

Saltfork Craftsmen

Artist-Blacksmith Association

May 2010



Photo by Ken Doner

**Saltfork Craftsmen
Artist-Blacksmith Association
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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

Trading Post

For Sale:

Army surplus round nosed pliers that make good scroll pliers for small items. They are 6" long \$5.00 each plus shipping. I also tie brooms on your handle or mine. \$20.00 plus shipping. Diana Davis 580-549-6824 or Diana-copperrose@hughes.net

50# New Style Little Giant Power hammer. Rebuilt late 2009. \$3500 Contact Bill Davis at 580-549-6824

Jim Dickey has a large amount of equipment for sale. A large shop forge, 3'x6' cast iron layout table, hand and power tools. Too many items to list. If you are looking for something give Jim, he might have it or know where you can get it. Call Jim at 580-748-0994

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.**

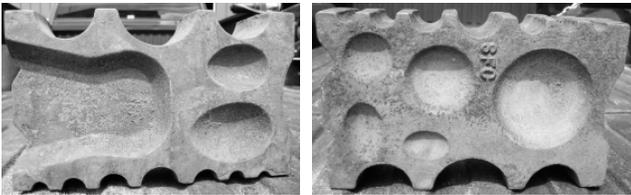
NW Region coal location:

Bring your own containers. Contact Tom Nelson at 1-580-862-7691 to make arrangements to pick up a load. **DO NOT CALL AFTER 9 P.M.** If you make arrangement well in advance, Tom can load your truck or trailer with his skid steer loader. Otherwise you will need to bring a shovel. The coal can be weighed out at the Douglas Coop Elevator scales.

NE Region coal location: Dan Cowart also has coal to sell. He can be contacted at ddcowart@gmail.com or CowartPat@gmail.com

Mail your ads to the editor or email them to Diana-copperrose@hughes.net by the 20th or each month.

New shipment of swage blocks now in.
\$80. plus shipping to members.
\$100.00 plus shipping to non-members
Contact Bill Kendall for more information



MEETING SCHEDULE

May

SE Regional meeting (May 1st) OPEN

NE Regional meeting (May 8th) Hosted by Gerald Brostek the trade item is a yard ornament. Please bring Gas forges only.

S/C Regional meeting (May 15th) Hosted by Gary Seigrist. Trade item is a hardy tool. Lunch provided, bring a side dish/dessert.

NW Regional meeting (May 22nd) Hosted by David King at Southwest Ironworks in Guthrie. Lunch is on your own. It is in conjunction with his annual swap meet. See page 4 for more info.

June

SE regional meeting (June 5th) Hosted by Mark Hammel in downtown Hugo, Ok at their Hugo Homecoming event. Lunch is on your own.

NE Regional meeting (June 12th) Hosted by Bill Phillips. Trade items is a animal/bird. Lunch provided but bring a side dish/dessert.

SC Regional meeting (June 19th) Hosted by Byron Doner. Lunch provided but bring a side dish/dessert.

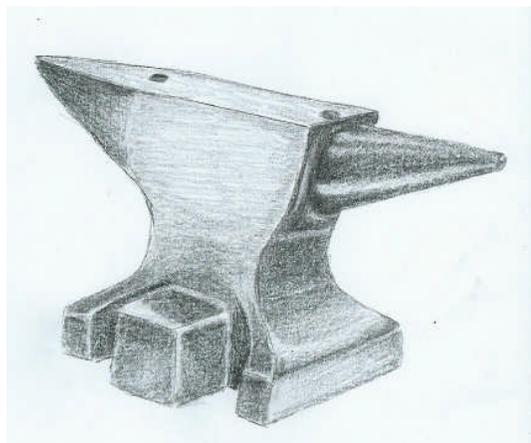
NW Regional meeting (June 26th) Hosted by Ron Lehenbauer in Fairview at the Major Co. Historical Society fairground. Trade items is something western. Lunch provided.

Demo Opportunity...

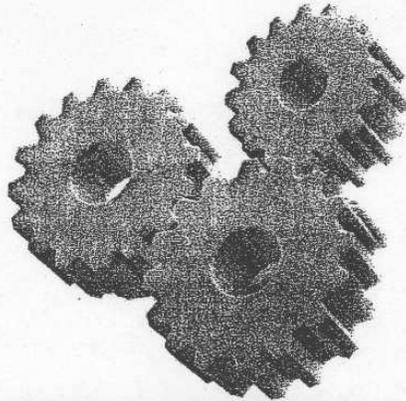
Pawnee Bill Ranch Museum Wild West Show...
Blacksmiths are needed for the last 3 Saturdays in June- 12, 19, & 26th. Set up about 9 to 10 AM would be good.

In the past we have had one to two Saltfork members working in or near the original ranch blacksmith shop. The demo smith can bring his own portable forge and tools or plan to use the forge and anvil in the shop. As with most demos, I recommend that you bring your favorite hand tools and precut material for the items you plan to make. The Museum staff normally feeds us lunch.

Read more: <http://wimgo.com/pawnee-ok/pawnee-bills-original-wild-west-show-series/events/105024#ixzz01mgvq062>



**SOUTHWESTERN
IRONWORKS**



**ANNUAL
SOUTHWESTERN IRONWORKS
TAILGATE SWAP MEET**

AND MODEL ENGINE DISPLAYS

MAY 22, 2010

**8:00 AM TILL.....
302 W. COLLEGE
GUTHRIE, OK**

**ALL HOBBY MACHINISTS, BLACKSMITHS
AND WOODWORKERS
BRING YOUR UNWANTED
TOOLS AND EQUIPMENT
AND BUY - SELL - TRADE**

FOR MORE INFORMATION CONTACT:

DAVID KING (405)348-0476 OR BOB PADDACK (405)634-8353

NW Regional meeting (Feb 27th)

NW Regional meeting was hosted by Mandell Greteman at his home in Foss, Okla ON the 27th of February. There were about 23 members that showed up for the meeting. The trade item was any tool/ Mandell and his helpers did out standing job in cooking lunch. We had a great lunch there was fried fish, fried potatoes, home made hush puppies; brown beans and okra salad that was a big hit. For desert we had home make pecan pies, cake, and peach cobbler, Ice tea and water and coffee. I would like to thank everyone for the salad and dessert they brought.

After lunch there was forging going on some made tools, some made tomahawks. There was a lot of good visiting and enjoying the sunshine the weather was great.



SCABA annual picnic....Sat. April 17th

We had a good turn out for the picnic in spite of the rain. We still had to share the area with the farmers market and a swap meet but that gave everyone more to look at. Ron Lehenbauer brought his forge and spent most of the day demonstrating for members and visitors alike. He always had a large group watching what he was forging.

Steven Knisely invited a friend to cook for us. He made some beans and sausage.

Teresa Gabrish brought her wire wrapping and made some new designs while at the picnic.



Carol had brought her embroidery machine but we didn't have anyone interested in seeing it work.

The club had decided to hold a silent auction during the picnic to help a fellow blacksmith. We had a great turnout of



merchandise for the auction. Everyone at the picnic was taking advantage of the auction to pick up some nice additions for their collections. Items were scheduled to end at different times, so everyone had to keep coming by to check if they still had the high bid.



SCABA board and members provided much of the noon meal but it wouldn't have been complete with out the donation from Vaughn Foods in Moore Ok. He donated all of the salads, beans and condiments that you enjoyed at lunch. Please remember Vaughn Foods for you future bulk food needs. We always have plenty of food so if you went away hungry it was your own fault.



After lunch the Board of Directors had a meeting to elect officers and discuss other club business.



After the BOD meeting, David Seigrist started the forging contest. The contest this time was a forge welding contest. Each person that wanted to try was given two 1/2" square bars that they were to forge weld together. The one that had the best weld won a book on Blacksmithing written by Antonello Rizzo



The Silent Auction brought in \$4320.00 for the Dyers. The Board of Directors would like to thank everyone who participated in the Auction. We also want to thank everyone who came to the picnic. We had a great day of visiting with members that we don't get to see that often and meet new members that came and joined our group. Hope to see everyone at the Conference in October. Look for the Conference flyer in the next newsletter.

President's Notes

Gerald Franklin

We had our Annual State Meeting and Picnic on April 17th at the Cleveland County Fairgrounds in Norman. There was a really good turn out but things were sort of hectic so we weren't able to get an accurate headcount. There was, however, plenty to eat thanks to the Doner family, Mark Vaughn of Vaughn Foods, and various folks who brought desserts. Rusty Doner was Chief Cook and turned out some mighty fine hamburgers, Bratwurst, and hot dogs from his grill.

This year, we had a very special event – a Silent Auction Benefit for the Dyer family. Our membership really pitched in to make this a real success. Saltfork members brought in numerous (about sixty, I think) items to be auctioned off. Once the items arrived and were laid out on the tables, bidding started and went on until 3PM. When it was all said and done, Treasurer Mike George reported that we had collected a total of \$4320 for the Dyer family. We are grateful for the opportunity to help out.

In addition to the auction and food (did I mention that we ate well) there was forging, tailgating, and just plain good fellowship. David Seigrist set up another forging contest this year. Contestants were to forge weld two pieces of ½" square stock. The prize was a nicely illustrated coffee table sized book written by an Italian blacksmith. Bill Davis won the contest and the book. Congratulations to Bill and thanks to David for putting the contest together again this year.

The Board of Directors met briefly to elect officers. We welcomed two new Board members, Dan Cowart and David Seigrist. I was re-elected President and Mike George was re-elected Secretary-Treasurer. David Seigrist was elected Vice-President. David and Dan replace J.C. Banks and Richard Dyer who were on the Board for the last several years. Many thanks to J.C. and Rick for their service and we look forward to having Dan and David serve your association.

In closing, I want to remind you again that the 2010 ABANA Conference will be held in Memphis in June. This is one of the closest locations to Oklahoma in recent years. Hotels are filling up fast so you need to make your reservations now if you want to sleep close to the event.

SOUTH CENTRAL MEETING DATES

January 16, 2010
Host: JC Banks
Phone # 580-482-3209
Trade item:

February 20, 2009
Host: Gerald Franklin
Phone #: 580-252-6002
Trade item: a riveted item

March 20, 2010
Host: Byron Doner
Phone #

April 17, 2010 STATE PICNIC NORMAN OK

May 15, 2010
Host: Gary Seigrist
Phone #
Trade item: Hardy tool

June 19, 2010
Host: Byron Doner
Phone #:

July 17, 2010
Host: Alex Scrudder
Phone #: 580-550-0882

August 21, 2010
Host: Terry Jenkins
Phone #:
Trade item: camping tool

Sept. 18, 2010
Host: Gerald Franklin at Sulphur tractor show
Phone #: 580-467-8667

October 16-17, 2010 Host: : SCABA Conference Perry, Okla.

November 20, 2010
Host: Bill and Diana Davis
Phone #: 580-549-6824
Trade item: door knocker

December 18 2010
Host:
Phone #:

SOUTH EAST MEETING DATES

January 2, 2010
Host:
Phone #:

February 6 2010
Host: Eddie Horton
Phone #: 580-513-8370

March 6, 2010
Host:
Phone #:

April 3, 2010
State Picnic Month

May 1, 2010
Host:
Phone #

June 5 2010
Host: Mark Hamell in Hugo, Ok
Phone #: 580-317-3700

July 3, 2010
Host:
Phone #:

August 7, 2010
Host:
Phone #:

Sept. 4, 2010
Host:
Phone

October 2, 2010
Host:
Phone:

November 6, 2010
Host: open
Phone #:

December 4, 2010
Host:
Phone #

NORTH EAST MEETING DATES

January 9, 2010
Host: Gary Gloden
Phone #
Trade item; something made at meeting

February 13, 2010
Host: Bill Kendall
Trade item. A heart

March 13, 2010
Host: Dan Cowart
Trade items: a 4 leaf clover or something

April 10, 2010
STATE PICNIC MONTH

May 8 2010
Host: Gerald Brostek
Phone #: 918-687-1927 trade item; yard ornament

June 12, 2010
Host: Bill Phillips
Phone #:918-823-4224
Trade item: Animal or Bird

July 10, 2010
Host: Clayton Hall
Phone # 918-605-6241 Trade item; spork/eating utin.

August 14, 2010
Host: Omar Reed/ Fort Gibson
Phone# 918-478-4088
Trade item Hinge

Sept. 11, 2010
Host: Dan Cowart/ Pawhuska
Phone #918-440-0653
Trade item: something with a feather

October 9, 2010
Host: State conference
Phone#

November 13, 2010
Host: Matt Goyer
Phone # 918-272-8424
Trade item: cross

December 11, 2010
Host: Charlie McGee
Phone #: 918-245-7279
Trade item: angel

NORTH WEST MEETING DATES

January 23, 2010
Host: Charlie Todd
Phone# 580-242-0105
Trade item; anything forged

February 27th, 2010
Host: Mandell Greteman
Phone # 580-515-1292
Trade item; tool

March 27, 2010
Host: Mike George
Phone #: 580-327-5235
Trade item; Flower

April 24, 2010
STATE PICNIC MONTH

May 22, 2010
Host:
Phone #
Trade item:

June 26, 2010
Host: Ron Lehenbauer at Fairview fair grounds
Phone #:580-758-1126
Trade item; something western

July 24, 2010
Host:
Phone #:

August 28, 2010
Host: Ron Lehenbauer, Fairview trade item: campfire tool
Phone #: 580-758-1126

Sept. 25, 2010
Host: Gary Seigrist (Elk city)
Phone #: 580-225-3007
Trade item; something from a horseshoe

October 23, 2010
Host:
Phone #.

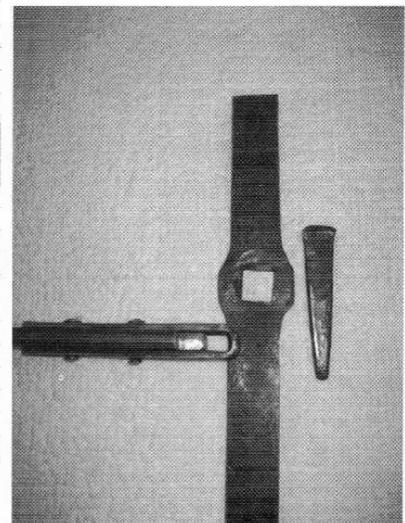
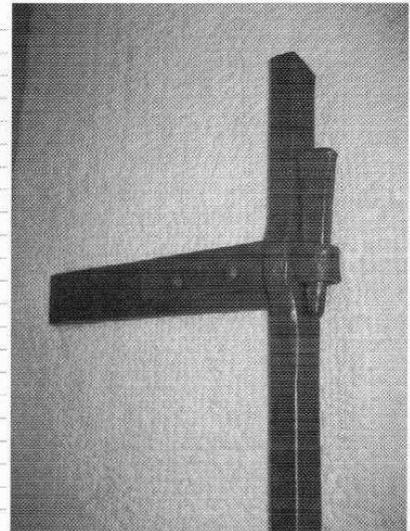
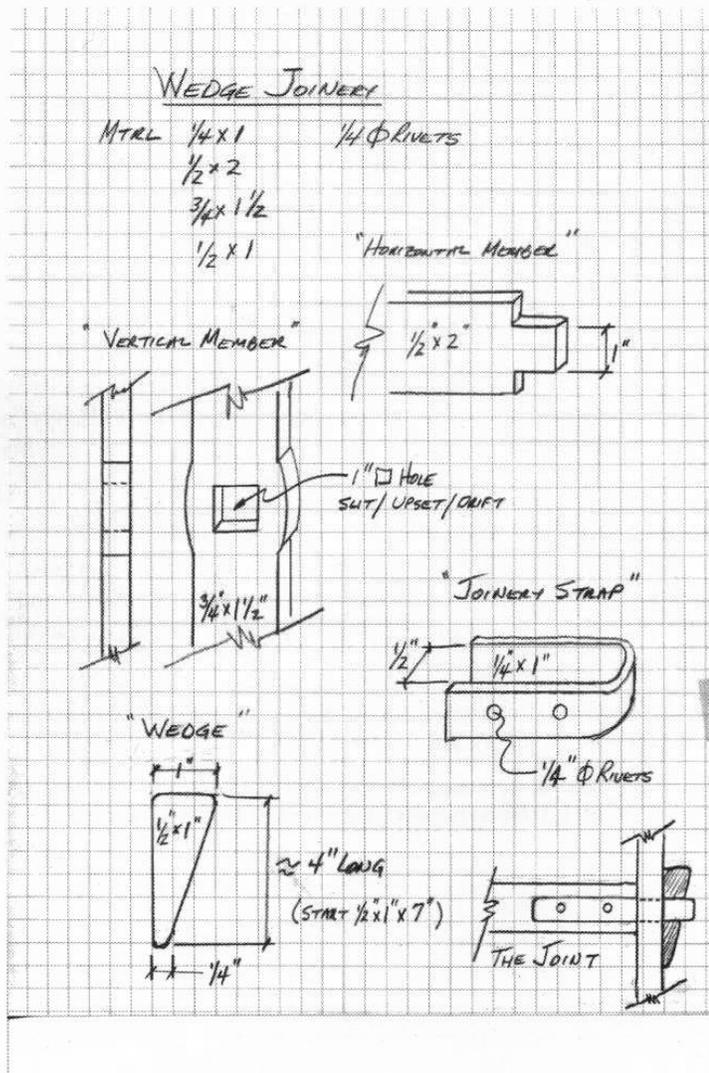
November 27, 2010
Host: Tom Nelson
Phone #: 580-862-7691

December 25, 2010
Merry Christmas

THE WEDGE JOINT

Len Ledet

In January Caleb Cullman conducted a "Innovating with Joinery" class (see March 2010 issue THE ANVIL'S HORN - page 7) at Sahuaro Ranch Park. One of the joints discussed and constructed was a WEDGE Joint. The following illustrates the components required and the material sizes we used during the exercise. The key to understanding the joint - the vertical member's square slit and drifted hold must be big enough to allow the horizontal member and the wedge strap to fit thru it. Try it, it was a very good forging exercise.



How To Make a Section Through a Cone-

Text and drawing by
Steve Alling, a MABA member

This is good to know if you want to make forms for frying pans, backs of coal shovels, bands for barrels and buckets, or any place you need to end up with a section through a conical shape.

You need to make a full size drawing of the side view of your conical shape and use that to construct the side view of a cone. Draw a centerline (C) between the sides of your conical section. Extend the sides of the conical shape until they intersect the centerline - this is the point of the cone.

The distance from the point of the cone to the side of your shape, (X), defines the radius you will need to make your first bend in your stock.

Figure out the top and bottom circumference. (Tcirc), (Bcirc) using the formula:

$$\text{Circumference} = 2\pi r \text{ or } 2 \times 3.1416 \times r$$

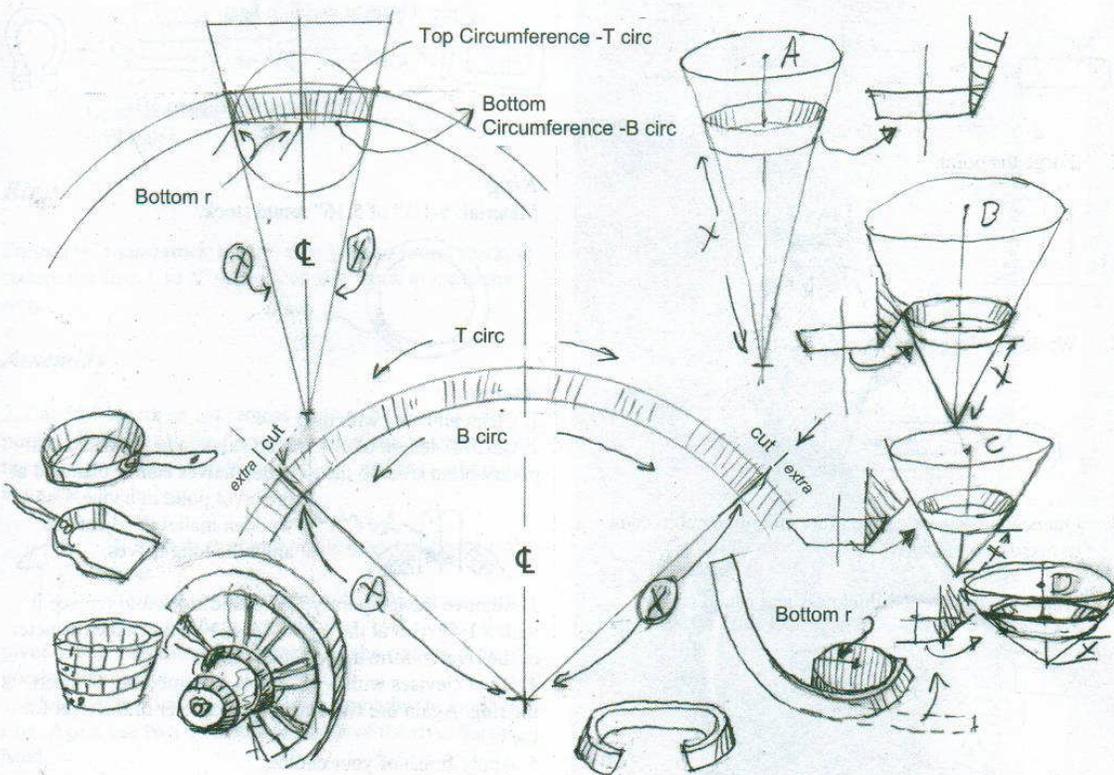
This will give you the length of the stock you need to bend.

Lay out the two radiuses (X and X + the material width). I find it's easier to add some to each end because you're going to bend this the hard way and it's hard to get a nice bend on the ends which you can cut off later.

When you have this bend made, you now bend it to the diameters of the top and bottom of your conical shape. Remember as you bend this, you're making a cone and it should be coming out so it will lay flat. It is easier to bend from both ends and finish by bending the middle. That way you can sort of see how the two ends are coming together.

As you can see in examples A-D, as length (X) gets shorter the angle at the cones point gets larger. This causes the sides of the conical section to lay over farther. Obviously when (X) equals the radius of the (Tcirc) a flat circle is the result.

To see if you like your conical shape, make a mockup by laying out the two radiuses on card stock and cutting them out. Also remember metal bends down the middle so the thickness of your stock and the width of your stock will affect the finished shape. But, remember you are going to be doing a lot of banging around so the final size will vary.



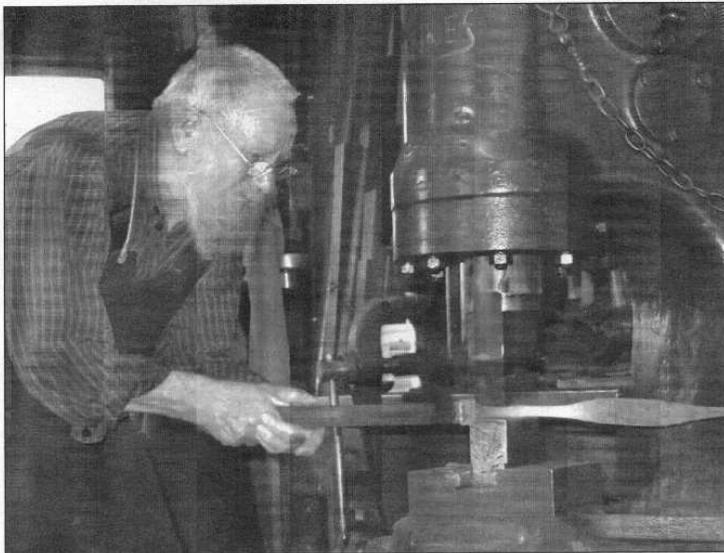
Paul Zimmermann's Harmony Element

story & photos by Andrew Kyte, Pliezhausen, Germany (formerly of Berkeley)

Paul Zimmermann developed this form approximately thirty years ago as an answer to the traditional scroll work his clients were requesting, as taking blacksmithing into more modern forms has always been the goal of his work. He realized early on that, often times, when a client would request scroll work, it wasn't so much the scroll itself they found appealing, but rather the movement of line and form. In the eighties Paul received the *Staatspreis* for a screen using this form. In Germany this is the highest prize awarded for applied arts.

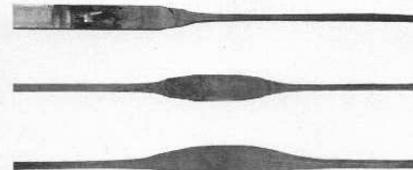
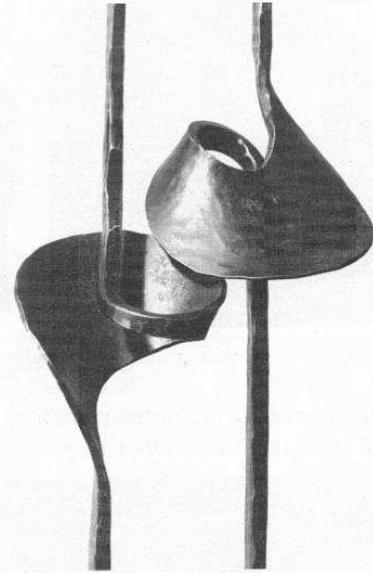
Located in Pliezhausen, Germany, Atelier (*Studio*) Zimmermann has been a forerunner for bringing the traditions of blacksmithing into a contemporary design context. Paul and Heiner Zimmermann's works are characterized by a high definition and clarity of design that is most apparent in the grave markers they've created.

Through years of international lectures and demonstrations, the Zimmermanns have become ambassadors of the craft through an open exchange of skills and design philosophy. I hope that if more people are exposed to their work through this step-by-step photo story and their website, they will be inspired to design in the present. I hope you will visit Atelier Zimmermann at www.atelierzimmermann.com, a very artistic and creative website.

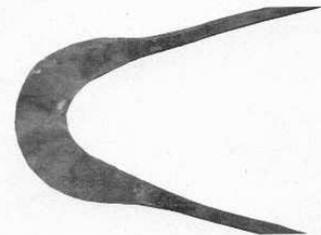


Paul at the power hammer. Note he is using slightly curved drawing dies.

The form can be forged out of square, round or flat bar using the same methods that follow. In this case I use 35mm x 6mm to achieve a larger form because, as the steps progress, you are left with more material to work with. The measurements I give are only as reference points.

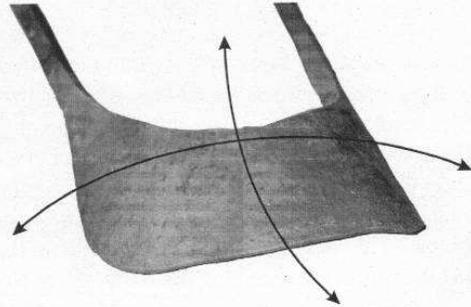
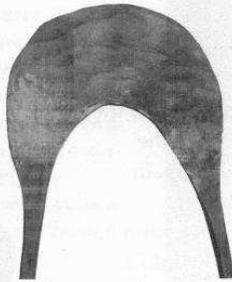


Draw out both ends of your bar creating a quick transition into a cross section of approximately 10mm x 10mm. Then offset each leg creating a flat side and a humped side on the piece.



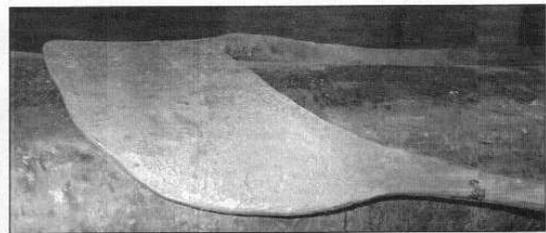
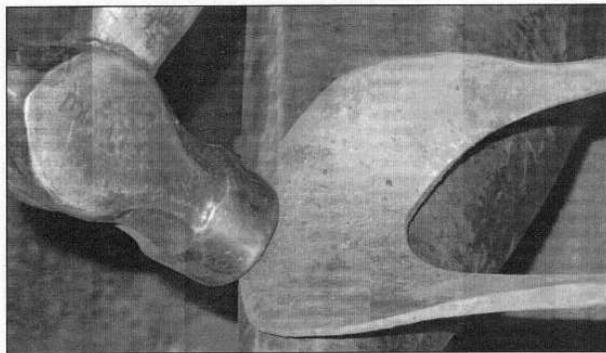
Bend the original sized material into a "U" shape. This is one of the most important steps in the process. The curve should be graceful inside as well as outside.

Harmony



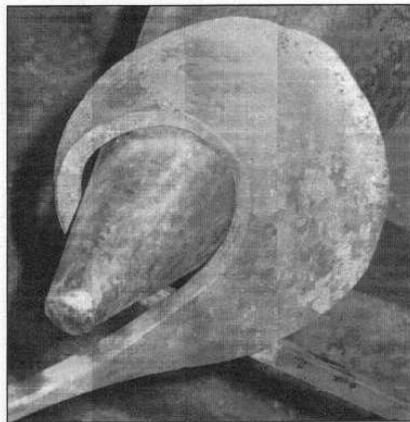
Take a good heat on the curved section and begin to spread the material as uniformly as possible. Rotate it under the hammer in a circular motion to distribute even blows, thinning the outside while keeping the inside a little thicker.

Now you will curve the piece in two directions.

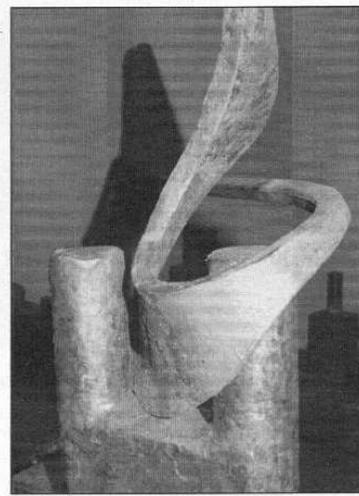


Forge the piece over the horn while also lifting up slightly.

It is best to really analyze the piece now because once you begin the next step, there is no opportunity to tweak. Using a dome-faced hammer, even up the curves and smooth out any kinks that may have developed.

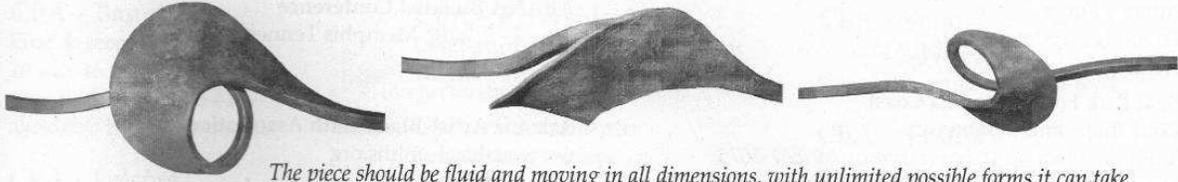


Moving closer to the tip of the horn begin to forge the piece into a graceful curve behind itself.



Bending forks and a torch are also useful tools to get good results. At this point as you work the piece, periodically turn it and look from all sides. Even up any remaining kinks or flat spots.

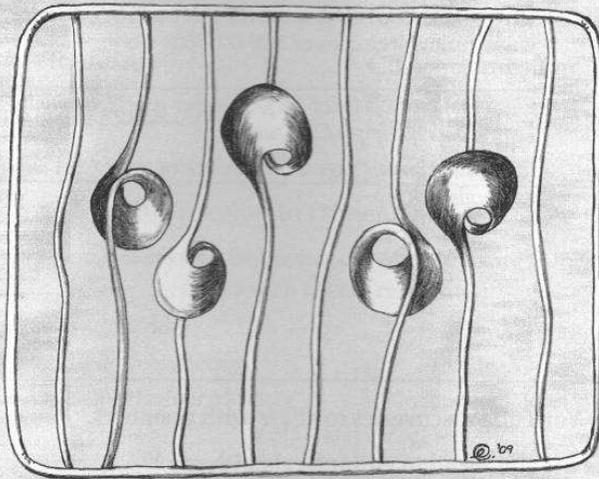
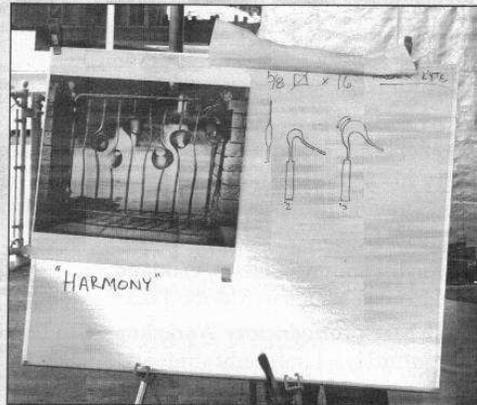
Harmony



The piece should be fluid and moving in all dimensions, with unlimited possible forms it can take.

Paul would always remind me that working this form is an exercise and should always be experimented with to find something new. So get out to the shop and experiment! ♣

"Paul Zimmerman's Harmony Element," Andrew Kyte's companion article to his 2009 CBA Spring Conference demonstration, fulfills his commitment regarding the scholarship he received from CBA that helped him journey to Germany. ~Ed.



(left) Andrew demonstrating at the 2009 CBA Spring Conference. Centering five harmony elements in a cluster offers pedestrians joyful expectation as they pass through this garden gate. This sketch is based on the photo of the garden gate Andrew displayed during his demonstration. (above)

*Photos by Bob Jensen
Sketch by Eden Sanders*

Dividing Circles

by Dan Jennings

Would you like to be able to divide a circle into an equal number of spaces? For instance, maybe you'd like to lay out a 5 pedal rose blank that is 3 inches in diameter. *Chordal Values* are the easy way to get it done.

From the chart below select 5 from the divisions column and multiply the number in the Length of Cord column times the diameter of the circle.

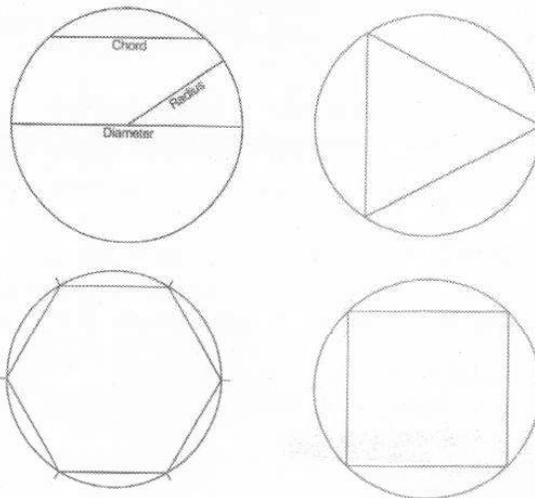
$$.5878 \times 3 = 1.7634$$

Set your dividers to 1.7634 and walk them around the perimeter of the circle.

What? Your tape measure only reads fractions? One cheap solution is to get a pair of digital calipers. I have a few cheap ones -that cost around \$20 from places like Harbor Freight and they work great. Of coarse, you can spend several hundred and get more expensive ones -I've got those, too.

Need more than 32 divisions? *Machinery's Handbook* lists up to 194 divisions.

Ref: *Machinery's Handbook* and Paul Quyle, in the June 2003 *California Blacksmith*.



Chordal Values

Divisions	Length of Cord	Divisions	Length of Cord	Divisions	Length of Cord
3	.8660	13	.2393	23	.1362
4	.7071	14	.2225	24	.1305
5	.5878	15	.2079	25	.1253
6	.5000	16	.1951	26	.1205
7	.4339	17	.1838	27	.1161
8	.3827	18	.1736	28	.1120
9	.3420	19	.1646	29	.1081
10	.3090	20	.1564	30	.1045
11	.2817	21	.1490	31	.1012
12	.2588	22	.1423	32	.0980



Sketch Book

By Diana

Bull head steak turner

By: Bryan Dale Headley

As seen on RFDTV, Rural Heritage



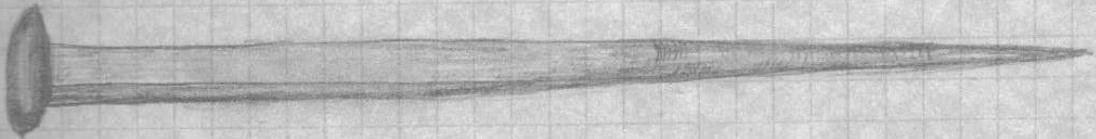
Start with a Rail Road Spike

Bring to good orange heat. Draw out a long

taper. It will take several heats.



Continue until you have a nice fine point on the end. Heat and work the taper round. You can round the whole length of the taper or only the last couple of inches.



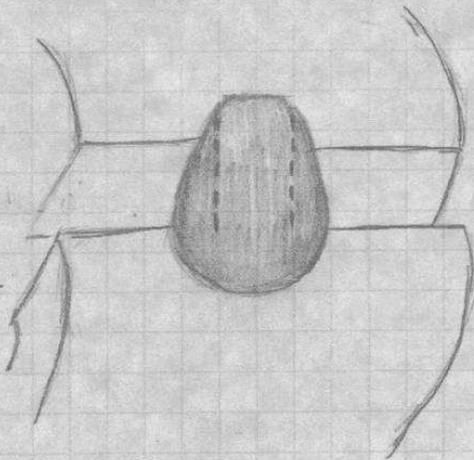
Now form hook on end. Bend the last 1 1/2" or so at a 90° angle.

Then curl the end to form hook.



Bull head.

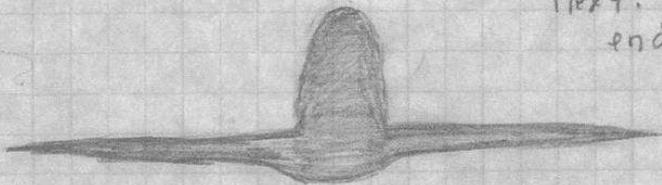
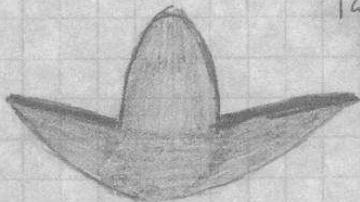
Place the spike in the vice using a hack saw -



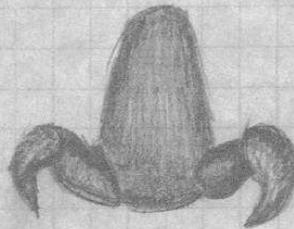
Make two cuts. Cuts will run along sides of spike about $\frac{3}{4}$ of the way.

Next: being careful not burn the horns off. Heat and bend outward both horns. Shape the nose as you go by rocking it back and forth on the anvil to round edges.

Take another heat a start to taper the horns. Use your own judgement as to how long to make the horns.



Next: curl the horns up at the ends:



Next, add eyes and nostrils.

Add hair and other details that you think it needs



SCABA membership application

April 1 2010—March 31– 2011

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 to March 30, 2011

Signed _____

Return to: Saltfork Craftsmen, 1227 Fourth St. Alva, Ok 73717



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

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 Membership (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
Contributory Membership <i>(amounts above \$55 / year may be tax deductible)</i>	One Year – <input type="checkbox"/> \$150 and up – \$_____	Two Years – <input type="checkbox"/> \$295 and up – \$_____
Public Library (US, Mexico, Canada)	One Year – <input type="checkbox"/> \$45	
Educational Institution	One Year – <input type="checkbox"/> \$250	

Mail to: ABANA, 15754 Widewater Drive, Dumfries, VA 22025-1212 USA

Please pay by Check, U.S. Money Order or Credit Card.

You can also join on-line at

or by calling 703-680-1632.

www.abana.org

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.
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Alva, Okla. 73717-1227

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