

# Saltfork Craftsmen Artist-Blacksmith Association

October 2013

Four of the workers that forged during the State Fair in Oklahoma City. Mark Carter and Richard Blasius worked together on the First Monday and Tuesday of the Fair.



Roy Bell and Benjamin Hughes along with Richard Blasius work together on the second Thursday and Friday.

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Artist-Blacksmith Association  
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## Editors ramblings....

This has been a very busy month for me. Getting ready for two different events so close together means there are two piles of printouts to sort through but everything is on schedule. By the time you get this we have the State Fair behind us for another year. I hope to hear from the workers to see how they think it went and what changes we need to make for next time. I had a good crew of workers for every day and even a few extra on the weekends.

The conference is our next event and it is rushing right on along. I have been asking everyone to try to get something to put in the gallery, iron – hat and auction, well now it is crunch time and if you plan to help out at the conference in any of these events you need to get out there and “GET ER DONE”.

Hotel rooms are going to be in short supply but if you don't mind camping out you can set up at the fair grounds. We would love to see everyone try to come and see Clay Spencer demonstrate. He is a multi talented blacksmith and metal worker.

The newsletter is sent to the printer by the 26th of each month unless I am running slow. Getting older and runner slower all the time. Anyway. If you don't get a newsletter by the 15th of the month, especially if you live in Oklahoma. Please call and let me know. Calling after 3 months doesn't help me find out what the problem is. If you move and don't send in a new address to me, you won't get a newsletter, they do not forward them. If we receive a notice from the post office on a returned newsletter and I can't make contact with you before the next printing date. You will be dropped from the list and not added back until you call and give us a new address.

Deadline for articles and ads is the 24th of the month. If you miss the deadline don't worry ,unless it is time sensitive, it will be in the next newsletter. If I receive something that needs to be out before the newsletter, I can send it to Dan and he can send it out by email. Diana

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)



## October President notes:

Boy I'm glad September is behind us! I buried a long time friend on the 10th, then on the 11th Diana, Richard, Bruce, Ron, Jim and I got the forging area ready for the state fair. Do to the blowers falling off the forges it took me two trips, but we were ready when the fair gates opened on the 12th. I sure felt for Diana, Teresa and Bailey since that day turned out to be the hottest day of the fair! I started to go up and help out because there was little, if any wind. Called Diana to see if I should bring anything, and was reminded that it was a women's only forging day! So I stayed home and didn't get beat up in front of a bunch of fair goers!

The next day (Friday) I got a call from a lady wanting me to come and do a TV spot at the fair on Monday morning at about 6:30AM! I figured Ron Lehenbauer had given her my number, but when I asked, she described Tony Cable. It's kind of hard to find the stuff and get a fire built in the dark, but I got it going and a piece hot in time and all was going well till they turned on the camera and it's light made me not be able to see the anvil. I still managed to pull it off and now thanks to Tony, I'm a semi-celebrity! Of course it always rains during the fair, but I think it actually helped us a bit because it cooled things off a bit. On one of the afternoons just as the native Americans started their dance, a storm blew things around a bit. Richard, Benjamin, mark and I rode it out in the teaching trailer. It got excited when the board holding up out shade tarp snapped in a couple of places and the tarp got one corner yanked off of it! I was told there was more damage around the fair, but I don't think anyone was hurt. Thanks Lord! In all we managed to burn four (30 gallon size )barrels of coal.

On Friday the 20th I thought I was pretty much done with the fair and was looking forward to the week-end of rest. Then I thought of Jim Dyer and the tractor show at Sulphur. After a phone call, I was home loading my stuff until about 10:30PM. I got a fire lit about 9:00AM on Saturday and we had a pretty good time hammering all the day thanks to Jim, Ricky, Bruce, Don, Allen and a new guy named Lucas that done a forge weld! A Big thanks should go to Ricky and his arm that pumped the pump handle forge. Also saw Doug and Linda Bliss along with Larry Roderick and his bride,. I'm sorry I sold away the bee smoker Larry, If I ever see another I will get it for you.

The wonderful people at the tractor show grounds have built us a building to blacksmith in. Just guessing I'd say it's about fifteen fee by twenty five feet (maybe a bit bigger) Anyway its has overhead doors in both ends and along the whole south side it opens up and out like a firecracker stand. Concrete floor and electricity. IT'S NICE! I'd like to apologize to these folks of Murray county as about the time they built this building for us, we (Saltfork) started doing the state fair and have dropped the all on our great friends at their tractor show. I hope that next year we can try and sooth (at least what should be) some ruffled feathers. I have my calendar marked for Friday 19th, Saturday 20th and Sunday 21st of 2014. This is no matter when the state fair dates are!

I have been told that Charlie Groom has been denied by his insurance company and is now open to us having a silent auction to raise money for his operation. Also there is an account at Arvest Bank for donations. I urge everyone to make/bring something for the auction and if you would like to make a cash donation you can go to any Arvest Bank to do so. I understand that you just tell them it's for Charlie Groom Medical Account and they can pull It up on their computer and get it to this account. If you have any questions about it call me at 405-650-7520 or call Carol (my wife) at; 405-760-8388. I'm also sure that Diana Davis can help you. We Love you Charlie!

I'm pretty sure we've picked up a few new members this month. I'd like to welcome you all! Any Happy Hammering to All!

Your president, semi-celebrity  
Babbling Byron

## REGIONAL MEETINGS:

### October Regional meeting....

- ⇒ SE Regional meeting (October 5th) (Open)
- ⇒ NE Regional meeting (October 12th) hosted by Ed McCormack at 15100 N. 270 Rd Okmulgee, Okla. Lunch provided, bring a side dish. Trade item a knife.
- ⇒ SC regional meeting (October 19th-20th) Annual SCABA conference. Perry Okla.
- ⇒ NW Regional meeting (October 26th) hosted by Don Garner at home in Thomas Okla. Lunch provided, bring a side dish to help out. Trade item is a cooking tool. Directions: hwy 33 west side of Thomas. 2 north 3/4 west on county road 860. white house on North side of road.

### 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) (open)
- 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 TBA.
- NW regional meeting (Nov. 30th) will be hosted by Mandell Greteman at his shop in Foss, Okla. 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 TBA. Lunch provided but bring a side dish to help out.
- \* NW Regional meeting (Dec 28th) Open

## **WOMEN ONLY, BEGINNING BLACKSMITHING WORKSHOP:**

When: November 30th 2013 9:00 AM to 5:00 PM

Where: Byron Doner's shop in Norman, Oklahoma

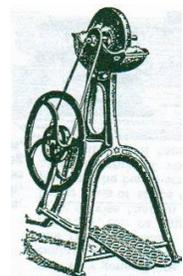
Class size will be limited to 8 students.

Cost: \$35.00 this includes lunch and all supplies used in the class.

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](mailto:Diana.copperrose@gmail.com) or call 580-574-8428



## Regional meeting reports:

September meeting for **the NE Region** was hosted by James Mayberry at the Rogers County Fair. So another September meeting has come and gone. It was a great day we had cool temperatures to work in over the heat of the forges. We had 14 or so blacksmiths show up and 4 forges going at anytime. I think we all had a great time. Thanks to all who came to the meet at the fair. We got a lot of publicity from the fair goers and hopefully some new members. Had a lot of folks stop by and watch as we all hammered on our projects and ask questions about blacksmithing. We told them that what we are doing here today is a dying art, if it wasn't for people like us that showed up here today. We may try to do it again at the fair next year if timing is right.

James Mayberry

The first weekend of the State Fair fell on meeting weekend for **the S/C region**. So I'm going to put the State fair write-up here.

The State fair goes for 11 days and I had 16 members that were on schedule to forge during that time. Byron Doner showed up on several days and Bill (my husband) came with me on Sunday and helped us tear down the blacksmithing area and get it all back in the trailer ready for Byron to come on Monday and pull back to Norman.

Opening day was set it up to be "Ladies day" and Teresa, Bailey Upchurch and myself had a full day. It was the hottest day of the fair but I told them when we started we were not going to kill ourselves but have a good time and I think we did. The fair provides us with access to their hospitality room and we each took our turns going to cool down and get a glass of lemonade. I was laughing with the gentleman from channel 4 that does the Great State reports, (sorry can't remember his name) about not getting in front of the camera's when he is around and then notice that Bailey is being interviewed by another channel. She was a natural at it. One camera person did catch me at the forge. Oh Well, hope I didn't break it...

Showers helped cool it down the rest of the time and aside from some minor damage in our area of the fair grounds it was a welcome change. I think some of the "Carny" people had tents blown down and some of their stuffed toys ruined.

I didn't work the weekends but during the week we had good days and slow days. Senior day was busy and though the schools brought kids each day I think Friday was the busiest. Had several young men express interest in blacksmithing and we gave them newsletters and directed them to our website to find meetings in their area.

I would like to thanks everyone that came and worked even if they were not on the schedule. Especially David King who came by that first day and helped me work on the tripod the soap lady next door needed fixed. We also repaired two of her wash board. She said one of them was over 100 years old. Mark Carter made a large staple and with guidance from the wood-turner, repaired the wash board the way it would have been fixed 100 years ago. It was a nice job and she gave some of us some Lye soap in thanks...

I hope everyone had a good time and will consider working again with me at the State Fair.

Diana

**The SE regional meeting** was held in conjunction with the Sulphur Tractor show. JJ McGill reports...That there were several that showed up to forge at the tractor show. Him and Jim Dyer would like to say "Thank You " to everyone that came to the 20th annual tractor show. And they plan to host the September meeting in 2014 so put it on you calendar and plan to attend.

## 2013 tool box list



### Item

### Donated By:

- |   |                               |
|---|-------------------------------|
| 1. Box                                      | Charles McDevitt              |
| 2. Cross Peen hammer                        | Gary Seigrist                 |
| 3. Straight peen hammer                     |                               |
| 4. Rounding hammer                          | OK's Farrier Supply (Ardmore) |
| 5. Wooden mallet                            |                               |
| 6. Handled slot punch 1/2                   |                               |
| 7. Handled slot punch 3/4                   |                               |
| 8. Handled slot punch                       |                               |
| 9. Hot rasp                                 | Gerald Brostek                |
| <b>10. Tongs</b>                            |                               |
| 11. 1/4 bolt                                |                               |
| 12. 3/8 bolt                                |                               |
| 13. 1/4 V bit                               |                               |
| 14. 3/8 V bit                               |                               |
| 15. 1/2 V bit                               |                               |
| 16. 3/4 V bit                               |                               |
| 17. 1/4 flat                                |                               |
| 18. 3/8 flat                                |                               |
| 19. 1/2 flat                                |                               |
| 20. 3/4 flat                                |                               |
| 21. Farrier's tongs                         | Nature Farms                  |
| 22. Scrolling tongs                         |                               |
| 23. Side grip tongs                         |                               |
| 24. Pick-up tongs                           |                               |
| 25. <b>Fire Tools</b> (shovel, rake, poker) | Jimmy Jo McGill               |
| 26. Hot Cut Hardy                           |                               |
| 27. Twisting wrench                         |                               |
| 28. Treadle/Hand Hammer Tooling             |                               |
| 29. Set of punches and holder               |                               |
| 30. Center punch                            |                               |
| 31. Eye punches                             | Gerald Franklin               |
| 32. Chisel (large)                          |                               |
| 33. Chisel (small)                          |                               |
| 34. Slitting Chisel                         |                               |
| 35. Hold down                               |                               |
| 36. Flat wire brush with handle             | Terry Jenkins                 |
| 37. Set of monkey tools                     |                               |
| 38. Rivet setting tool                      |                               |
| 39. Hacksaw                                 |                               |
| 40. Bolster plate                           |                               |
| 41. Square                                  |                               |
| 42. Dividers/compass                        |                               |
| 43. Scribe                                  |                               |
| 44. Bending forks                           | Jim Carothers                 |
| 45. Spring swage/fuller                     |                               |
| 46. Flux spoon                              | Jim Carothers                 |
| 47. Flux                                    | Jim Carothers                 |
| 48. Metal folding ruler                     | Nature Farms                  |
| 49. Soapstone and holder                    | Gerald Brostek                |
| 50. Ball tool (round blunt nose punch)      |                               |
| 51. Hook ruler                              |                               |
| 52. Finish wax                              |                               |
| 53. Brass brush/steel brush                 | Diana Davis                   |

Remember, if you have tools for the toolbox they need to be gotten to Mandell Greteman. His contact information is in the Board of Directors section in the front of the newsletter.

Inside Dimensions of tool box: 25 1/2 x 7 1/4

## 2013 Conference demonstrator

This year Clay Spencer will be our demonstrator at the 17th annual conference to be held in Perry Oklahoma.

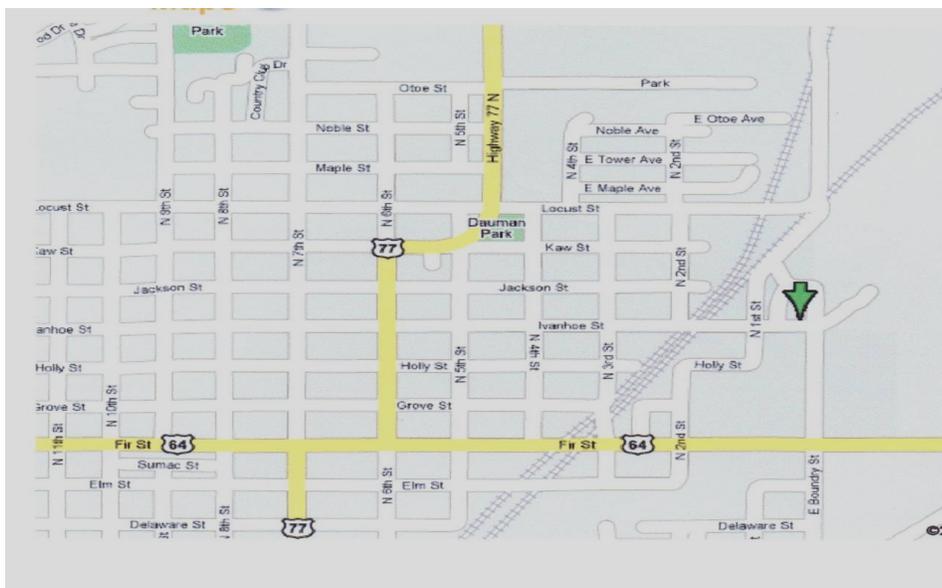
Clay started blacksmithing in 1987 in a class with Jim Batson and continued with many other classes, including traditional joinery techniques under Francis Whitaker. When Francis stopped teaching at John C. Campbell Folk School, he asked Clay to take over his classes. Clay started teaching in 1988, continues to teach, lead workshops and demonstrate blacksmithing all over the US. He redesigned the treadle hammer twice and led workshops to build them. He is now leading workshops to build 50lb Tire Hammers.

Clay was active in the Alabama Forge Council and served as writer and Editor of “The Bituminous Bits” for 10 years and won ABANA’s first Joe Humble Newsletter Editor of the Year, 1994 Award. He served on the ABANA Board for several years and received the Alex Bealer Award (ABANA’s highest award) and Life Membership in ABANA in 1997. He is also lifetime member of the Alabama Forge Council and Blacksmith Association of Missouri. The new timber frame blacksmith shop at the J.C. Campbell Folk School is named for Clay.

Clay worked for NASA at Marshall Space Flight Center in Huntsville, AL where he headed the design group for the rubber tired transporter for the lower stage of the Saturn V. he was working on the Solid Rocket Booster of the Space Shuttle when he retired in 1988.



Map to Conference location in Perry Okla. Address is 1 Ivanhoe



SCABA Family classes:

Saturday AM:

Wire wrapped pendant: 8:30-11:45 AM  
Instructor: Teresa Gabrish  
Cost: \$40.00 (includes supplies)  
Limit: 10 students

Sewing: Spicy Spiral Table Runner (42"x25") 8:30-5:00  
Instructor: Carol Doner caroldoner@hotmail.com  
Limit: 8 students

Supplies:

8 fat quarters

Thread for assembly and quilting

1 yd fabric for backing

Batting 40"x60"

Sewing supplies (pins, scissors etc)

Sewing machine (If you need Carol to bring a sewing machine for you to use you need to contact her and make arrangements before October 16th.)

Cost: no charge if you bring your own supplies, \$45.00 if Carol provides a kit.

Saturday PM:

Steampunk jewelry: 1-5 PM

Instructor: Teresa Gabrish

Cost: \$40.00

Limit: 10 students

Bring found items like old keys, old metal buttons, etc

Continue with table runner: 1-5 PM

Kumihimo (braiding for jewelry designers) 1-5 PM

Instructor: Donna Dove

Cost: \$40.00 (includes cost of kit).

Limit: 6 students

Sunday AM:

Copper etching: 8-11:45 AM

Instructor: Teresa Gabrish

Cost: \$40.00 (includes cost of supplies)

Limit: 10 students

Continue with table runner: 8-11:45 AM

Sunday classes need to be finishing up by 2:00 PM

**These are the classes that are being offered at the conference this year. If you have any questions before you register you can call the instructors listed or Diana Davis.**

### Kumihimo Class, instructor Donna Dove

Kumihimo (pronounced koo-mee-HEE-mo) is the term for Japanese board braiding, an ancient art. In this class, the student will learn traditional Kumihimo braiding on a hand held portable foam disk using American made rayon rattail cord to produce a braided necklace or bracelet. The cord ends will be finished with a toggle clasp. Most anything that is flexible enough to be braided may also be used in Kumihimo braiding including ribbons yarns, metallic thread, and embroidery floss. Kumihimo artist also use beads in their braids and many of these designs are very easy to achieve. Each student should be able to complete a finished piece or jewelry and will leave with their kit supplies and instructions to complete projects at home. Including instructions on how to add beads to designs. This is an easy class that produces quick and beautiful results!



### Spicy Spiral table runner.

Will be taught by Carol Doner. Carol is a member of the Cleveland County Fair board and has taught countless sewing classes to both youth and adults alike. Carol is an avid quilter and is always looking for a unique pattern to try. She took this class and wants to teach you how to make one for yourself. If you are interested in sewing check out the information on the classes page. Looks to be a lot of fun and your

friends and neighbors will want one too.



### Wire Wrapped Pendant instructor Teresa Gabrish.

This is an oldie but a goody. We will be taking a cabochon, coin or other flat, round item and create a framework of wire to secure it into a pendant. This is a fun project that gives you all the fundamentals of wire wrapping so you can go on to wrap other items into jewelry items.



### Etched Copper Bracelet

In this class we will take pieces of copper and use markers or stamps and ink pads to draw out designs on the metal. Once these are drawn to our liking we will submerge the metal into our etching solution until the design is etched into our metal. We will then clean and polish the metal and use the etched items to make bracelets, pendants or even key chains. These make great personalized Christmas presents.

### Steam Punk Pendants:

This is a fun and creative class. Bring small found items or old charms that you may have with you as well as any tiny gears and watch components. I will have charms and beads to go with them. We will use these items along with wire I will provide to make adorable little pendants.



**These classes are always fun and you will leave with a finished piece. Come join in and learn a new skill as well as spend the day with friends.**

## **Silent auction to help raise \$21,000 for an operation for a fellow blacksmith..**

Charlie Groom, long time member of the Saltfork Craftsmen has been having health issues for several years. Charlie Groom's heart doctor has requested that he have a metabolic surgery to reduce the high risk of early death due to his complicated medical conditions. Hopefully, help with his insulin resistance diabetes which would in turn help with his kidney failure and improve his overall cardiovascular health including his diastolic heart failure. Charlie's insurance has repeatedly denied the surgery saying its not a "covered procedure". Byron and I would like to invite everyone that would like, to participate in donating items to a silent auction and /or to come and bid on donated items during the Saltfork Craftsmen Conference, Oct. 19th and 20th. Directly following lunch on Sunday Oct 20th, at 1:45 PM slips will be picked up, new owners can pay for their items, and we can deposit the money in an account set up for Charlie at Arvest Bank in Owassa. If you would like to deposit a check directly to this account, make it out to Charles Groom Medial Assistance Account and take it to any Arvest Bank. The bank should be able to look the account number up. If you have any questions please contact me; caroldoner@hotmail.com 405-760-8388

Carol Doner

## **Upcoming event..Mark you calendar...**

On February 14,15 and 16th of 2014 JJ McGill will be hosting the Scout troop 970 for the weekend. JJ McGill has already gotten approval from the Tractor club to use the grounds for that weekend and have been in touch with Mr. Darrell Scott about it. They are very excited. This is the weekend they had on the calendars to do the blacksmith camp out. J.J. will need help from any one willing to come over and spend the day. He plans to start blacksmithing around 9:00 AM, take a lunch break at noon and pick back up as soon as they can. They( the scouts) want to make a knife and other things for self defense or to eat with in the case of a Zombie attack. The scouts are calling this "The Zombie Survival Camp Out". If you are interested in helping J.J. and Scout troop 970 prepare for a Zombie attack, contact J.J. at: jjmcgill88@yahoo.com

## **Bring to the conference: Place to be on October 19th and 20th is Perry, Okla.**

We always have a good time at the conference each year. Here are a few things you should bring.

1. Notebook and pencil so you can take lots of notes.
2. Safety glasses are required and ear plugs recommended.
3. Your family, we have classes that they will love. It is a Family Friendly event.
4. Your nail to place in the nail board. If you don't have one we will have nail headers available for your use.
5. Something to help with the Iron-N-Hat drawing. Any little thing will do.
6. Your best piece to put in the Gallery so we all can admire it.
7. A donation to the auction. This is the one time some of us can acquire something from one of our fellow members.
8. Your checkbook. The tailgating area is a great place to pick up some tools or material. We will also have swage blocks and cone mandrels and lots of other club stuff for sale. You can save the shipping.

## Tulsa Scottish Festival:

On September 13th, 14th and 15th, the Tulsa Scottish Festival was again held in Tulsa's River West Festival Park. As in years past, members of Saltfork Craftsmen were there. On those days, about a dozen members shared our craft, along with stone carving (Thanks Gary) while surrounded with the sights, sounds and tastes of the highlands. Five forges and Gary's stone carving bench were kept busy making things ranging from tent stakes to knife blades under the watch full eyes of the attendants of the event. Along with the other spectators were several members of Saltfork and several relatives of some of our members who have passed. It was especially good to see Clayton Hall and his wife as they were some of the first demonstrators that many of us met before we joined Saltfork. On Sunday one of the local TV Stations (Channel 2) interviewed Gary for their morning show and Alissa for their evening show. A special thanks goes out to Mecca Waite and Wendy Odgen for all that they did to keep us supplied while we were there.

## Washita County Fair:

Three members of the Saltfork Assoc. set up and demonstrated at the Washita County Fair September 6-7 2013 in Cordell, Okla. Those attending were Mandell Greteman, Gary Seigrist and Don Garner. Even though it was HOT HOT and not a breath of air, there seemed to be a lot of interested lookers for the dying art. Set up next to us was Papa Bear Carving with chainsaw man from Garkand NE. Nick Jensen. He was really interested in the blacksmithing.



## Hammer making workshop:

On August 30th 2013 there was a Hammer Class at the Blacksmith Shop in Elk City. With a good turnout, we got an early start around 7:30 AM. We started out showing how to lay out a hammer head. Then punching and drifting out a hole by then it was warming up. By noon everyone had done most of their hammering. We had a good lunch furnished by the ladies, after which we showed how to grind and polish the hammers and then tempered them. Everyone made a very nice hammer. Something they could be proud of. They all said they learned a lot and enjoyed themselves and the class.

Those attending the class were Bill Dean from Broken Arrow, Okla., Doug Redden, from Oologah, Okla. Ricky Vardell, from Temple, Okla. Ted Culver, from Elk City, Okla. Monte Smith, from Hammon Okla. Frank Sheldon and Mike McFall.



Instructors were Don Garner, Mandell Greteman, Gary Seigrist and Bob Kennemar.

# Rivet Tool

Doug Wilson adds his mark to this useful tool

- Ian Walker

This is a handy tool for making various size rivets from round stock. The end of the round stock is heated, the stock clamped in the tool between vise jaws, and the head is formed.

One variation of this tool (Fig. 1) appeared in the *Bellows and Breeze*, newsletter of the New Zealand Blacksmiths.

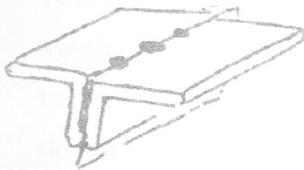


Fig. 1 Angle Iron

Two pieces of thick angle iron the length of the vise jaws are clamped together as shown with a thin strip of card (a business card, for example) between them, and several holes the size of the required rivet shanks are drilled down the joint. The top edges of the holes are eased with a round file.

To use the vise, clamp the angle iron pieces together with a piece of round stock, leaving a suitable amount of material above the angle irons, and forge the head.

A variation of this tool (not shown) is made from a single piece of angle iron about 10 inches long. The web is cut through on one side, the middle heated, and the two five-inch long ends folded back on themselves. The finished tool is similar to the New Zealand tool, but is in one piece, not two.

I had seen a Rivet Heading Tool

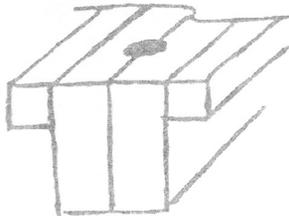


Fig. 2 Bar Stock

in Doug Wilson's Deer Isle, Maine shop made from bar stock (Fig. 2).

Doug said he got the idea from Francis Whitaker. Doug's rivet tool is made from two pieces of 3/4" x 1-1/2" bar and a single piece of 1/2" square stock that has been tapered at the center and bent into a "U" form. He prefers to use bar stock because, unlike angle iron which has an inside radius where the webs join, the bar stock can be assembled with a clean 90 degree angle so that the tool sits down solidly on the vise.

Doug said he'll make his next rivet tool with the 1/2 inch stock welded lower on 3/4" x 2" bars so that the top can be tapered (Fig. 3), thus getting the tool out of the way of the hammer head.

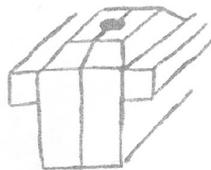


Fig. 3 Modified Bar Stock

Doug's other suggestions:

1. Assemble before drilling the holes.
2. For hot rolled rivet stock, drill the holes -1/64 inch. For cold rolled stock, - 1/32 inch. Use a card spacer.

Doug says that Francis drills slightly smaller holes and taps them to form very shallow grooves which help grip the rivet stock.

3. It is essential to relieve (file or slightly countersink) the top of the holes or the sharp junction between the rivet head and rivet shank will tend to be weak.

4. Doug leaves between 2 and 2.5 times the diameter of the rivet stock extending above the

tool. His rivet heads are frequently decorative, and he doesn't like them "dinky." But you should experiment.

5. Bring the rivet shank to a bright heat below the top of the tool so that the rivet shank seats well in the radius formed at the top of the tool.

6. Leave the partially formed rivet in the tool, reheat with a torch, and finish forming the head. Do any decorative work at this stage.

(Note: hammering on the rivet head after it is in place in your project will risk damage to the work.)

7. Remove the finished rivet from the tool, hook the head over an anvil edge, mark the rivet with chalk using a measured distance marked on the anvil, and sever the rivet on a hot cut in the hardie hole. Return rivet stock to fire while hot, repeat. Don't waste heat by cooling, sawing, and reheating.

8. When installing back up decorative rivet heads with a thick copper plate to prevent their being damaged.

9. Use modeling clay to experiment with decorative rivet head patterns

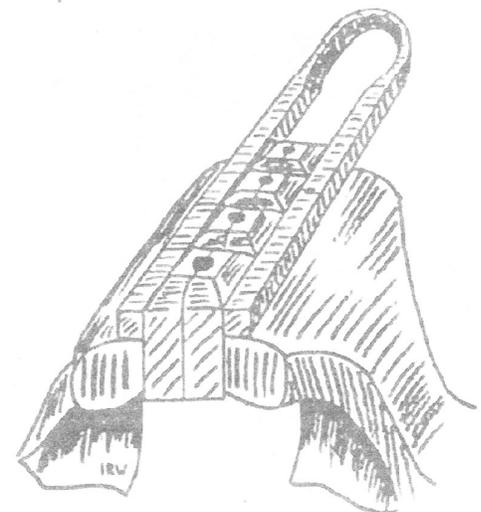
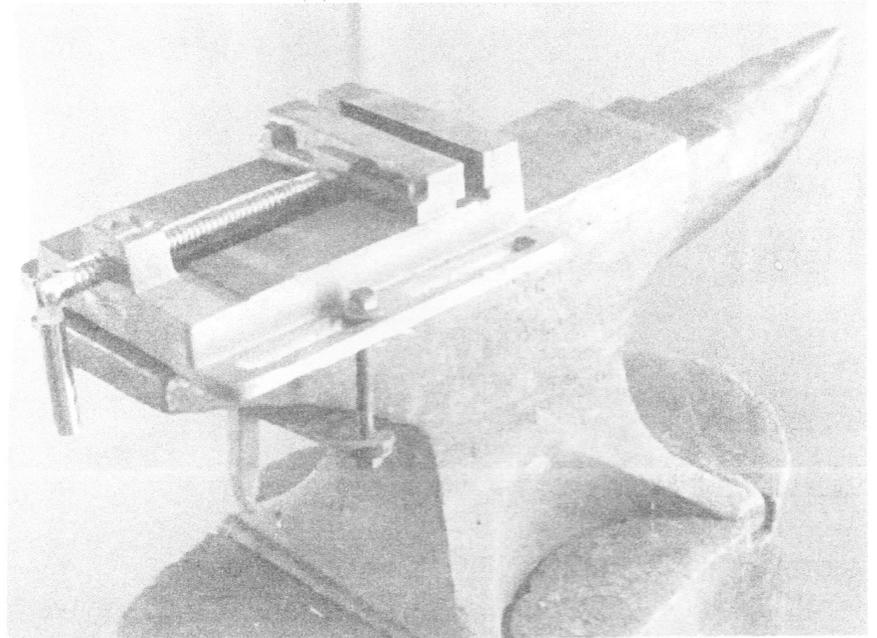


Fig. 4 Completed rivet tool shown in vise

# How to Attach a 6" Machinist Vise to Your Anvil to Make a Handy Portable Vise.

by Emil Badovinac,  
a MABA member



If you have a machinist vise that has mounting tabs along the sides of the vise, then this could work for you! The machinist vise can be attached to your anvil by a U bolt and a railroad spike.

Modify the rail road spike to loosely fit the hardie hole - you may need to upset the spike. When the bottom end of the spike is pulled away from the anvil, the head of the spike shouldn't interfere with the movement of the vise jaw. If the machinist vise doesn't sit on the face or the jaw won't slide over the spike, grind or cut part of the head off so the vise will sit flat and move freely.

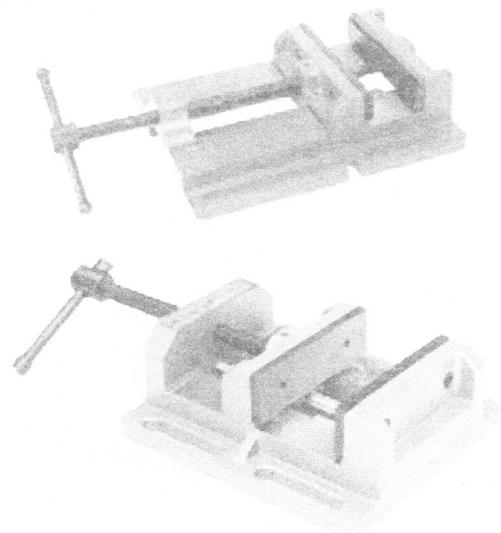
Use about 1 foot of 1/2" threaded rod, bent in a squared "U" bolt to fit around the heel, between the spike and the anvil's waist, and through the mounts on the vise. Use 2 washers and 2 nuts or 2 flair nuts to tighten the vise base to your anvil. The spike in the hardie hole keeps the U-bolt and vise from sliding off the heel of the anvil.

Editors note - I had a vise mounted to my anvil in less than an hour after reading Emil's write-up, though a few things were changed. As seen in the picture, the vise is a cheap, imported, cast iron, drill press vise with lots of room (air) under the body. It sits flat on the anvil face and the moving jaw clears the head of the spike, but this vise won't withstand any hammering at all. A hardie sleeve was put in the hardie hole so the spike fit snugly and didn't need to be modified. Lastly, I just had 2 short pieces of threaded rod so I put a bar with holes in it, between the spike and the anvil, then tightened it down. I'll be able to saw, file, drill, twist and bend light material, when needed, on this set-up. Talking with Emil, he men-

tioned this was a nice height to hold 2 pieces of steel together to braze or weld them.

Emil also mentioned, instead of using a RR spike, braze a leaf spring onto a piece of square stock to hold it in the hardie hole. After you remove the vise from the anvil, just push the square stock out through the bottom of the hardie.

*Emil will be 93 in September!*



Reprinted from *The Upsetter* July/August 2012



**CBA Level I Instructor Public Demonstration**

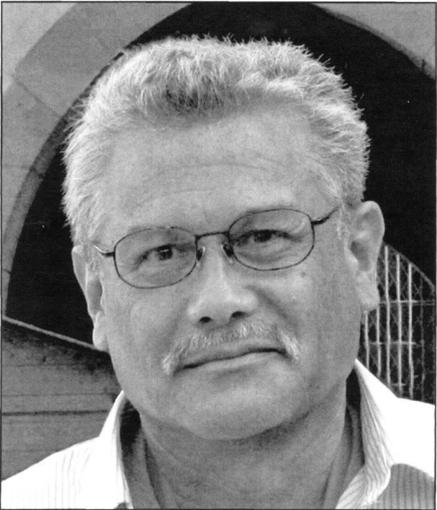
*story & photos by John Kashuba, Ontario*

My demonstration was this scrolled cap lifter – aka bottle opener and church key – conducted for our monthly class in the smithy at Gilman Ranch Park in Banning. The project was a bottle cap opener that has been demonstrated by Beth Holmberg and John Barron before her. We worked from my new handout, and for reference, I distributed Beth’s two pages covering tooling and alternate techniques.

One of the charms of this project is the finish of the handle. When flat bar is twisted the faces of the bar cup. Here we dress down that cupping by hammering flat – roll and hit – to get a twisted yet smoothly cylindrical grip.

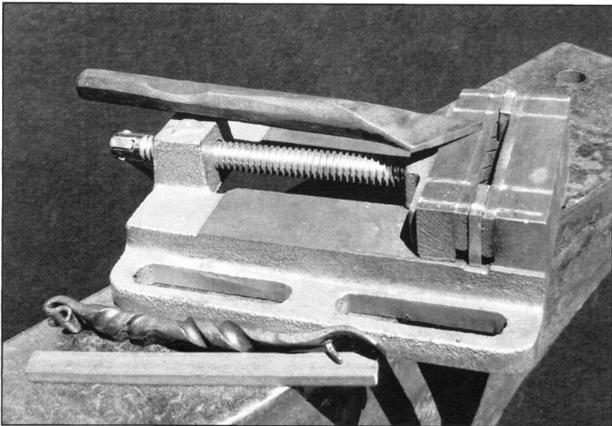
My innovation is a portable bottom tool for punching the tab on the business end. This is an inexpensive Harbor Freight drill press vise clamping two short lengths of  $\frac{3}{16}$ " x 1" bar.

The work piece is placed over and parallel to the gap with its end at the far chalk line. The punch is placed in the center of the heated work at the second chalk mark with the belly of the punch toward the lifter’s handle. When the punch is driven down, it shears the piece in three planes, leaving a hanging tab. With two tool sets to pass around, the smithy’s post vises were available for twisting and other chores.



*John received his Level I Instructor certificate at Spring Conference 2011.*

*Special tooling for punching the hook. Drill press vise and angled punch.*



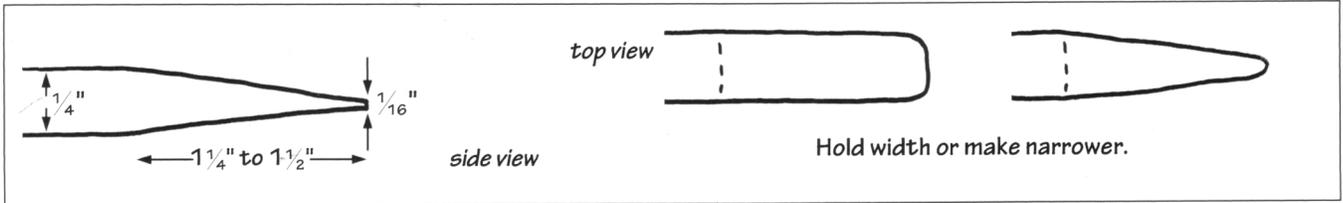
*See Beth Holmberg’s story of her version of this opener in the July/August 2008 issue of California Blacksmith.*

# Cap Lifter

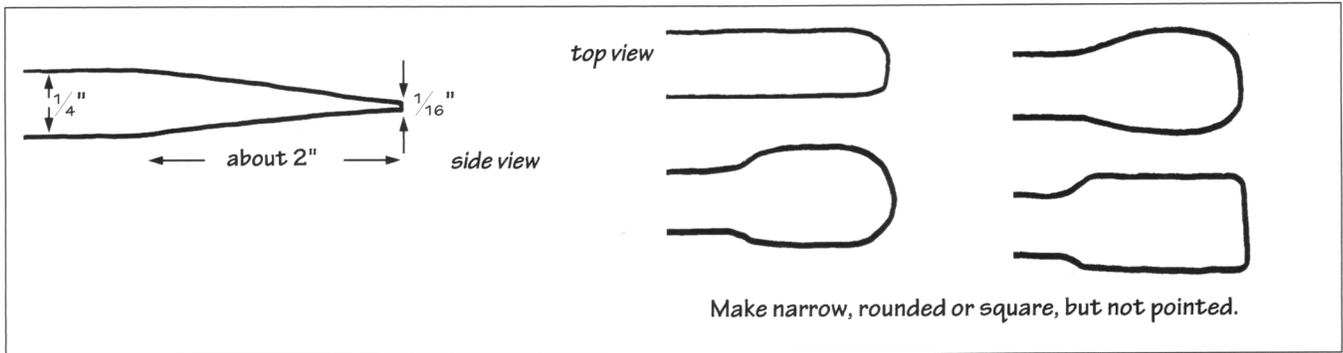
Material: Mild Steel  $\frac{1}{4}$ " x  $\frac{1}{2}$ " x  $5\frac{1}{2}$ ".

## Construction Steps

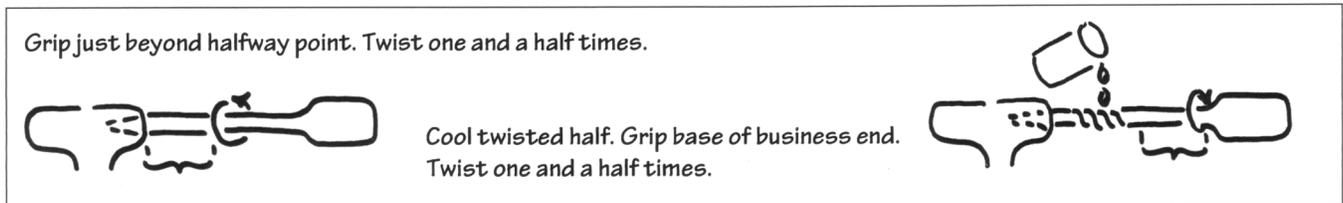
1. Taper scroll end flat.



2. Taper business end flat.

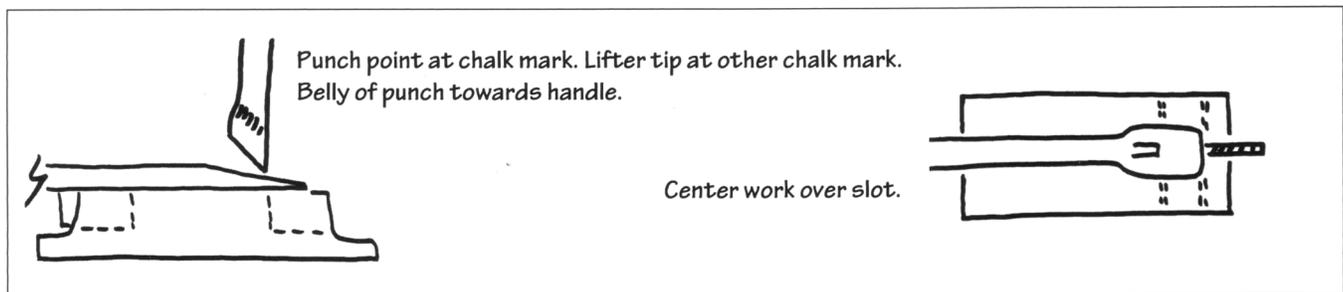


3. Twist half of center. Reheat. Cool previously twisted section. Twist other half the opposite way.



4. Scroll the end. Dress the center.

5. Punch the hook.



6. Clean and shape business end. Finish by waxing while warm. ♣



# Dutch Oven Lid Lifter

By Bob Ehrenberger

Start with about 2 feet of 3/8" sq.  
Make a blunt taper on about the first 3".  
Mark the center line while at a black heat.

Split the end and forge each point, clean up the cut  
ragged edge either by filing or forging the ragged  
edge back into the bar.

Bring the tips back together to protect them while  
welding.

Fold back about 1.5" of the unforged bar onto  
itself.

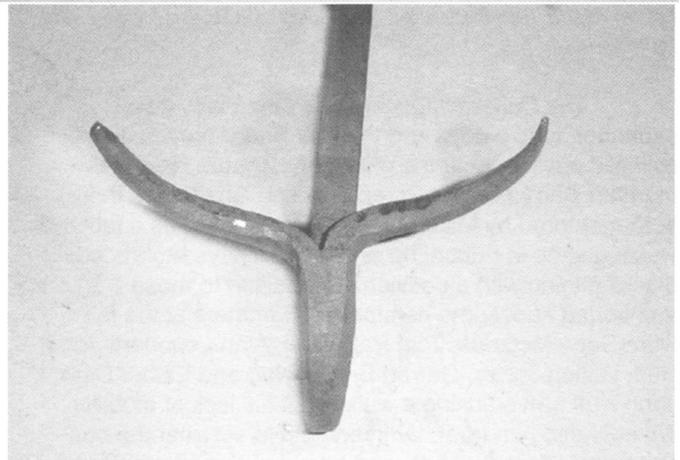
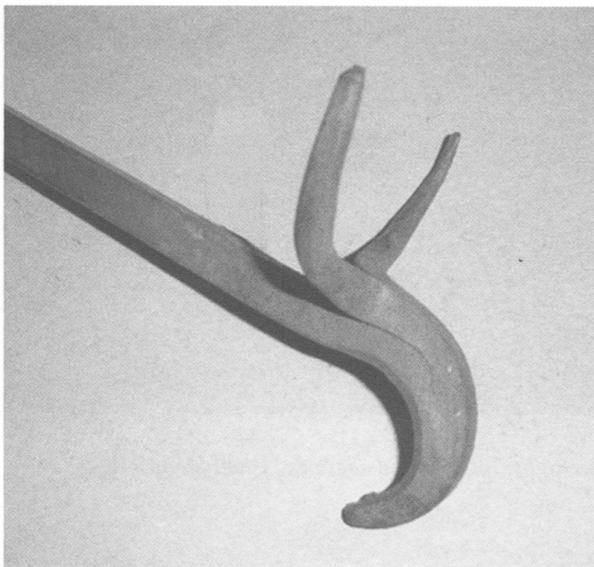
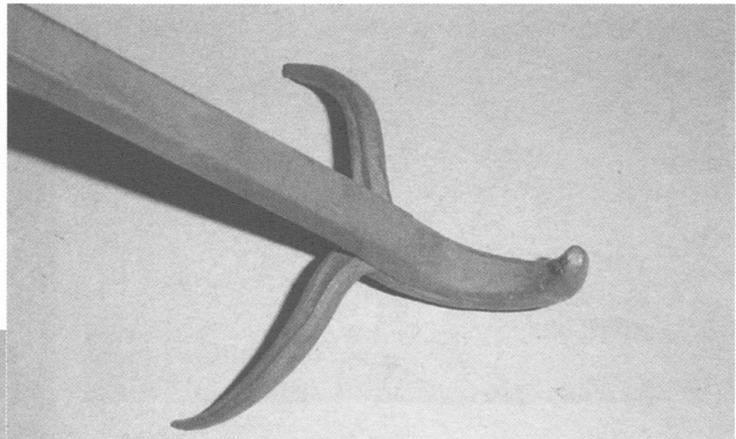
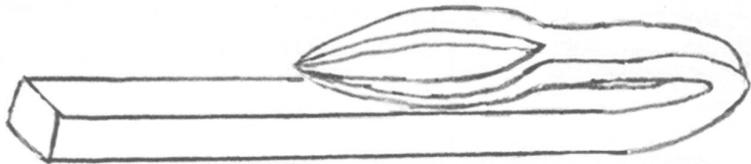
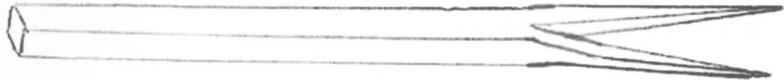
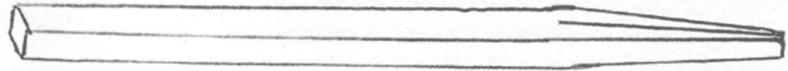
Forge weld the bar to itself and draw to a blunt  
taper.

Make sure to work the welded area at close to a  
welding heat. Form the hook. A bending fork in  
the handle hole makes this easier and puts less  
strain on the weld.

Once the hook is finished spread the tines out  
straight from each other. Curve the tines down so  
they make contact with the lid when the hook is  
under the handle.

Each dutch oven lid is different, you should expect to make  
some adjustments once you have the lid it will be used on.

Forge the other end of the bar to be handle design of your  
choice.



## ***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](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@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](mailto: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 2012 SCABA conference t-shirts available. Contact Dan Cowart or Diana Davis for sizes available.**

**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
Feb	Feb	Feb	Feb
March	March: Doug Redden	March	March: Mandell Greteman
April	April	April	April
May	May	May	May
June	June	June	June
July	July	July	July
Aug	Aug	Aug	Aug
Sept	Sept: James Mayberry	Sept	Sept
Oct	Oct	Oct (SCABA)	Oct
Nov	Nov	Nov	Nov: Mandell Greteman
Dec	Dec	Dec	Dec

**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 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**

**Upcoming event...Mark your calendar.**

What: 9th Annual Dutch Oven Cook Off and Fall Festival  
Where: Avard, Okla. In NW Oklahoma  
When: October 5, 2013

We are looking for a Blacksmith Artisan to come and be an exhibitor at our festival. Jim white from Kansas was with us last year and was a delightful character and real trooper since the weather was less than favorable (very cold). We anticipate much nicer weather this year, and we think that the art and skills of a blacksmith fit right in with our festival theme.

If you are interested in this event. Contact Susan Parent at [suzdae@gmail.com](mailto:suzdae@gmail.com)

**Knife group Association fall shop tour.**

Don't forget about the shop tour on Oct. 12 2013, 10:00 AM till around 4:00P.M. \  
4008 N. Redmond Ave  
Bethany, Ok. 65803  
Roy Miller Transmission Shop

**Remember to Bring a Friend....**

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.  
10380 N. 4010 Road  
Wann, Okla.74083

U S Postage Paid  
Non Profit Organization  
Permit #8  
Sterling Ok.  
73567

Address Service Requested

