

Saltfork Craftsmen Artist-Blacksmith Association

November 2013



Clay Spencer demonstrating at the SCABA 2013 Conference

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Editors notes...

It's the first part of November and we have survived our 17th annual conference and have the upcoming holidays to look forward to. I hope everyone that was able to come enjoyed watching Clay Spencer.

Many of you have commented on the fact that you received two newsletters for October. Some of the pages in the first one were so faded out that they were unreadable. It was a combination of events that I hope to watch out for in the future. Any way I hope that everyone received the replacement.

Many of you send me articles and pictures taken during meeting, etc. The camera on a cell phone, while convenient, is not meant for publication. These pictures, when inserted, are pixilated and do not reproduce clearly. Please, if you think you might be taking pictures for me, take a digital camera with you. I hate for you to go to the trouble of taking pictures, sending them to me and me not using any of them. Also, drawings, maps etc need to be done in ink and not pencil unless you really apply pressure and get a good copy. They are the ones that become faded the worst.

Many of the articles you see in our newsletter were first printed in one of the other ABANA affiliate's newsletters. The Editors exchange newsletters either by hard copy or electronic copy. This way we can share information, ideas and techniques with other like minded individuals around the world.

ABANA has two quality publications that you receive with your membership. There are a lot of other perks that you can check out by going to their web site. Check them out and see what they have to offer.

Remember that meetings are first come first served. Or the early bird gets the worm or meeting date as the case might be. Check out the meeting page and see if there is a date free for next year that you want to grab for yourself. Fill out the form and get it to me. Thanks for letting me be your editor... Diana Davis

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



November Presidents' notes.

Another conference is now behind us. I hope that everyone enjoyed it and had a good time. Folks that came from Kansas (and farther north) told me they had driven through sometimes blinding snow. I thought WOW, but when I got outside Saturday morning, I realized they had brought the COLD with them!

I believe the number of people attending the conference was down this year in comparison to years past. Not sure if we can blame the economy this year, but I am sure the lack of motel rooms at least made it hard on some people. I know that several of us made and received phone calls trying to help folks to find a place to stay. We are in the process of moving the conference to Norman (Cleveland County Fairgrounds) next year. There would definitely be more lodging. The only dates available were November 1st and 2nd with Friday October 31st being set up day. We have received a call back from Elizabeth Brimm and that weekend is better for her also. So mark your calendars for next year and get the hotels rooms booked early.

While on the subject of the conference, I would like to Thank everyone who helped to make it a fun and what I believe was a successful conference this year. I know it was a lot of work and as usual it was done mostly by the same folks that do it every year. I would like to ask people to please get involved in YOUR club activities. At least some that keep doing it year after year are getting tire and could sure use some help! It seems we always hear how something was done or handled wrong, but if the person with the gripe is asked to help, we are promptly looking at their back as they are slithering away! I really feel if we don't get a little help from a few more folks, we may be like one of those other clubs that have kind of "went by the wayside". I can't speak for everyone else, but I haven't gotten to actually watch a demonstrator since becoming a board member!

I think it's time for me to get down off my soapbox and quit griping and whining, but I do want to thank everyone for the great job that was done. Gerald Franklin also needs a big Thank You from all of us for tending the fire the whole time for Clay Spencer who I am told did a great demonstration.

Now I would like to thank all the people that participated in the silent auction, and opened your hearts and wallets to help Charlie Groom! The goal has been met and now Charlie and Gerry have one less thing (money) to worry about. There may be unexpected costs, therefore donations can still be deposited in Charlie's Arvest Care account. God bless you all.

I was lucky to get to go to Ed McCormack's place for the northeast meeting. If you haven't been there and seen his place, you are sure missing out. That is one guy that isn't afraid to weld a little! Everywhere you look you will find his awesome artwork!

I'm writing this just after getting back from the northwest meeting at Don Garner's place in Thomas. Just as I figured, he has a very organized shop, and his home looks like one you would see in a Better homes and Gardens magazine.

JJ McGill has invited a boy scout troop to come to the Murry County Antique Tractor & Implement Association's ground on February 15th for their Zombie apocalypse training. They want to learn to forge things to combat zombies with, if I have it right. He has chosen to have the south central meeting in conjunction with them, hoping to lure some Saltfork folks to show them forging and help the boys with forging. There are going to be around fifty boys. If you can please come and bring your equipment and help out, I'm sure we will all have fun. You can call me if you are interested, or have an questions at 405-650-7520 or email me at byrondoner@esok.us or if you want to reach JJ his info is.. jjmcgill88@yahoo.com or 580-369-1042

I hope everyone has a safe and happy Thanksgiving!

Babbling Byron Doner

I want to thank everyone so much for your generous donations of items and money for the silent auction. We deposited \$7549.00 today. You are all awesome and I am proud to be in your circle of friends.

Carol Doner

REGIONAL MEETINGS:

November Regional meetings

- SE Regional meeting (Nov 2nd) Will be hosted by Bill Phillips at his shop at 14360 St. hwy 113 lunch is provided but bring a side dish. Trade item is a chisel. Map will be in next months newsletter.
- NE Regional meeting (Nov 9th) Will be hosted by Mike Krukoski at 22558 E. 320 Rd. Chelsea, Ok. Lunch is provided but bring a side dish. Trade item is a snowflake.
- SW Regional meeting (Nov 16) will be hosted by Bob Mckelvin at his shop west of Rush Springs. Lunch is provided but bring a side dish. Trade item is a shovel and he would like for you to use the shovel blank on the SCABA swage block if you have one.
- NW regional meeting (Nov. 23rd) will be hosted by Mandell Greteman at his shop . (directions are from Hwy 44 and main street in Foss, Okla... go 2 blocks west) Trade items is a soup dipper. Lunch provided but bring a side dish to help out.

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

Forging Wrenches.

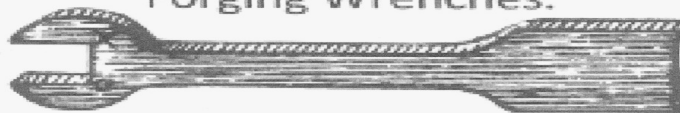


Fig. 60—Shows Faulty Method of Forging Jaws.

To make a wrench of this kind proceed as follows:

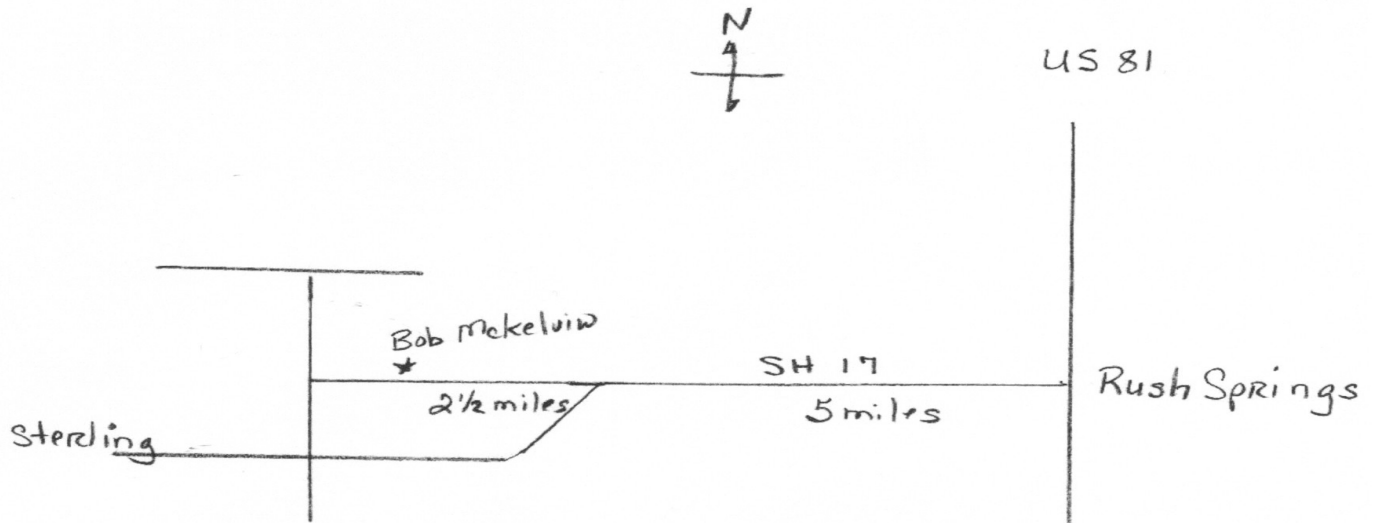
Fuller Fig. 58 at A A, forge and round D as C in Fig. 59 ; now get the center of C and punch the hole, letting the outside of the hole strike the center of C, as shown in cut. This gives us a strong corner at XX. Then split out as per dotted lines finish. Never make a corner in a wrench as is the case at X O in Fig. 60, as it is more apt to break than when made rounding.



Fig. 58—Shows Points to be Fullered.



Fig. 59—Shaping the Jaw.



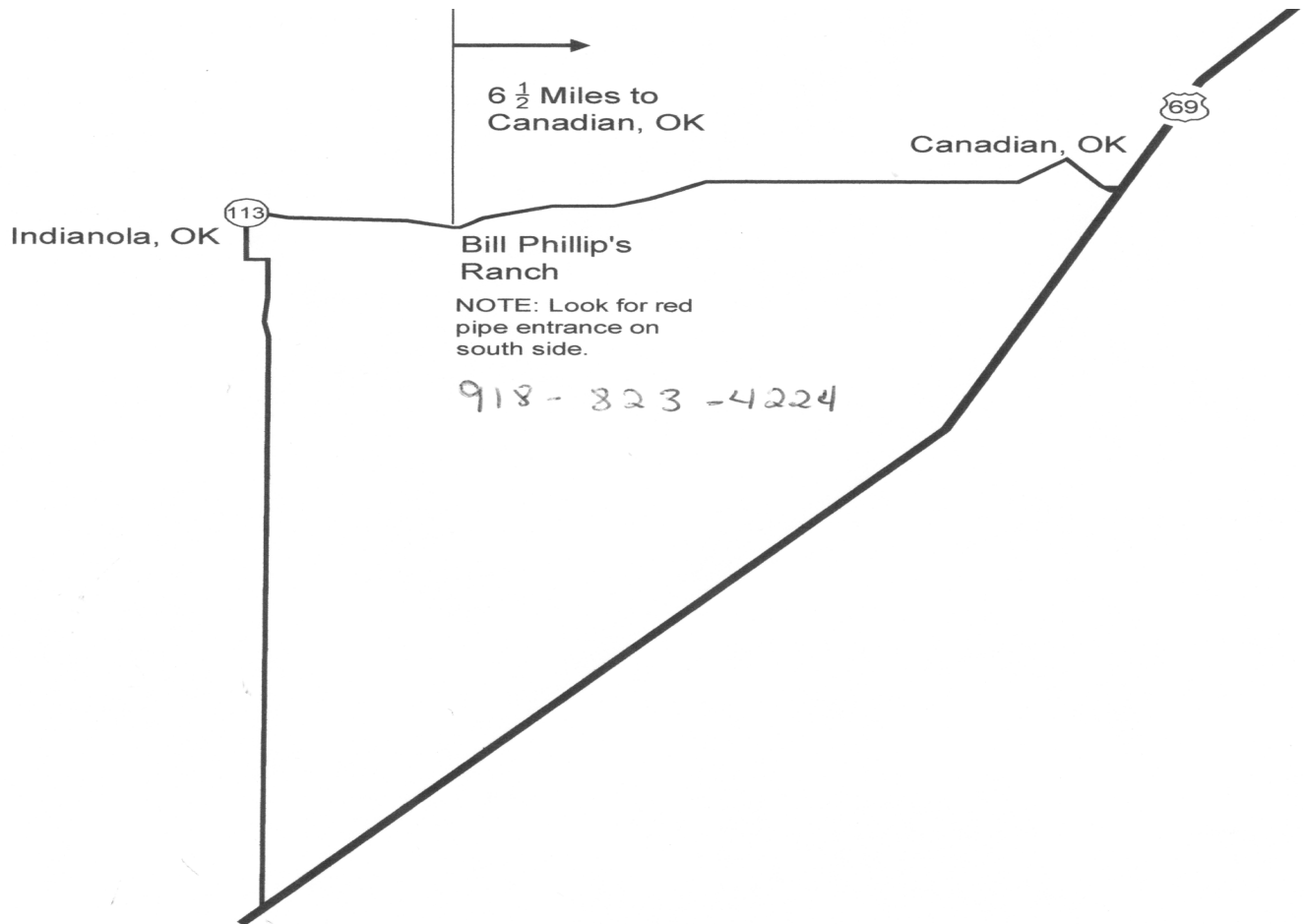
At the intersection of US 81 and SH 17 near Rush Springs, turn west and go about 5 miles. SH 17 breaks south here. Continue going straight west for about 2.5 miles. Bob and Shirley McKelvin's home is on the north side of the road. Watch for the anvil signs.

Phone numbers:

Bob McKelvins 580-365-4470

Or Bill Davis 580-549-6824

MARLOW



Traditional Chest

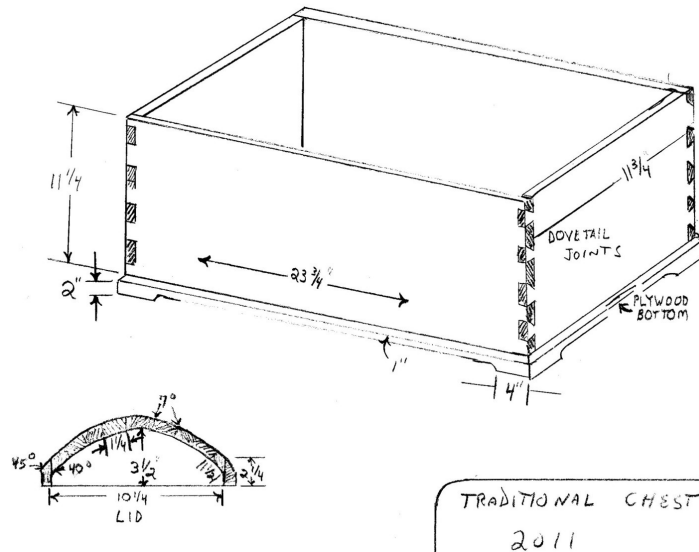
Aubrey Washington
Rock Creek Forge



In March, Gerald Franklin and I attended the Traditional Chest class taught by Bob Alexander and Pat McCarty at John C. Campbell Folk School in Brasstown, NC. I am grateful to SCABA for partially supporting my attendance with a scholarship. And, I am especially grateful to Bob and Pat for generously allowing me to share their knowledge, techniques, and creativity. In this and coming articles I will describe how to build the chest we made in the class. However, there are many ways you can adapt this for your own design.

Carcass Construction

Construction begins with the four sides of the chest. The outside of the chest is all $\frac{3}{4}$ " wood. I used red oak, but you can choose your favorite wood. The front and back are $11\frac{1}{4}$ H X $23\frac{3}{4}$ W; the ends are $11\frac{1}{4}$ H X $11\frac{3}{4}$ W. (See Figure 3.) You will probably need to glue up two or more boards to get the $11\frac{1}{4}$ dimension. We used dovetail joints. But you could use box joints (finger joints), which are almost as strong and easier to cut. Once all the joints fit neatly, number each corner so that you can put it back together in the same way.



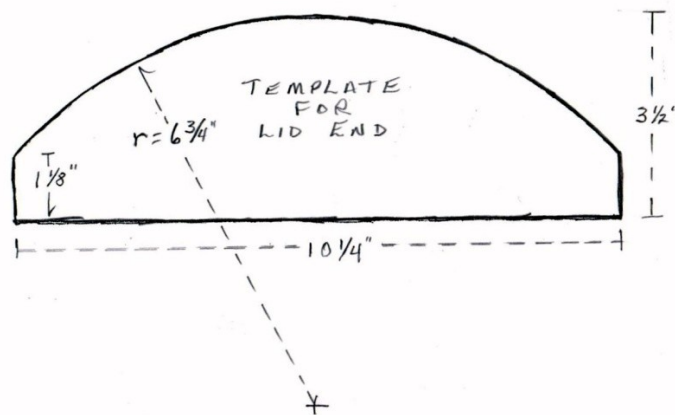
Now take the box apart. (Note: An extra pair of hands will be helpful for this next part.) Apply a good quality wood glue (e.g., Titebond II) to all mating surfaces of the first corner. Assemble quickly, as the glue will begin to set in a few minutes. Quickly apply glue and assemble each of the remaining corners. Then apply clamps in all directions to hold the joints tightly together. Avoid placing clamps on the end grain of the pins or tails of the dovetails (or finger joints) because this will not be effective in closing the joint. Measure across diagonals to make sure the box is square. Make adjustments as necessary. (Note: Assembly should be done on a flat surface. The only really flat surface in my shop is the table saw.) Using a damp sponge or rag, clean up glue squeeze-out. Allow glue to set up overnight.

This might be a good time for a break. (I like a good IPA or a dry Merlot.) But, if you still have some energy, you could make the plywood bottom for the box. We used $\frac{3}{4}$ " plywood. The dimensions are the same as the outside dimensions of the box: approximately $11\frac{3}{4}$ X $23\frac{3}{4}$. But, measure your box for the exact dimensions.

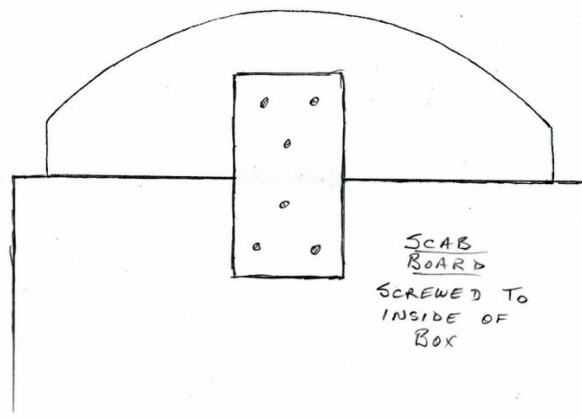
(Note: It is better for the bottom to be slightly smaller, say $\frac{1}{16}$ " , than for it to be slightly bigger. You don't want the plywood to "peek out" around the sides of the box.) We will make the feet of the chest later. When the glue is well set, turn the box upside down and place the plywood bottom on it. The bottom will be fastened to the box with screws, but no glue. This is important because we will need to remove the bottom several times during construction. Drill and countersink pilot holes for the screws, say 3 along the front and back and 2 on each side. We used drywall screws, $1\frac{1}{2}$ " I believe. (Note: If you start with 2 screws near opposite corners, they will hold the bottom in the right place while you drill all the remaining holes.)

Construction of Coopered or Barrel Top

The lid or top of the chest is the most complex part of the woodwork. The first step is to cut out the two ends of the top. In the class we used a template provided by the instructors. But this is not strictly necessary if you are not trying to make a bunch of boxes the same. Start by cutting 2 pieces of wood the length of the inside of the end of the box, appx. $10\frac{1}{4}$ " long and $3\frac{1}{2}$ " to 4" high. (See Figure 4.) The straight vertical part is $1\frac{1}{8}$ " long before the arc starts. The radius of the arc is $6\frac{3}{4}$ ". Lay this out carefully, cut close to the line with a band saw or jig saw, then sand to the line for a smooth arc. You can use the first end as a template for the second one.

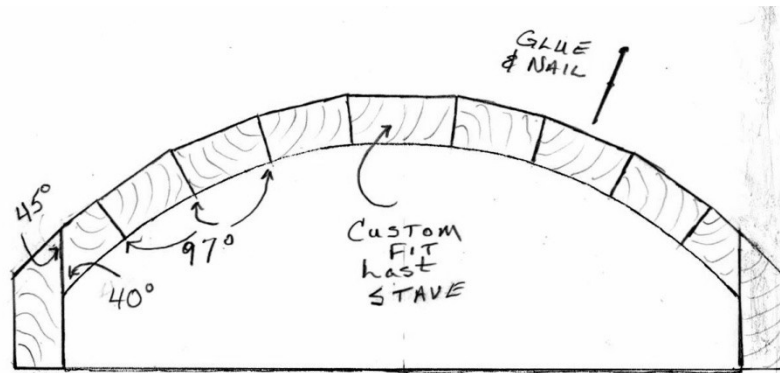


When the ends are ready, attach them temporarily to the box with scab boards screwed to the inside of the box. (See Figure 5.) (Note: Be sure the screws do not protrude through the outside of the box!)



You will need a table saw to rip the staves for the top. First cut the stock for staves to the length of the box, $23\frac{3}{4}$ ". There are three different stave profiles. (See Figure 6.) The two vertical pieces that run along the front and back of the lid are ripped to 45° along one edge and 90° along the other, and are $2\frac{1}{4}$ " wide on the long side. The second staves up, on front and back, are cut to 40° on one edge and 97° on the other, and are $1\frac{1}{2}$ " wide. (Note: The instructors referred to these 97° angles as 7° cuts because the saw blade is tilted to 7° from vertical. So, I will do so also.) The remaining seven staves are ripped at 7° along both edges (keystone shape) and are $1\frac{1}{4}$ " wide on the narrow side. Actually, the seventh stave (which fits at the middle of the top) will be

wider or narrower than 1 ¼", so wait to cut it to final width. (Note: All the 7° staves can be cut from one or two wider boards with one table saw set-up by flipping the board end for end after each successive cut.)



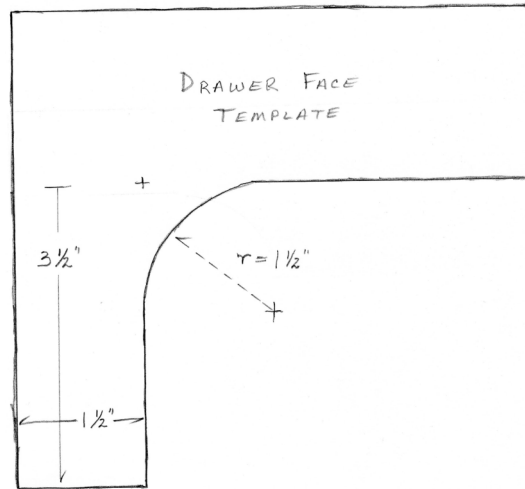
Now is a good time to take a break. Relax with the cold, refreshing beverage of your choice. And, find a friend to help with this next part.

The staves are glued and nailed to the end boards. (Note: A pneumatic finish nailer with 1 ¼" finish nails is very handy for this!) Before you start gluing, you want to avoid gluing the lid to the lower section of the box. Blue painters tape along the top edge of the box works well for this. This is also a good time to remove the plywood bottom of the box. This will be your only access to the inside of the chest to clean up glue squeeze out. You will be adding staves to the lid starting from the bottom and alternating front and back until you meet in the middle. Start with the two staves with the 45° angles. Be sure that the angle slopes to the outside of the box. (See Figure 6.) Apply glue to the mating surfaces of the first board and lid end, hold the board in place, and shoot two nails in each end to hold it in place. Repeat for the other 45° staff. Next comes the staff with the 40° cut. (Here is where your helper will come in handy.) Apply glue to all the mating surfaces including the long joint between the first two staves. You need to work fairly quickly from here on because the glue will start to set in a few minutes. Place the 40° staff in place and shoot one nail in each end. Repeat for the other side. The next six staves (three on each side) all go on pretty much the same way. Be sure the joints are fitting together tightly and you have good glue coverage. You will be left with a gap at the center of the top. This last staff may need to be slightly wider or narrower than the others. It also may need to taper slightly from one end to the other. Measure the gap at both ends. Saw the final staff to the width of the wider end of the gap (if they are different). You can taper the staff with a wood plane, sander, or whatever works for you. Once it fits properly, glue and nail it in place.

Before the glue sets, you can do some minor tweaking to close gaps, press down staves that are squeezing up, etc. This may require the creative use of wood blocks, ratchet straps, clamps, weights, whatever it takes. Clean up as much excess glue as you can while it is wet. Once everything is close enough, let the glue set over night. Take a break. You deserve it!

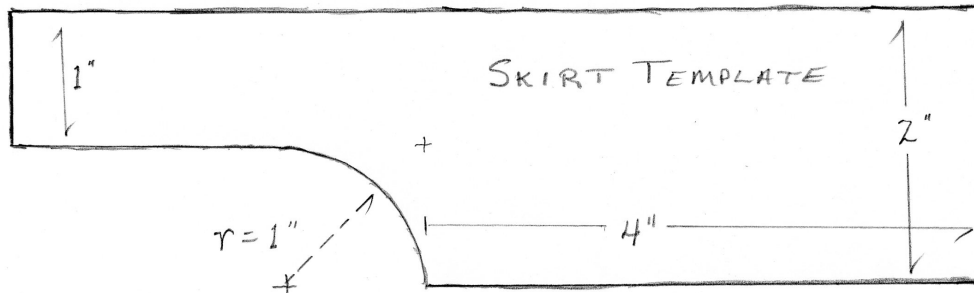
Cutting the Drawer Face

Consider the drawer in the bottom of the chest as an optional feature. You could opt to skip the drawer, maybe adding sliding tills inside the chest instead. But, if you decide to tackle the drawer, the first step is to cut the drawer face from the front panel of the chest. My drawer face is 3 ½" X 20 ¾". The top corners are curved with a radius of about 1 ½". (See Figure 7 for template.) We used a jig saw to make the cut. Mark the cut with a pencil and cut carefully. (Note: When making the curved cut, the jig saw blade will have a tendency to bend, making a cut that is not perpendicular. So, take it slowly and carefully.) When the cut is complete, clean it up with sandpaper and set it aside for later. We will make the body of the drawer later.



Making the Bottom Skirt and Feet

Despite appearances, the chest does not actually rest on the skirt that runs around the bottom. It actually rests on four small $\frac{1}{2}$ " X $\frac{1}{2}$ " feet, one in each corner, hidden by the skirt. We will deal with the feet later. The skirt is made from $\frac{3}{4}$ " X 2" stock. The front and back strips are rough cut to about $25 \frac{1}{2}$ ", and the two end strips are rough cut to about $13 \frac{1}{2}$ ". The corners are mitered. You will be fitting the skirt around the plywood bottom, not the chest carcass itself. I find I get a better fit if I cut each piece a hair long and "sneak up on" the perfect fit by trimming a little at a time. Number the pieces so you can get them back in the same order later. It is best to make a template for the profile of the skirt pieces so that all eight curves come out the same. (See Figure 8.) You could make these cuts more decorative, if you like. These can be cut out on a band saw if you have one. If not, a jig saw will work.



Place the plywood bottom, top down, on a flat surface. Check the fit of all the mitered corners (remembering to match up your numbers). Now glue and nail the skirt to the bottom. You may need clamps to pull the corners together neatly.

Now you can cut the feet to length from $1 \frac{1}{2}$ " X $1 \frac{1}{2}$ " stock. The feet should protrude about $\frac{1}{8}$ " below the bottom of the skirt. Glue one foot inside each corner of the skirt.

Sanding

The outside of the chest is basically complete. (We still need to make the false floor, drawer and tray.) This might be a good time to tackle some heavy sanding. The glue on the barrel top and dovetail corners should be well cured by now. Using a belt sander, sand the ends of the pins and tails flush with the sides of the chest. Sand the staves of the barrel top until you have a nice smooth curve all along the top. This can take some time, but it really pays off if you do it well. Go over all the surfaces of the chest until it feels smooth. (Don't forget to sand the drawer front.)

Good job! Now take a break and wash the sawdust out of your throat with your favorite beverage. (Oh? You wore a dust mask? That's okay, have a drink anyway.)

False Floor

Feel better? Okay, back to work. Cut the false floor out of $\frac{1}{4}$ " plywood to the inside dimensions of the box. Mine was about $10 \frac{1}{8}$ " X $22 \frac{1}{4}$ " and made from red oak plywood. The false floor needs to be supported 4" above the actual floor of the box. Using $\frac{3}{4}$ " wood, cut two pieces 4 " X $10 \frac{1}{8}$ ". Attach these inside the short ends of the box with screws, being careful that the screws do not protrude through the outside of the box.

(These floor supports also serve as drawer guides.) Now cut the front and back supports out to fit between the end supports, approximately 1" X 20 1/2". (The front support also serves as the drawer stop by contacting the drawer front.) Attach these with screws. Later you can attach the false floor to the supports with screws. But leave it off for now to allow access to the drawer.

Drawer construction

The drawer is fairly simple. Using 3/4" wood, 3/4" cut two short sides at 2 1/2" X 9 1/2" and two long sides at 2 1/4" X 20". The bottom of the drawer is 1/4" plywood cut to 9" X 20". About 1/4" above the bottom of each side piece, cut a dado 1/4" wide and 1/4" deep to accept the bottom. On both ends of the two 9 1/2" end pieces, cut a rabbet 1/2" wide and 1/4" deep to accept the 20" front and back pieces. (Note: Dados and rabbets can be cut on a table saw or with a router.) Assemble the drawer with glue and nails. A pneumatic finish nailer helps here. Check diagonals to make sure it is square; adjust as needed.

While the glue is setting, remove the barrel top and screw the bottom of the chest in place. When the glue is set, you can fit the front of the draw to the body. The front is held in place by three screws. Drill clearance holes for the screws through the front panel of the drawer body. Insert the body of the drawer into its place in the chest. Now place the drawer front in place. (Note: A layer or two of masking tape along the bottom edge of the drawer front will raise it slightly and prevent it from dragging when the drawer is opened and closed.) Now, with the drawer front and body both in place, screw them together from inside the chest. (Remove the masking tape.) The drawer should now slide freely in and out. You can now screw the false floor in place.

Tray Construction

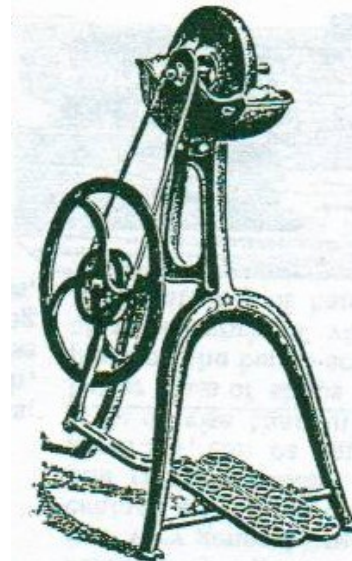
The construction of the tray is much like the drawer, with the addition of the center divider. The short sides are 3 1/2" X 10"; the long sides are 3 1/2" X 20 1/2". The center divider is 3" X 20 1/2". The plywood bottom is 9 1/2" X 20 1/2". As with the drawer, cut dados in all sides to accept the bottom and rabbets on the two short sides to accept the long sides. The short sides will also need a 1/4" X 1/4" dado to accept the center divider. Everything gets glued and nailed together. (Note: There are a lot of pieces that need to come together at once, so it helps to have an extra set of hands.) Check diagonals to make sure everything is square.

Finish

If you like, fill nail holes and other flaws with wood filler. (I just left them as they were.) Go over all the wood one more time with fine sandpaper. When the surface is to your liking, finish the wood with your favorite finish. I just used Tung Oil. But you can stain it and finish it any way you like. (Note: In my experience, stain makes wood filler stand out in an unnatural way.)

I can imagine that by now you are saying something like, "Geez! What's with all the sawdust?! I'm a blacksmith!" Well, congratulations! You are now finished with all the wood work. By the way, in the class we did all the basic woodworking in less than two (long) days, with a lot of help from the instructors.

In future installments we will look at making the hardware for your chest.





BOW Class of 2013 Becoming an Outdoors- Woman

Pictured are 23 of the 40 students who learned Basic Blacksmithing Skills from Saltfork Craftsmen ABA members, Mike Krukoski, and Gerald Brostek at the 2013 BOW Conference held at Camp Waluhili, located on Fort Gibson Lake in eastern Oklahoma. Each student worked with anvil, hammer and forge to complete a “Drive Hook” of their own design with their newly learned skills using both gas and coal forges.

November workshops...

November has a 5th Saturday and so it is Workshop time. One of the workshops this month will be held at the Route 66 Museum Blacksmith shop in Elk City on November 30th.

Intermediate Blacksmith Class

Teachers: Don Garner, Mandell Greteman and Dorvan Ivy

Limit 10 people

Cost of class is \$35.00 (lunch and materials provided)

Please contact Gary Seigrist at (580) 243-8228 between 6pm and 8pm only.

WOMEN ONLY, BEGINNING BLACKSMITHING

Another workshop this month will be held at Byron Doner’s shop in Norman. It is for women only. Class size will be limited to 8 students.

Cost: \$35.00 (lunch and materials provided)

Instructor: Diana Davis

You will learn how to start and maintain your coal fire, basic techniques needed to draw a taper, twist, bend and upset, we will create a scroll, a square corner and punch a hole. It’s going to be fun. Come and join me.

To Register contact Diana at: Diana.copperrose@gmail.com or call 580-574-8428

Clay Spencer's Spare tire power hammer workshop. (see front cover)

Is anyone interested in building one of these power hammers as part of a workshop. Clay is willing to come to Oklahoma and teach this workshop. There will be a minimum of 15 people for the class. If you are interested, contact Jim Stubbs at blacksmithing-gone@gmail.com. Please put power hammer workshop in the subject line. If you don't have access to email you can call the editor at 580-549-6824 and she will forward the information. There is a fee for this project. It will be determined by the number of participants and the cost of the metal and other expendable supplies.

17th annual conference report...

The weather was not what we would have like to have while trying to get things set up on Friday. It started with a cold drizzle that morning and turned into a downpour for a time that afternoon. We all were hoping that the weatherman knew what he was talking about when he said it would be calm and about 60 degrees on Saturday. And true to his word, Saturday broke bright and sunny. A perfect day for a blacksmithing conference.

There was a lot going on all day. Clay Spencer demonstrated in one building while Teresa Gabrish, Carol Doner and Donna Dove held classes in the women's building. We set up for the auction and silent auction and had some nice items in the gallery. We didn't have the turnout for the auction and gallery this year that we have had in the past but we still had some extremely nice things.



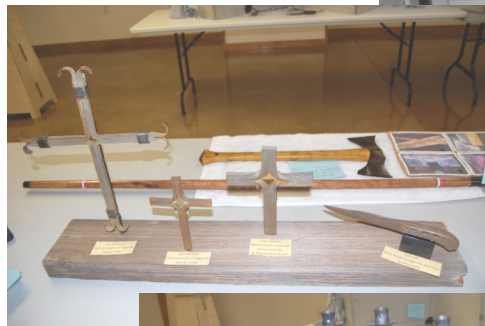
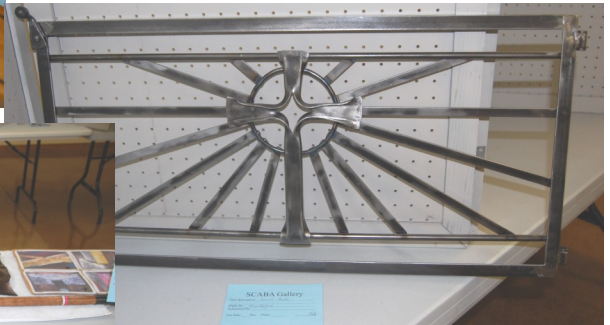
Ron Lehenbauer kept the tailgating area organized and there was a good selection of things to choose from. Gerald Brostek brought a lot of his collections of small anvils and Nathan brought some nice hammers to choose from. From the beginner to the more experienced



smith, there was something for everyone. Ron had all sizes of storage boxes, rivet and tools. Ricky Vardell had kaowool and I had round nosed pliers. Like I said..something for everyone.

We had some extremely nice items in the gallery. Both Gerald Franklin and Aubry Washington brought the chest that they made at John C. Campbell folk school.

This is a nice double faced ax that was made by Gerald Brostek. What is hard to see is the beautiful pattern of color that is on it.



I want to thank everyone that brought something to put in the Gallery. Ed McCormack has volunteered to help me with the Gallery and the People's Choice award next year. I was swamped and didn't get the contest set up this year. Diana

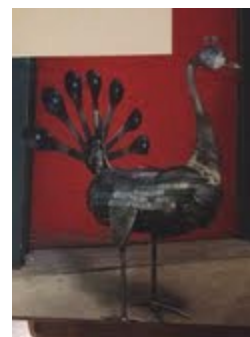


We had another successful drawing for our tool box this year. The number of tickets sold was down but that was alright for the lady that won it. She bought 3 tickets during the conference. Patty Tappel said she couldn't get her husband to buy any so she was not sure he would get to use any of the tools. Patty is a member of BAM and came to Oklahoma to see Clay Spencer and we hope she enjoys the box and all the tools that it contains. We want to thank everyone that made or bought a tool to put in the box and also everyone that sold the chances for it. We need to start on another one for next year. We held out 4 tools that were duplicates from this box as seed stock for next year.

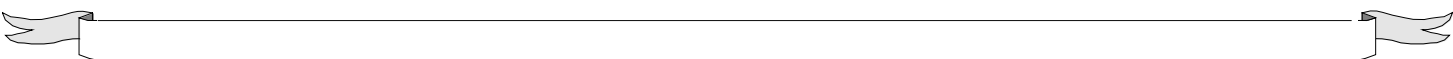


Silent Auction for Charles Groom Medical Assistance...

We want to thank everyone that help with the auction by either donating an item or bidding on them. We had a lot of great items and are glad to say that we managed to raise enough money that when added to that already raised by Charlie's family and neighbors, he is able to get the operation that the Dr.'s think will help him. Pictured below are a few of the items donated.



There were a lot of very nice items and I'm sorry that we didn't get pictures of each and everyone of them. But Thanks you for your donation....



Blacksmiths continue to forge a link to the past

Ed McCormack keeps tradition alive by hammering, bending and cutting wrought iron and steel

By **HERMAN BROWN**

Okmulgee Times editor

We live in a time when people constantly search for that next *amazing* electronic gadget.

We have our iPads and smart phones - and all those cool little phone apps. We log hours on the computer surfing social media sites. Precious time flies as we communicate endlessly with our Facebook friends. Sadly, we seldom have face-to-face conversations with our *real* friends.

We have gained so much in this modern new world. These inventions enrich our lives in countless ways. At the same time, we have lost many personal skills and talents of our past. We have high-productivity machines doing the work that individuals used to perform. The hand-made approach has given way to assembly lines in our computer-driven society.

Ed McCormack understands the logic in our mass-production society. He knows that individuals will continue to lose ground in this Internet age. Even so, the Okmulgee County native is determined to keep alive the skills of blacksmithing - a trade that is centuries old.

So, what does a blacksmith do? They create objects from wrought iron or steel by forging the metal with tools to hammer, bend, and cut.

According to *Wikipedia*, blacksmiths produce objects such as gates, grilles, railings, light fixtures, furniture, sculpture, tools, agricultural implements, decorative and religious items, cooking utensils, and weapons.

McCormack has practiced the craft of blacksmithing for most of his life.

It was passed down by his father decades ago. The retired welder is determined to see blacksmithing continue long after he takes his final breath. McCormack is not alone in his passion for the craft. He is an active member of the Saltfork Craftmen Artist-Blacksmith Association. He travels across Oklahoma to attend meetings hosted by Saltfork colleagues.

He has twice hosted northeast regional meetings at his home east of Okmulgee. His most recent gathering came on Oct. 12. Members came from all points on the compass, with the most distant members driving here from his home at Hammon, north of Elk City.

“We had 20 to 30 come here for the meeting,” McCormack said. “It was a pretty nice turnout. Three of them came from Elks City.”

The total might have been a little higher except that the event fell on the same day as the Oklahoma vs Texas college football game. A few of the regulars chose the pigskin rivalry over blacksmithing. However, those members who crowded into McCormack’s spacious workshop were treated to a full day of fun.

The meetings are always very informal. Members drift around in small groups and share stories of their current blacksmith projects. They also detail successful items they have crafted over the years. These members are quick to trade their ideas, tips and information. Some even offer hands-on classes and demonstrations of their individual techniques.

The host always provides the main course for the group lunch. In this case, McCormack cooked 5 pounds of beans and 3 pounds of sausage to feed his guests. Each visitor brought a side dish to extend the menu to a nice level.

Another interesting feature of the regional meetings is the trade program. In October, the trade item each person was invited to bring (if they wanted to participate) was a knife. These blacksmiths create knives and countless



other items from all kinds of objects. McCormack's trade knife was a small pipe-wrench on one end – with the handle on the other end converted into a sharp knife blade.

"It's a novelty knife," he said. "You don't have to bring one. You can make one will you are here. Old Bill (McCormack) made one out of a horse shoe this morning."

Three forges were constantly burning in the shop. The coal-fed forges providing members a chance to make an object or show off their method of blacksmithing.

"We trade ideas and procedures at these meetings," McCormack said.

The knives were all placed on the trade table. A 'blind' drawing was then held to determine who would end up with which knife.

Much of the talk at McCormack's regional meeting was related to the Saltfork state conference that was schedule the following weekend in Perry. The annual event attracts members from Oklahoma and neighboring states. They converge on the county fair-ground to enjoy a 2-day get-together.

McCormack was eager to attend the 2013 state conference. He was the defending winner of the 2012 "People's Choice Award." He was heading back to Perry with hopes of repeating as the blue-ribbon winner. McCormack recently revamped a beautiful coffee table in anticipation of the state event. This table might provide a chance to repeat as the winner.

The 150-pound table features walnut wood obtained from Pennsylvania. McCormack created the table legs and frame from a 1-inch solid square bar of metal "twisted and forged and riveted together." He added 'grape vine' as a design element. He forged the leaves and the grapes and the vines. He then attached them to the table for artistic decoration.

McCormack spent hours and hours on the small details for his table. He was proud of the final product. However, he admits that when he began working he had no idea of what it would look like when finished.

"I start on a piece and it just kind of evolves," he said. "I had this wood. A friend of mine gave it to me. His son was an engineer on a Pennsylvania turnpike years ago. When they were clearing the right-of-way he would collect all the walnut trees and have them sawed up. This (wood for his table) had been sawed up since about 1960 or 1961. I've had it over 40 years myself." From the Pennsylvania wood, McCormack has created the coffee table and an occasional table. He still has a 6' by 6' section of walnut left for possible use in a smaller item.

The table he created was nothing short of a masterpiece. It would be very, very expensive if sold in a furniture store. Just how high the price would be is unclear.

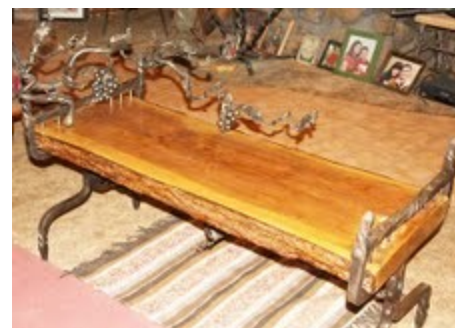
"I wouldn't have *any* idea what it would bring," he said. "I have no idea."

The table is a quality piece and is unique. Those facts would spike the price to a lofty total. But, for McCormack, his pride comes for the quality of the object – not the price tag.

To his dismay, the state conference did not include the "People's Choice Award" competition in mid-October. McCormack was unable to defend his title.

"Maybe I'll get a chance to do it next year," he said.

As for blacksmithing, McCormack plans to continue to create objects for a long time to come. He is proud to carry forward a craft and trade he learned as a small boy. He hopes that future generations will continue to feel the same passion felt by him and other Saltfork members.



Meeting of the SCABA board..

This is not an official set a minutes for the board meeting that was held on Friday night, October 18th. This is just information to let the club know the issues that the board is dealing with.

The meeting was called to order by President Byron Doner at 7:22 pm. Board members present were: Byron Doner, Dan Cowart, Bill Kendall, David Seigris, Mandell Greteman, Mark Carter and Diana Davis. Others present were Tracy Cowart, Carol Doner

The first thing that was taken care of was the vote on the minutes for the last meeting. Vote was taken and the minutes were accepted. You can find a copy of them on the next page of this newsletter.

The next item on the agenda was a discussion concerning upgrading our video equipment to digital. There seems to be a large expenditure to do this but will make the editing of the conference tapes much faster. Right now, each tape has to be uploaded to the computer while digitizing it. This has to be done in real time which means that if you have 4 hours of tape you have to monitor it for 4 hours to get it on the computer and ready to edit. You then have to edit it which means setting there and cutting out sections like tending the fire and heating metal up to get it ready to forge, you know the boring parts of a video. If we upgrade to the digital camera's, one it eliminates our need for the tapes that are getting harder to find and more expensive. Plus the storage of the tapes if we want to keep them. You can't reuse them very many time until you loose quality. Second, it will speed up the editing and make the time from conference to you being able to sit in front of your TV and watching the demo again, or as in my case, for the first time.

The down side to buying digital cameras is their cost and the pace at which everything is being out-dated. It was not that long ago that we were buying these camera we are using now because of the tapes and editing procedure required to get them to disk.

If we do go digital now, the cameras we have still have some value in resale. I don't suggest we keep them to loan out to video workshops because we would still have the same problem with editing, etc.

The decision of the board was to table any vote until Tracy could do more research and bring it back before the board for further discussion.

The next thing that was discussed was the Club helping out the groups that do the Rein fairs to the same extent that they do the group that does the state fair. Past board members set the precedence that club funds were used to purchase water and coal that was used during the state fair. The club funds were also use to pay for the insurance rider that the State Fair board requires. The request before the board was that if an organized group was representing the club at an event that is an annual event and that lasted longer than 3 days and had more than 3 members present on each day of the event, that the club help them out with the water and or ice and coal used during the event. They didn't ask for help with the insurance rider. The discussion was tabled until the next meeting.

Under new business, Bill Kendall told the board about a change in the casting that he authorized that should make the casting have fewer flaws. We had some show up in the shovel areas. All approved the change.

The last this that was discussed was the trouble with rooms we have had the last several conferences. We even tried to get the local hotel to block out some rooms for us and it seemed every time anyone called the first response they got was NO ROOMS. It took several calls to get the right person that knew what was going on. Byron asked about moving the conference to Norman. Carol Doner came and talked about the fees that the Fair board charges and the dates that were available. It was decided that if the demonstrators that we have for next year could change then we would give it a try. There should be no trouble getting hotel rooms or camping if that is what you like to do. We will also be closer to the airport and much of the equipment that is needed at each conference that has to be hauled to Perry each year. There will also be more opportunity for the ladies to go shopping etc. Maybe I should not have pointed that out...

The board meeting was adjourned at 8:35pm with the next meeting to be in February. If you have an opinion on any of these subject you are encouraged get on the agenda and to come to the meeting and add your support or disapproval for them.

Editor...

SCABA Board meeting
Minutes
Aug. 24, 2013

This third meeting of the board is being held at Elk City at the Route 66 museum blacksmith shop in conjunction with the NW regional meeting.

Board members present: President– Byron Doner, Vice President– David Seigrist, Sec/Treas.– Dan Cowart, Directors– Mandell Greteman, Diana Davis, Mark Carter and Bill Kendall.

Meeting was called to order by President Byron Doner at 1:00 PM

First order of business was the approval of minutes from last meeting.

Mandell Greteman made the motion that the minutes be approved as submitted, motion was seconded by Dan Cowart. Minutes approved unanimously.

Second item of business was an update on the State Fair. Diana Davis gave her report stating that everything was in order for the fair. She had a full schedule of workers for the 10 days. She reported that they had requested the comp. room for only 3 nights instead of the full 10. Fair documents would be gotten to each worker as soon as they were received. Set up for the fair would be at 9:00 AM on Wednesday, Sept. 11 2013.

Third item of business was an update on the Scotfest held on Sept. 13 & 14th. Steve Knisely had requested that the board send a proof of insurance to the organizers. Dan Cowart reported that it had been done.

Fourth item on today's agenda was to go over the SCABA Conference task list for the upcoming conference. David Seigrist, conference chair, did a line item review of the list. Necessary changes to the task list were made. The T-Shirt contest entries were reviewed. There were seven submitted. The entry submitted by Gerald Brostek was chosen for this years Conference T-shirt.

Last item was New business, Byron Doner reported that long time member Charlie Groom was in need of an operation that his insurance was refusing to pay for. It was discussed as to what if anything the club could do to help. After much discussion, David Seigrist made the motion to have Dodie set up a webpage to accept donations to help Charlie Groom, it was seconded by Byron Doner. Passed Unanimously

Addendum to the minutes...

Byron talked to Charlie and he requested that we wait about setting up any account or webpage until after his doctors has had a chance to talk to the insurance again. He will let us know the results of that meeting.

3D Snowflake

Michael Wollowski

In this article, you will find constructions notes for a three dimensional snowflake. Don Neuenschwander showed me one that Ken Dettmer made based on Don's specifications. Don himself saw someone up north make one of these.

The snowflake is made from a 3" piece of $\frac{3}{4}$ " square stock. It needs to be cut it several ways. To start, make two $1\frac{3}{4}$ " cuts along one side, splitting the side three ways. From the opposite end, make two cuts that are $\frac{3}{4}$ " long, again splitting the side three ways. You will be left with $\frac{1}{2}$ " in the center that is not cut. The cut layout is shown on the left side in figure 1 below.

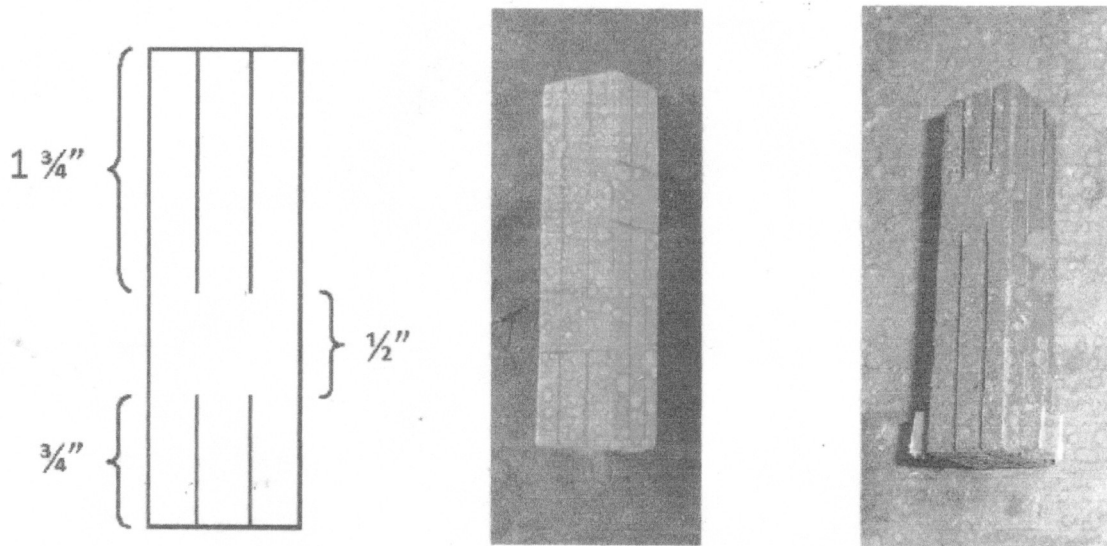


Figure 1: Cut layout (left), blank with marked cuts (center), cut blank with spacers (right)

Turn the bar 90 degrees and make the same cuts except from opposite ends. I like to put masking tape on the steel and draw my lines on it. The marked up blank can be seen in the center of figure 1. I insert some old saw blade pieces in the short cuts of one end. This is the end that gets to be put in the vise first. By placing the spacers in the cut, it is easier to open them up later on. The sawn blank, prepared for heating is shown on the right in figure 1.

In order to get the three dimensions, the primary bends are along the long cuts. When bending this piece, it is advisable to use tongs and a vise rather than a hammer and anvil, as the folds will be rather delicate and can easily be bent beyond repair.

To begin, heat up the bar and place the end with the saw blades in the vise so that the saw blades are parallel to the jaws. You need to place the bar in the vise so that the long cuts are about $\frac{1}{4}$ " proud of the top of the vise. This ensures that there is space for the jaws of your tongs. Bend down the outer two long sides. Before bending the long sides, it helps to open them up with a chisel first and then use flat tongs to grab a side and bend it out. You may have to perform a sequence of grabbing part of the side, bending it, grabbing some more, straightening it with the tongs and bending it. See about producing a nice bend, not too tight and not too wide. The picture on left side in figure 2 gives you a sense of the radius of the bend as well as how much the long cuts have to be proud of the top of the vise. If the arms are not straight, a chisel can be used to pry them off the vise jaws.

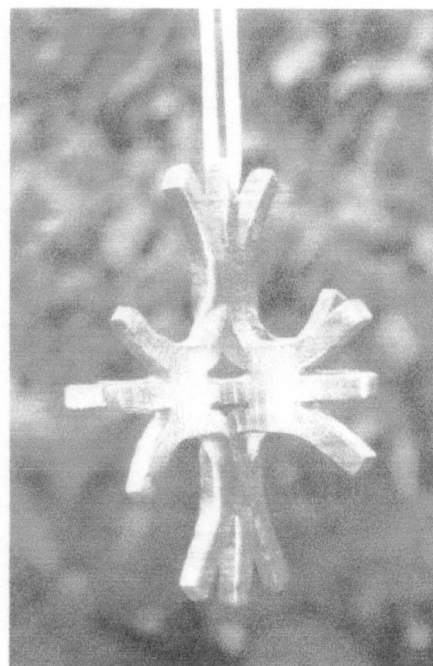
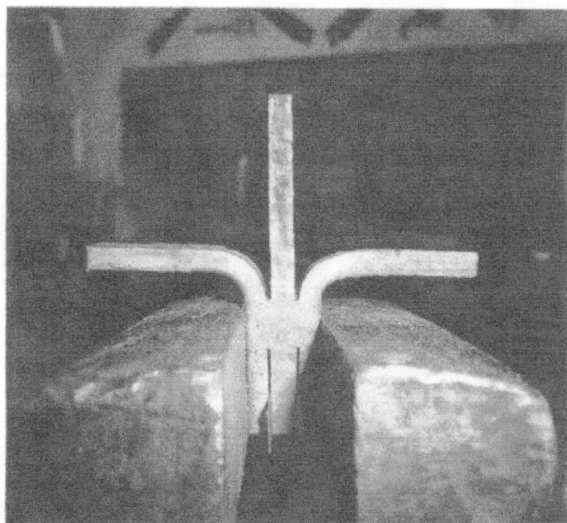


Figure 2: Blank after first set of bends, notice the spacers (left), finished snowflake (right)

Next, put a little bit of heat in the end that contains the saw blades and knock them out. Heat up the bar and cool down the center of the piece. Use a chisel to open up the long ends that are to be bent next. Put the piece back into the forge and heat it up. Now comes the hard part. The entire snowflake will be orange hot and any attempt to cool parts of it invariably cools down other parts that should not be cooled. Furthermore, any bending you do, will upset other parts of the piece. When opening up one of the hands, you will bend the snowflake out of shape, just ensure that when you bend the other hand, you bend it back into shape. You may consider using several heats to open up the two long hands.

The four bent arms should be in one plane. You may consider placing the piece in the hardy hole, placing a piece of pipe over the hands that need to be aligned and gently tapping on it. Notice that the sum of the two hands that have not been bent remains 3" long, yet the sum of the bent hands making up either of the two other dimensions are about 3 1/2" long. This is due to the fact that the outside hands are 1/4" off the center of the bar. The unequal length cannot be helped except for cutting 1/4" of the ends of each of the bent hands and then deepening the cuts by 1/4". You may consider hanging the snowflake so that the bent hands are vertical.

You are now left with having to bend the outside fingers made by the 3/4" cuts. If you split open the fingers with a chisel, you need to cool down the center of the snowflake as the hammer blows will compress the delicate bends at the center of the snowflake. You want to use some fairly narrow tongs to open up the fingers to about a 45 degree angle. Here again, consider using a process of repeatedly grabbing, bending, re-grabbing, straightening and bending. Notice that fingers of neighboring hands will end up parallel to each other.

I finished my snowflake by immersing it in vinegar overnight, brushing off the scale using a brush and water and polishing it with an angle grinder and the Dremel tool.

2013 Meeting schedule

SE Region (1st Sat)

Dec. **Open**

NE Region (2nd Sat)

Dec. **open**

SC Region (3rd Sat)

Dec. Ricky Vardell

NW Region (4th Sat)

Dec. **open**

2014 Meeting schedule

Jan	Jan: Gary Gloden	Jan; Gerald Franklin	Jan: Dorvan Ivey
Feb	Feb	Feb	Feb: Gary Seigrist
March	March: Doug Redden	March	March: Mandell Greteman
April	April	April	April: Bob Kennemer
May	May	May	May: Roy Bell
June	June	June	June: Don Garner
July	July	July	July
Aug	Aug	Aug	Aug
Sept	Sept: James Mayberry	Sept	Sept: Don Garner
Oct	Oct	Oct (SCABA)	Oct: Cheryl Overstreet
Nov	Nov	Nov	Nov: Mandell Greteman
Dec	Dec	Dec	Dec: Ted Culver

Saltfork Craftsman Regional Meeting Hosting Form

Region _____ SE _____ NE _____ S/C _____ NW

Date: Month _____ day _____ [correct Saturday for region selected above]

Name _____

Address _____

Phone/email _____

Trade item _____

Lunch provided _____ yes _____ no

Directions or provide a map to the meeting location along with this form.

****All meeting are scheduled on a first come basis. Completely filled out form MUST be received by editor no later than the 23rd of the month TWO months PRIOR to the meeting month.**

Completed forms can be mailed or emailed.

You will receive a conformation by email or postcard.

A form must be filled out for each meeting.

SCABA Shop and Swap

For Sale:

6" round nosed pliers (great for putting scrolls on small items) \$5.00 each. Brooms tied, \$20.00 on your handle
Please contact me for help with handle length.

Contact Diana Davis at 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@sbglobal.net

Wanted:

Sand Blast cabinet. Contact Tom Nelson
580-862-7691

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 or (home) 918-245-7279 or (cell) 918-639-8779

NEW CLUB COAL LOCATION:

Club coal is now available at Norman at Byron Donor place. Call Byron to make arrangements to come by and get coal.

ALL Coal needs to be paid for at time of pick up or arrangements made ahead of time with the treasurer.

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.



Show your pride in SCABA

License plates for \$5.00 each.

We have coffee cups for \$9.00 with two images on them and We have a new shipment of caps for \$10.00. There will be caps at the SC meetings and-Dan Cowart has cups and caps .

We have some 2013 SCABA conference t-shirts available if you didn't get to get one. Contact Dan Cowart or Diana Davis for sizes available. The t-shirts cost \$15.00

I also have the insulated cups marked down. You can get one for \$6.00 each or 2 for \$10.00. see me at a meeting..Diana

SCABA Membership Application

January 1, 20____ to March 31, 20____

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 for the period ending March 31, 20____

Signed: _____

Return to: Saltfork Craftsmen, 23966 N.E, Wolf Road, Fletcher, OK 73541

 ABANA	NEW & RENEWAL MEMBERSHIPS
---	--------------------------------------

Name : _____ Membership ID # _____
(For renewals. Optional)

Business Name (optional): _____

Street : _____

City : _____ State/Prov : _____

Zip/PC : _____ Country : _____

Phone : _____ Fax : _____

E-mail : _____ Website : _____

Membership Type: New Renewal

Regular (US, Mexico, Canada)	One Year - <input type="checkbox"/> \$55	Two Years - <input type="checkbox"/> \$105
Senior (65+, US, Mexico, Canada,)	One Year - <input type="checkbox"/> \$50	Two Years - <input type="checkbox"/> \$95
Full-time Student (US, Mexico, Canada)	One Year - <input type="checkbox"/> \$45	Two Years - <input type="checkbox"/> \$85
Foreign	One Year - <input type="checkbox"/> \$65	Two Years - <input type="checkbox"/> \$125
Public Library (US, Mexico, Canada)	One Year - <input type="checkbox"/> \$45	Two Years - <input type="checkbox"/> \$85
Youth (18 years & younger) non-voting Hammer's Blow only	One Year - <input type="checkbox"/> \$20	Two Years - <input type="checkbox"/> \$40 (No discount)
Educational Institutions	One Year - <input type="checkbox"/> \$250	
Contributory Membership (amounts above \$55 / year may be tax deductible)	One Year - <input type="checkbox"/> \$150 and up \$ _____	

Additional contributions to ABANA's special funds:

Exhibition Fund	\$ _____
Metal Museum Library Fund	\$ _____
Next Conference Seed Money Fund	\$ _____

Total: \$ _____

Credit card orders can be faxed, be sure to sign this form. Fax: 423-913-1023

Card Number	Expiration Date	CVS

Mail to: ABANA, 259 Muddy Fork Rd, Jonesborough, TN 37659 USA
 (Please pay by Check, U.S. Money Order or Credit Card)
 Phone: 423-913-1022 or join online at www.abana.org

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Wann, Okla.74083

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