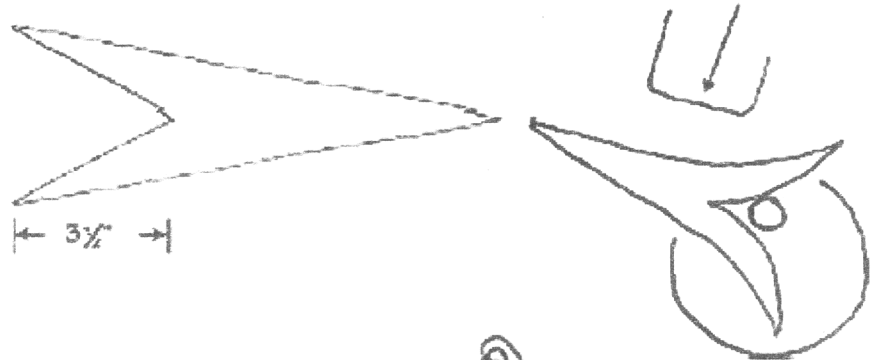
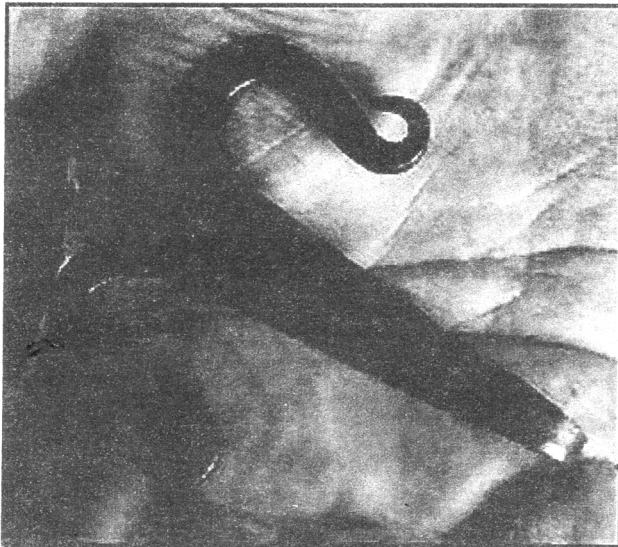


## Bornholm Belt Buckle

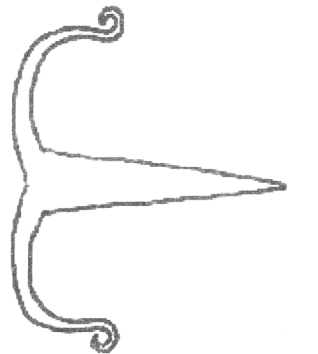
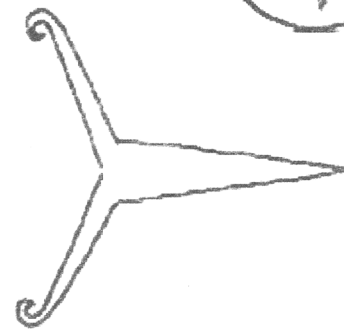
8. Fork the two tongues out into a nice, symmetrical Y. Open the angle by pushing it onto the horn and hammering just behind the horn.



9. Make tiny scrolls on the end, curling toward the center.  
10. Scroll the tongues outward 180°, making them match.  
Cool the small scrolls before making the larger bends.  
11. To fit your belly, put a gentle bend into the buckle.  
12. Scroll the tip to form a hook for the belt holes.  
Inside diameter of the hook should be about 1/4" to 3/8".  
You should have 180° of turn, or the buckle won't hold. ♦



*Successful student work at the 2012 workshop.*



# Channeling Blacksmiths of One Thousand Years Ago

*An interview with Beth Holmberg, April 27, 2014*

*Where does this story start?*

We were in Odense, Denmark, working on a reproduction of the Ladby (pronounced *led-bu*) ship. The Ladby ship is the one and only **buried** Viking ship in Denmark.

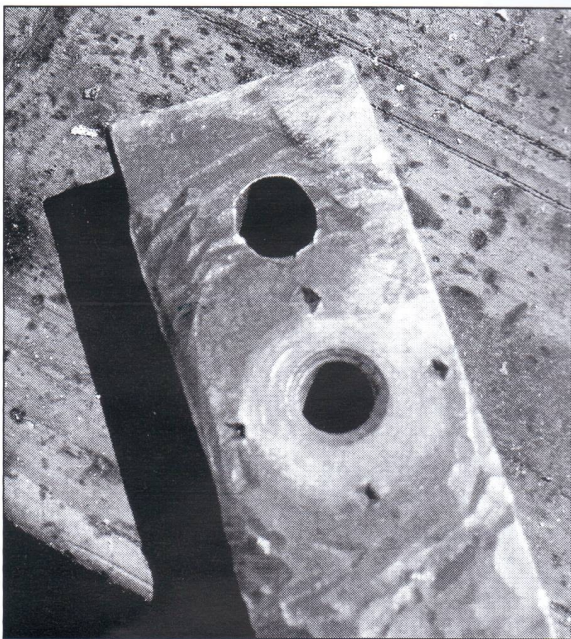
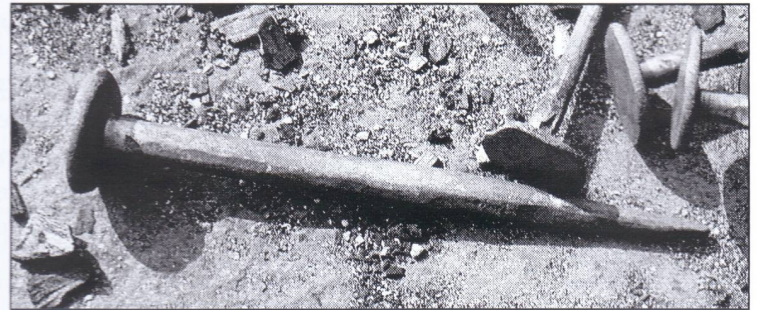
*Buried?*

Yes. This was a ceremonial Viking burial ship, dating back to the 9th or 10th century. They have found others that were sunk, but this is the only Viking ship buried in Denmark. It was a ceremonial burial where seven horses were slaughtered on it, a bunch of hunting dogs, game, hunting arrows – all the equipment this guy needed to have a great time in Valhalla. It was a 22-meter ship.

*So what were you doing?*

We were forging the nails that would hold this ship together. We were working under a master shipwright from Roskilde where they do the big Viking ship reconstructions. Their work is incredibly historically correct.

We had been sent specs from the archeologists and shipwrights saying this is what the nails have to be like: 8mm shaft, 50mm long, with heads so many mm across, round shanks.



photos by Beth Holmberg

So, we took our nail header and put four center punch marks at the right distance out from the center so that we would know when we had our head the right size.

We started making our nails. We had a few made when the master shipwright came from Roskilde to visit for his first visit. We're very nervous. He's like a rock star, only goes by one name: Hanus.

Hanus looks at our nails, while we're very nervous.

Then he says, "Those are great nails." Next, he looks at our nail header and at the bottom of our nail heads where there was a little bit of a ding where the nail head had run into the positive side of the header sticking up from those punch marks.



## Channeling Blacksmiths

"These are perfect!" He says, "These are archeologically correct. We have found that the old nails have four marks on the underside where they ran into something on the nail header. This is exactly what you've produced.

"In fact, when we find these sunken ships, we discover these headers clinched down tight and wood has that impression on it. The wood is compressed under the nail head and has four little positive bumps where the wood has come out into the nicks on the nail head, from the marks on the nail header."

Thus, we were channeling guys from a thousand years ago!

*Did these leave an impression in the wood?*  
Sometimes only the wood gets preserved, and sometimes only the nail gets preserved. These marks have been seen on both the nails and the wood.

*How were these used?*

Because the ship would be subject to forces over a long time, the nails were often clinched into a backing plate, much like a rivet. The round shank and tight clinching were important because the wood was so thin and flexible. The hull was made of oak boards only  $\frac{3}{4}$ " thick. As the ship goes over the waves, the whole thing flexes and bends. The round shanks let the wood twist without splitting, and the clinching plates kept it tight together. This photograph shows recovered Viking ship nails that have been clinched. ♣





# Herb Chopper

Bob Ehrenberger

When I had one of my regular customers request that I make her an herb chopper, I went back to an old copy of BAM (Jan-Feb 99) and found an article on it by Jim McCarty. Along with the article, Jim included some templates from Doug Merkel (found on the next page). Well Doug's templates required cutting a blank using a plasma or Oxy/Act torch, neither of which I have. Cutting the blank with a chisel or hot cut looked like way too much work. So I came up with my own method.

I start with a flat bar 3/16" x 2" and butcher down 1 1/2" from the end.

I take the butcher down until 5/8" or so is left.

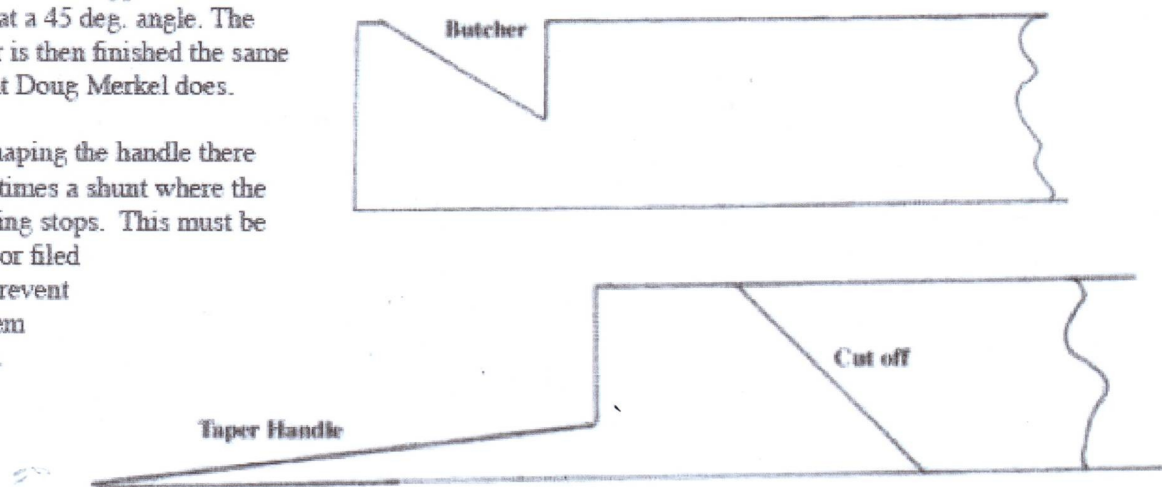
I then draw out the butchered section until it is about 8" long. This will be formed into a handle later.

I then cut the chopper loose from the bar at a 45 deg. angle. The chopper is then finished the same way that Doug Merkel does.

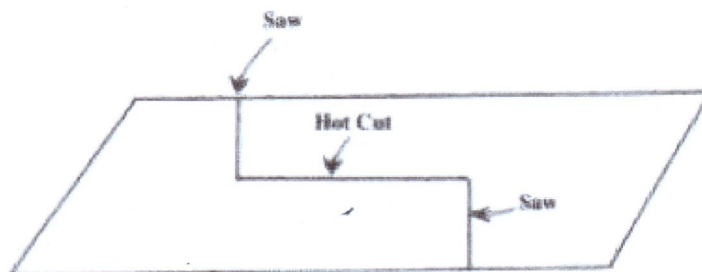
After shaping the handle there is sometimes a shunt where the butchering stops. This must be ground or filed out to prevent a problem later on.



My Finished Herb Chopper



A while later I came across an article written by Doug Hendrickson. Doug had a little different approach to making his blank. He cuts a bar at a 45 deg. on both ends and then saws half way through in two places. He then separates the two blanks using a hot cut. Once the blanks are separated he tapers the handles and finishes them pretty much the same as Doug Merkel and I do.





## Christmas Tree

By Steve Anderson, a MABA member

Stock-

Large Tree: 1/4" round x 60"

Small Tree: 1/4" round x 40"

Taper down leaving 3/4" on end.



Place in vise and upset the end to about 3/8".



Bend the upset end to 90°, then wind 1/4" round stock into a tight coil, stopping about 4" from the end.

Heat the entire coil to uniform orange and clamp the end in a vise while supporting opposite side of the largest coil with tongs. Pull upwards on the center with a vise grips. As the first coil separates, use the tongs and a flat bit screw driver to support top of the coil as the next one pulls up. Continue to support, moving up as each coil separates. When the rings do not readily separate, use a flat bit screw driver to coax them apart.

Taper the last 3" of the tail end to a two sided taper.

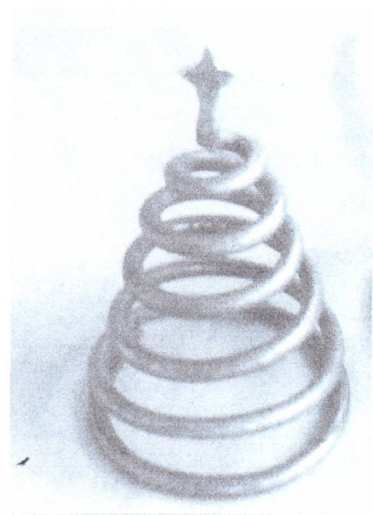


Then complete the last coil on the anvil horn.

Heat and flatten upset center to thin.

When it's cool, adjust the coils to form a symmetrical cone and file a star, cross or other ornament at the top.

Brass brush is optional and finish with wax, clear coat or paint.





## SCABA Shop and Swap

### For Sale:

6" round nosed pliers (great for putting scrolls on small items) \$5.00 each.

Brooms tied, \$20.00 on your handle Please contact me for help with handle length.

Contact Diana Davis at [Diana.copperrose@gmail.com](mailto:Diana.copperrose@gmail.com)

### For Sale:

24"(wide) x 1"(thick) Ceramic fiber blanket (similar to Kao-wool) \$1.00 per inch of length. Twisted solid cable 1/2" diameter \$2.00 per ft.

Contact Larry Roderick at 940-237-2814

### Wanted:

Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or [Mike-Marideth@sbcglobal.net](mailto:Mike-Marideth@sbcglobal.net)

## Club Coal

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

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

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

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

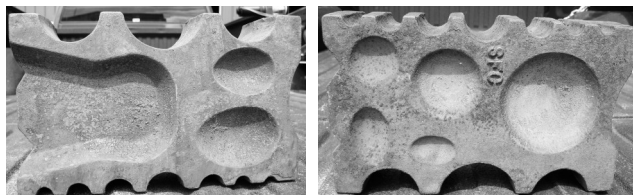
**S/C region coal location:** Club coal is now available at Norman at Byron Donor's place. Call Byron to make arrangements to come by and get coal.

SCABA swage blocks

\$110.00 plus shipping to members. (1st block)

\$130.00 plus shipping to non-members

Contact Bill Kendall for more information



SCABA Floor Cones are now available from Bill Kendall, Byron Donor and Gerald Franklin. The price is \$200 plus shipping and handling.



**Show your pride in SCABA**

**License plates for \$5.00 each.**

**We have a few caps for \$10.00.**

**We have SCABA t-shirts available. They are a grey pocket "T" with the SCABA logo on the pocket. Contact Diana Davis for information. The t-shirts cost \$15.00 each. Free shipping is you buy 2 or more. Add 2.00 for shipping of only one shirt.**



## SCABA Membership Application

January 1, 2015 to March 31, 2016

New Member \_\_\_\_\_

Membership Renewal \_\_\_\_\_

**Please accept my application**

Date: \_\_\_\_\_

First Name \_\_\_\_\_ Last Name \_\_\_\_\_

Married? \_\_\_\_ Yes \_\_\_\_ No Spouses Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

Home Phone (\_\_\_\_) \_\_\_\_\_ Work Phone (\_\_\_\_) \_\_\_\_\_

E-mail \_\_\_\_\_ ABANA Member? \_\_\_\_ Yes \_\_\_\_ No

I have enclosed \$20.00 for dues for the period ending March 31, 2016

Signed: \_\_\_\_\_

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

### Saltfork Craftsman Regional Meeting Hosting Form

Region \_\_\_\_ SE \_\_\_\_ NE \_\_\_\_ S/C \_\_\_\_ NW

Date: Month \_\_\_\_ day \_\_\_\_ [correct Saturday for region selected above]

Name \_\_\_\_\_

Address \_\_\_\_\_

Phone/email \_\_\_\_\_

Trade item \_\_\_\_\_

Lunch provided \_\_\_\_ yes \_\_\_\_ no

Directions or provide a map to the meeting location along with this form.

**\*\*All meeting are scheduled on a first come basis. Completely filled out form MUST be received by editor no later than the 15th of the month TWO months PRIOR to the meeting month.**

Completed forms can be mailed or emailed.

You will receive a conformation by email or postcard.

A form must be filled out for each meeting.

If you don't receive something from the editor within 10 days of your sending in your request, call to verify that it was received.

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.  
23966 NE Wolf Rd.  
Fletcher, Okla 73541

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