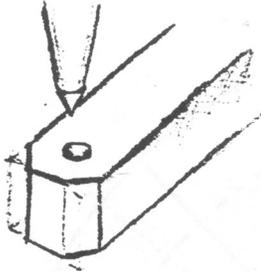


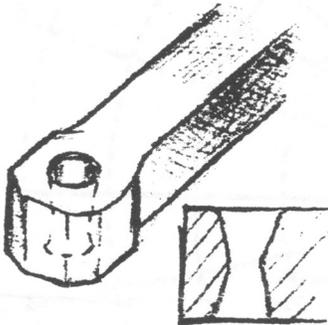
Bottle Opener

By Hugh McDonald Gooseberry Hill, Western Australia
Hugh's demo presented by Jock Dempsey on iForge
(<http://www.anvilfire.com/iForge/>)
September 18, 2002



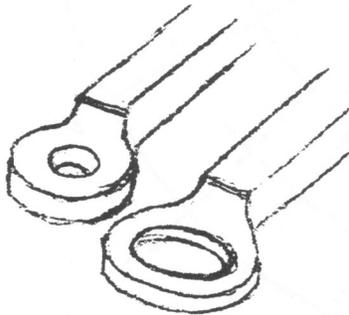
Starting with 5/8" square bar I would begin by rounding the end of a bar in one axis. Knock the corners off then give it a tap on the end to clean up where it pinches out and roll the corners. Then flatten to clean up.

Mark with a square and scribe then center punch both sides equally from the sides and end.



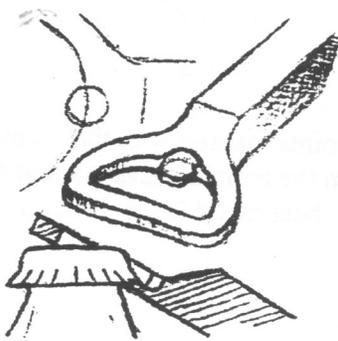
Take a good heat and using a point punch, punch through most of the way then flip over and finish.

Put over the pritchell hole and drift open with the same punch.



Next heat, with the hole about 1/4" from the edge of the anvil flatten to 1/2 thickness, then drift open some more. This can be done over the hardy hole, large monkey tool or swage block.

When the hole is about 1" in diameter thin the loop some more. You want it between 3/16 and 1/8" thick. Then work the loop over the horn until it is about 1-1/4" in diameter INSIDE.



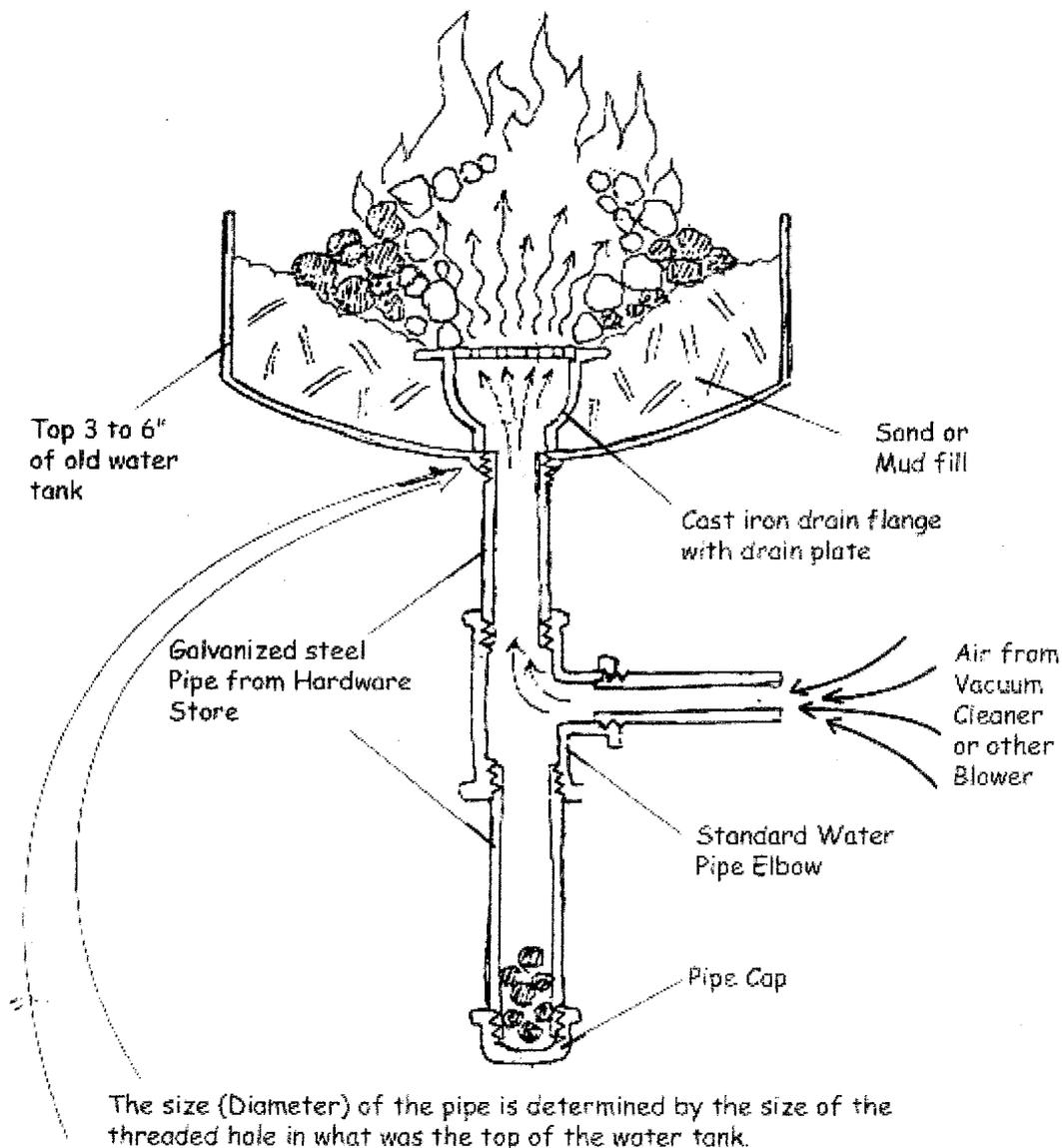
Shape the loop to a "D". This can be done by taping from the end and then working on the face of the anvil. If you intend to make a bunch of these you should make a mandrel or a drift to the right shape.

Last step is to take a flat ended punch 5/16" in diameter, place it half on and half off the inside of the loop and punch the "tooth" about 1/2 way through the thickness or until the tooth is about 1/16" thick.

Building a Forge from a Water Tank

Walt Rave

Known as a "Riveter's Style Forge," these are sturdy, movable, and capable of handling an enormous amount of heat. You should be able to assemble one in less than a day and at a very reasonable cost. Legs may be of wood or metal, depending on the tools that you have available and what you feel will give the most sturdiness.



The easiest way to cut around a water tank is by using an abrasive or cut-off wheel on an angle grinder or Skil saw.

KGA Spring Shop Tour

May 3, 2014

The details for the agenda of the spring shop tour of the Knife Group Association have been started. Still need to line up a couple of demonstrators for the first two demos. [Time: May 2, 2014, 10:00 AM till around 4:00 PM, Place: The home of Ray Kirk, 25494 So. 530 Road, Park Hill, OK 74451](#) The most important part of the day will be the meal, just kidding. It is a great point of interest and this year I haven't figured out what it will be. Trying for barbque. For those that want to bring a side dish, please feel free to bring something that goes with it. Our first demo will be ??????? Our second demo is still ??????????

The third demo will be Ray Kirk and will forge the integral from start to finished knife. Bring camera and pics are encouraged.

The Iron in the Hat drawings will be after lunch . Others are encouraged to bring something for the Iron in the Hat drawings. This is how we support help support our shop tours. It also gives many a chance to win something for a small donation. As usual, we encourage tail gate sales and if you want, bring a works in progress to show others how you may be doing things or to ask questions. There may also be a discussion about how to build gas forges. A few have expressed an interest in this information and there should be several at the meeting that can answer their questions. Looking forward to seeing every one again and if you can, please let me know if you plan on attending. This does make it easier to plan for the meal. Email me at tray@rakerknives.com or call me at [918-207-8076](tel:918-207-8076), which is my cell phone.



Display at Smokey Mountain Knife Works

WORKHORSE

by Bruce Manson

How many times have you wanted to clamp something horizontally in your vise to position it for grinding, welding, drilling, sharpening...or whatever? Do you need a sturdy surface to beat against or one that's a little bigger than your anvil face? How about a firm edge to clamp something to hold it for bending, torch cutting, or sawing? Having seen a display of knife making equipment and tools at Smokey Mountain Knife Works in Tennessee, with a little imagination, some scrap materials, and a bit of time, here's what you can do....

The inspiration came from a trip to Smokey Mountain Knife Works. A knife making display there includes a post vise mounted horizontally on a bench to allow the jaws to clamp a knife blade for shaping and sharpening. This might also be useful for saw sharpening.

The vise I used is a wagon tongue vise I acquired from Anthony Seniunas. I replaced the wagon tongue mounting bracket with a plate for horizontal mounting. If you have or can find a post vise with a broken post, here is a perfect way to salvage the vise's usefulness. I welded legs to a piece of 6" H-beam I found at the scrap yard (length is optional, mine is 32" long). The top of the beam is about 32" high, which is a comfortable working height for me and matches the height of my workbench. This makes a very sturdy surface for hammering on, clamping, laying tools, or a small work/assembly platform. It is portable (though somewhat heavy – about 80-90 lbs), so it can be moved to the worksite. It is handy to move outdoors and clamp metal onto it to hold for torch cutting.

Just wanted to share an idea that might also spark your imagination.....

Bruce Manson



Under Construction



Completed Vise Stand

Pick-up Tongs

Michael Wollowski
wollowski@rose-hulman.edu

The tongs you see in figure 1 are designed to pick up pieces accidentally dropped on the floor. Despite my best intentions and some kick-ass tongs I purchased and built over the years, there are times when a piece just slips. The tongs I have do a very good job at holding stock, but to pick up materials from the floor, they do not do that well. Many times, I find myself doing acrobatics picking up a hot piece of steel off the floor.

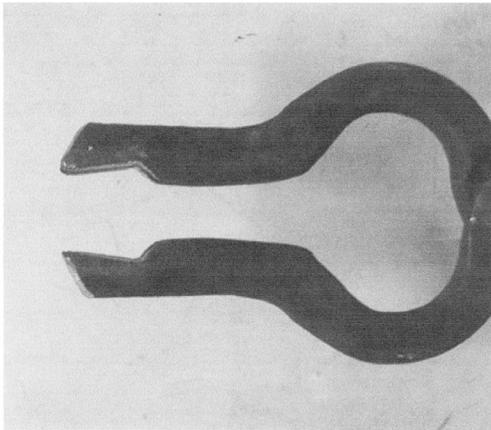


Figure 1: The modified tongs.

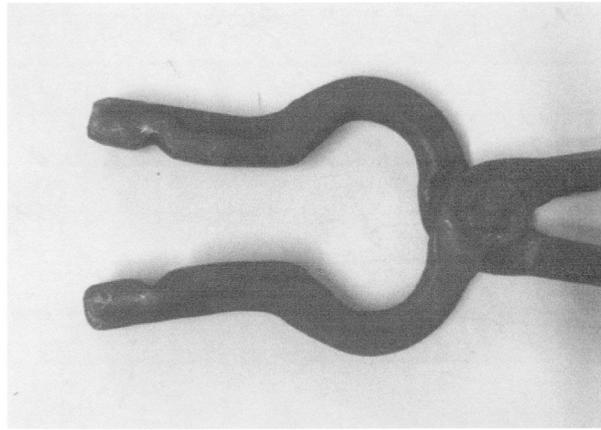


Figure 2: Off-Center brand V-bit tongs

After a good amount of trial and error, I decided to modify some tongs I already had. I rather much like the Off-Center brand V-bit tongs (see Figure 2). They are light-weight tongs with an additional V-notch to hold pieces perpendicular to the bits. These tongs do a fine job handling materials and they are somewhat of a workhorse in my shop. However, they are not made to pick-up stock off the floor.



Figure 3: Stock V-bit tongs grab poorly



Figure 4: When tilted, the tongs will lift

Consider figures 3 and 4. In those figures, the shapes of the bits are exaggerated to make a point. In figure 3, notice that a square piece would be held at its top-edges. Any slight wiggle and the piece you are holding will drop to the floor again. Trying to pick up flat stock or round stock is nearly impossible. Furthermore, if you were to tilt the tongs a little bit, as shown in figure 4, one bit will lift naturally. However, due to the straight end of the bits, both bits will be further lifted off the floor. This makes it almost impossible to pick up anything.

As it turns out, the solution to both of these problems is very straightforward and easy to accomplish. Consider figures 5 and 6. In order to avoid that the tongs lift off the ground when tilting them, simply grind the bit ends to about a 75 degree angle. To ensure that a piece is securely held, extend the lower portion of the V to the end

of the bits so that the bit ends come to a fairly sharp point.

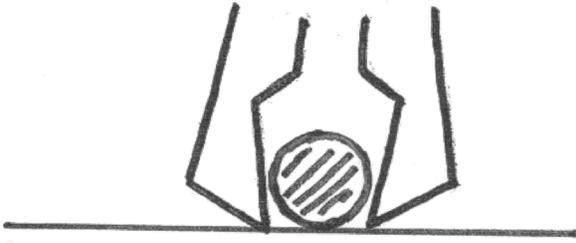


Figure 5: Points partially enclose the piece



Figure 6: Tilting will not lift tongs

As shown in figure 5, the bit ends will partially enclose the lower portion of round stock, thereby holding it very securely. When it comes to square or flat stock, if your ground is uneven or more likely, if the piece is not entirely straight, you will again be able to grab the piece in a manner where the bits will partially enclose the lower portion. If the piece and your floor are flat, then the force exerted by the points will hold square and flat pieces fairly securely. Alternatively, when tilting the tongs, the bit on the ground may just slide underneath the piece.

Penetrating Oils

Machinist's Workshop MagT recently published some information on various penetrating oils that I found very interesting. Some of you might appreciate this. The magazine reports they tested penetrates for break out torque on rusted nuts. They are below, as forwarded by an ex-student and professional machinist. They arranged a subjective test of all the popular penetrates with the control being the torque required to remove the nut from a "scientifically rusted" environment.

Penetrating oil	Average torque load to loosen
No Oil used	516 pounds
WD-40	238 pounds
PB Blaster	214 pounds
Liquid Wrench	127 pounds
Kano Kroil	106 pounds
ATF*-Acetone mix	53 pounds

The ATF-Acetone mix is a "home brew" mix of 50 - 50 automatic transmission fluid and acetone. Note this "home brew" released bolts better than any commercial product in this one particular test.

Our local machinist group mixed up a batch and we all now use it with equally good results. Note also that "Liquid Wrench" is almost as good as "Kroil" for about 20% of the price.

Steve from Godwin-Singer says that ATF-Acetone mix is best, but you can also use ATF and lacquer thinner in a 50-50 mix. *ATF=Automatic Transmission Fluid

Editors Note: The above information was supplied by Richard Metz

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@sbcglobal.net

Club Coal

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces The coal is \$140.00/ton or .07 /pound to members .**No sales to non-members.**

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

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

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

S/C region coal location: Club coal is now available at Norman at Byron Donor place. Call Byron to make arrangements to come by and get coal.

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, 2014 to March 31, 2015

New Member _____

Membership Renewal _____

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, 2015

Signed: _____

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



ABANA

NEW & RENEWAL MEMBERSHIPS

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

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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

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