

JOHN MCLELLAN'S

Square up the twist. Don't thin the jaw too much, but forge it down to remove the twisted area. Fig. 9

The area of the tongs that will hold the rivet is called the boss. Lay the boss area on the anvil face with the offset of the jaw over the edge. This will help keep the surfaces that pivot against each other flat and smooth.

Round out the corners on the boss where the rivet will go. Use the round corner of the anvil and hold the piece at an angle when rounding this area. Fig. 10

Take a yellow heat and hold the jaw/boss assembly at the offside edge of the anvil. Ensure that the jaw of the tongs is hanging over the edge of the anvil and that the flat side is uppermost.

Set the punch where you think the hole should be and give it a light blow. Check to be sure the mark is where you want the hole to be. Adjust the position of the punch if the hole isn't in the right place and hit it again. Fig. 11

If the boss is still hot, drive the punch in with 2-3 good blows and take it out and cool the punch. Heat the boss as necessary and continue to punch until you feel and hear the punch bottoming out on the face of the anvil.

Turn the bar over and look for the "dark" spot on the other side of the boss. Set the punch in the middle of the dark spot and punch through.

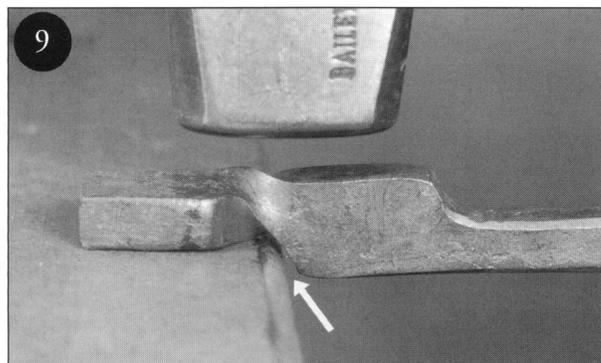
Continue to drift the hole over the pritchel hole and drive the punch in until the hole is $\frac{5}{16}$ -inch in diameter. Fig. 12

Cut the piece in half where the center was marked. Finish drawing out the reins; they can be square, round, or flat, it's all a personal preference. They should taper from the boss to the end of the reins.

The jaws on my tongs have a slight taper. I create that taper now and, to allow the tongs to grasp round stock, fuller a $\frac{1}{4}$ -inch groove along the center of the jaw in line with the rein. Figs. 13 - 16

Check the pieces to be sure that both sides match and that the rivet will go in the holes.

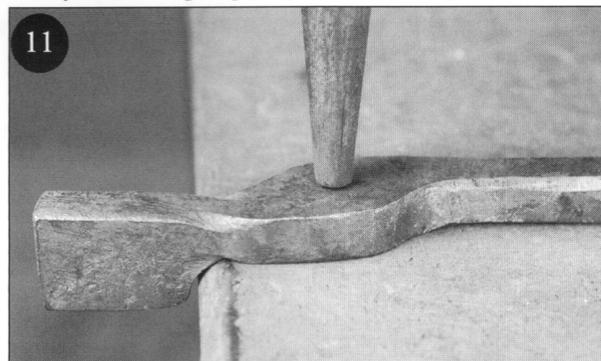
Cut a length of round bar for the rivet.



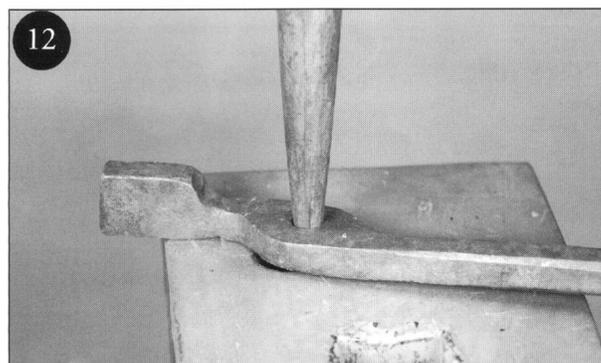
Protect the boss from the edge of the anvil as you dress the twisted area



Round up the boss using a heavily relieved edge of the anvil face. A sharp edge may cause cracking later

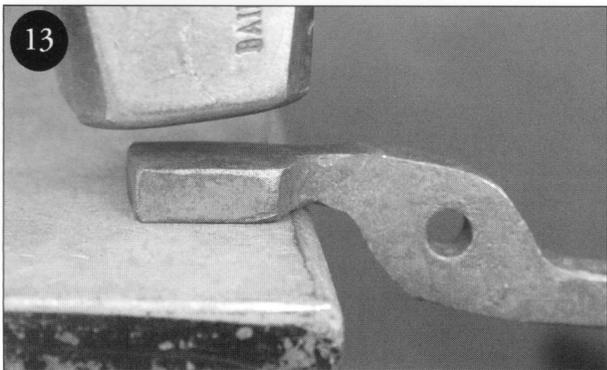


Punching from the outside of the boss now allows for an easier time when back punching the slug out

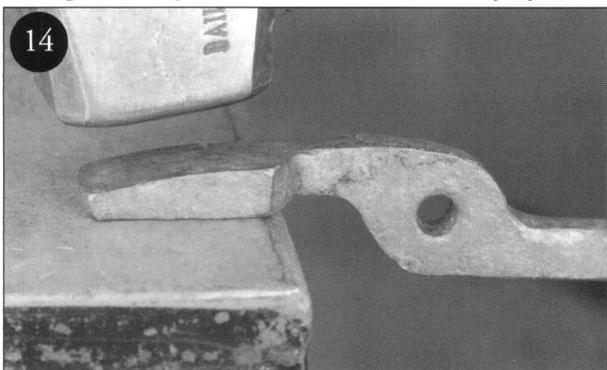


The jaw is protected from damage as you clear the slug and drift the hole to size

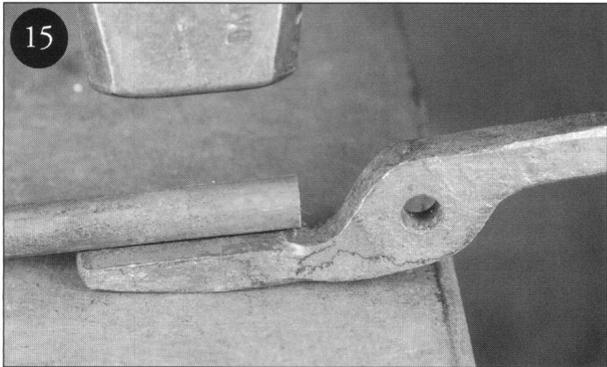
SIMPLE TONGS



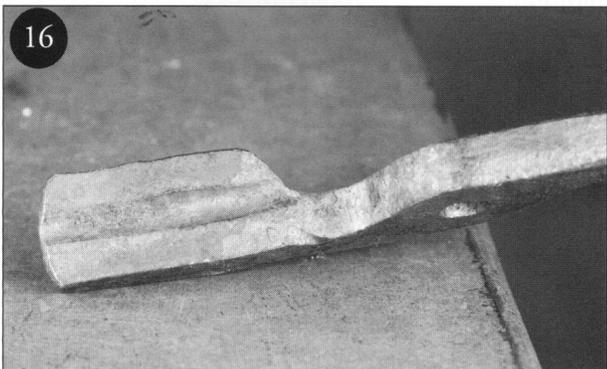
I like for the jaws on my tongs to have a slight taper. The taper allows for easier access into the coals of a fire



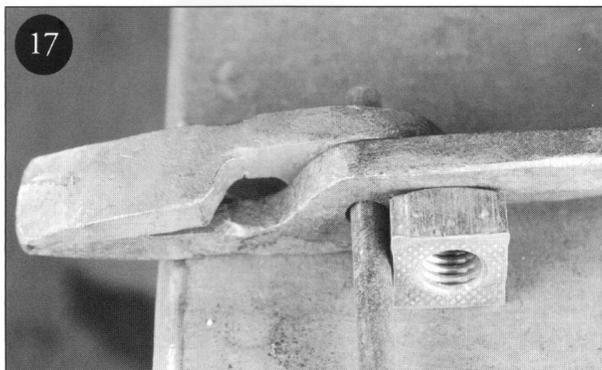
Make sure that you measure the lengths of the jaws as you draw them out. The jaws should match in length



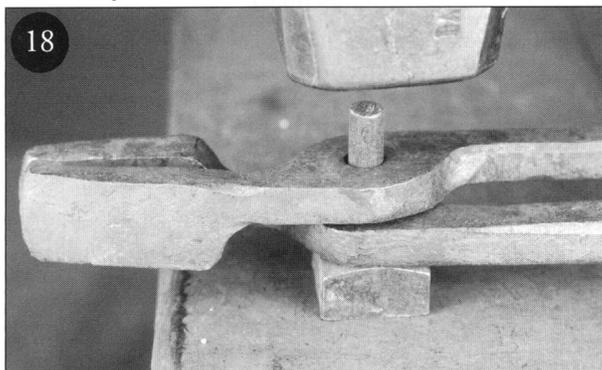
A half-round depression will enable these tongs to grip round stock



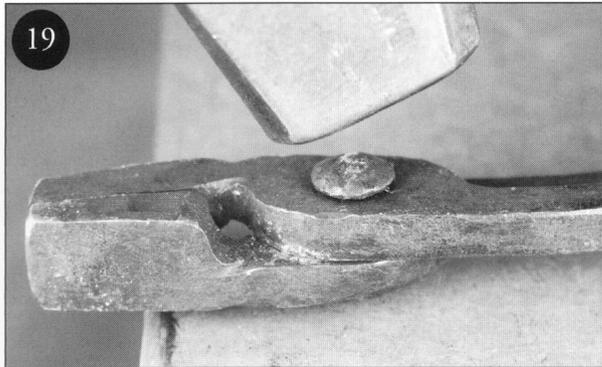
Here is the finished jaw, ready for assembly



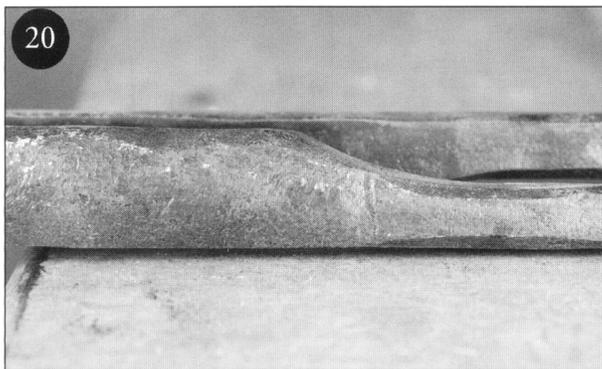
I use a nut whose thickness is a little less than twice the diameter of the rivet stock thick



The nut acts as a spacer as I head the initial side of the rivet



Heading the second side does not require the use of the nut spacer



These reins have been made to lie one above the other for use in either hand

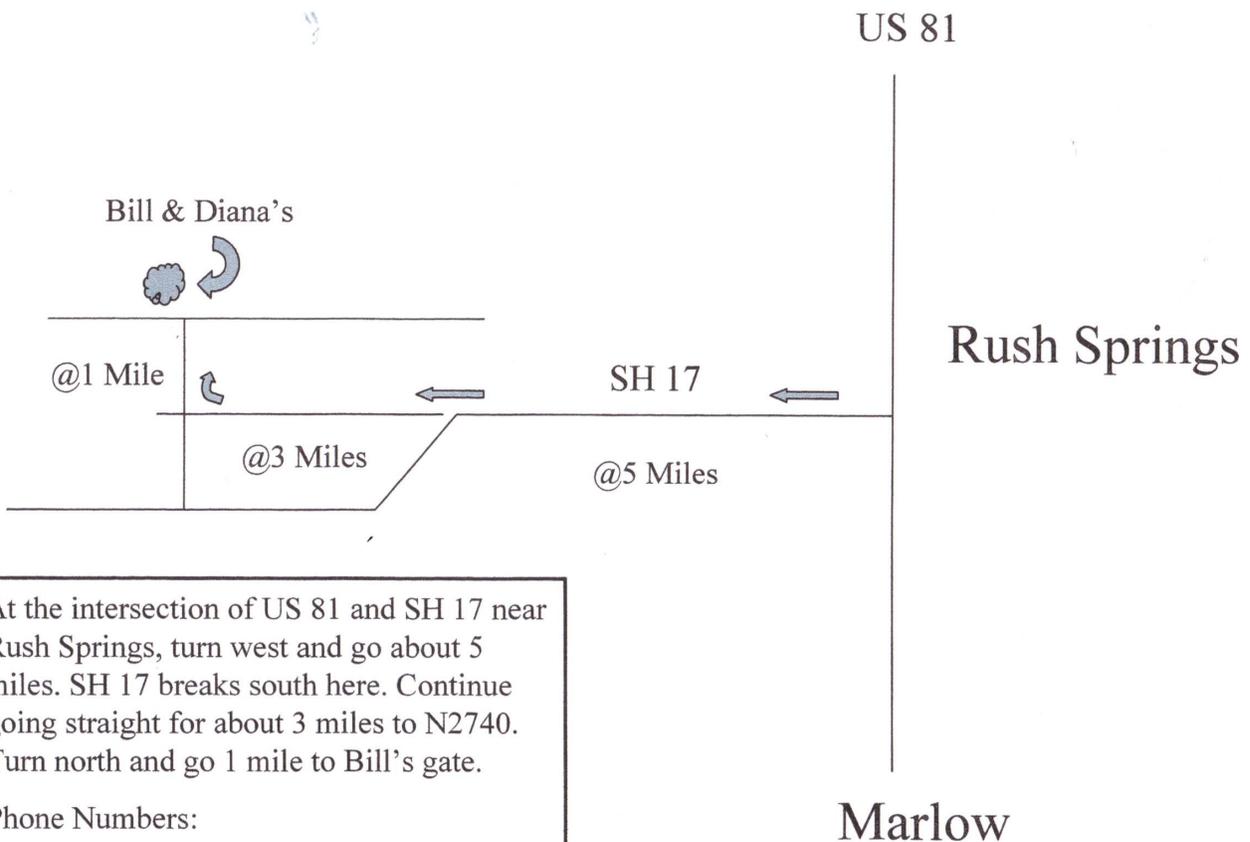
Beginning Blacksmithing workshop..

May 31st is one of our 5th Saturday workshop dates. This time it will be a Beginning Blacksmithing workshop that will be held at the Lazy Ass Forge Shop located west of Rush Springs, Ok. Diana Davis will be the instructor for this workshop. Registration will open at 10:00 AM on May 14th. There will be a limit of 8 students. There will be a charge of \$35 to pay for materials and lunch. If you have your own forge and anvil you are welcome to bring it, just let me know when you register. Registration by phone only (580-574-8428) because it is on a first come, first served basis. There will be a waiting list and a second workshop set up as needed. Unlike the last one I taught, this one is open to everyone. I do ask that you be a member or bring your membership application with you when you come.

We will be learning basic techniques of tapering, curling, twisting and punching holes. We will be using these techniques to make some tools and other pieces that you will be able to take with you for your tool box.

I have a full day planned. Please arrive by 8:30 AM and plan to stay until around 4:00 to help clean up and reload the teaching trailer.

Lunch will be provided along with water and lemon aid. If you want soda, etc please feel free to bring some. I have several refrigerators that they can be place in to keep them cold.



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 for about 3 miles to N2740. Turn north and go 1 mile to Bill's gate.

Phone Numbers:

Bill & Diana 580-549-6824

2014 Salt Fork Conference Tool Box

Item	Donor
Box (25 1/2" x 7" I.D.)	Charles McDevitt
Hardware for toolbox	Charles McDevitt
1 1/2 lb. cross peen hammer	
2 1/2 lb. cross peen hammer	
Rounding hammer	
Handled hot cut	
File flat bastard cut	
File, half-round bastard cut	
Farrier's Rasp	
Hacksaw	
Rivet backing tool for 1/4"	
Rivet setting tool for 1/4"	
Rivet backing tool for 5/16"	
Rivet setting tool for 5/16"	
Rivet backing tool for 3/8"	
Rivet setting tool for 3/8"	
Scribe	
Center Punch	
Center Finder	
Dividers	
Tongs	
1/4 V-bit	
3/8 V-bit	
1/2 V-bit	
Scroll pliers	
Soapstone and holder	
Abrasive block, small piece of grinding wheel	
Angle Transfer	
Chisel, Large	
Chisel, small	
Metal folding ruller 24" or 72"	
Ball tool (round blunt nose punch)	
Hand held spring swage for tenons	
Hand held swage for necking down	
Set of monkey tools (1/8", 3/16", 1/4")	
Adjustable square	
Bending forks	
Flux spoon	
Flux	
Twisting Wrench	
Hot cut hardy	
Hot slit chisel	
Bolster plate	
Finish wax	
Fire Tools	Diana Davis
Shovel	
Rake	
Poker	



Saltfork Craftsmen passing skills to younger generation

The Saltfork Craftsmen organization is a passionate group that keeps the fires burning for the art of blacksmithing.

Members huddle together frequently at meetings across Oklahoma. The most recent session in the Northeast region was April 12 at Ed McCormack home east of Okmulgee.

“We had about 35 here,” the retired welder and blacksmith said. “That’s about the same number as we usually have here.”

Members bring a hand-made metal trade item and a little food for the group lunch. They also bring many years of experience and know-how in the field of blacksmithing. This incredible knowledge is passed along to each other during the Saturday get-togethers. They spend the entire day sharing tips and providing hands-on demonstrations.

“Everybody has a good time,” said McCormack. “We try to learn a little something from each other. That’s what these meeting are all about. I try to have two of them a year at my place.”

The Saltfork Craftsmen have a motto for the group. Their success comes from “teaching those who will forge the future.” They hope to keep blacksmithing alive and thriving by passing their knowledge and skills on to younger members. Last week’s meeting provided a perfect opportunity to live up to the motto.

Brendan Crotty was one day shy of 12 years old when he arrived at Ed McCormack’s place on Saturday. The Muskogee boy looked a little out of place around the much more ‘mature’ members of the group. Even so, Brendan was like a kid in a candy store as he bounced around the meeting and talked to different people.

“I really like it here,” he said. “This is so much fun. I’ve been to a couple of meetings before this one.”

Brendan was not on hand just to watch others hammer and forge their metal items. He was eager to create his own.

“I’m making a knife today,” he said. “I’m making it out of a railroad spike. It’ll be the third thing I’ve ever made.”

Brendan has previously made a letter opener and “some other tool.”

Ed McCormack was impressed with his youngest guest.

“He’s really sharp,” the Okmulgee native said. “He knows what he’s doing.”

McCormack had earlier visited with Brendan’s father, Jim.

“I wondered how long he’d been doing this (blacksmith work),” he said. “Jim told me he’d never done it. It was his boy’s idea to do this.”

Brendan has falling in love with the art of blacksmithing. He doesn’t just limit his efforts to the meetings like the one on Saturday. He is often dreaming up ideas to turn metal into tools and other objects.

“I’m home-schooling so I have time to do this,” the boy said. “It’s great!”

Jim Crotty said his son likes to get on the Internet and look up web sites about blacksmithing.

Ed McCormack is thrilled to see someone so young being that passionate about it.

“This is something we all want,” he said. “We want to pass this along to the younger people to keep it alive and going.”

The old-timers at Ed McCormack’s meeting were living up to the motto - “teaching those who will forge the future.”

At this meeting, Brendan Crotty represents that future.



By HERMAN BROWN
Okmulgee Times editor

SOUTHWESTERN IRONWORKS
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Editor,
Please publish this information in your newsletter.

Rocky Mountain Blacksmithing Conference, August 6-10, 2014, Carbondale, Colorado
Demonstrations by Peter Ross, Mindy Gardner, James Honig and James Makely.
Complete information at www.rockymountainsmiths.org

Come enjoy the hiking, fishing, and, of course, blacksmithing in the colorful Colorado Rocky Mountains. Demonstrations at the Francis Whitaker Forge at Colorado Rocky Mountain School. Also participate in the gallery, tail gate sales, group forging project, slide shows, forging competition, auction, iron-in-the-hat and open forge. Lodging and meals available on campus – the vegetables are fresh, grown on site.

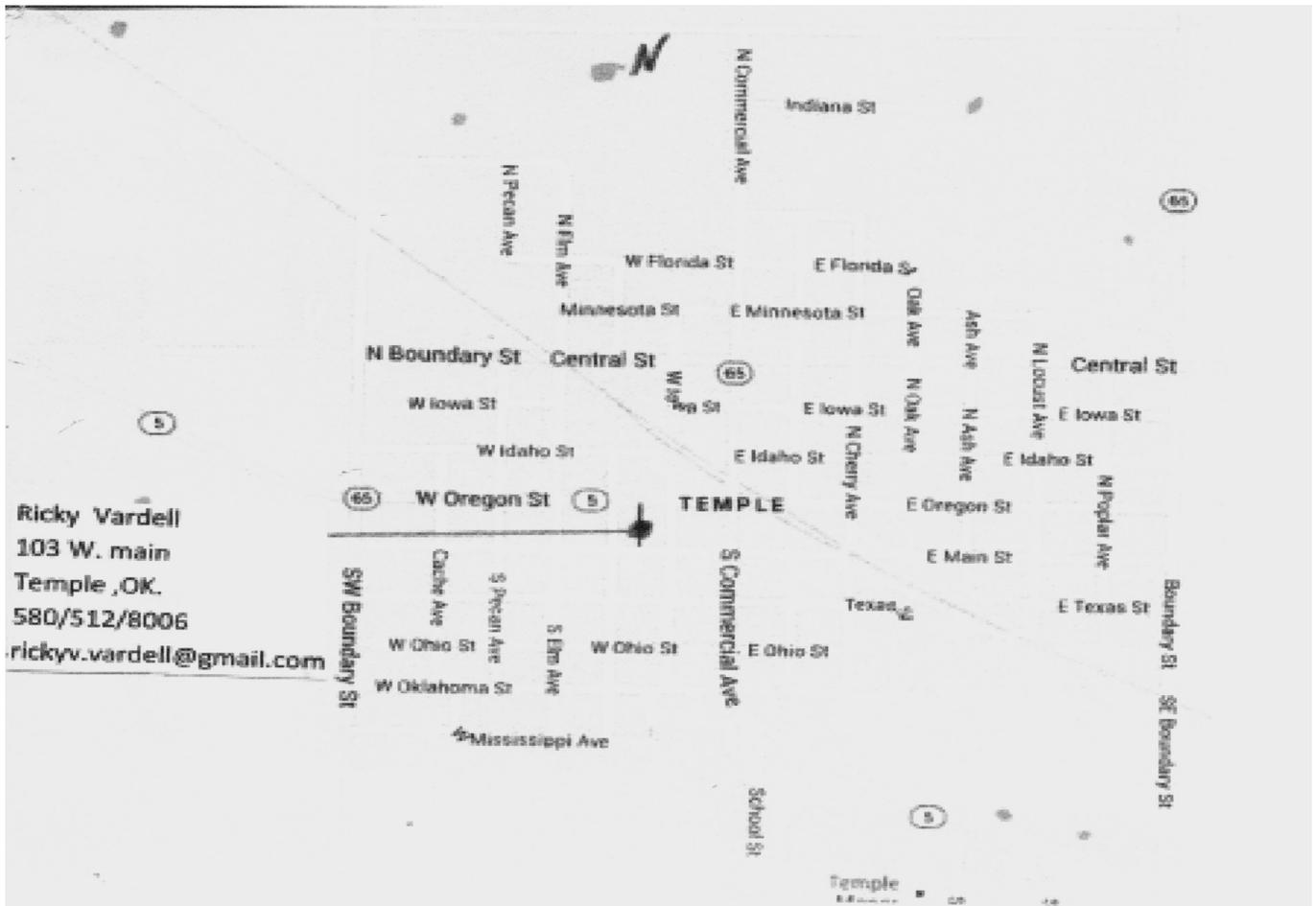
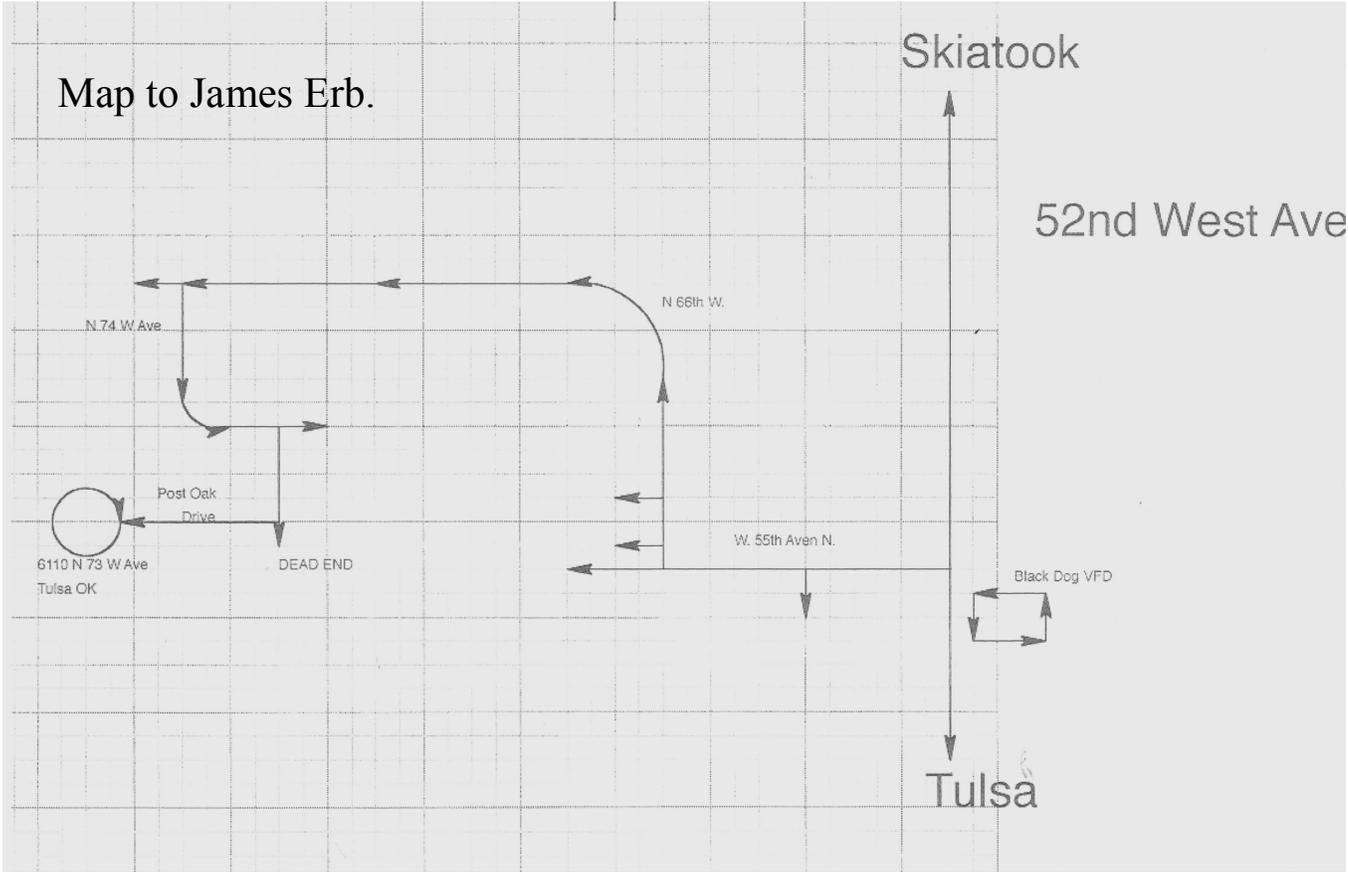
Dan Nibbelink
Rocky Mountain Smiths, Treasurer

Map to James Erb.

Skiatook

52nd West Ave

Tulsa



Ricky Vardell
103 W. main
Temple ,OK.
580/512/8006
rickyv.vardell@gmail.com

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
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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

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Mail to: ABANA, 259 Muddy Fork Rd, Jonesborough, TN 37659 USA
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