



Saltfork Craftsmen Artist Blacksmith Assoc.Inc.
Fourth Street
Alva, Okla. 737171227

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ORGANIZATION
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Saltfork Craftsmen

Artist-Blacksmith Association

June 2008



Lady Liberty at the BAM Conference held at Sedalia Missouri. The second ring on the Left side was made by SCABA member Gerald Brostek. Lady Liberty sold for around \$4000.00 and will be located in College Station Texas.

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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:

Trading Post

For Sale:
¾" round bar of 5160 (\$3.30 per foot plus shipping)
¾" and 1" round bar of 52100 (\$6.00 and \$9.45 per foot plus shipping) Contact Ray Kirk, ray@rakerknives.com or 1-918-456-1519



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 lazyassforge@tds.net



Due to health problems, I have decided not to rebuild any more Little Giant hammers. I have for sale :One decent used 100# hammer (\$3,500), one completely rebuilt 50# hammer (\$4,500), one good condition used #50 hammer (\$3,500), two rebuildable 50# hammers (one at \$1750 and one at \$2,000), I have some miscellaneous parts, dies, babbit mandrels, and etc. for sale. Contact Mike George at 580-327-5235 (home), 580-829-1968 (cell) or Mike-marideth@sbcglobal.net



Wanted:
Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or o Mike-Marideth@sbcglobal.net

Notice... The SE Regional Meeting for June 7 that was listed in last months newsletters has been CANCELLED. The community changed the date for a celebration that it was going to be held at.

Saltfork Craftsmen
Artist-Blacksmith Association
Membership Application
April 2008 thru March 2009

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, 2009

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



Name: _____ Email: _____

Address: _____ www url: _____

City: _____ Phone: _____

State: _____ Zip: _____ Fax: _____

Country: _____

TYPE OF MEMBERSHIP:

NEW MEMBER RENEWAL

Regular - \$55.00 Contributing-\$100.00

Student- \$45.00 Library-\$45.00

Senior (65+) \$50.00 Foreign-\$65.00

ABANA Chapter Affiliation: _____

CREDIT CARD INFORMATION:

VISA Mastercard Expiration Date: _____

Card Number: _____
Submit check, money order -U.S. Banks only, or by credit card:

PO Box 3425
Knoxville, TN 37927-3425
Phone: 865.546.7733 Fax: 865.215.9964

FIRST ANNUAL FRONTIER FAMILY DAY

AND WESTERN SASS REGULATION SHOOTING CONTEST

(MUST BE INSURED, CONTEST FROM 10:00AM-2:00PM)
SPECTATORS WATCHING SHOOTING MUST BRING EYE AND EAR PROTECTION.
SHOOTERS FEE \$20.00
OVER 30 PRIZES

SATURDAY, JUNE 28

9:00AM-8:00PM

GENERAL ADMISSION \$5.00

BAR-B-QUE

FRONTIER DEMONSTRATIONS

WAGON RIDES

OLD TIME FAMILY BASEBALL 89ER STYLE

FRONTIER FAMILY GAMES

COWBOY ENTERTAINMENT

BRING YOUR CHAIRS!!

**COME AND ENJOY PRIMITIVE WESTERN
FRONTIER FUN! HOW DID THEY DO IT
WITHOUT ELECTRICITY AND RUNNING
WATER!**

ON 155 ACRES NORTH OF GUTHRIE,
15 MILES WEST OF I-35 OFF THE MULHALL RD EXIT
(THAT IS 2 MILES SOUTH OF THE 51 EXIT TO STILLWATER)
FOLLOW THE SIGNS
DIRECTIONS OR QUESTIONS CALL 405-282-8687 OR 405-301-6594

Club Coal

Saltfork Craftsmen has Arkansas coal for sale. The coal is \$95/ton to members and \$145/33non-members. 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. The coal is in large chunks; bring something to break up the coal into manageable size pieces.

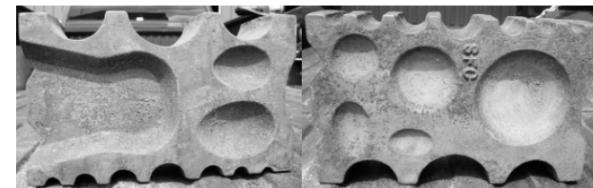
S/C Region coal location: Coal is in 1-2" size pieces. Bring your own container. The coal is at Max Scrudder's place in Mountain View. Contact Max for load out instructions.

Cost for this coal is .06/pound or \$120.00/ton. NO SALES to non-members.

Max Scrudder can be contacted at (405) 226-9951
NE Region coal location: Dan Cowart also has coal to sell. He can be contacted at dacowart@dishmail.net or CowartPat@gmail.com

Saltfork Craftsmen Swage Blocks \$105.00 each plus shipping. SCABA members can purchase one block for a special members price of \$85.00

Contact Mike George at 1-580-327-5235 or mike-marideth@sbcglobal.net or Bill Kendall at 1-918-742-7836 or wwkendall@aol.com



Mail your ads to the editor or email them to lazyassforge@tds.net

MEETING SCHEDULE

June

South/Central region—June 21st. Hosted by Larry Morefield across from the Old Plantation in Medicine Park. Lunch is not provided but the Marauders are cooking close by as a fund raiser for the Fire Dept. The trade items is a punch or chisel.

Northeast regional meeting. June 14th hosted by Charlie McGee at his home near Sand Springs. Trade item is a hat/coat rack.

Southeast regional meeting. June 7th. Open **Northwest regional June 28** hosted by Charlie Todd at his shop at 701 E. Cornell Ave. Enid Okla. Lunch is provided but bring a desert. Will do a knife making demo and if time allows will show how to make Damascus. *See Map*

Bam Conference

Sedelia Missouri and the BAM Conference was the place to be from April 30 thru May 3rd. After about 7 hours of driving time we arrived in Sedelia about 5:30

and went straight to the hotel to rest for a few minutes before going out to the State Fair Grounds where the conference was to be held.



The Fairground turned out to be the perfect locations for this conference. It has a large open sided building where the tailgating was located so no matter what the weather was, the tailgaters were protected from it.

Registrations went quickly and we were soon strolling through the tailgating area visiting with vendors like Sid Seudimier and his daughter Keri.



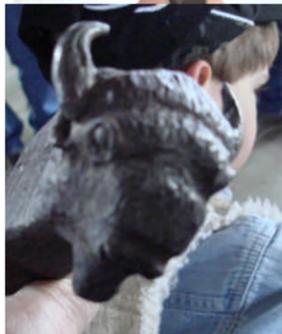
Not only did Sid bring parts and equipment for rebuilding power hammers, he also brought a display of power hammers

The first night they held a forging contest. The challenge was to take a piece of square rod and create a door hook. It had to have an eye on one end and a hook on the other and a twist in the middle. They had about 10 takers on the challenge. They had 10 minutes to complete the hook. Not everyone was able to finish in that length of time but there was one young man that did have his hook finished before the time was called.

Daniel Haumeser age 14 won the beginner/novice forging contest. One of the demonstrators at the conference was Daryl Nelson. He forges animal heads from 1 to 1 1/2 inch square stock. He is a very talented smith and presents a good demonstra-



tion. During the conference many of the demonstrators repeated their demos so that everyone had the opportunity to see them all. Daniel made a bear, wolf, and buffalo at the demo that Bill and I watched. We also watched Bob Patrick repeat a process he used to create a grill. He also made several forge welds. He makes it look so easy.. This is one end of a pot rack. He added slip on hooks along it.



On Friday night they had a dinner and auction. There were about 375-380 registered at the conference and think they all attended the dinner/auction.



When the

ABANA conference for 08 was scheduled to be in New York, the design for the ABANA rings project, that has been a part of the conference for a long time, was to include the statue of Liberty. The ABANA conference was cancelled but Tom Clark kept the ring project alive by including it in the BAM Conference. The finished project is pictured on the front cover. What you can't see is the stained glass that makes up the torch. They had a nice collection of rings to choose from. Those that didn't make it on Lady Liberty were auctioned off on Friday night.



Saturday was cold and windy so we cut our time short and started back to Oklahoma. We had a good time and saw many acquaintance's and other SCABA members. Besides the SCABA conference, BAM is a very good conference to attend.

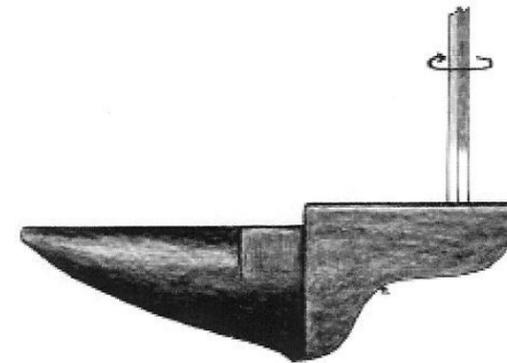
PUBLIC DEMO'S AND REQUEST

- June 7th** Women in the Outdoors
Instructor needed. Contact Beth An Amico at (405)769-4108
- June 14th** Frontier Days Celebration in Marietta
- Sept 26-27** 18th National Two Cylinder Show at Fairview, Ok. This is what they call a working show with games, plowing, baling, threshing, etc. Contact James @ 580-227-4985
- October 18-19** SCABA conference at Perry Ok.

SCABA TOOL BOX

Raffle tickets are now available for the tool box. If you would like to purchase tickets or get some to sell for the club please contact David Seigrist, tool box chairman. The tickets are \$2.00 each and come in booklets of 5 tickets or \$10.00 each booklet. The drawing for the box will be done during the conference in October. Check out the list of tools and pick out something to make and donate to the box. All the boxes in the past have been really nice because of the box and tools made by the members.

CONTROLLED HAND FORGING



Holding the bar on the anvil top

Look frequently at the hot end as you are working. As soon as you see the bar bending, stop upsetting and straighten, using as few blows as possible. Overzealous straightening can lead to drawing out the bar... negating your progress. You do not need to get the bar perfectly straight, but close.

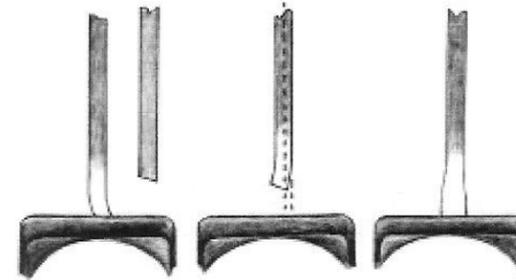
As soon as possible, return the bar to upright and strike two or three more upsetting blows. Continue in this manner until you have slightly exceeded the target dimension, taking additional heats if the bar cools below a medium orange.

Note:

While checking for straightness, remember also to keep watching the end. If you see the end of the bar going out of square, you must stop upsetting and correct as illustrated in step 1.

What can be done to minimize the time used in straightening? Many smiths will rotate the bar 1/4 or 1/2 turn between blows to keep minor mistakes from compounding.

Occasionally, a correction can be done without much interruption. If the bar end goes out of square and causes a bend, bending the bar in the opposite direction will address both corrections (straightening the bar, and squaring the end) at once. Remember, reducing the interruptions to actual upsetting means fewer heats to accomplish the goal. Every second saved counts.



Correcting an end that is out-of-square

Step Three:

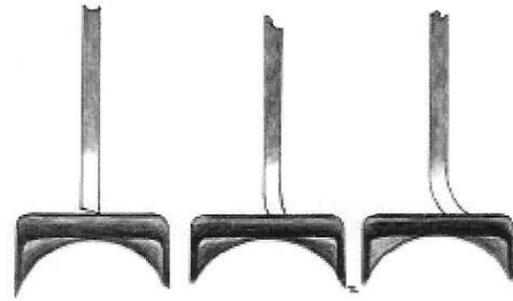
Smooth and straighten the upset area, being careful to draw the bar just to size. A lower heat (dark orange to bright red) is best for this step.

Check the bar dimensions to confirm it is square in cross section, straight, and proper size (5/8"). Correct as necessary (see lessons on drawing, straightening, bending)

Target:

With practice this exercise may be accomplished in one heat, though a beginner may take two or three at first. The finished upset section should be within 1/32" of the intended 5/8" thickness and the bar should be straight and square.

CONTROLLED HAND FORGING



A bar end that is out-of-square causes bending

If this continues, there is no easy way to correct the problem.

The likelihood of any smith holding and striking the bar perfectly plumb every time (or even once, for that matter) while working as quickly as possible is slightly less than winning the lottery. Most experienced smiths count on the bar bending frequently. There is almost no way to prevent this. The object is to notice bending as soon as it occurs and correct it right away. The sooner a problem is noticed, the simpler (and faster!) the correction can be made. This sometimes means only one or two upsetting blows between straightening, so the key to upsetting is to work quickly and make constant corrections.

4. How solidly the bar is supported will determine the effectiveness of each blow. A bar backed against the anvil will upset much faster than one supported in the hand.

A bar can be held in the vise for upsetting. However, there are some serious drawbacks to this method. For one thing, the vise will pinch the bar (especially at very high heat) and leave scars. For another, it is awkward to straighten a bar while it is clamped in the vise. Proper straightening is best done at the anvil, and it is quite slow clamping and unclamping the work every two or three blows. Finally, the vise is an effective heat sink, and cools the work appreciably.

5. You have the choice of holding a short bar with hot end up or down. If down, the length of the bar absorbs some of the blow, so less is accomplished. If the hot end is up, the blows fall directly on the heated end, which is good. However, it's much harder to hold the upper end steady if you grip at the bottom and strike at the top. You will also get many scale burns on your wrist. Holding the cold end up with the heated end down on the anvil face is the best compromise.

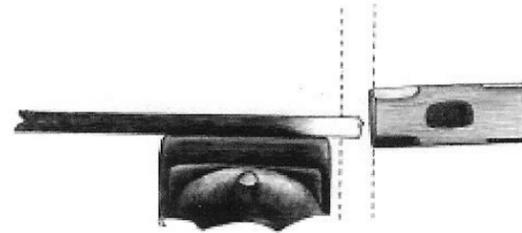
Note: it may be tempting to use tongs to hold the bar, enabling you to hold the hot end up after all. This sounds like it solves all the problems, but in fact it can slow down the quick changes from upright to straightening to upright so much that extra heats will be necessary. It is better to learn the proper hand grip method.

Step One:

If you are starting with a bar with an uneven end, you must square it first. To do this you will upset the very tip of the bar. Since only a small area is to be worked, you can usually do this

easily in one heat. Hold the bar so that the hot end projects beyond the far edge of the anvil an inch or two and strike the end of the bar. You will be hammering almost directly towards yourself and bracing the cold end of the bar against your thigh. Remember to keep straightening as necessary until the end of the bar is square to its long axis and the original dimension (in this case, 1/2" square). Check with your square if necessary.

Note: it is possible to start with a bar that has been cut hot on the hardie, but only if it has been cut evenly from all sides; leaving the resulting burr centered on the cut end. After the first one or two upsetting blows the burr will be gone. An uneven cut will leave an off-center burr and this will guarantee bending.



Bar and hammer in position.

Now for the real work. Take a near welding heat on the end of the bar. It is important to heat only 1 -2 inches. Even with the best of intentions, the heat is sometimes too long. In this case, quickly quench all but the area to be upset. The fastest method is to submerge the long end of the bar (along with your arm) in the slack tub. This works well with a short bar such as the one in this lesson. If you move the bar around in the water it will cool even faster than holding it still. Remember, wasting time at the tub means the bar will be much cooler by the time you are ready to strike. Best results come from heating the bar correctly so you can go directly to the anvil.

Target:

If you have taken a good heat, you should be at the anvil and ready to strike within 1 or 2 seconds. If quenching is necessary, try to take no more than 3 or 4 seconds from fire to striking the first blow (beginning of step 2) .

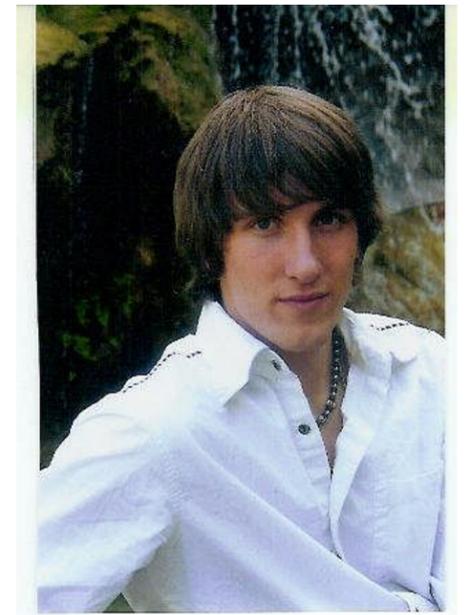
Step Two:

Hold the bar upright on the anvil and strike the upper end two or three quick, hard blows.

SCABA TOOL BOX AND TOOLS for 2008

Tool/Item	Maker/Buyer	Cost/Value
Box	Adam Hall	\$300
Hardware for toolbox	Mike George	
Cross peen hammer		
Straight peen hammer		
Rounding hammer		
Tongs:		
1/4 v-bit		
3/8 v-bit		
1/2 v-bit		
3/4 v-bit		
1/4 flat		
3/8 flat		
1/2 flat		
3/4 flat		
Scrolling		
Side grip		
Pick up tongs		
Fire tools (Shovel, rake, poker)		\$75
Hot cut hardie		
Cold cut hardie	Tommy Dean	\$25
Twisting wrench		
Treadle/Hand Hammer Tooling	JC Banks	\$200
Set of punches and holder		
Center punch		
Chisel, large		
Chisel, small		
Chisel, hot slit	JC Banks	\$25
Slitting chisel		
Hold Down		
Flat wire brush w/handle	Tommy Dean	\$30
File, flat bastard cut w/handle		
File, half round w/handle		
Set of monkey tools		
Rivet backing tool		
Rivet setting tool		
Hacksaw		
Bolster plate		
Square		
Scribe	Bill Kendall	\$30
Bending forks	JC Banks	\$50
Spring swage (necking down)		
Flux spoon		
Metal folding ruler 24" or 72"		
Soapstone		
Ball tool (round blunt nose punch)		
Hook Ruler	Gerald Franklin	\$30
Iron Mountain Flux	Diana Davis	\$22
Finishing Wax		
Nail Header		
Dual Caliper	David Seigrist	\$35
Total value to date:		\$822

Spotlight on a member..



Brahk Hadick

Five years ago Brahk moved from California to the Midwest City Oklahoma with his family. Approximately one month later his neighborhood was ripped apart by the May 8th tornado in 2003. While burning some of the debris from the remains of the family workshop, Brahk became interested in how the fire affected the metal. Needless to say he began working at fashioning various items from the scrap metal he found. People started asking to buy his work which increased his passion for the craft. One thing led to another and finally Saltfork Craftsmen was discovered. Brahk loves being a part of SCABA.

Meeting the other members, gleaning from the skills, wisdom, and humor that they so easily share is always a pleasure and always greatly appreciated!

Brahk has made significant progress since the days of bon fire metal working. Brahk is building a second forge, the shop has been rebuilt, he's bought a second anvil, swedge, welder, and plasma cutter. The Saltfork workshops always add handy tool to the shop!

At a very young age, a strong desire to build and artistically create began forming Brahk's goals. In the fall of 2003 Brahk began his freshman year of high school continuing his studies at home. In his junior year, in addition to his full load of academic courses and extracurricular activities he began training and studies in carpentry at Mid-Del Technology Center.

He has a strong love for the Lord and for people. Some of Brahk's many accomplishments throughout his high school years are as follows:

Active member S.C.A.B.A. since October 2005
 Active member A.B.A.N.A. since December 2006
 Blacksmith demonstrator at various community functions
 Mid-Del Technology Center (MDTC) Representative and Student Leadership
 MDTC Representative/ Speaker/ and Recruiter at: Del City High School, Carl Albert High School, Midwest City High School, Rose State College Night, and Rose State forth annual Home School Symposium.
 Skills USA member 2006 – 2008
 National Technical Honor Society member 2006- 2008
 Forth Place Honors 2007 District Job Skill Demonstration
 2007 – 2008 MDTC Perfect Attendance Award
 March 2008 MDTC Student of the Month
 MDTC Outstanding Senior 2007 – 2008
 Certificate of Training in Carpentry: completed 1050 hours at MDTC 2006- 2008
 Two Certificates of Training in Welding: combined total 81 hours completed fall of 2007
 E.C.H.O. Student body President 2007 – 2008
 Honor Troop mentor 2005 – 2006
 Youth America Intern summer 2006
 Youth America Facilities Director summer 2007
 Worked with Habitat for Humanity and other community improvement projects 2006 – 2007
 Spent one month building orphanages and evangelizing in Cambodia summer 2007
 Weekly worship leader and instructor in Kids Church since January 2006 at Church of the Harvest
 Weekly choir member and Background vocalist at Church of the Harvest
 Studies ballet weekly with his sister at Dance Masters by Christi
Graduated with honors from BOTH
 Mid-Del Technology Center on May 13th 2008 and
 American Academy on May 17th 2008 with a four year combined GPA of 3.989

When Brahk had written out his educational plans and ambitions after having graduating high school this is how he worded it.

“After graduation it has been my intention to take a year prior to entering college to further my studies and skills as an artist blacksmith through apprenticeships and various “smithing” schools in the nation. In addition I plan to continue sharpening my skills in basic courses of study while seizing opportunities for community service. Upon entering college I will pursue an associate’s degree in business with a master’s degree in architectural design or construction management. I wish to build on the skills and knowledge invested in me through the years, and to further develop personal growth and continue building upon the foundations laid by others.

I have demonstrated good citizenship and hard work which is evident in my years of leadership commitment and community service. My long term goals are to combine quality carpentry, blacksmith artistry, and architectural design with which I may professionally invest in our nation’s communities and around the globe. I especially enjoy sharing my time and skills with others through relationships and mentoring. Our neighbors, nation, and world deserve the very best we have to offer in love, relationship, and skills! I choose to example that to the best of my ability and to always encourage the same in others.”

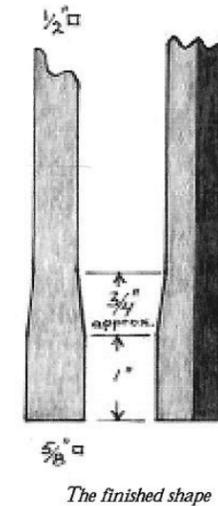
Brahk is looking for opportunities to apprentice over the next year and is hoping to draw from the wealth of experience within our blacksmith community. You may have a project, or several projects, that could expose Brahk to design, bidding, construction, application, and techniques used in metalworking that can help shape this eager learners future. Please consider the possibilities around you and get in touch with Brahk.

Brahk Hadick
 10818 Newey Ave. Oklahoma City, OK. 73150
 Hm.Ph: (405)869-2043 Cell: (405)406-3704
 E-Mail: kahadick@hotmail.com

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CONTROLLED HAND FORGING

Upsetting



By Peter Ross
 Illustrations by Tom Latané

Lesson Number Eight—Upsetting

Definition:

Upsetting increases the cross sectional area by deforming existing material instead of adding material.

Upset 1" of the end of a 1/2" square bar by 25% (drawing of finished shape)

Intent:

The student will learn the basic principles for upsetting the end of a bar efficiently, practice the methods, and be able to produce accurate results.

Tools needed: basic tools only, including a square

Materials:

14" of 1/2" square mild steel

Method:

The bar is hammered end-on. This shortens the bar and causes it to swell where it is hot.

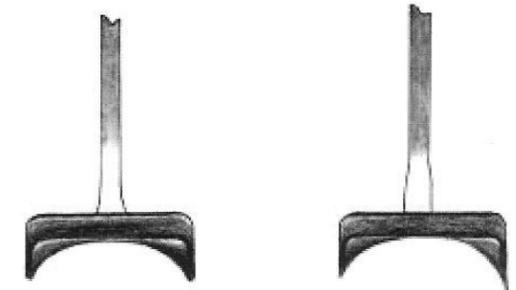
In order to work efficiently, the following conditions must be met:

1. the bar must remain straight.
2. the bar must be at a very high heat
3. the bar must be hit hard

Managing these factors is more difficult than it might appear. This is one process where almost everything works against you. Since hot steel bends so easily, it is very likely for a bend to start even while striking on end. Once even a little bend starts, almost all upsetting ceases and the blows simply cause more bending (If you have ever tried to drive a nail once it has bent even a little bit, you will understand the situation).

Very little is accomplished unless the bar is at its softest. At a medium orange heat or below, results are almost negligible. Therefore, it is crucial to start at the highest heat and work quickly.

As a practical example, try to make a small section of rope swell by pushing from both ends. If you hold too far apart, the rope will bend. It only swells when you keep everything straight and localize the work area. Also, compare the resistance between upsetting and bending the rope. It will bend with much less force. This illustrates the necessity of following the three requirements when working steel.



Upsetting with lighter vs. heavier hammers

Factors to consider when upsetting:

1. The size of the hammer affects the results. A light hammer can be used faster, but since it has less mass, the blows work only the very end of the bar.

A heavier hammer will have a deeper effect.

If too heavy, the hammer cannot be used fast enough; adding extra heats. For this exercise, a hammer between 1 1/2 and 2 pounds will be adequate.

2. The length of the heat is very important. If too long a heat is taken, the bar will bend rather than upset.

3. The end of the bar affects straightness. Even though the end of the bar will deform during upsetting, how it looks at the start is crucial. If the end is not square to the bar length, the first blow will cause bending. Additional blows only exaggerate the condition.

Punches For making

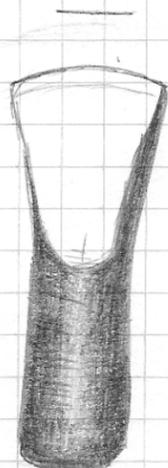
Faces



flat round



center Punch



canoe shaped
chisel



Eye Punch

Punches can be made from coil springs from automobiles, allen wrenches or you can rework old chisels and punches.

Start by normalizing the metal. This is done by heating to non-magnetic and allowing to air cool.

The eye punch is made by using a center punch to create a pupil (hole) in the center and then grinding or filing the outside eye  shape.

The round flat punch should be approximately 1/2 the width of the square stock you are using to make the face.

Heat completed punch until non-magnetic, quench in oil, when cool, Buff and then reheat and watch for straw color to move to tip and then quench in water.

Saltfork Members:

Having the state wide picnic still fresh on my mind; I'd like to share a few thoughts with you all. I believe having a state wide picnic was Ron Lehenbauer's idea back at a NW Regional meeting last year out at the Saltplains Lake. Very little discussion was needed to get picnic idea accepted and the plans rolling. Everyone likes a good picnic. It did take quite a bit of work by the members of the SF Board of directors (family and spouses) and a number of volunteers from the general membership. With all our experience in organizing the annual conference, a picnic is pretty easy.

Now about **all** those bolts – nearly 4000 pounds of bolts. My friend and bolt mentor Robert Lomas (LTR Fastener & Supply 7424 Melrose Lane Oklahoma City 405-603-2585) was our benefactor. Rather than let a lot of old inventory, company buy-out stock, and floor sweepings be hauled off for scrap, he ask me if Saltfork would like to “recycle” them. Tom Nelson, Adam Hall, and I managed to get them stored for a few months and then loaded on to my trailer for distribution at the picnic. I still have about 500 pounds in the truck. I'll try to bring these to one or more of the regional meetings in July.

I have heard from some of our members that we should schedule an Annual Picnic early in May each year. I'm sure for doing that; it seems that getting as many of us together as we can at an informal central event is a good thing. Our demos were good (Jim White and Gerald Franklin) and the “drawing out” contest was a lot of fun. The cooks did an outstanding job, and the classes Diana organized and taught were excellent. Thank you all very much for your hard work and for your personal time. This was fun.

Tentatively mark your 2009 calendars for Saturday, May 16th for the Second Annual Saltfork State Wide Picnic. At the next SF Board meeting this can be an agenda item.

Our VP & Librarian, Gerald Franklin has been ask by ABANA if he would be interested in serving on the ABANA Board. At the picnic, several of us signed the ABANA petition to get things started; Gerald will bring a lot to ABANA. He also will not have time to do justice to the ABANA position and continue with all that he does for Saltfork. So if Gerald does take on duty with ABANA, we will need a hardworking replacement for VP, Librarian, and 2008 Conference Co-Chair. Most of the ground work is in place for the Conference, but there is still a lot to do.

And finally (but certainly not least), the recent passing of our friend Ruth Burns reminds me that life is short. And so with this very fresh thought about life, it has been suggested that the Saltfork organization honor the 13 founding members with a Life Time Membership. Not all of the 13 are still with us, but many are. To me this is a really good idea.

March 2008 marks the 13th anniversary of the Saltfork Craftsmen Artist-Blacksmith Association. For more SF history, check out the website (<http://www.saltforkcraftsmen.org> click on About Us). I am really glad these folks did what was in their hearts and have helped me to have so much fun with the group and get to know such a great bunch of people.

Jim Carothers, President (2008) Saltfork Craftsmen ABA

SCABA Statewide Meeting and Picnic
May 10, 2008
Cleveland County Fairgrounds
Norman, OK



We held this event at the suggestion of several members who wanted to get more of the membership together in one place more often than the annual conference. I think we succeeded in that as we had 66 members present. Several members came from out of state and we were glad to be

able to visit with them. Jim White, a long time member from Mansfield, TX, gave a very informative talk/demo on branding iron design and construction.



Diana Davis conducted two classes, one on papermaking and one on the construction of a decorative bulletin board. Both of these drew good participation.

We ate well. Ron Lehenbauer furnished meat for the grill. Advance Foods from Enid donated the meat for this picnic and also the picnic that will be held on July 26th at the SaltPlains Reservoir. Byron



Doner supplied the grill to cook it on. Several members took turns cooking all the burgers. Other members brought beans, potato salad, drinks, and desserts. There were enough pies, cakes and cookies there to put several dentists' kids through college. As I said, we ate well.

After lunch, Diana Davis drew names for the door prize give-away. We had 62 folks registered for door prizes and all of them left with something. Our thanks go out to all of you who donated items for the drawing. Your effort and generosity certainly added to the meeting.



After the door prize drawing, we retired to the forging area for the drawing contest. The task was to heat a 2 foot stick of 1/2" square stock and draw it out as far as you could (or wanted to) in one heat. The prize was a really nice Otto Schmirler book that went home with the contest winner – LARRY MILLS. Congrats to Larry and thanks to all who participated in the contest. It was fun.

After the drawing contest, Gerald Franklin demonstrated forging of a dove tailed square corner. He did this as part of his scholarship fulfillment. The corner makes a nice square corner for some applications and is relatively

easy to do after proper layout.

David Seigrist had a display of some of the tools for this year's toolbox raffle. He also brought some tickets for us to take with us to sell. If you didn't get any tickets, get in touch with David to get a stack to sell. This is a good money making project for the club. Also, if you haven't signed up to make and donate a tool or two for the box, you need to contact David on that as well.



Jim Carothers brought a trailer loaded down with 4000 pounds of nuts and bolts etc.. Free to anyone with a bucket to put them in. It was like a bunch of women at a "buy one get two free" sale.

There were bolts, screws, cotter pins, etc. of all sizes and descriptions free for the grabbing

Mike getting his fire started at the picnic.



The tailgate area was something to see. There was a good assortment of the usual items – anvils, post drill, vises, etc.

True story "Forge Welding"

Whenever I get ready to forge weld I always remember Bill Davis telling me "Like they say, you can weld or you can whine. Its up to you." The other day I was doing a forge weld on a custom order grille. It was a challenging weld due to its location. After pulling the metal out of the fire the piece was brought to the anvil quickly scattering coke in the process. Usually any small pieces of coke just fall on the floor. Welllll on that day the coke did fall but one piece about the size of a golf ball landed on my shoe. If it were my work boots it would've been no problem and just rolled right off. Since I'd been out in the shop all afternoon, I decided another more comfortable pair of shoes would be better. My more comfortable shoes are an old pair kind of like docksiders that have a flat top and a lip around the toe area created by the stitching, it resembles a small dish. That particular piece of coke landed right on top of the toe area, to be more specific on my second toe knuckle, and stuck. I focused on the weld and begin hammering when my toe becomes very uncomfortable..Still focusing and with determination I ignored the burning sensation and made a few more hits. By now I was sure someone had lit a torch and laid it right on my foot. Displaying a sense of calm, I dropped my hammer on the floor and kicked the coke off my shoe. Whew that was hot! Wait...the burning didn't stop! Is my sock on fire!?! I pulled my shoe off and began rubbing my foot vigorously, (While holding my forge welded piece) and jumping around the anvil on one foot, kind of like one of those circus monkeys. I did have a witness to this bizarre spectacle, Forge Kitty, the cat who took up residence in my shop. She looked at me down her nose as if to say "Did you finish the weld?" I told her "Yes, I finished it! Thank you very much!" Some things are better experience in the shop and not in front of a crowd.

David Seigrist



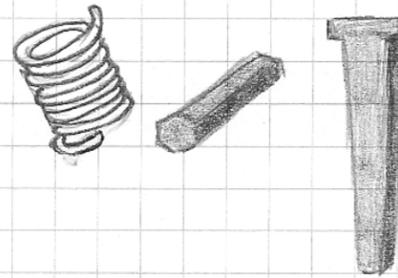
Sketch Book

By: Diana

Decorative Punches for Ironwork, silver and copper. As taught by Don Witzler at the John C. Campbell Folk School

Scrap Yard Material:

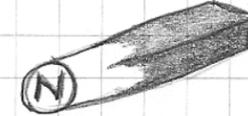
Coil springs
allen wrenches
square concrete nails
old puncher or chisels



* Heat coil spring and straighten. Flatten two side over the anvil. Cut to desired length.

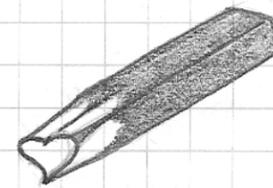
Heat to "non-magnetic" and allow to air cool.

old letter or number stamps



* Next, create your design using a dremel and or files. Heat about 1/2" of the design end until it reaches critical temp. (non-magnetic) quench in oil. A cooking oil is best because it has a high flash point. Keep the piece moving around in the oil until it turns black.

For small stamps to use in silver or copper, try the square concrete nails. Grind design and reharden and draw back to straw color.



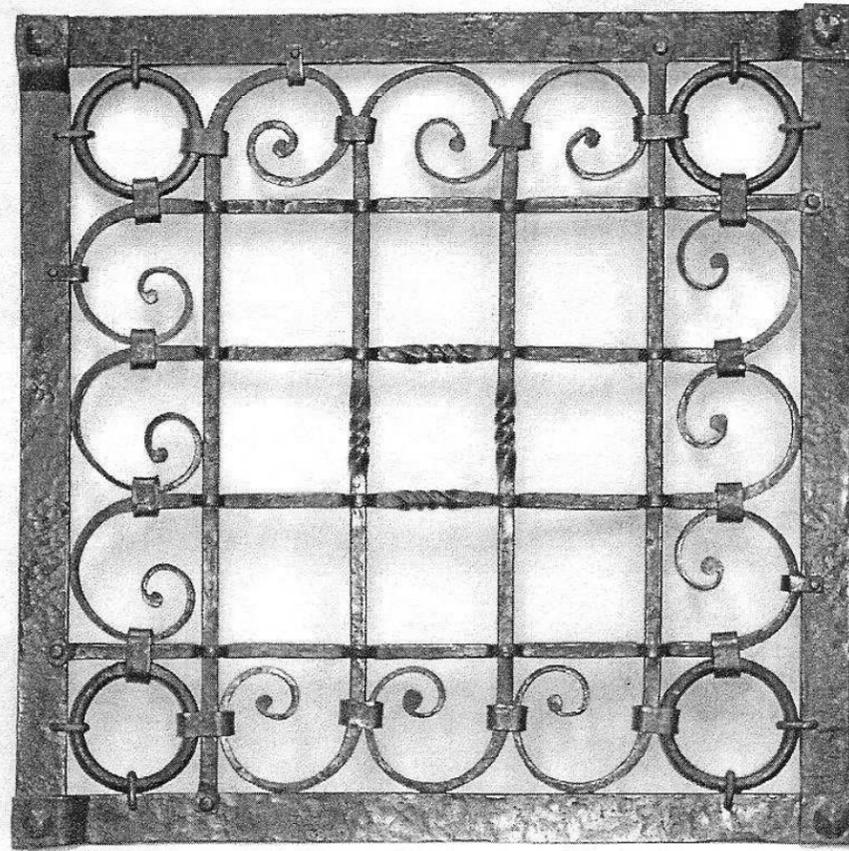
Important step:

* Buff end of stamp until shiny. Heat stamp approximately 1 to 1 1/2 inches down from tip. Watch color run into the tip area. Quench in water when color is a straw or gold color.

David Seigrist:

David, from Oklahoma, attended my class at the Campbell Folk School in January of 2007 and his project was to forge a copy of a portion of the grille that Francis Whitaker helped to build while working for Julius Schramm in Berlin. I met David at the Saltfork Oklahoma Conference in October of 2006. He was my assistant during the demo and decided he would like to come and take a class. He went to the Folk School with a scholarship from his Chapter and promised the Chapter he would donate his project at their Conference Auction in 2007. He completed the piece the week before the auction. Bidding started at \$200, and ended at \$1200 (two people bidding together at \$600 each). The two that purchased the piece then gave David the grille, donating the money to the chapter. A great piece of ironwork with a great story.

The 16 pass throughs in the piece are as precise as any I have seen. David worked and worked to get them to just slide together and that they did, with no forcing required. He was meticulous with the details and you will note a missing collar on his piece that is also missing on the original. A picture of the original grille can be found on the back cover of A Blacksmith's Craft, by George Dixon or there is a small picture in Francis Whitaker's original Blacksmiths Cookbook.



NORTH EAST REGIONAL MEETING DATES

- January 12, 2008
Host: Bill Kendall 918-691-2173
- February 9, 2008
Host: Gary Gloden Letter opener 918-321-5015
- March 8, 2008
Host: Dan Cowart 918-534-0299
Trade item something for the grill
Lunch:
- April 12, 2008
Host: Mark Coatney
Phone #: 918-476-6755
- May 10, 2008
Host: *State meeting*
Phone #:
- June 14, 2008
Host: Charlie McGee
Phone #:918-643-3299
Trade item: hat rack (wall or floor)
- July 12, 2008
Host: Dwayne Moss
Phone #:918-260-3267
- August 9, 2008
Host: Omar Reed
Phone# (918)478-4088
- Sept. 13, 2008
Host: Dan Cowart
Phone #:918-534-0299
Trade item is a tool to be added to the tool box
- October 11, 2008
Host:
Phone #:
- November 8, 2008
Host: Mike Sweany
Phone #: 918-245-8460
- December 13, 2008
Host:
Phone #:

NORTH WEST REGIONAL MEETING DATES

- January 26, 2008
Host: Ron Lehenbauer :(580)758-1126
Trade item: spoon
- February 23, 2008
Host: Ron Lehenbauer (580)758-1126
Trade item: fork
- March 22, 2008
Host: Bob Kennemer (tool for cooking on a grill)
Phone #: 580-225-3361
- April 26, 2008
Host: Mike George (pair of small Shelf brackets)
Phone #: 580-327-5235
- May 2008
Host: State meeting –No regional meetings
Phone #:
- June 28, 2008
Host: Charlie Todd
Phone #:580-242-0105
- July 26, 2008
Host: Ron Lehenbauer
Phone #: 580-758-1126
- August 23, 2008
Host:
Phone #:
- Sept. 27, 2008
Host:
Phone #:
- October 25, 2008
Host:
Phone#
- November 22, 2008
Host: Tom Nelson
Phone #: 580-862-7691
- December 27, 2008
Host:
Phone #:

SOUTH CENTRAL REGIONAL MEETING DATES

January 19, 2008
Host: JC Banks
Phone #(580)482-3209
Scroll jig workshop

February 16, 2008
Host: Gerald Franklin
Phone #: 580-467-8667
Scroll ends workshop

March 15, 2008
Host: Byron Donor
Phone #(405)650-7520

April 19, 2008
Host: Terry Jenkins
Phone #(580)485-2394

May 2008
Host: State meeting no regional meetings
Phone #:

June 21, 2008
Host: Larry Morefield
Phone #: 580-529-3081
Trade item: Punch or Chisel

July 19, 2008
Host: Max Scrudder
Phone #: 580-654-2229

August 16, 2008
Host: Richard Simpson
Phone #:

Sept. 20, 2008
Host: Dawnavan Crawford
Phone #: 405-520-3712

October 18, 2008
Host: : SCABA Conference Perry, Okla.
Phone #:1-405-344-7413

November 15, 2008
Host: Bill and Diana Davis
Phone #: 580-549-6824

December 20, 2008
Host: Aniela Hadich
Phone #:405-869-2043
Trade item: some kind of vessel

SOUTH EAST REGIONAL MEETING DATES

January 5, 2008
Host: Bois D'Arc Forge
Phone #:

February 2, 2008
Host:
Phone #:

March 1, 2008
Host: Gerald Franklin Durant Stockyards
Phone #: 580-467-8667

April 5, 2008
Host:
Phone #:

May 2008
Host: State meeting in Norman Ok
Phone #:May 10 ..Info in newsletter

June 7, 2008
Host:
Phone #:

July 5, 2008
Host:
Phone #:

August 2, 2008
Host:
Phone #:

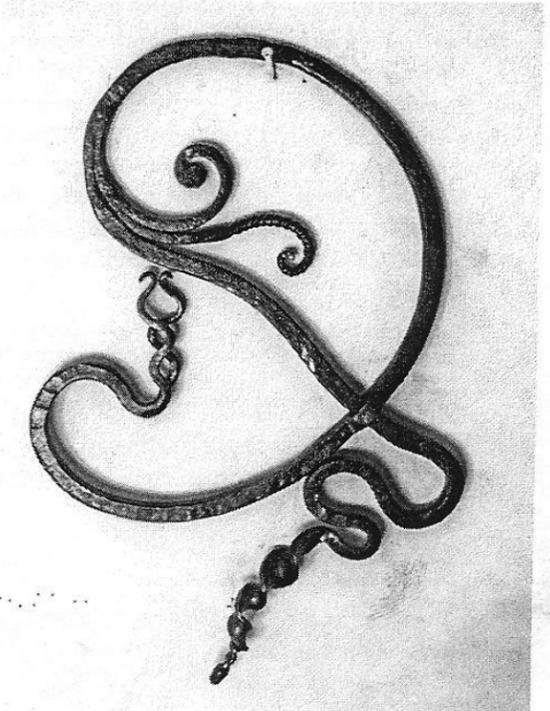
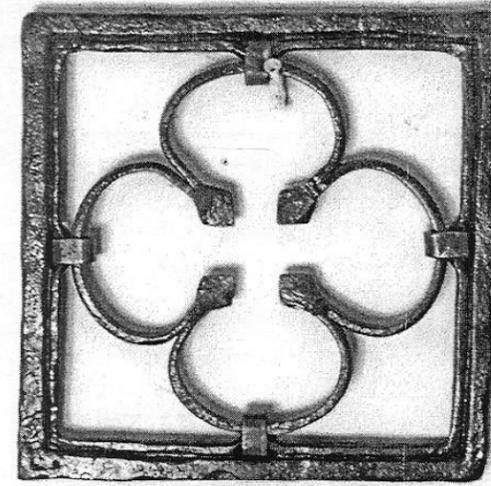
Sept. 6, 2008 (Being Planned)
Host: Omar Reed to be held at Ft. Washita)
Phone #: (918) 478-4088

October 4, 2008
Host:
Phone #:

November 1, 2008
Host:
Phone #:

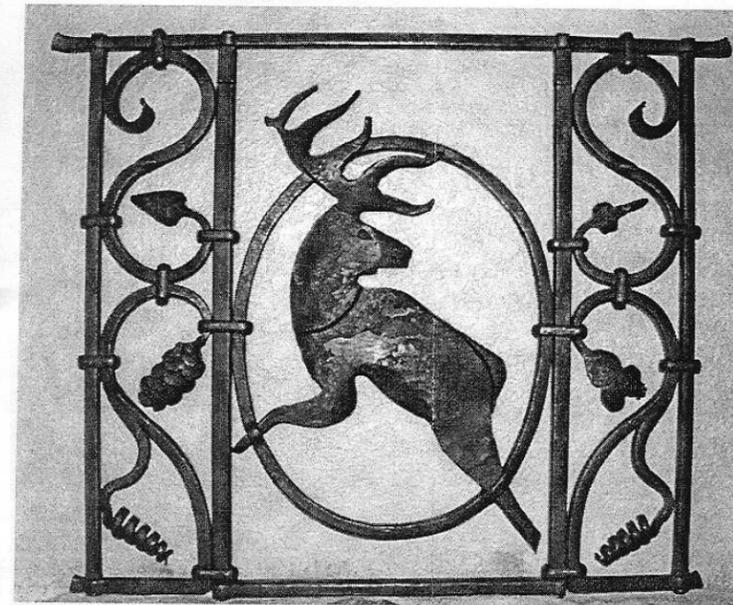
December 6, 2008
Host:
Phone #:

Philip Bowling:



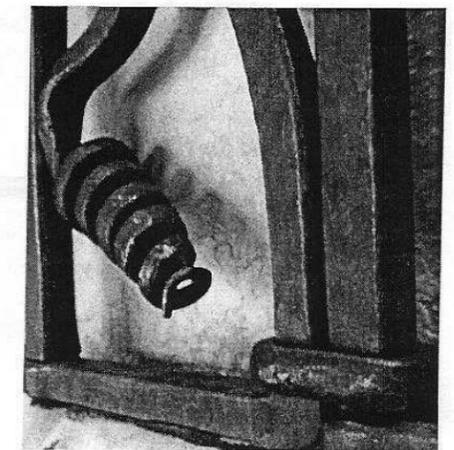
Philip Bowling from California forged a piece of wall art (right) using forge-welded branching scrolls and other techniques. His other piece (above) used 4 corner welds, a quatrefoil, with collars.

J. P. Jones:



JP Jones from Montana forged a beautiful grille with an elk as its centerpiece. The design, choice of stock sizes, joinery and execution all speak for themselves in this piece.

Detail below:



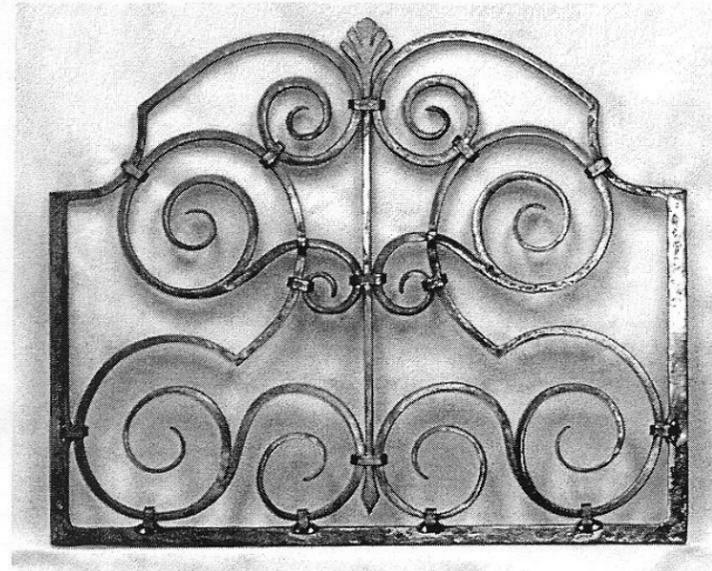
Tal Harris – Works Produced By His Pupils

By Tall Harris

Last August I had the privilege of teaching a master class at Francis Whitaker's shop in Carbondale, Colorado. It felt strange as I entered the shop, this being my first return to the school since Francis passed away. The school has done an excellent job of keeping the shop as it was, while continuing to use it as a classroom for blacksmithing students. Handwritten notes in Francis' writing remain on a blackboard with all tools in their proper places.

Four students attended the class, all with projects to work on.

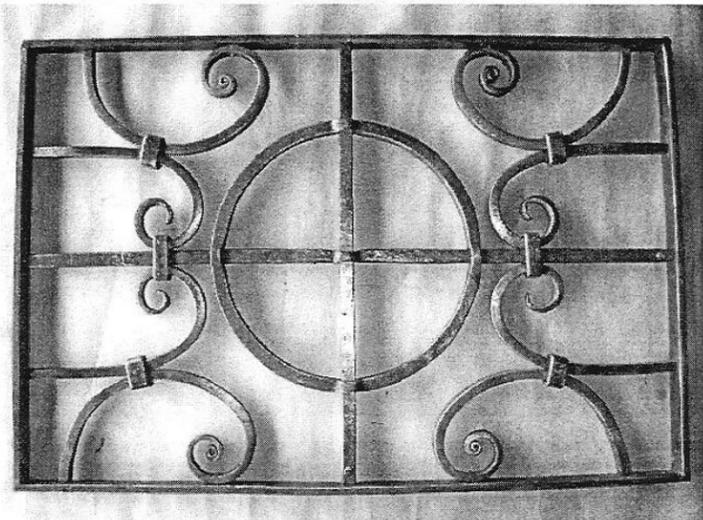
J D Banks:



To the left is a grille designed by **J C Banks**. JC learned quickly the benefits of test pieces and figuring out the sequence of events. His frame has 2 corner welds, plus 2 others in the middle of those concave curves at the top left and top right of his piece. The branching scrolls with the pass-through added a challenge, made a little more interesting as the stock is 3/8 inch square.

Gerald Franklin:

This grille was made by Gerald Franklin. Gerald and JC are friends and traveled together from Oklahoma. It is 16 x 24 inches. The digital camera made the piece look bowed, but it is very square and straight. The corners are assembled with dovetails, which were forged and filed to fit. The pass-through ring was also a good exercise.



Demo at the "Taste of the West" Chuck Wagon Cook-off

Gerald Franklin

I was asked to come to Healdton, OK on May 17th to demo for the Taste of the West Chuck wagon Cook-off. Boy, what a day. I got there about 7:30 AM to the smell of breakfast cooking over chuck wagon fires. All the wagons weren't cooking yet, just the one's detailed to cook for the "hired help", like me. After getting unloaded and set up, I had a bite to eat and then stole some fire from a chuck wagon. I was ready to face the day.

About 9AM the public began to arrive. I had a good steady crowd of folks around the forge literally all day. For some reason, hoof picks of any kind were hot items and I couldn't keep them on the sale table. When I shut the forge down (after 5PM) there were still some people there wanting hoof picks but I was "give out" and had to put them off. Next time, I'll go well armed with picks and won't sell a one if Murphy's Law holds.

This is a good place to demo. Lots of interest and pretty good sales. I'll stay in touch with these folks and see if we can get more smiths for their event next year.

Fourth Graders in Duncan

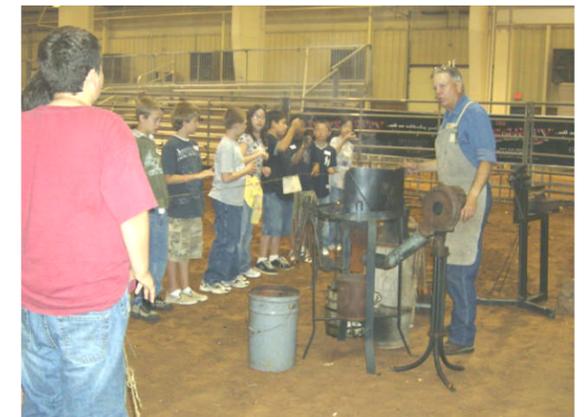
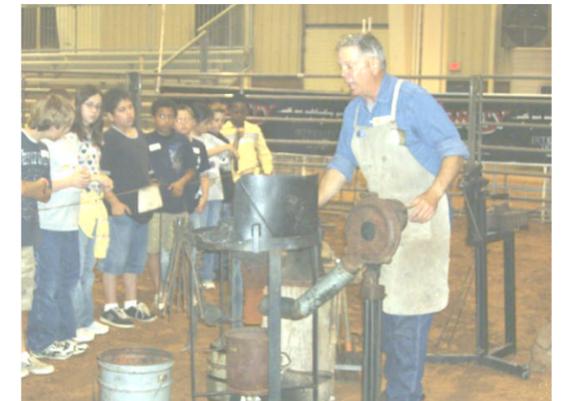
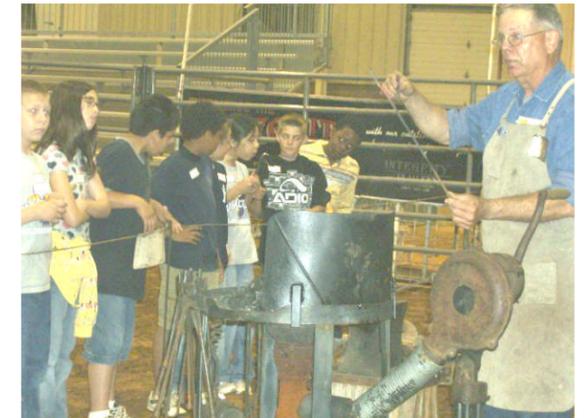
On May 7th, 2008, I did a demo for the Stephens County Natural Resources Conservation Service in Duncan, OK. They were hosting this event for all Fourth Grade classes in Duncan Public Schools. The event was originally set up to be held at the Halliburton Recreation Facility, but the (much-needed) wet weather drove us inside the Stephens County Fairgrounds buildings.

I don't know how many elementary schools there are in Duncan, and I for sure don't know how many 4th Grade classes there are, but I can tell you, there are about a ba-zillion kids in those classes. Including my smithing demo, there were fourteen exhibits set up. I didn't get to see all of them but the ones that I did see were pretty good. The most interesting one

that I saw was set up by some Halliburton chemists who were demonstrating some of the chemical aspects associated with cementing oil wells.

I demonstrated nail making for the most part even though I did make an S-Hook for one group. A school-kid demo is not complete without at least one S-Hook demo. This was a good event, well organized and well supervised. This was the first time that NRCS set up an event like this. I hope that they can continue to do it in the future.

Gerald Franklin



Workshop reports

Power hammer tooling workshop held at JC Banks.

Ten members traveled to JC Banks shop in Altus, Oklahoma to learn how to make tooling for us under a power hammer. Those attending were: Phil Shelton, Gerald Franklin, Jerry Cathey, Gary Seigrist, Bob Kennemer, Dawnavan Crawford, Richard Simpson, Don Gardner, Roy Tate and Charlie Grooms. It was a full day of forging, grinding and polishing, but everyone left with a full set of tooling along with a customized pair of tongs. Below is a picture of the raw stock that each student started with. The picture on the right is JC's set we were using as examples



JC had the tong blanks left over

from a POZ tong workshop and he had worked out a method of modification that would allow them to hold the tooling that we were to make. He had also created a forming die for his new air hammer that formed the groove in the tool where the tongs gripped.



Picture on left shows the forming of the groove using the air hammer. Picture on the right shows the modification of the poz tongs.



A second modification to the tong was the forming of a locking clip on one rein that allowed you to lock the tongs on to a tool.



Using a belt sander to start rough shaping each tool.



This is a finished set of Tooling. It is a combination of Bill's set and the set that the students at the workshop started for the editor (Diana). Bill also made a touch mark for both sets. These workshop are to help you get the basic skills to get started the rest is up to your needs and imagination.

New Forge by Tommy Dean

I just finished restoring me a new forge. On the side of the blower notice the patent date of April 6 1886! I was able to find the Patent on the internet with drawings and description of how it works. It shows the patent date of Aug 10, 1887.. I'm wondering if mine is the prototype...Built my first fire in it Sat. and was amazed at how fast it gets the metal hot. I will be using it for the demo next Sat., ought to fit in real well with all the Chuck Wagons..



Update on Tom Clark:

Tom Clark has been dealing with some pretty serious health issues. Last word (according to post on the internet) is that he is home and feeling good enough to go down to the forge shop, especially if he hears one of the air hammers working.

Workshops: David Seigrist has been doing an outstanding job researching and organizing the workshops that we have enjoyed attending so far this year. He has been working on some more advanced workshops for later this year. If you have an idea for a workshop or would like to have one in your area, contact David and let him know. Workshops are usually limited to 10 students. Anyone that sends in the workshop survey requesting a workshop is contacted first.

New look for newsletter....By now everyone has received their May newsletter. Hopefully you notices that the pictures were clearer and sharper. There were also holes for placing your newsletter in a three-ring binder. These improvements are thanks to Tony Cable. Tony works at HSC printing Services which is a part of OU Health Science Services. Tony has been able to help me improve the quality of the newsletter without any increase in printing cost. These improvements are due to Tony's ability to print directly from a computer file. This gives us first generation copies. These are the clearest ones possible. Every time you make a copy of something you loose quality. I hope you enjoy the newsletters and if anyone has any ideas of how we can make further improvements let me know. Other than color pictures. I don't think we can afford to pay \$5.00 per copy to get color.

Thank you Tony Cable for all your help on the newsletter..Diana

Historic Metalsmithing at MGP

On May 24, I went to the Museum of the Great Plains in Lawton to speak to the Greater Southwest Chapter of the Oklahoma Anthropological Society on "Historic Metalsmithing". These are the folks who go out and dig at archaeological sites around the state. I felt like I was asked to talk about basket weaving to a group of Navajo's but it turned out that I was actually able to give them some new information that may help them in their digging activities.

I started the talk with a very short discussion of the different "ages" (stone, bronze, etc.) that historians use to classify and date artifacts. I quickly moved on to talking about metals and the alloys that people used in the past and still use today. I concentrated on bronze and iron, but we also talked about copper, brass, and steel. I had a collection of samples of copper, brass, bronze, wrought iron and mild steel that I passed around so that they could test the relative hardness with a file. I wrapped up the inside portion with a short run-down of iron and steel making and how the term "blacksmith" came about.

We wrapped the session up by going out to the museum's blacksmith shop where the staff had a good fire going in the forge. I forged a few things while I talked about the impact that blacksmithing had on the technical and social quality of life of early settlers. I even fixed a couple of trammels for the museum's trading post that were in need of repair. This wasn't a typical demo for me as usually I'm talking to a group of school kids or the general public and typical questions deal with getting burned and getting coal. These folks actually asked good questions and were interested in more than just seeing hot iron come out of the forge. It was a really enjoyable talk/demo for me. Hopefully the OAS folks got something out of it, too.

Gerald Franklin



Touchmark workshop

A touchmark workshop was hosted by Bill and Diana Davis at their home near RushSprings Oklahoma. There were three members that attended this workshop. They were Larry Morefield, Lanny Powers and James Wolf. A touchmark is a punch that has a design formed on the business end. This design could be your mark that you wish to put on your artwork or it could be a design used at a decorative marking on ironwork.



The instructions were in last month newsletter.

Larry is using a belt sander to form a flat area on the end of the rod.



You use files, stamps and dremels to create the design. Here a dremel is being used with a small drill bit to form o's for the word LOBO. After each step in order to see who the stamp would look it was stamped into soft lead. This protected the work until it could be heat treated depending on the type of metal used.



We had a good lunch of pulled pork sandwiches. After lunch they got back to work and each left with two or three stamps.

After everyone left we had another member from Burlington Maine stop by to visit while he was in Oklahoma. Dan Reed, whose son lives in Oklahoma City and was in town for his grandson's graduation decided he needed to get out to see some of the sights so called to get directions to our shop. He arrived around 6:30 and stayed until after 8:00P.M. He watched Bill make a man from a RR Spike. Bill gave him the man to take back to Maine with him. He renewed his membership and we are glad that he included a trip to our shop in his busy vacation schedule and we hope that the next time he comes to Oklahoma he can pick a weekend when there is a meeting going on so we can invite him to visit with more SCABA members. We also gave him a map with directions to Medicine Park as another place he might like to take his family while he was here. A Grandson was needing to take pictures of his trip to Okla. for a school project so we thought he could get some of the Oklahoma wildlife.



.Anvil repair

Gerald Franklin is in charge of the teaching trailer and after bringing it to his shop each of Duncan he decided to try to work on some of the equipment to improve them. The teaching trailer



has four anvils that the club purchased for the trailers inventory. There had not been any repair done to these anvils. They were in nice shape but could use the edges repaired. After Gerald Talked to Bill Davis it was decided that Bill would bring two of the anvils out to his shop and do the repairs.

Here Bill is using a weed burner to heat up the anvils so he can weld up the edges. You can see where he has already been welding on the anvils. This is hot work. After they are welded and allowed to cool the tops will be ground smooth.



Later the other two anvils will be brought out and the process will be repeated.

There was another anvil that Bill repaired this month. After leaving the BAM conference we did a little antique shopping and came across a anvil that had been broke in half and bolted together. Bill purchased the anvil and started the repair. He cut the bolt and I took pictures of the result. It fell in two pieces.



He marked how far to grind back for the bevel needed to get a good weld job.



After a lot of welding, grinding, welding, grinding..... He got the anvil repaired. He then used some bleach and peroxide to even out the rust look. CAUTION do not breath the fumes of this mixture;

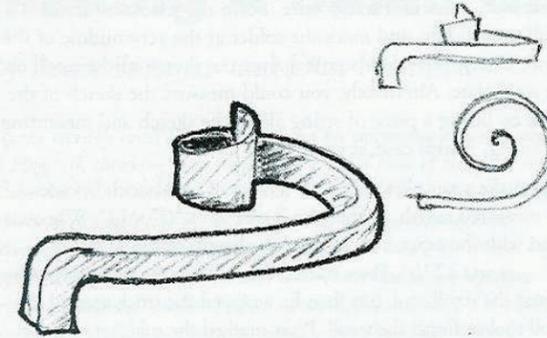


Figure 5—The Scroll Tool

S-scrolls. Next, he tested the four scrolls in the frame. Make sure the scrolls are all touching in the same horizontal and vertical points... this is where the collars will secure them.

Anneal the collar material. This is only necessary if using cold-rolled steel. It's best done ahead of time so that it can be cooled and soft by now.

Next Peter made the collars. Two collar sizes were needed, and a mandrel was needed to form each size of collar. Peter made the smaller mandrel by folding about 3" of the end of a 3/16" x 3/4" bar. The larger mandrel was formed from the same stock, but folded again. (Figure 6)

Peter calculated the length of stock needed for the collars using the following formula:

$$2 \times W + 2 \times T + 2 \times C + \frac{1}{16}''$$

where W=width of the pieces (3/4")
 T=total thickness of the pieces
 C=thickness of the collar stock (1/16")

This gave 3 1/16" and 2 1/16" for the larger and smaller collars, respectively. Peter started the collars in the tool shown in Figure 6. This is a simple jig that he used in a vise to start the collars.

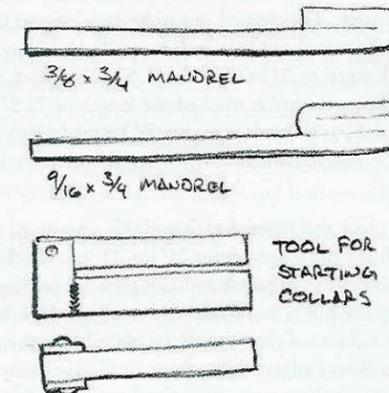


Figure 6—Collar Tools

He placed the annealed collar stock crosswise in the tool, then clamped the tool and stock in the vise and hammered down one side, cold. He then reversed the tool and hammered down the other side.

After heating each half-formed collar to red, he placed it at the step of the anvil, slipped it into the mandrel and hammered down one side. He then turned it 90 degrees and hammered down the second side, rotating the collar as needed as he did so. He then closed up and squared off the collar by hammering on three sides (Figure 7). Before the collar could cool on the mandrel, Peter placed the collar over the edge of the anvil and hammered the mandrel out of the collar.

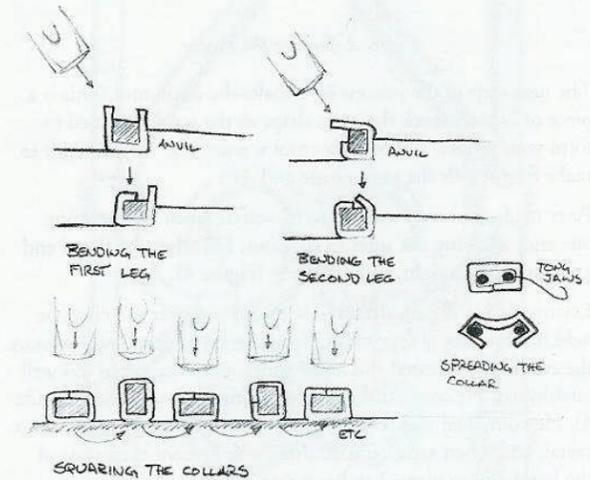


Figure 7—Forming the Collars

After making twelve large and six small collars, Peter was ready to assemble the grille. For this he used three tools: a pair of tongs, a pair of Channel Lock pliers, and a pair of "large-jaw locking pliers" which he highly recommended. Peter reheated the collar to red and spread it with tongs. He then took the hot collar in the Channel Lock pliers and closed it over the pieces to be joined. With the Vise Grips he clamped down on the collar, first from the front and back of the screen and then from the sides. Tightly clamp the collar and pour cold water on it. This combination of clamping and rapid cooling will tightly secure the collar.

Some of you may feel that this is an excessively laborious process that could be greatly speeded. In the long run, however, you will find the job will be done sooner if you do it by the numbers. It can take an incredibly-long time to fix up a forging that was not done correctly.

Peter Sevin lives in Phoenix, AZ, and has been a full time smith since about 1975. His mentor was Jesse Hawley who, though not a practicing smith, is still alive at 91.

ARCHITECTURAL BLACKSMITHING

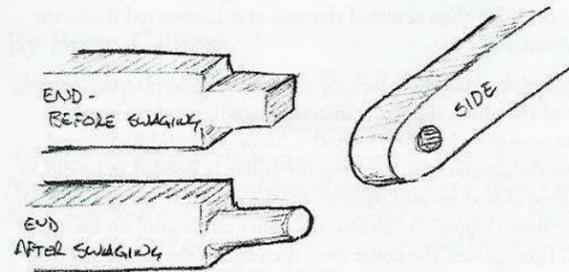


Figure 2—Joining the Frame

The next step in the process is to make the scroll tool. This is a piece of heavier stock the same shape as the scroll. It's used to form your scrolls. Without this tool it would be very difficult to make four scrolls the same shape and size.

Peter made the scroll tool from $\frac{3}{8}$ " square stock by flattening one end, allowing the sides to flare out. He offset the flared end and cut it off straight, using a hardy (Figure 4).

Laying the bar flat on the anvil with the end over the edge, he held his hammer almost vertically and stroked downward to start the curve. He repeated this a few times, until the curve was well established. He continued the scroll using back-up blows (Figure 4). He compared the developing scroll to the sketch on the sheet metal, and when satisfied with the scroll, he bent the excess of the bar down to give a handle to grip in the vise.

(Peter recommends the use of gloves while forging. Otherwise you end up constantly washing your hands as you bounce between different demands. This can dry your hands to the extent that you may end up with serious skin problems.)

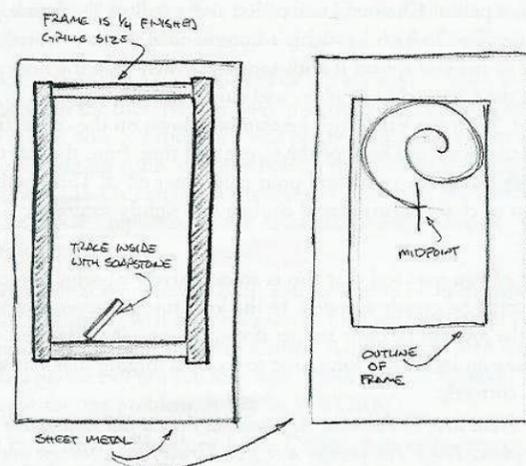


Figure 3—Scroll Layout

Measure the scroll requirements by using some easily pliable material... Peter uses solder wire. Form the wire around the scroll tool tightly, and mark the solder at the very middle of the scroll. Check the solder scroll against the sketch of the scroll on the steel plate. Alternately, you could measure the sketch of the scroll by laying a piece of string along the sketch and measuring the string. In this case, it came to $11 \frac{3}{4}$ ".

Now make a sample scroll. Take a piece of scroll stock in excess of the measured length, in this case it was $\frac{3}{8}$ " x $\frac{3}{4}$ " x 12". When satisfied with the taper, he measured the length of the drawn-out bar... it was $12 \frac{3}{4}$ ". Peter started the scroll in the same way as he started the scroll tool, but then he wrapped the stock around the scroll tool to finish the scroll. Peter marked the midpoint on the sample scroll, then transferred this mark to the scroll tool.

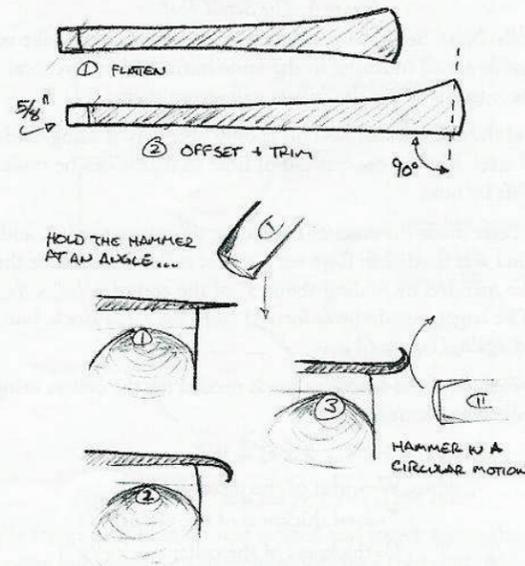


Figure 4—Starting the Scroll

He then measured the excess stock on the test piece... in other words, the part of the scroll which extended beyond the midpoint on the sketch. This turned out to be $1 \frac{1}{2}$ ". From these measurements he calculated that each S-scroll would require a length of stock equal to 21" ($12 \times 2 - 1.5 \times 2$), which would have to be drawn out until it reached the length of 22.5" ($12.75 \times 2 - 1.5 \times 2$). Each piece would be made into an S-scroll, using the midpoint mark on the scroll tool as a guide when to stop.

Peter cut one piece and tapered each end. He continued drawing these out until the piece grew from 21" to $22 \frac{1}{2}$ ". He then started each scroll as in Figure 4 and completed it on the scroll tool. Reversing the piece, he formed the scroll on the other end. To test the overall size of the S-scroll, he placed it in the measuring jig (Figure 3) and adjusted the shape until it fit easily but snugly. He then cut three more pieces and made the remaining

SouthEast Saltfork Craftsmen..demonstrated on May 3rd at the annual Roxton Hawg Waller Festival. Members present were Brazos and Melvin White, Gary ;and Ann Butler, and Howard Bost. There was a good turn out with a lot of interest, we all had our wares out for display. Several newspapers came and took our pictures for their paper. A good time was had by all. We hope to do it again next year.

Melvin White

Too Late to Classify:

Complete blacksmith line-shaft. Good Running Condition with post drill, pedestal grinder/wire wheel and 40 lb Perfect Power Hammer, Lots of extras, Call for info. 817-329-5299 Jim White 115 Depot St. Mansfield Tx. 76063

Upcoming Picnic

If you couldn't attend the club picnic in May then you have a second chance to meet a lot of members that you may not have seen in a while. On **July 26th**, the **North West Region** will be the location of another get together. Ron Lehenbauer will be the main host for this event but there will be a lot of other members helping him put on this event. It will be held at the **Pavilion at Salt Plains Reservoir** just off River Road below the Dam. (Same location as last years SaltPlains Picnic) There will be plenty of burgers to partake of but bring a side dish and a lawn chair. Everything gets started at 10:00 A.M. Bring your forges and come enjoy the day. It will also be a day to remember one of our members that has been called home. Ruth Burns passed away last month. Ruth, along with husband John were among the founding members of this club. It is only right for us to spend a day sharing memories of her and all the influence she had on all of us during her life.

ABANA?

If you look in any magazine or publication you will see the monogram A. B. A. N. A. which stands for Artist Blacksmith Association of North America. What is ABANA you might ask. Maybe to understand what something is you need to know a little of its history.

Alex Bealer (author of "The Art of Blacksmithing) and the Westville restoration village in Lumpkin, George hosted a Blacksmithing Convention back in March of 1973. There were approximately 47 people in attendance. After the event that first night about eight people were sitting around discussing how good it was to share the knowledge of blacksmithing. That night, one of those present by the name of Dimitri Gerakaris, after returning to his room couldn't sleep. He kept thinking about a notion of a loose-knit organization for those interested in blacksmithing. The purpose of the organization would be the exchange of information. He made notes in his notebook and the next day during the lunch, Alex allowed Dimitri to read his proposal. Dimitri Gerakaris read his thoughts about what a blacksmith was and the mission statement for an organization wishing to promote blacksmithing. The first response from a Mr. G. A. Long from Georgia. Mr. Long was in his 70's and had been a blacksmith for a long time and was thrilled that there a new generation that was interested in learning and caring on the craft. He reached into his pocket and pulled out some money and requested to be the first to join the organization. From that first member the club has grown through the years to have over 5000 members both in the United States but other countries around the globe.

ABANA is a non-profit organization directed by a board of 15 members who serve voluntarily as officers and on committees. It continues to grow steadily with about 300-400 additional members each year. Schools and workshops around the world that offer blacksmithing classes are increasing in number as well. ABANA affiliates are springing up all over the US with a list of over 50 groups currently chartered with ABANA. Saltfork Craftsmen ABA is just one of these affiliate groups.

ABANA organizes a conference every two years (except 08 when it had to be cancelled due to funding) with their next one in the planning stages for 2010. They also put out two different publication (The Anvils Ring and The Hammers Blow) filled with information that all skill levels can benefit from. ABANA also has scholarship that can be applied for from ABANA to help members attend schools and workshops.

All this information and much much more can be view on their official web site. You can also find information about how to join ABANA. Remember you only get as much out of an organization as you are willing to put into it. Check out the ABANA site at <http://www.abana.org>

Employment opportunity:

Small ornamental metal fabrication shop in Tulsa serving the high end residential market. Position requires layout, cutting, welding and finishing of ornamental metal. Organizing installation of the finished product is a large part of this position. Experienced metal craftsmen is preferred. Will consider a general metal worker or person with carpentry skills who is willing to learn. Desire a skilled metal craftsman who will make a positive impression on customers. Must have a passion for ornamental iron work.

Hours are generally Monday-Thursday (40 hours) and occasionally Friday overtime. Please reply with your qualifications.

Compensation; \$14.00—\$18.00 per hour depending upon experience.

Contact: Jason Axtell

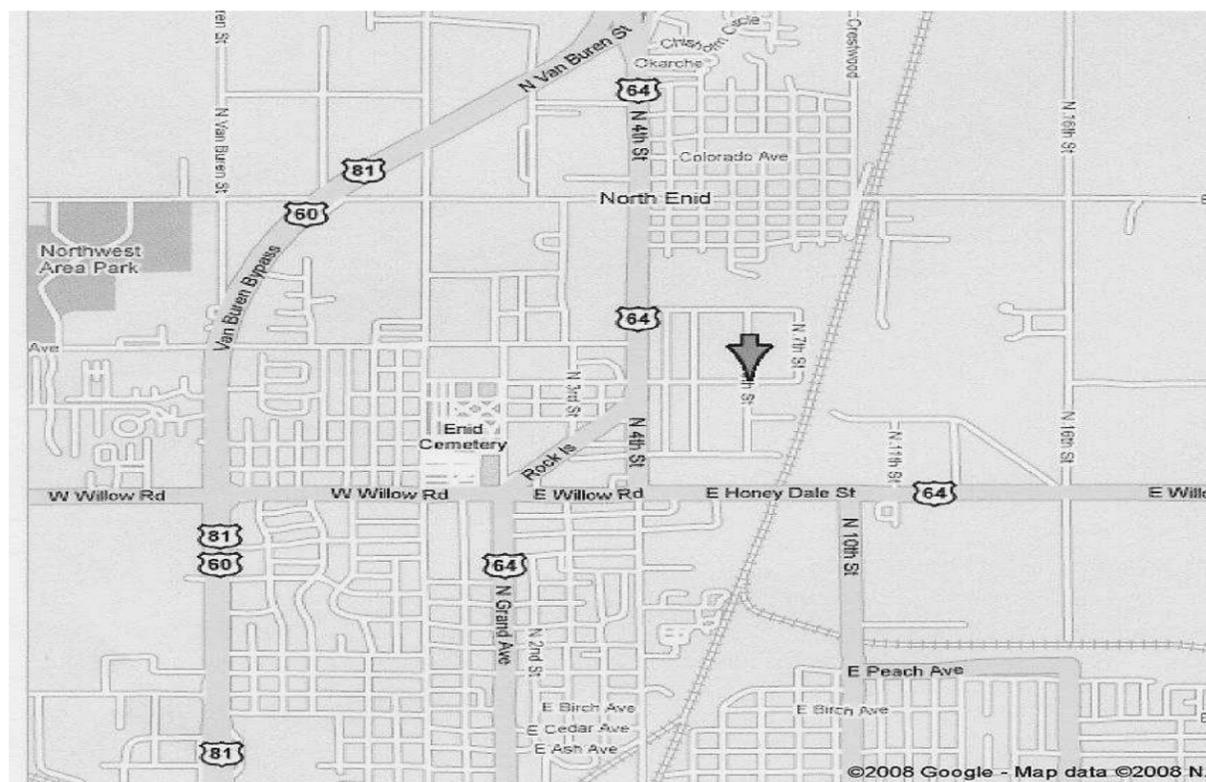
Iron Décor

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Tulsa, Ok 74120

(918) 584-2080

Map to Charlie Todd's home and shop located at 701 E. Cornell in Enid Ok.



Directions to Charlie McGee's place....take either East or West Hwy 412 to Sand Springs, Ok. Exit 129th, follow the main road which will turn into 97 Hwy, about 10 miles to the John Zink ranch. Hwy 97 ends at this point, turn west and go two and one quarter mile. 4th house on right....Look for anvils.

Ray Kirk sent me an email with some information about their annual knife show. It will be held in Oklahoma City on Sept 20-21 2008 and will be at the Holiday Inn at 2101 S. Meridian. Ray will be sending more information as the date gets nearer. Mark your calendars....

Diana

Making A Small Grille

By Bruce Freeman and Don Plummer

I spoke recently with Peter Sevin about his upcoming demonstration at Flagstaff, thinking folks might like a small taste of things to come at the ABANA conference in July of this year. Peter's demonstration will be very much like the one he gave at the Early American Wrought Iron Conference in Dover, Delaware in 1998. Bruce Freeman and Don Plummer were both there and wrote separate articles. Since each author picked up on different things, I thought a combination of the two articles would cover Peter's upcoming demonstration pretty well.

Note—Portions of this article originally appeared in the New Jersey Blacksmith's Assn., the Furnace Town and the Mid-Atlantic Smiths Assn. newsletters and are used with permission—Editor

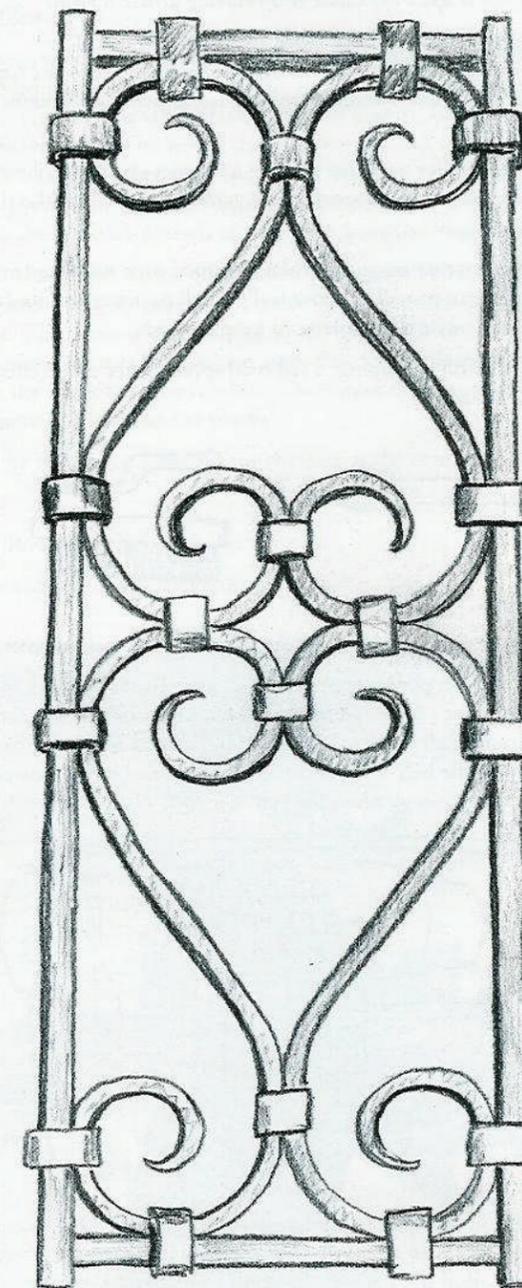
Peter Sevin's demonstration at the Early American Wrought Iron Conference was great... one of the finest I've seen in quite some time. I'll tell you what I liked best about it... it was done by the numbers. By that I mean Peter stepped carefully through a sequence of events that took us to a finished product. That's half the secret of successful blacksmithing; do this in step one, that in step two, etc. Make sure each step is correctly done before you move on to the next

To start, build the frame. Peter had pre-cut the $\frac{3}{8}$ " x $\frac{3}{4}$ " stock to length, rounded and drilled the ends of the side pieces, and hacksawed the ends of the end-pieces as a start for the tenons (Figure 2). He completed the tenons by rounding in a spring swage and squaring up the shoulders with a monkey tool (see "Tenons, Monkey Tools & Clappers" in this issue—Editor). He assembled the frame by heading over the tenons to join ends to sides. Make sure the frame is perfectly square. Check it with a square and tap it into shape as necessary.

(For a slack tub, Peter has found a large plastic barrel. He put gravel in the bottom and added a metal rim around the top... best tub he's ever had.)

Next, Peter used a measuring jig or spacer form made of $\frac{3}{4}$ " square tubing, sized to exactly fit one scroll. In this grille there will be four scrolls of the same size. This process is greatly eased and accuracy assured by having a frame in which you can test-fit and tweak each scroll before you try to fit it in the finished frame. Measure the dimensions of each quadrant (just divide the inside of the frame in half vertically and horizontally).

Trace the quadrant space onto a piece of sheet steel. Peter removed the frame, found the midpoint of the traced rectangle, and sketched the scroll. Peter prefers to draw his freehand... he has a sense of proportion that lends a wonderful quality to his work. You could also use design aids, such as french curves or S-curves, or you could use a computer-generated layout. You'll only have to draw one scroll, since the other end is a duplicate facing the other way (Figure 3).



The Completed Grille—finished size 18" x 6"