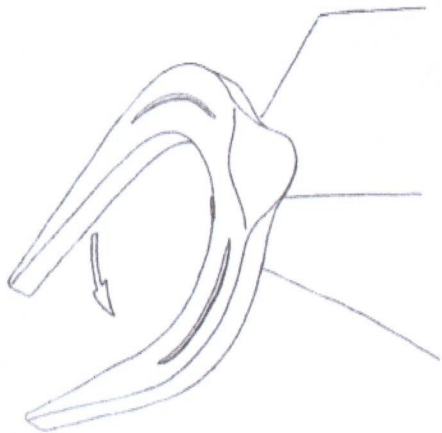
Created by: Steve Anderson

- 1) Start with 1/4" x 1/2" flat bar stock 4-1/2" long.
- 2) Taper from both ends to center to obtain a total length of 7". Be sure to maintain the 1/4" thickness.



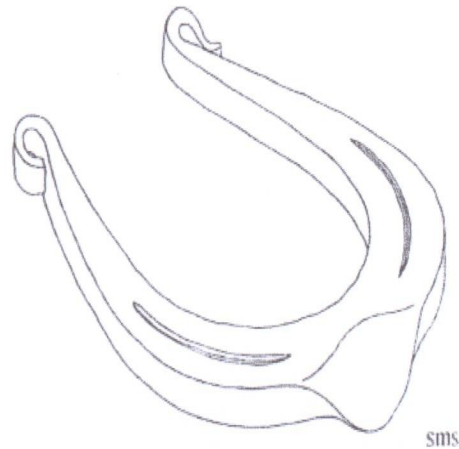
- 3) Chisel a 1-1/4" nail groove 1/2" off both sides of center as shown.

- 4) Bend to a pleasing horse (reindeer) shoe shape.

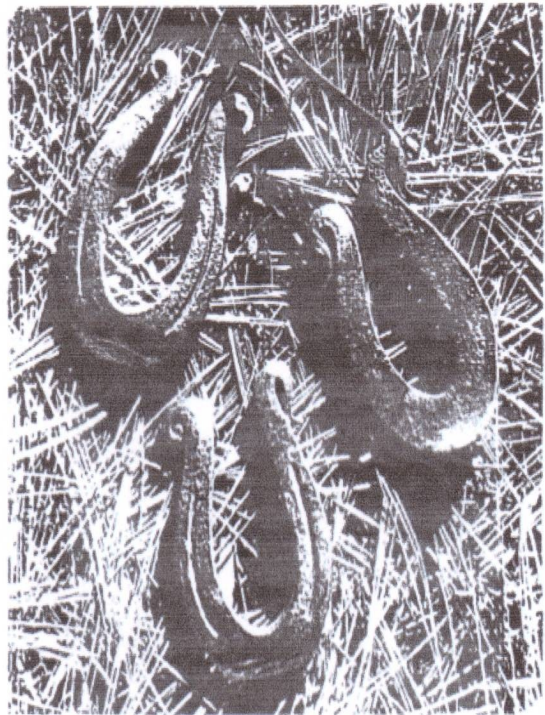


- 5) Forge a toe clip on corner of anvil heel.

- 6) Use small scroll tongs to shape heel ends as creative as you like.



- 7) Use fish line and a paper clip to make a hanger.  
\*Use a brass brush for Rudolph's shoes (they were always made of gold).

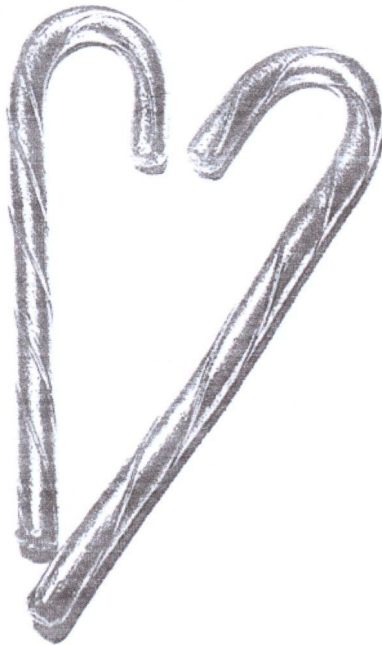


(editor's note: for me, these 3 shoes took 2 hours to finish. While Steve Anderson has them down to 15 minutes each.)

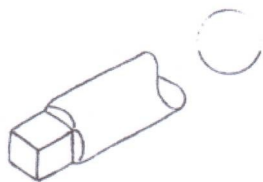
As the holiday season approaches, here are a couple of items you might find fun to make at the forge. Both would be good beginner projects.

## Iron Candy Canes

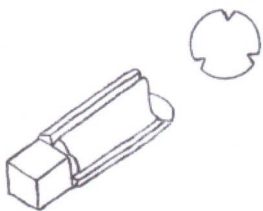
Created by: Steve Anderson



1) Start with 1/2" diameter round stock. I use a piece about 2 feet long to avoid using tongs.



2) Heat the end and square up about 1/2" of the stock for holding in vice.



3) At a yellow heat, groove 3 lines for 11 inches, using a chisel while placing the stock in a half round hardy or swage block. Repeated heats will be needed. You will only get a few inches

at a time. (You can also use a spring groover on a power hammer by making two passes.)

4) Place the square end in a vice and use channel locks or vice grips to make a slow twist in grooved portion. Quench if necessary to keep the twist even.



5) At a yellow heat cut twisted portion off on hardy while rolling piece to center. This keeps the stock round and looks more like an actual candy cane. Dress and round over ends to remove any sharp edges.

6) At a yellow heat use a wooden mallet to bend shape over horn.



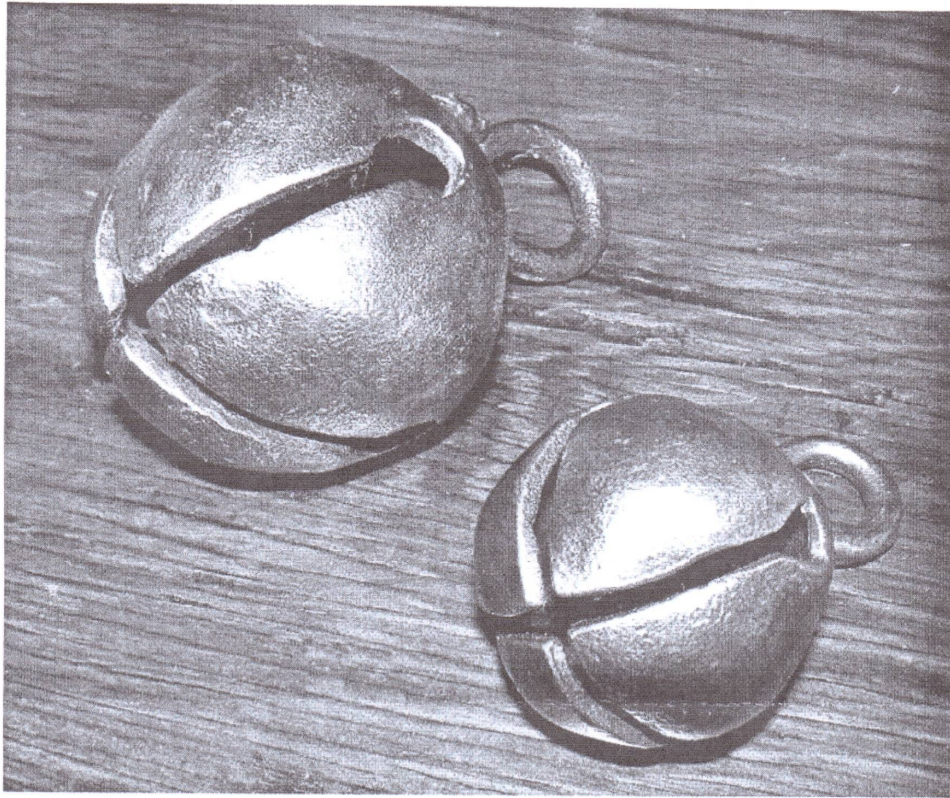
7) Clean up the candy cane with a wire brush or on a wire wheel. Apply a wax or other finish.

\*If you want to get creative, add a ribbon made from flattened 1/4" x 1/4" angle iron.

(editor's note: When I tried the candy cane for the article I flattened both ends and grooved the entire length. Because the stock was hot I used a 1/2" bolt tongs to position stock in vise. I twisted both halves and made two 11" candy canes from the 24" piece of stock. The grooving took me a little time, this first pair of candy canes were finished in an hour and a half. Steve Anderson said he can make one in about 15 minutes. They were fun to make!)

# Ring In the New Year

LIFT THIS SECTION OUT AND START YOUR PROJECTS NOTEBOOK TODAY



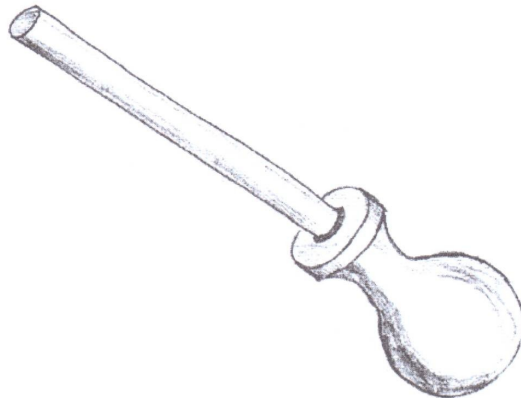
Two Bells made by Bill Clemens – large bell is approximately 2 1/2 “ and smaller one is approximately 1 3/4”

### Article by Bill Clemens

I began experimenting with making these bells over a year ago when a how to article appeared in an affiliate newsletter.<sup>1</sup> I quickly discovered that cutting out the bell blank was a stumbling block in making them. I first tried making them from thinner material than called for and found out that they don't form well from thin material. I then cut, **ground**, and **filed** one from the right material and was able to complete a bell but wasn't happy with the top half which seemed to be flat bent petals on a round hemispherical base. I next got a dozen blanks plasma cut at a local metal supply shop that only required some grinding on one side to remove the flash. I subsequently have had blanks laser cut and now after having made several dozen bells think I have the "how to" down well enough to offer this article to all.

### Tools

**Top Swedge** –Tailer hitch ball or ball bearing(2" for large bell 1 1/2 “ for small bell) with 10-12 inch 1/2 -3/4 stem welded on.

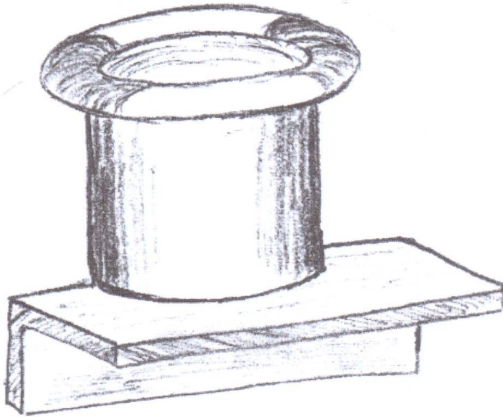


**Bottom Swedge** – Pipe with top end flared using horn of anvil

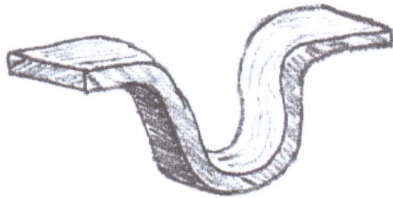
Large – ID ~ 2 3/8 “ ( 3 inch thick walled pipe)

Small – ID ~ 1 3/4” ( 2 inch pipe )

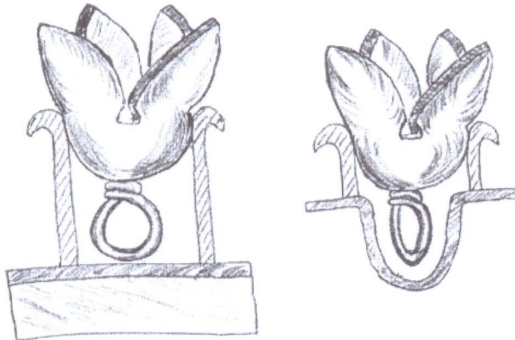
Add angle iron for use in vise or hardy stem for use on anvil.



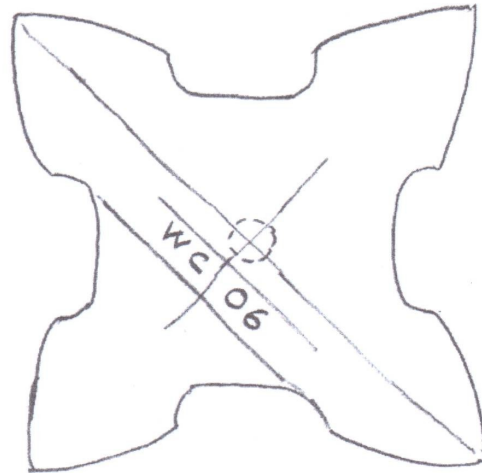
**Shown** below is a quick hardy stem made from flat stock 1/8-1/4” thick and the width of the hardy hole.



**The** space from the top of the flared pipe to the bottom of the tool needs to allow the bottom of the bell and ring to be inserted. This is a minimum of 2 3/4 “ for the large bell and 2 1/4” for the small bell.



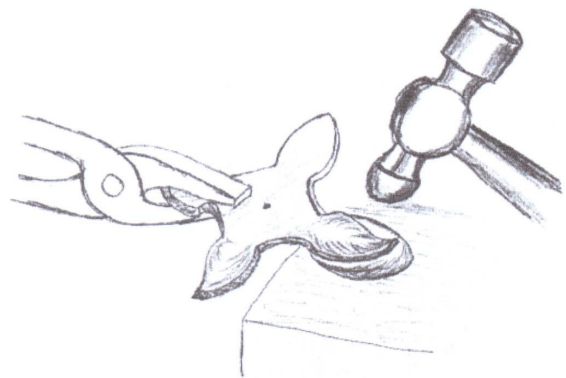
**Bell Blanks** – Cut (or have cut) bell blanks using the templates at the end of this article. Use 3/16” (or 7 Gage) for the large bell and 1/8” (or 11 Gage) for the small bell. Make a center punch hole on the inside of the blank for drilling the stem hole and touch mark the blank on the outside.



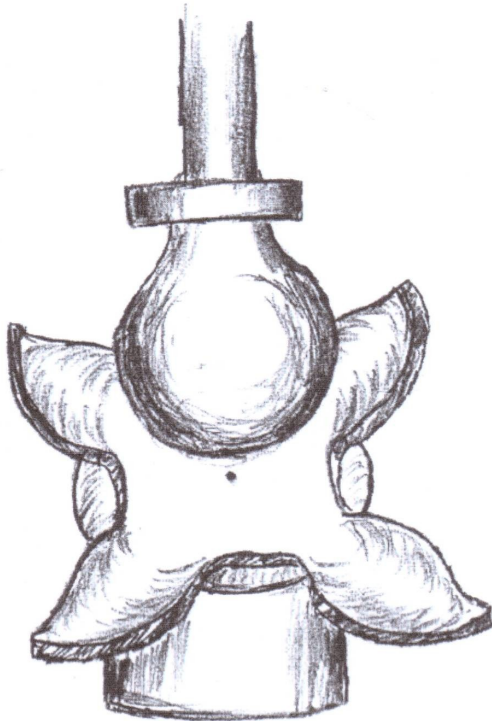
**You** may also decorate the outside of the bell at this point, such as adding leaf veining to each of the 4 petals of the bell as shown here:



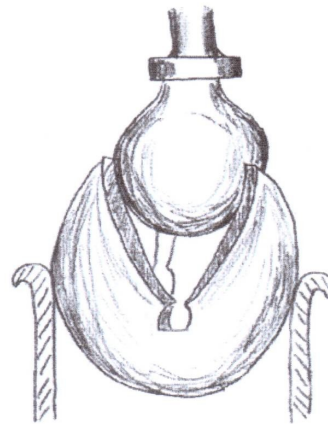
**Dish** each of the petals of the bell blank using a spoon swedge and ball peen hammer.



**Form Bell** – Heat the blank uniformly to a yellow heat and begin sinking it into bottom pipe swedge with the top ball swedge. This will take several heats as you are upsetting the material between the bell's petals.

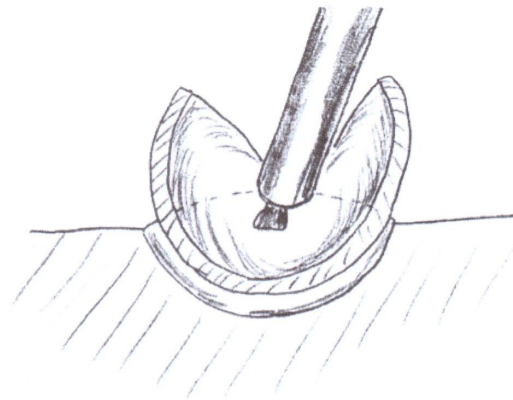


**Continue** sinking the bell until the ball swedge can just be removed from the bell.

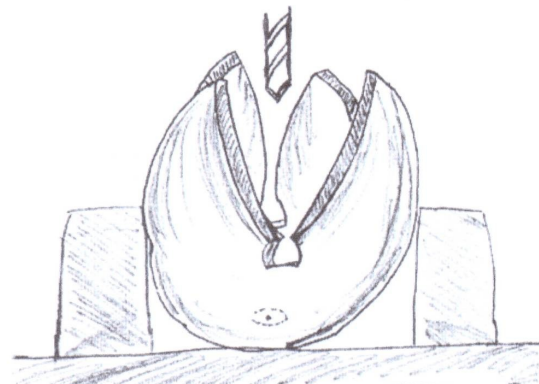
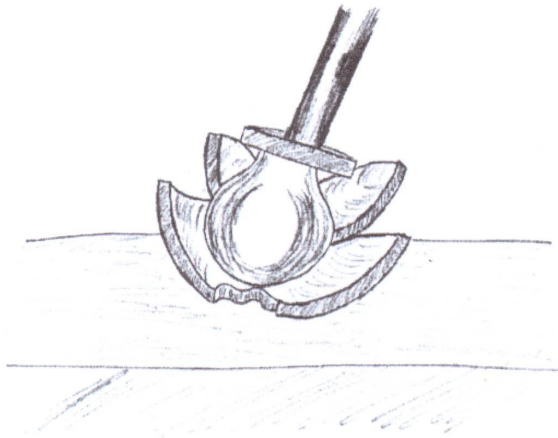


Use the smaller ball swedge on the large bell or a 3/4 inch rounded end rod on the small bell to round out the area between the petals into a ladle swedge block.

To help shape the bell use the top ball swedge on the anvil to smooth out and round the portion of the bell being upset between the petals.



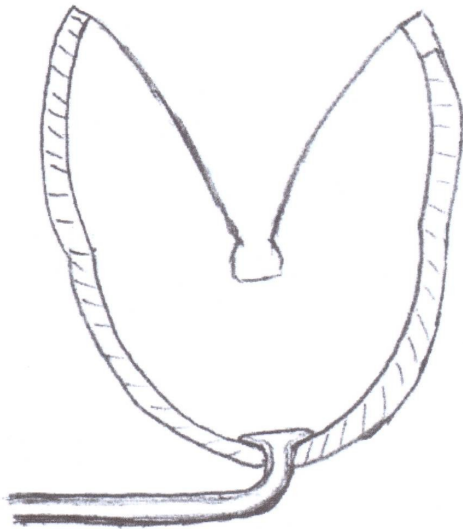
**Stem** – Drill 1/4" hole in bottom of bell to accept stem



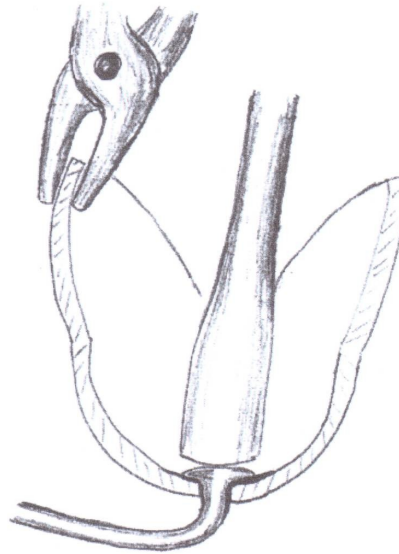
**Forge** stem from 6 inches of 1/4 inch round. Head one end and taper 1 1/2 inches of other end to a blunt taper.



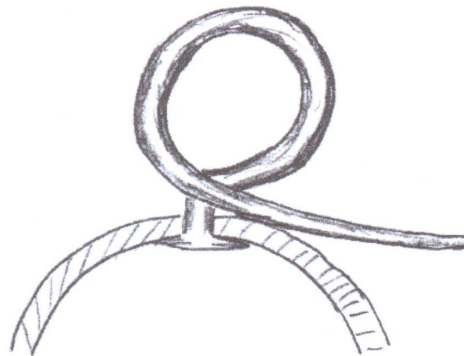
**Heat** the headed end of the stem and insert in the bell bending the stem at approx 90 degrees close to the bell.



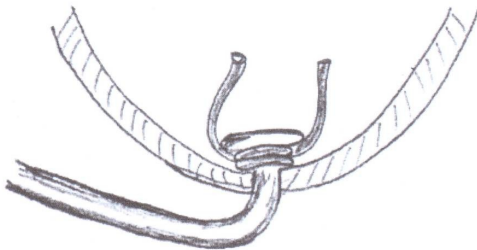
**Remove** from forge and hold head in place until bell cools and copper hardens.



**Heat** stem and form ring with scrolling tongs. Take care not to overheat the bell and break the copper braze.



**Heat** and flux the stem head and then wrap with copper wire. Preheat the bell and then reinsert the stem. Heat slowly to near welding heat watching until the copper wire melts.



**Heat** tapered end and wrap around stem with scrolling tongs to finish ring.

