

# Saltfork Craftsmen

## Artist-Blacksmith Association

April 2015



Dutch Oven Lid Lifters made by Boy Scouts, with the assistance of Saltfork Member Eric Jergensen, at "Encampment" at Camp Adventure near Chandler on March 6-8. (Page 12).

**\*\*2015 Board of Trustees Election Ballot Enclosed\*\***  
**Return to Diana Davis by April 18th**

# **Saltfork Craftsmen Artist-Blacksmith Association Officers and Directors**

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dseigrist2004@yahoo.com

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## **Editors notes...**

I have been contacted recently by some members asking if the newsletter has been sent out because they haven't received their copy when expected. As a member, I get a copy of the newsletter mailed to myself as well since my name is on the membership roster. And I am one of the members who have been getting the mailed copy of the newsletter pretty late in the month.

We have been completing the newsletter right after the third weekend of each previous month (generally about the 23rd of each month) and sending the file to the printer that day. They have been getting them printed quickly and in the bulk mailer's hands, usually in 3 or 4 days, for processing. It seems that some members are getting the mailed copies pretty quickly and others are getting them late. Diana and I are looking into this issue and will try to find a way to improve getting them all delivered in a timely manner if possible. It seems that the differences in arrival may be due mainly to differences in processing through the Postal System.

In the mean time, with help of our webmaster, Dodie, we generally have the newsletter up on the website around the first of each month. Not everyone has internet access and is comfortable with computers but the online version will almost always be available before the print copy arrives. We have made steps to reduce the file sizes as much as we can to help the download speed. The online copies have the additional benefit of being available in color as well as black and white.

Of course, it is always possible for an occasional copy of the printed newsletters to get lost in the mail so if you have not received your copy by the end of the month, please let me know so that we can get you another copy mailed directly to you.

Russell Bartling - Editor

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization 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](http://www.saltforkcraftsmen.org)

## President's Notes:

I probably need to start out with an apology to John Cook. When we, (the board) decided on a date for the picnic, we failed to realize that that date was already taken by John Cook for the South Central meeting. He has very graciously opted to move his meeting date to 17th of October. Thank you John! This years picnic will be held at the museum in Elk City on 18th of April. Mandell spoke of having a Forge welded 3 inch ring for a forging contest. Now we just spoke about the contest briefly at the south central March meeting at my place, so it may not be for sure.



After talking to Eric Jergensen and doing a little reading, I've learned more about the didymium glasses that I had spoke about in last months newsletter. The way I understand it, they only help for sodium flair. It turns out that for forging, we actually need a welders type of glasses, or lenses. A number three shade should be sufficient. I believe that is about what cutting torch goggles are. If anyone knows more about this, I would certainly like to know, because I feel that I am not educated enough on this to really even be talking about it. But I do feel that our eyes are important!

On Wednesday the 18th of March, I received a phone call from a Nora Swidler with Leftfield Entertainment. She is a casting associate who is looking for weapons experts for a TV series that they are going to have, that shows possibly teams of folks forging and finishing weapons. I expect it is the usual, swords, and maybe knives. As I tried to tell her that I was not the guy for the job, and that I felt that there are many, many people that are very much more qualified than myself, she told me that she thought that I was wrong, and might very well be what they are looking for. I could just imagine this lady from New York City listening to my speech, and forming a mental picture in her mind of this Okie hick on the other end of the phone line! I couldn't help but wonder if maybe she felt I might be the "uncle Si" or "Jethro Bodine" blacksmith that they might want to round out their show! All kidding aside, they really are looking for people for this TV series. I am going to try to include the email I received from them so maybe someone interested may be able to pursue this. *(See the e-mail from Nora Swidler with her contact information on the next page - Editor.)*

Spring is here and if you are like most folks, you are getting a bit more busy! I hope to see you all at the picnic, and happy hammering to all!

- Byron

### **QUILTS WANTED!!** **2015 Cleveland County OHCE Quilt Show**

Our quilt show is rapidly approaching! May 8 and 9th at the Cleveland County Fairgrounds from 9am to 5pm. Any quilt not entered in the 2014 Cleveland County OHCE Quilt Show is eligible to enter. Quilts are judged unless requested otherwise. The Grand Champion Quilt is awarded a sewing machine from Stitching Post in Moore. For any more information, contact Carol Doner at 405-760-8388 or caroldoner@hotmail.com

Thank you for your time,  
Carol Doner

**From:** Nora Swidler <[nora.swidler@leftfieldpictures.com](mailto:nora.swidler@leftfieldpictures.com)>  
**Date:** March 18, 2015 12:35:04 PM CDT  
**To:** <[byrondoner@esok.us](mailto:byrondoner@esok.us)>  
**Subject:** Blade Experts and Enthusiasts for Competition Series

Hi Byron,

Thank you for taking the time to speak with me earlier. If you are interested in the show, or know of anyone else who may be interested, that would be great.

A brief introduction is that I'm a Casting Associate with [Leftfield Entertainment](http://LeftfieldEntertainment.com), in association with Outpost Entertainment. We're an award-winning television production company, responsible for hits like *Pawn Stars*, *American Restoration* and *Counting Cars* on The History Channel, as well as programming for networks like Discovery Channel and National Geographic.

We're currently searching nationwide for charismatic weapons experts, enthusiasts, and engineers looking to showcase their weaponry manufacturing skills on an exciting new competition series! This thrilling new project will focus on experts that pride themselves on producing the best blades in the world, whether they be historical or modern, large or small. Showcase your talent for a chance to win a substantial **CASH PRIZE**!

If you're eager to put your skills on the national stage, along with your competitive edge and larger-than-life personality, contact us today! I've included our casting notice below. Please feel free to pass this along to anyone you think would be interested.

Thanks in advance, and I look forward to speaking with you soon!

**Casting Notice:**

**NOW CASTING: BLADE EXPERTS AND ENTHUSIASTS FOR NEW COMPETITION SERIES!**

Are you a Weapons Master?

Do you handcraft the best blades in the world?

Do you have a competitive edge, and will you stop at nothing to be the best?

Would you like to showcase your talents on the national stage for a shot at a **CASH PRIZE**?

If so, we want to hear from you!

A major cable network is currently searching nationwide for charismatic weapons experts, enthusiasts, and engineers looking to showcase their weaponry manufacturing skills on an exciting new competition series. This thrilling new project will focus on experts that pride themselves on producing the best blades in the world, whether they be historical or modern, large or small.

If interested, please email: [nora.swidler@leftfieldpictures.com](mailto:nora.swidler@leftfieldpictures.com) with your name, age, location, contact information, photo and a brief explanation of your expertise and we will contact you with further information.

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**Nora Swidler**  
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Saltfork Craftsmen  
Artist Blacksmith Association. Inc.  
Board of Trustees election April 2015

There are four trustee terms expiring this year. The four trustees whos terms are expiring are: Byron Doner, Bill Kendall, Mark Carter and Mandell Greteman.

You may choose from the candidates list or you may write in any other persons who are members in good standing. Please vote for only four candidates by putting a check mark on the line next to their names.

Byron Doner	Norman Ok	_____
Mark Carter	Mcloud Ok	_____
Mandell Greteman	Foss Ok	_____
Bill Kendall	Tulsa Ok	_____
Chuck Ogden	Yukon Ok	_____
Doug Redden	Oologah Ok	_____
Other	_____	

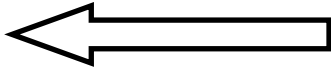
These candidates are all good people. Any of them will be an asset to the Club and to the Board of Trustees. Please vote once per membership. The election deadline is April 18th. Please fill in your ballot as soon as possible and mail to:

Saltfork Craftsmen 2015 Ballot  
C/O Diana Davis  
23966 NE Wolf Rd  
Fletcher, Okla 73541

***You may also turn in your ballot in person at the Annual Picnic that will be held at the Route 66 Museum Blacksmith shop on April 18 in Elk City, Ok.***

**stamp**

Saltfork Craftsmen 2015 Ballot  
C/O Diana Davis  
23966 NE Wolf Rd  
Fletcher, Oklahoma 73541



## **Your Vote is Important....**

The 2015 Board of Trustees Election Ballot is enclosed on the previous page. Please remove the ballot and send in to Diana as soon as possible or bring to the Annual Picnic at Elk City on April 18th. The election Deadline is April 18th so please get any mailed ballots into the postal system as soon as possible to make sure your vote counts!

## **Annual SCABA Picnic - Saturday, April 18th**

The Annual SCABA picnic will be hosted by the NW Regional group. It is being held at the Route 66 Museum Blacksmith shop in Elk City on Saturday April 18th. Everyone is invited to attend and have a good time.

Menu will be hot dogs and hot links. Please help out by bringing a desert or other side dish. Hope to see you there.

SCABA Secretary  
Diana Davis

## **Rural Heritage Festival In Perry, OK Postponed...**

Dear Saltfork Craftsmen and CSMA members,

Due to Interior Renovation plans at the Cherokee Strip Museum this year, the Rural Heritage Festival has been postponed until October. I will send information about the exact date in October as soon as possible.

I really appreciate your willingness to participate in our event and certainly hope you can be a part of RHF during the new date.

Please call or email me with any questions you may have. Again, as soon as I have an exact date I will make sure to let everyone know.

Thank you for your help.

Sincerely,

Kelly Houston

## Work Shop Schedule

May 9th there will be a beginning Blacksmithing workshop at the Murray County Antique Tractor & Implement Association Grounds outside Sulphur Oklahoma. JJ McGill is hosting the class. Cost will be \$35.00 and registration Opens May 1st. Class is limited to 6 students. Attendees MUST be members of SCABA or join during the class.

May 30th there will be a beginning Blacksmithing workshop at Temple Oklahoma. Ricky Vardell is hosting this workshop and assisting teaching. Cost will be \$35.00 and registration will open May 1st. Class is limited to 6 students. Attendees MUST be SCABA members or join during the class.

Hammer class is May 30 at Elk City Museum blacksmith shop, 8:00 a.m. Lunch will be served. \$35 for materials and lunch. Maximum number of students is 10. Call Bob Kennemer to reserve place in class ([580-799-1878](tel:580-799-1878)). Each student will make their own hammer.

August 29th– Play day – hosted by Don Garner at 23713 E. 860 Rd. Thomas, Ok. 580-661-2607

Oct 31- pattern-welded steel demonstration by Gerald Brostek, Elk City Museum blacksmith shop, 8:00 a.m., no charge, no lunch.

Diana keeps track of the workshops and the monthly meetings. Regular monthly meetings are always open to anyone that wishes to attend. If you want to host a meeting in your area you need to fill out one of the host forms in the newsletter and get it mailed in as soon as possible. Consider having a beginning blacksmithing workshop in your area. We have a lot of new members that need a little guidance getting started. A one day workshop will give many of them just the encouragement they need. Let me know if you would like to plan a workshop in your area.

-Diana Davis 580-549-6824 or [Diana.copperrose@gmail.com](mailto:Diana.copperrose@gmail.com)

### SCABA Library Titles:

Robb Gunter Basic Blacksmithing parts 1,2,3 and the controlled hand forging series  
Clay Spencer SCABA conf. 2013 pts. 1,2 and 3  
Jerry Darnell 18th century lighting, door latches and hinges  
Brent Bailly SCABA conf. 2011  
Mark Aspery SCABA conf. 2011  
Robb Gunter SCABA conf. 1998  
Robb, Brad and Chad Gunter 2009 joinery, forging, repousse, scrollwork, etc.  
Bill Bastas SCABA 2002 pts. 1 - 6  
Jim Keith SCABA conf. 2007  
Power hammer forging with Clifton Ralph pts. 1 - 5  
Doug Merkel SCABA 2001  
Bob Alexander SCABA 2008  
A. Finn SCABA 2008  
Bob Patrick SCABA 2004  
Gordon Williams SCABA 2010  
Daryl Nelson SCABA 2010  
Jim and Kathleen Poor SCABA 2001  
Ed and Brian Brazeal SCABA 2006  
Ray Kirk Knives SCABA 2002  
Frank Turley SCABA 1997  
Frank Turley SCABA 2003  
Bill Epps SCABA 2003  
M. Hamburger SCABA 2007

*When I copy a set for someone I make three copies. Best time to contact me is in the A.M. by phone.  
- Doug Redden, Librarian*

### **Demo Opportunity...**

I have a request from the Claremore Chamber of Commerce for a blacksmith to demo at the upcoming Home and Garden show April 10-12. The Contact person is Ann Baker 918-520-9748. Anyone interested should contact Mrs. Baker for more information.

-Diana





## Regional Meeting Schedule

- SE regional meeting April 4th (Open)
- **NE Regional meeting April 11th** Will be hosted by Doug Redden at Will Rogers Birthplace. The trade item will be anything from a horse shoe. I have no information about the meal so assume it is on your own.  
Go north out of Oologah on Hwy 169 and turn east (right) on E380 Rd (Birth Place Rd). There is a blue sign at the road. Go east about 2 miles to the site.
- SC Regional meeting April 18th **This date has been set aside for the Annual Picnic. It will be held in Elk City at the Route 66 Museum Blacksmith shop. Check out notice in this newsletter.**
- **NW Regional meeting April 25th** will be hosted by Dorvan Ivy. It is being held in conjunction with the Hammon Pioneer Days Celebration in the town of Hammon. The event is held in the park. The group has been invited to demonstrate at the event so check with Dorvan to see what is needed if you wish to demonstrate. I assume that lunch is on your own due to the number of food vendors at this kind of event. Trade item is a bottle opener.

From Hwy 40, take exit 41 at Elk City and go north about 10 miles on Hwy 34 to Hammon. In Hammon, turn west (left) on Foster Street and go three blocks to the park (on north side of Foster Street).

The Cheyenne-Arapaho Pioneer Days Celebration is the same week-end. Every five years, Hammon celebrates the Cheyenne Arapaho Land Run held on April 19, 1892 with the Cheyenne Arapaho Pioneer Days Celebration. This event officially began in 1912 and continues today with two days of old-fashioned events. These events include a quilt show, parade, rodeo, dance, arts and crafts, car show, flea market, BBQ cook off, gospel singing, a FREE BBQ, and fireworks. During the celebration, the little town of Hammon grows from about 500 to several thousand people.

The Hammon Fire Dept. will also be having a pancakes and sausage breakfast. I think for donations.




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### 2015 meeting dates....

#### SE Region (1st Sat )

Jan.3rd  
Feb. 7th  
March 7th  
**April 4th**  
May 2nd  
June 6th  
July 4th  
August 1st  
Sept. 5th  
Oct. 3rd.  
Nov 7-8 Conference  
Dec 5th

#### NE Region (2nd Sat )

Jan 10th  
Feb. 14  
March 14th (James Mabery)  
**April 11th (Doug Redden)**  
May 9th (Ed McCormack )  
June 13th (Doug Redden)  
July 11th  
August 8th  
Sept. 12th  
Oct. 10th  
Nov. 14th  
Dec. 12th (Charlie McGee)

#### SC Region (3rd Sat)

Jan. 17th (Byron Doner)  
Feb. 21st (Tony Cable)  
March 21st  
**April 18th**  
May 16th (JJ McGill)  
June 20th (R. Vardell)  
July 18th (Larry Mills)  
August 15th  
Sept. 19th (Jim Dyer)  
Oct. 17th (John Cook)  
Nov. 21st  
Dec. 19th

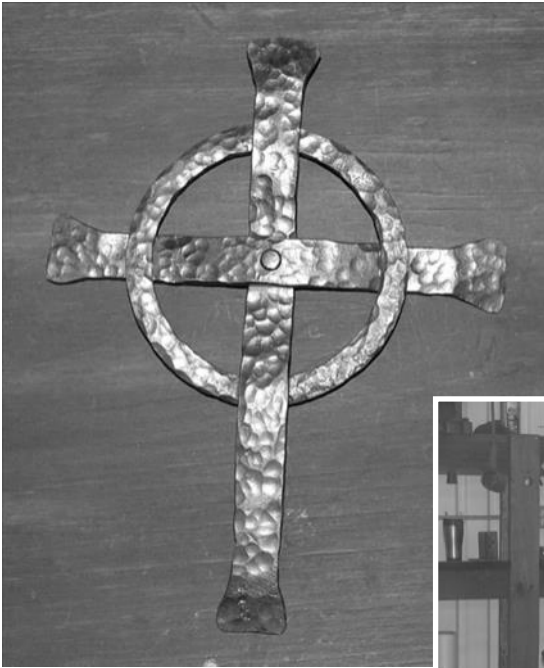
#### NW Region (4th Sat)

Jan 24th (Gary Seigrist)  
Feb. 28th (Bob Kennemer)  
March 28th (Mandell Greteman)  
**April 25th (Dorvan Ivy)**  
May 23rd (Terry Kauk)  
June 27th (Don Garner)  
July 25th (Gary Seigrist)  
August 22nd (Monty Smith)  
Sept. 26th (Roy Bell)  
Oct. 24th (Cheryl Overstreet)  
Nov. 28th (Mandell Greteman)  
Dec:26th (Merry Christmas)

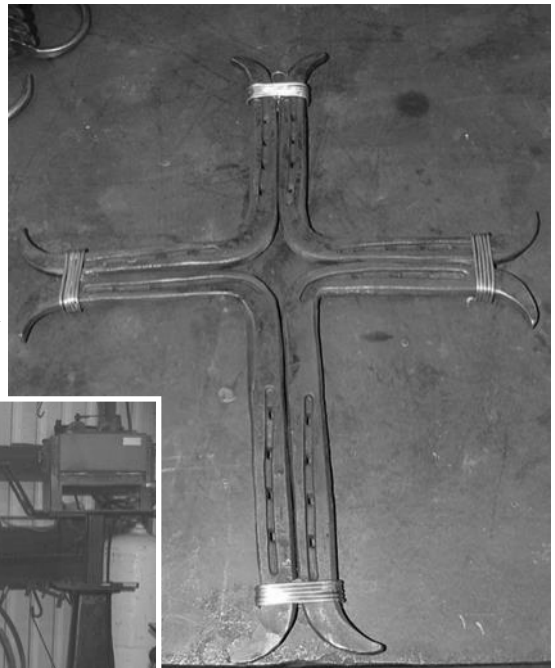
Meeting hosting form can be found on the last page along with membership application form.

## Around the State....

**NW: North West Region February Meeting:** The February 28th meeting for the NW region



was hosted by Bob Kennemer at the Route 66 Blacksmith Shop in Elk City. There was a nice turn out for the meeting even though the roads were icy and snowy and it was cold. Ten brave blacksmiths



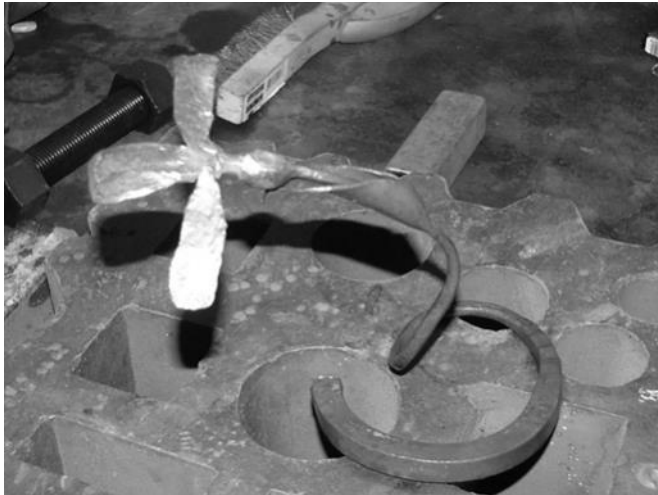
arrived to enjoy the day. The trade item was a Cross. They kept four forges going all day making a wide variety of items. The heat from the forges was nice. Some even enjoyed just watching others. Lunch was homemade Pulled Pork, baked beans, and all the fixins, with all sorts of good things to go with it and wonderful deserts. I would like to say "A



Big Thank You" to everyone that came.  
- The Gretemans



## Around the State (continued)....



**NE:** No meeting notes available.

**SE:** No meeting was held in March.

**SC: South Central March Meeting:**

By the time I got outside on Saturday morning, my meeting was already underway! I went to get the newspaper for my father-in-law, and Ricky Vardell along with Bill Yeager pulled in, and caught me at the mailbox. I think those guys had been driving longer than I had been awake! I'm starting to understand what my grandmother meant when she told me, "it's hard to soar with the Eagles in the morning, when you've stayed up and hooted with the owls too late the night before!"

When I got out to the shop, Tim Jones had brought doughnuts, and he along with Bruce Willenburg, already had coffee ready, and were cooking the chili.

Hunter Ogden was busy hammering out hamster swords! (swords made from concrete form nails) Several guys were hammering away using a gas forge, and the induction forge. JJ made some bracelets out of dinner forks. Mandell ran the 100 pound little giant hammer a little bit. I seen a little man that someone had made from a railroad spike, and John Cook had made a letter opener or knife with an owl on it.

There were four trade items, and I apologize for not getting a picture of those. It was a treat to get to see Ron Lehenbauer out and about again. Folks continued to show up all the way until lunch time. I think we had right at 30 people show up, if you count my two little grandsons that showed up later in the day!

We all had a good time and I want to thank everyone that helped pull it off! – Byron





## 250 Boy Scouts Try Hammering...

Eric Jergensen

About 250 Boy Scouts attended "Encampment" at Camp Adventure near Chandler on March 6-8. Saturday was a full day of old west activities like candle making, tomahawk throwing and, of course, blacksmithing. We had a continuous flow of boys and adult leaders from 9 to 5 (minus a well-earned lunch). We kept 6 anvils ringing the whole time.

Camp Adventure features a smithy with a brick forge, 2 vises and 3 anvils. We rounded that out with the Saltfork Craftsmen teaching trailer equipment so that we could have a demo station outside and 5 hands-on stations inside.

The event almost went wrong before it started. The other blacksmith had a serious







family emergency just two days before the event and had to back out. Fellow Saltfork Craftsmen member Gary Whiteman responded to the emailed plea for help and ran the demo station outside the smithy. He did a nice



mixture of lantern hooks, drive nails, leaves and other simple projects. Depending on the crowd, he also let the boys do some hands-on work.



My son Elliot and I had come down Friday evening, unloaded the teaching trailer and set everything up. We were joined by my son Eli and



daughter Riana Saturday morning. The four of us and a Boy Scout leader manned the hands-on stations inside the smithy where boys would set down, slit, punch, shape, twist and rivet their way to a dutch oven lid lifter. Due to the line of boys waiting, each boy did just a few steps and then yielded his spot to the next boy.



Towards the end of the day, the crowd thinned enough that we could allow a bit of "free form" work. We ended up with several other items made including a "crow bar" and, of course, a knife-shaped object.

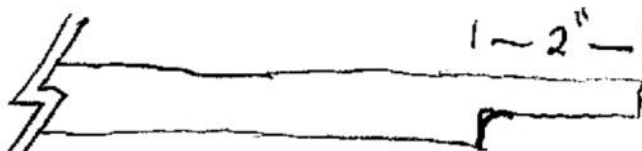
Overall, we burned 100 pounds of coal and 4 pounds of propane while generating over two hundred slightly sooty smiles.

### These are the steps we used to make the lid lifters...

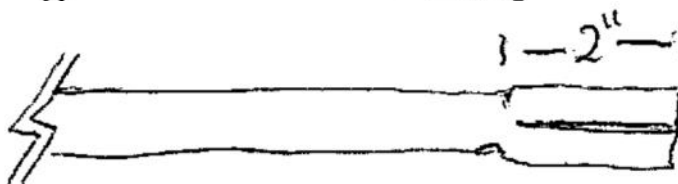
This is a highly simplified version of Jim Coke's elegant lid-lifter: <http://www.iforgeiron.com/topic/41339-lets-go-camping/> (2nd post). My goal was a project that a boy scout could do under the direction of a blacksmith. I used only light forging and made sure it covered a good variety of techniques including forging, bending, twisting, slitting, punching and riveting.

Stock: 3/8" round, 25" for the handle and 12" for the lever.

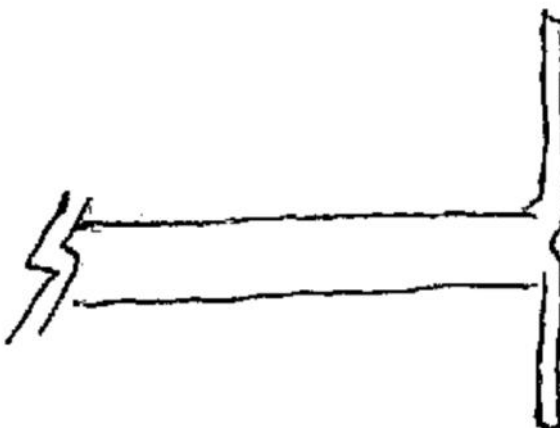
**Step 1:** Using the near edge of the anvil lightly set down 2" of stock.



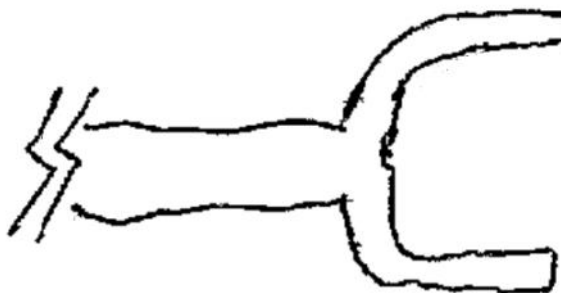
**Step 2:** Using a slitting chisel, cut the set down lengthwise. I like to flip the stock over after setting down and establishing the cut with the remaining heat. It's easier to do when the metal is darker. After cutting through, put the stock in the vise and bottom the cut out from the end. Then, use a blunt chisel to round the cut.



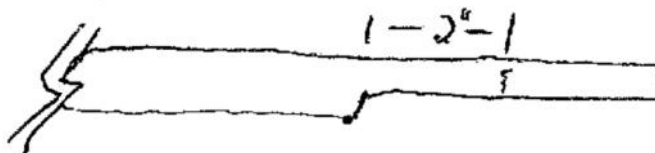
**Step 3:** Bend the arms out into a "T". There are many ways to do this. I find it convenient to pry them apart with the blunt chisel before I remove the stock from the vise. For a cleaner look, file away the rag from slitting. (I didn't bother.) Use the edge of the anvil to finish the bend and the face to straighten things up.



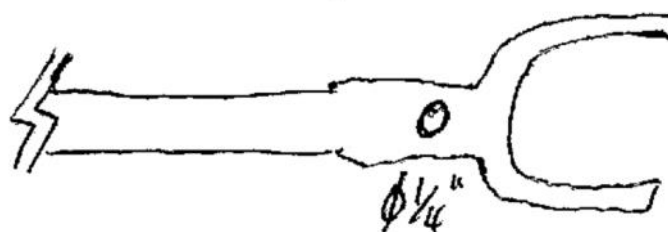
**Step 4:** Use the horn of the anvil to form the arms of the "T" into a "U". Aim for 1 1/2" between the prongs.



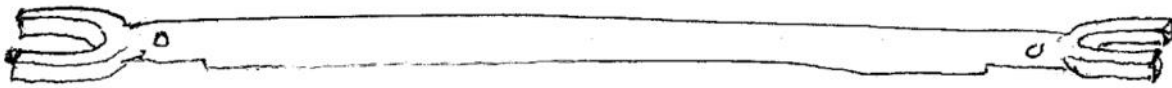
**Step 5:** Lightly set down another 2".



**Step 6:** Punch a 1/4" diameter hole near the "U" end. Don't center it in the 2", most of the 2" is clearance for the hook lever arm. Put the set down face down at the edge of the anvil so you have the flat side down for the back punch and pritchel work. (Note: you can retain more material for a stronger boss if you slit / slot punch and drift.)



**Step 7:** Repeat for the other end. Make sure both set downs are on the same side.

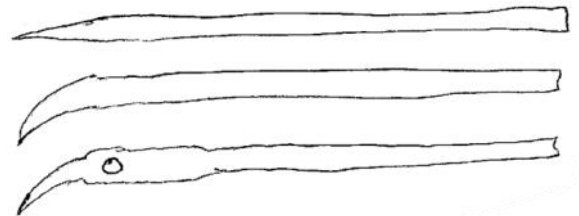


**Step 8:** Heat the center of the bar. If the set downs were rotated a bit from each other, stick one set down in the vise twist the other into alignment. Now, bend the two set downs together so the 1/4" holes align. (This bend is an eye-opener for a beginner: the ease with which the metal bends tends to be a big "oh!" moment.) I use the horn to tweak the holes into alignment. I started by holding the long side vertically on the face and hammering the bend on the other side, but that tended to distort the prongs on the "U" at the supporting end. Finish by bringing the sides together to form an eye.



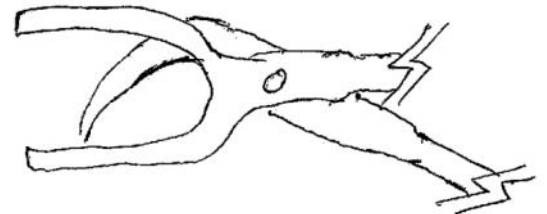
Now, take a long heat starting at the base of the eye and then as far toward the "U" prongs as you can. Place in vise with the "U" prongs down, put a bar in the eye and twist. (See the final drawing for my suggestion of the eye alignment in the finished twist.) At this point, make the lengths of the "U" prongs match if they don't. I used bolt cutters and a file.

**Step 9:** For the hook and lever, start with a blunt conical taper about 2" long. Put in a slight bend for the hook. Compare to the "U" prongs of the handle and note the punch location. (The next picture shows the alignment.) Very lightly set down just enough to punch. Punch a 1/4" hole. Finish the (symmetric) flattening, both down onto the hook and well up the lever arm. I usually end up with a slight twist in the hook that I fix with scrolling tongs while clamping the flat/hole in the vise.



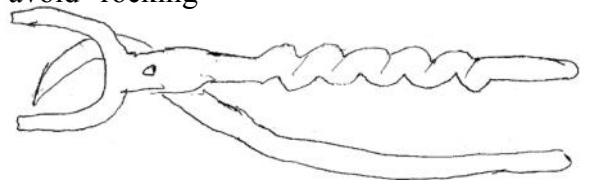
**Step 10:** A word of warning to those with coal forges: it is very easy to burn the "U" prongs in the following steps!

Rivet the hook and lever into the handle. You may need to heat and spread the "U" prongs a little to get it in. I found that a 7/8" to 1" rivet is about right.



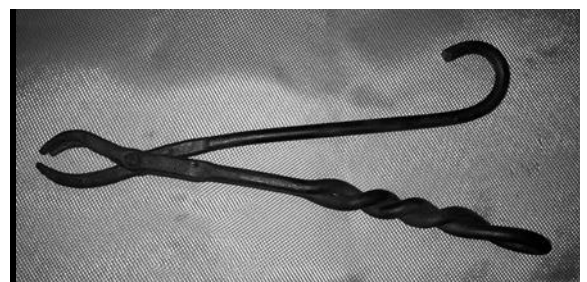
Carefully heat both sides of the prongs. Place upside down in vise and use scrolling tongs to spread them about 30° outward. (By outward, I mean away from the plane of the hook and lever.) I used the flat backside of my coal scoop to tweak them to all roughly touch. (That is, to avoid "rocking table legs".)

**Step 11:** Now heat the lever for a short heat centered about 2-3" from the rivet. Place on a dutch oven lid and bend the lever handle. (This heat is tricky in a coal forge, but you don't need a very hot heat.)



The resulting lifter is not spectacular, but the sense of accomplishment and pride for the boy scout definitely is! Takes about two hours with the scout doing all hammering, bending and twisting and the smith holding chisels and punches and doing some of the fix-up for misalignments.

After making a pile of these, I've found that the basic holding is done by the front prongs and the lever. When I do this next time, I'll probably make one like this:



# NWBA Mentoring Center Monthly Hammer-In January 24th, 2015 Tri Ficker: *Forging pipe*

*Notes by Hardie Swage, photos by Amy Mook except as noted*

Farriers rasp pipe handle. Clearly follows Joe Elliott's rule: Tools should be eye sweet and hand friendly.

Tri benefits from using his own tongs, they grip firmly and have enough mass to work well without being overly heavy. His pipe tongs have a tapered round upper jaw that nests in a wide "V" lower jaw, it holds the lip of the open pipe very firmly.

Start with 6 1/2" of 3/4" ID Schedule 40 pipe. Draw 2 1/2" of pipe into a long tail.

The tail is a long taper and the open end is worked on the end of the horns (Nimba anvil used) to keep it from forming a fold (pucker). Keep turning the piece as you work it to keep squaring it, making sure not to collapse it. The end result is a tapered tail with no fold lines, the pipe walls have been upset on themselves to become thicker as the outer shape is transformed.

Start at the base of the tail (2 1/2" mark), pipe at 45 degree angle to near anvil edge. Keep pipe end cool by dipping in water as you work to form the step. When step is fully formed, bring tip of the tail down to a small square, and then taper the area between. Important to keep top line straight during whole process.

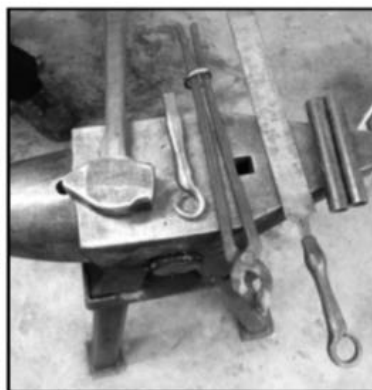
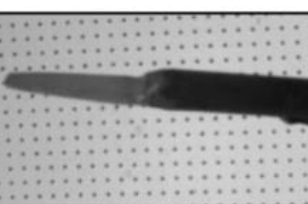
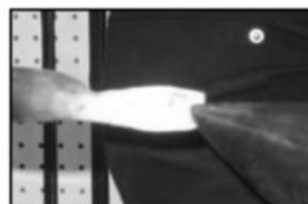
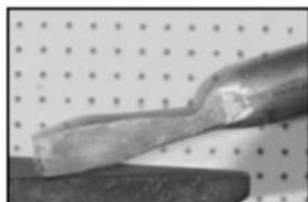
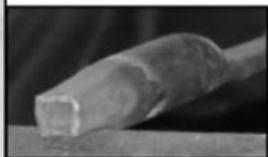


Photo courtesy Gregg Watson



Reverse hold and start drawing down the other end. Do the anti fold/pucker work you used before. If you do not have an anvil with the fine ends to the horns make a vice or hardie tool for this purpose. The goal is a rectangle opening that fits the taper of the rasp tang. Make a drift that reproduces the area of the tang you wish the finished handle to grab. Once you drive the drift in, the challenge is to get it out. Grab the struck end on the vice and wiggle pipe slightly side wise and up/down until it releases. Not difficult if the pipe end still has color.



Next form the gentle reduced valley on the middle of the parent pipe. Tri used a radius hammer on top and the radius of the horn below, with light blows and constantly rotating the pipe. Important to keep things straight. Follow the basic blacksmith rule "Be aware". The hammer was not as pronounced radius as the horn, so the horn did most of the work.

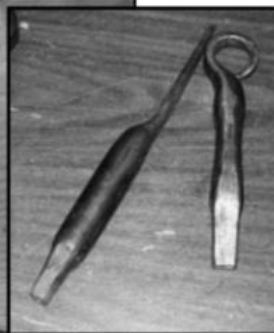


Make sure the angle of the loop handle is oriented to the same plane as the flat of the rasp, or it will tend to irritate the hand when gripping.





**The finished rasp handle.**



Tri went on to show his exceptional forging skills by rounding a pipe end to a perfect circular dome. He upset the end of the pipe into itself using the step of the anvil to nestle it and enable the gentle hammer blows to work opposite sides of the opening at once. He used a sweet spring fuller tool that was part of the on-site tooling at the Mentoring Center. The flat area on the top fuller bar is to add spring to the fuller. He forged the ball into a pointed dome using the heavily radiused edge of the anvil, demonstrating one way to make a finial using this technique. Another version Tri demonstrated was the squared dome.

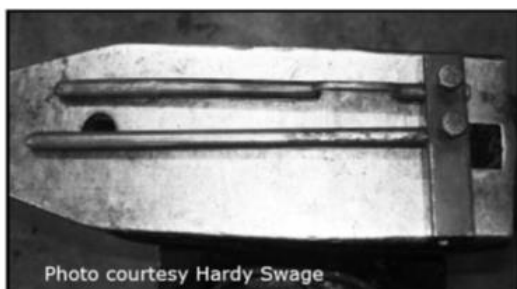
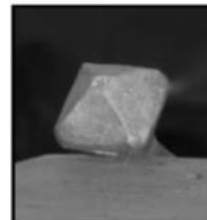
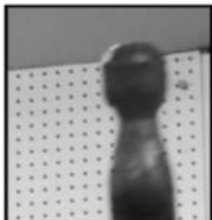
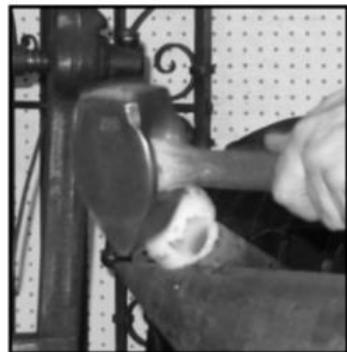


Photo courtesy Hardy Swage



Tri spread the other end of the pipe way past the trumpet mouth to a wide lip 90 degrees to the center line of the pipe; thus forming a stand base that is effective in candle sticks and other uses. A lot of it was the pipe end hanging a little ways off the far anvil side and striking the lower lip edge with a round hammer peen. Again always rotating the pipe and using mild blows while keeping everything in line.



**Hot Iron News**



*Thank you Tri for the great demo, as always, you make it look easy.*

## Some Forging Tips

Through the winter months, I worked on several projects that taught me some valuable lessons. I thought you might like to benefit from my mistakes.

### 1. Remove potential Hot or Cold Shuts:

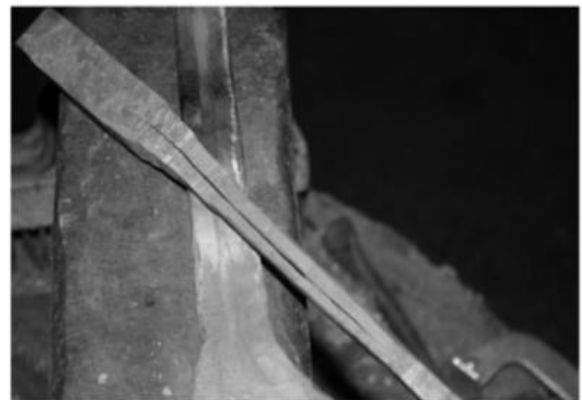
While forging some heavy truck leaf springs (approximately 3" x 3/4" sections), I noticed the outer edges worked thicker than the middle. As I worked the material a crease formed in the center as shown in this picture.

I left the crease and figured it would eventually close as I continued to forge.

The crease did narrow to a fine line, but never closed.

As I approached my desired dimension of 5/8 round for a pitchel tool, I noticed the fine line had progressed to a crack completely through the material.

Lessons Learned: Less aggressive forging with attention to maintain a common thickness across the width of the stock can minimize the creation of shuts. If a crease appears, a grinder can be used to remove the potential shut.



### 2. Forging pipe or tubing:

Forging a cant hook for rolling logs. This required tapering the 2" pipe business end to join to a 1" pipe handle.

Safety is paramount when working with tubing. Here are some commonly communicated safety tips:

- Never forge coated or galvanized tube or pipe. The fumes are toxic.
- Plug the end of the tube with a rag and/or tape to limit heat conduction from gases flowing through the tube
- Exercise extreme caution when quenching. Sudden steam formation can blow out the end of the tube causing severe burns. Do not rely on the rag or tape plug to contain the steam.
- Larger tube diameters may carry hot coals from the forge, which can create a fire hazard.

Forging tips:

- Relatively thin wall sections can crush or collapse.
- Heat evenly to avoid soft and hard spots
- Strike easily when tapering to avoid crushing
- Rotate more often than solid stock to maintain round or square cross section
- V-blocks add another contact point, reducing tendency to crush round material
- Use a piece of round rod as a mandrel when twisting square tube. It will lessen tendency for flats to collapse to center
- Use point of horn or anvil bick to flare the end
- Guillotine tools are very useful when isolating material for diameter transitions.

## Towel/TP Holder

Demonstration by:

Owen Creteau, a MABA member

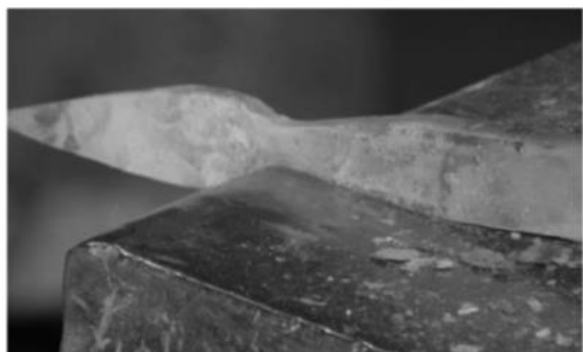


22 inches of 1/4 x 3/4, A36 steel (common low carbon steel) was used for the towel/toilet paper holder.

To create the leaf finial, point one end of the bar – keeping the point centered in the bar.



Neck the other end of the leaf down (for the stem area) on the far-side of the anvil, then break the edges around the stem.



Use the peen of the hammer to spread the leaf out.



After the leaf has been widened, use the face of the hammer to shape and smooth the edges, then thin the edges of the leaf down.



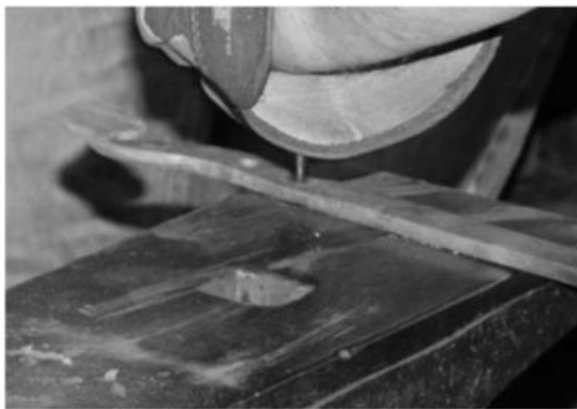
Use straight or curved chisels to add veins to the leaf.



Heat the stem area and several inches of the parent stock. Use a hardie mounted bending fork (allows good control when shaping the stock) to put two offset bend below the leaf area.



Punch two mounting holes in the straight area below the offset curves. Use the pritchel hole in the anvil to guide the punch and use as a material back-up for the hole punch to keep the stock flatter. Check the diameter of the holes with one of the mounting screws, drift the hole larger if needed.



Let cool, then heat and point the other end the same as was done for the leaf.



Heat 5-6 inches behind the tapered point and thin the edges slightly along the length of the heat. By thinning the edges, more mass is left in the center of the bar and

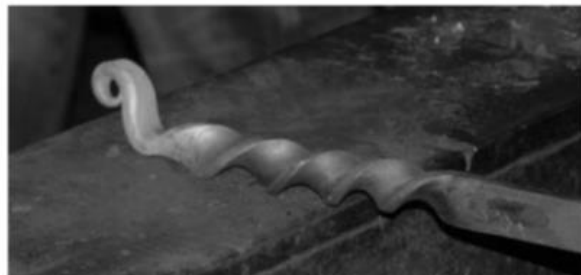
the twist stay straighter. Reheat and then clamp in the vise. Use a bending wrench, or two adjustable wrenches, placed about 6 inches away from the end of the vise jaws. Slowly twist the bar 2 and a half times working to keep an even twist. The pointed end should be 90 degrees to the parent stock – straighten the twisted section if needed.



Heat the point and curl it back towards the twist.



Reverse the curve so a feature is created that will pass through the toilet paper tube and keep the TP roll from slipping off the holder.



Just after the twist, put a tight 90 degree bend in the stock. About 3 inches away from this bend put in another tight 90 degree bend. Make sure the bends are pointed "out" from the side of the leaf finial with the veins on it.



Put a sweeping 90 degree bend in the stock, below the mounting holes, that is centered on the twist.



Other finial possibilities are ram's horns or a heart.



## Angle Iron Circle

### Write-up and Drawings

by Steve Alling, a MABA member

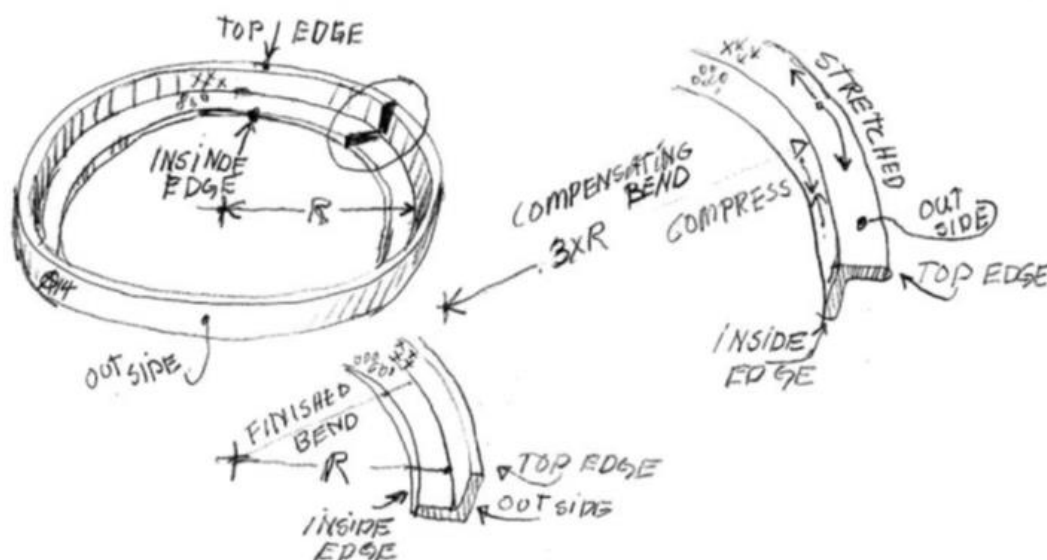
I learned this technique from Francis Whitaker and he learned it on the west coast from the guys who made the angle iron tracks that moved the tuna cans around the factory.

You will struggle if you try to bend angle iron into a circle all kinds of weird things happen because of the two different planes of the metal.

Francis said make a compensating bend with a radius three times the radius of your finished circle.

You need to carefully look at the drawing to get this bend in the angle iron correctly. What you are doing with this pre bend is stretching the part

of the angle iron which will become the outside of your circle and compressing the web that will be on the inside. Once this bend is made you can go ahead and roll up your circle and it should come out without too much distortion. Francis said he always bends these angle iron circles cold unless they are of a larger size. And that is advisable because as we know when twisting a bar if the heat is not even the twist is not even. Here where you're dealing with such uneven distribution of metal I think Francis is right.





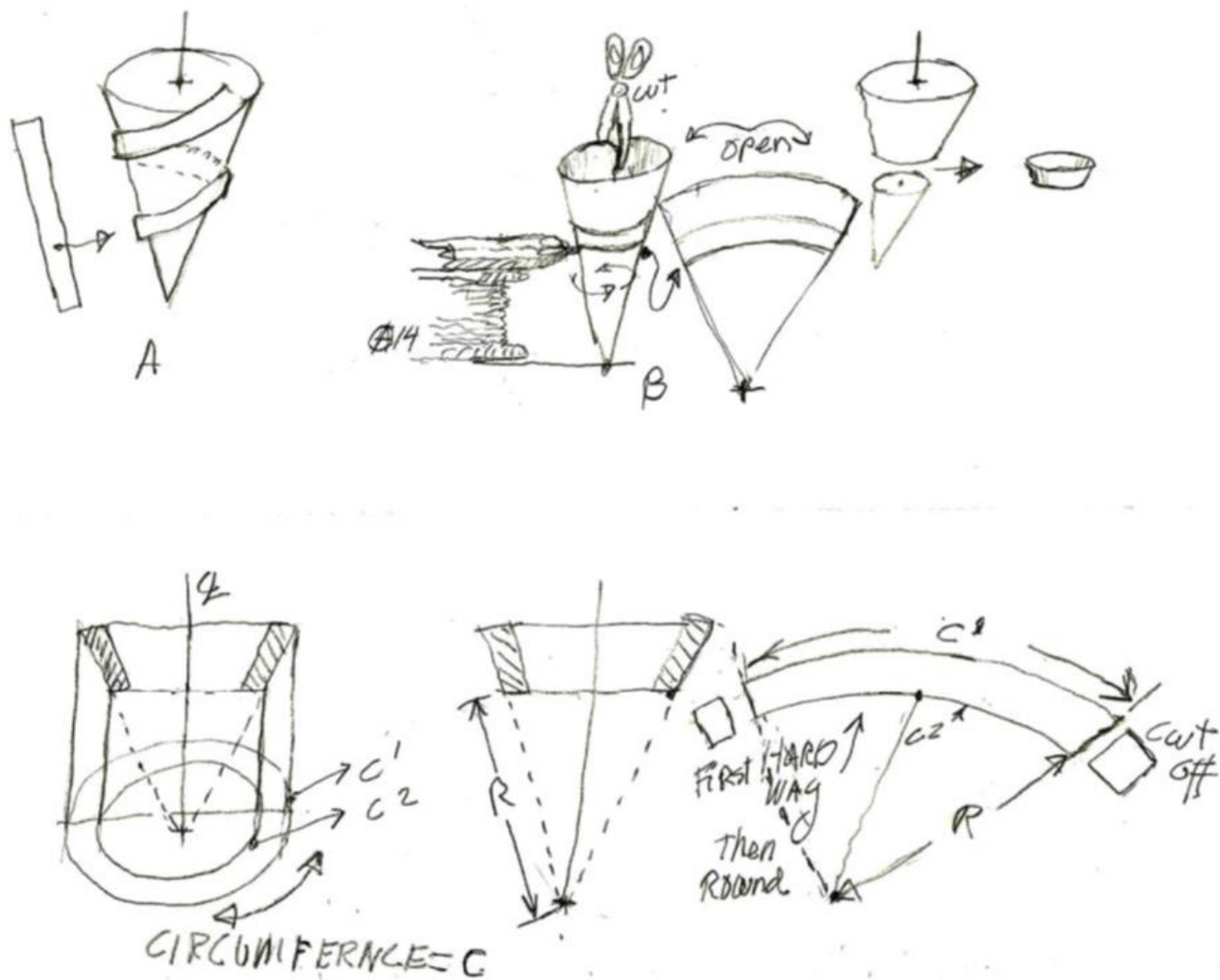
# How to Make a Section of a Cone

Write-up and Drawings

by Steve Alling, a MABA member

The shapes such as frying pans and barrel hoops are sections of a cone. To understand how to bend the metal to end up with that shape you have to first make a compensating bend. As you can see in example "A" if you try to wrap a straight piece around a cone you get a spiral. So you can perform a little experiment to understand why you need this pre bend. Make a small paper cone out of a note card and tape it together. Stand it on its point and rotate it against a pencil supported on a book. This will give you a line which represents either the top or the bottom of one of these shapes. Now with a sharp pair of scissors cut the

cone open and flatten it out. You will see that the nice straight line you drew on the paper cone is now a curve which is defined as a radius from the point of the cone. To construct this circular line make a full size side view drawing of your object with a vertical center line. Extend a line off one of the slopping sides till it intersects the center line. That will give you the length of the radius of the arc that you will need. To find the length of that line calculate the circumference of that point on your drawing. Use a piece of string to mark that length on your arc that also tells you the length of material you will need. (When bending on the edge, I find it very hard to get a nice bend on the ends, so I always bend my stock oversize and trim it back.) Now when you have your compensating bend finished you can roll it up into the proper circle and it will straighten itself out and come out the way you want.



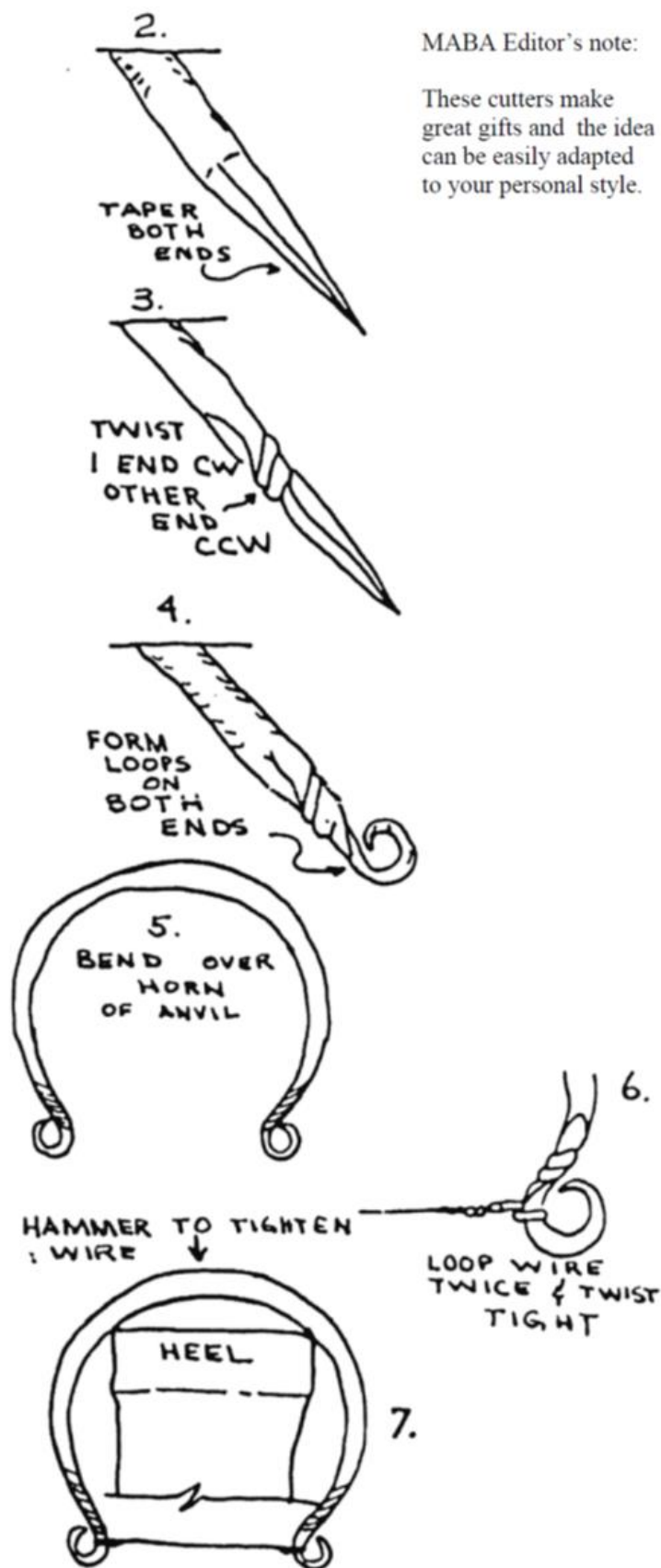
## Making a Cheese Cutter

Here's a nice quickie project that has real customer appeal.

1. Start with a piece of 1/4" or 5/16" stock, either square or round, approximately 9" long.
2. Taper both ends an inch or so, whatever you think you'll need to make a nice loop on the end.
3. Twist the ends. Twist one end clockwise and the other counter-clockwise. You could also make decorative twists in the center of the handle at this time if you care to.
4. Then form loops on each end.
5. Bend into (GOD.....FORBID) a horseshoe shape by using the horn of the anvil.
6. Wrap a wire through one end of the loops twice, stretch to the other loop and wrap twice again. Wire such as .035 MIG wire, solid guitar or banjo strings, or solid piano wire work well.
7. Using the heel of the anvil, hammer the middle of the handle over the heel to tighten the wire.
8. Finish with a little vegetable oil to preserve the look you want.

MABA Editor's note:

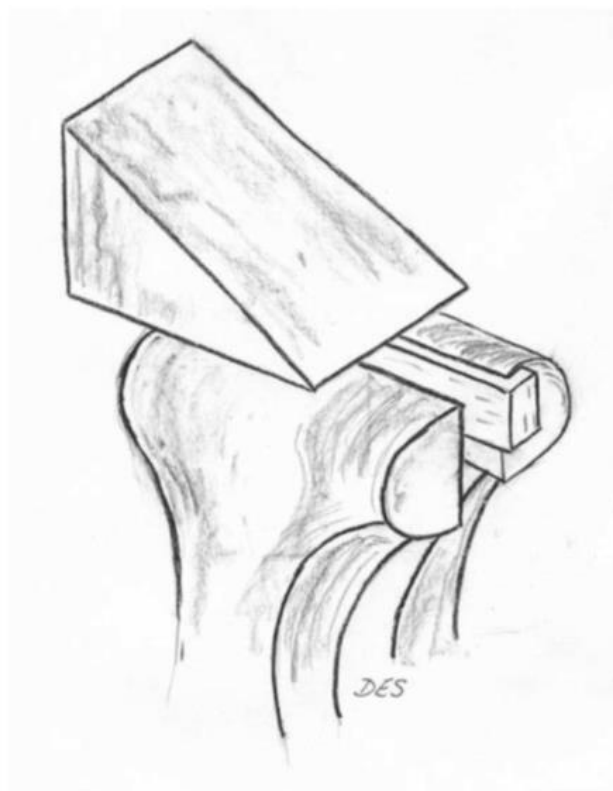
These cutters make great gifts and the idea can be easily adapted to your personal style.



## Vise Anvil or Detailing Wedge

by Dave Smucker

Here is a tool that I consider a "have to have tool". If you are going to do blacksmithing you need a forge, anvil, vise, tongs etc. Once you have collected these tools, a most useful accessory for your vise is what I call a vise anvil or detailing wedge. My wife says it looks like a wedge of cheese set on top of your vise jaws.

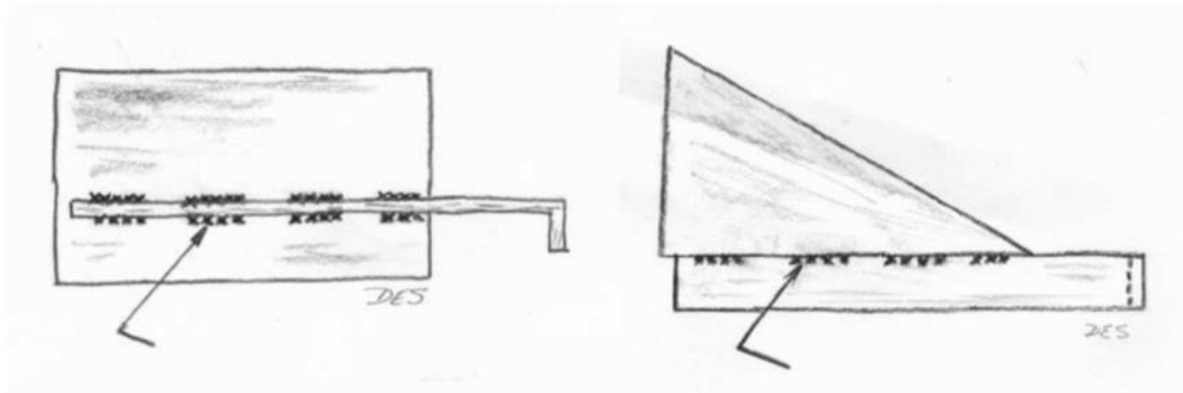


What does it do? It lets you clamp hot items in your vise and then use hand held punches, chisels and other tools to put details into the item you are working on. If you want to make things like wizards, dragons etc. it is a tool that is very very useful. (I'm sure someone somewhere works on these items without one but once you make one you will wonder how you ever got along without it.)

As Francis Whittaker used to say, **"if you can't hold it, you can't hit it."** Well, this little tool lets you clamp your work piece in the vise and then presents a solid angled surface for you to work against.

The size of the block is not important nor does the angle of the wedge have to be some exact value – many different sizes and angles will work. Mine is made out of 2 1/2 x 2 1/2 square stock because that is what I had but smaller sizes will work just fine. Mine is cut at a 30-degree angle, and that is about right but other angles will work too. To the bottom of the wedge is welded a length of 1/4 x 1 inch bar stock that is several inches longer than the wedge. On the end of this wedge is welded a tab that keeps the block from falling off the vise when open. The extension of this bottom bar clamps both the wedge and your work piece when you close the vise.





will work fine. One of the harder things to do is to cut the angle for this block. It is not hard to saw in a small cut off saw, but it may be hard to hold to make the approx. 30-degree angle cut. Here is a trick that will help. First cut your block to its overall length. Then tack weld it to a length of wide bar stock or plate, setting the angle and arranging the bar stock so that you can clamp it in the saw's vise. This is much easier than trying to angle the saw's vise and still clamp the wedge block. When done you will need to grind off the tack welds but this should be easy. With the saw cut done you should end up with two wedges – so you can make one of these vise anvils for a friend or make one and put it into "iron in the hat" for some lucky blacksmith. If you don't have a cut off saw yourself, find a blacksmith friend that does, do the sawing in his shop and give him the other wedge.

Now to finish the vise anvil all you need to do is weld a length of 1/4 x 1 bar stock to the bottom. It has to extend well beyond the front of the wedge so that you have a surface that will both clamp in the vise and clamp against the work piece. If you use a large block for your wedge like I did you will need to weld or bend a tab on the bottom bar to keep the wedge from falling off the back of the vise when it is opened. If you use a smaller block you will not need to do this.

After welding the bottom bar to the wedge you may find that you need to grind the weld on the backside so that it will clamp well with the top edge of the vise jaw.

I noticed on Steve Williamson's vise anvil that he has a longer extension on his bottom bar than I do and that he has it bent down so that it is out of the way. This gives his a handle that remains "cooler" so that he can pick it up to take it in and out of the vise, without having to use another tool. When I use my vise anvil it gets too hot to handle without picking it up with tongs or vise grips. (I should add a handle extension to mine.)

In use you can heat your work piece in the forge and then clamp the item in the vise – and use a punch, chisel, etc., to work details. As the piece cools you will need to return to the forge for another heat or you can heat it with a torch right there in the vise. I often use the torch if working on a small item or if I want to heat just a small portion of the work piece.

If you don't have one of these tools, make it soon. You will like it and use it a lot

## Buffer Safety

There was an incident recently that was discussed on *The Forge*, the online email blog that is hosted by ABANA.

A knife maker was buffing a knife and was found with the blade through his heart. Yep, he died.

Jerry Frost, aka Frosty, a smith in Nova Scotia, and Todd Rich did the math: Figure that a 9" buffing wheel on a 3,450 RPM motor results in about 8,130 feet per minute surface speed, or 135.5 ft/sec.

Frosty went on: "What part of a human chest is going to stop that? How much momentum does a 6 oz. knife blade have moving at 135.5 ft/sec? I'm thinking it'd defeat plate armor if it hit end first, either end. Don't think of it as a "thrown" blade, think of it as one fired out of a gun.

"People have been trying to figure out how to make a guard to prevent objects from getting caught and thrown from wire wheels and buffers for centuries, well better than one century anyway, nobody has come up with anything that isn't more dangerous than no guard at all.

"When you say prevent it from traveling 360\* you're thinking 180\* and that is right back at you. The wheel covers almost guarantee anything that won't stall the motor WILL come directly back at you. Usually aimed at your waist, but it doesn't make a whole lot of difference where something going that fast hits you it's going to take it's pound of flesh if not your life.

"There is only ONE thing I know of that CAN make wire wheels and buffs reasonably safe and that's operator technique. STAY OUT OF THE PLANE OF ROTATION! You guys have probably read me saying this till you're sick of it, but that's it, as safe as you can be using wheels. Heck, grinders catch things once in a while and throw them at the operator. Just don't be in the way WHEN it happens. Learn to operate grinders, wire brushes, buffers, etc. from the side, NEVER in front of the wheel. You've seen water or mud slung off a bike wheel? THAT'S the plane of rotation! Just stand to the side or the steel version of water spray might come to visit.

"Something else for you blade guys to think about: you all know you can build stresses in the blade grinding, you normalize or even anneal after grinding before hardening and tempering to relieve stresses or risk a failure be it outright breaking or cracking. Buffing imparts heat and high frequency vibration to the steel and if there is a potential crack buffing can cause it to appear. Nothing like a crack to grab a buffing wheel, even if you're doing everything right.

"If you're not at least a LITTLE afraid of wire and buffing wheels you're not paying attention or just not aware of what you're doing. You just can't let fear effect how you operate machinery or it WILL get you. "You can't fear the machine but you MUST respect it." My Father said that or a version so many times I got sick of hearing it but no truer words were ever spoken."



I added that the setup of the buffer or grinder in the shop. The machine should be set so that the wheel should be mounted proud from the bench. There must be nothing below the wheel to rebound the knife or what-ever into you. It will fly straight down. Now, you need an **open** plywood box below the wheel to catch the whatever. The guy who showed this to me had 4" of foam in the base of his box as he didn't want his knife to be hurt if it was ripped from his fingers.

So, **stay out of the plane of rotation** and set up your buffer/wire wheel **over nothing**.

Next time we can talk about Kevlar gloves to keep your fingers from leaving your hands...Barry

## Shop Tip

Gerald Franklin

I have resisted using wire wheels and cups on angle grinders because they are, in short, dangerous. Most 4" or 4 1/2" grinders turn at about 10,000 rpm and that speed causes problems when the wheel hangs up on the work piece. The high speed also causes the wheel to shed wires that can stick into your hide in some of the most interesting places. The wires can be rough on bystanders, too.

I started using a router speed controller to slow the speed of the grinder down. It makes the grinder/wire wheel much more pleasant and safer to use. I bought my controller at Harbor Freight for about \$19.

I have experienced no adverse effects of the grinder running at slower speeds.

### Description

**drillmaster**

**HARBOR FREIGHT TOOLS**  
Quality Tools at Ridiculously Low Prices

This router speed control works with any universal AC/DC brush-type motor, 15 amps or under, to give you control over your router speed. The result is longer bit life and better results depending on the application. Featuring a three-way rocker switch, the dial controls router speed as you work on wood, plastic and even aluminum.

- Plug your router into the control unit and you instantly have a variable-speed tool
- Works with any universal AC/DC brush type motor, 15 amps and under
- 6 ft. cord



# Quick Projects – Leaf/Spoon Swage

Gerald Franklin

A small piece of hardwood (or 4X4) can be used as a great little swage to shape leaves and spoons. Just burn the wood deeper as you use it.

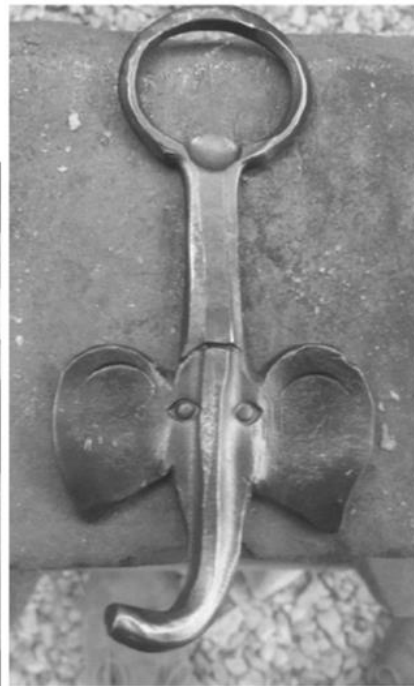
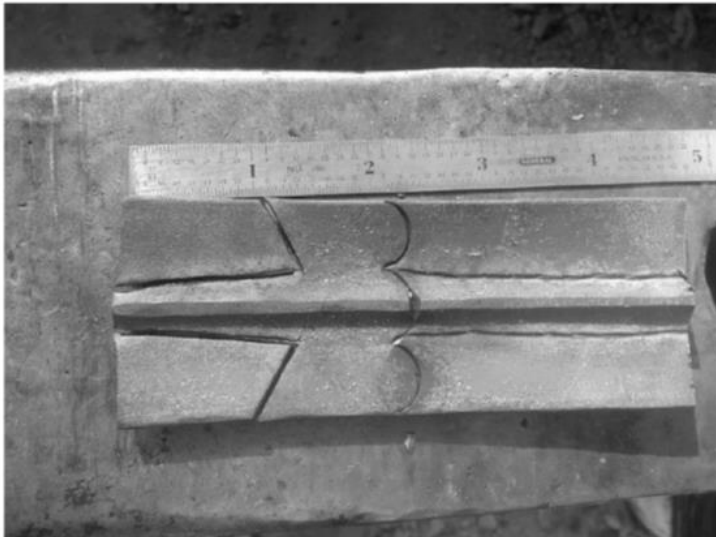
If the “swage” gets too deep, use a belt sander to remove wood until the desired depth is reached. When the wood block is about gone (we’re talking years of use here), just replace it with a new one.



The one in the photos is made from a piece of plum tree with an angle iron hardy shank attached with a self-tapping screw.



Here is a cute idea I saw somewhere - Facebook I think - that you might like! Think a flattened scrap piece of angle iron.



*This idea is reprinted courtesy of the Phillip Simmons Artist Blacksmith Guild “On the Anvil” newsletter - Editor*

## New DVD Illustrating Wrought Iron in the Washington National Cathedral Available...



The DVD, *Beauty in the Shadows: An Illustrated Inventory of Wrought Iron in the Washington National Cathedral*, is now produced and available for purchase. The description on the back of the sleeve sums it up concisely:

*"This disc is intended to complement "Beauty in the Shadows", a recently published book by Nol Putnam. The book is a work of art; a journey through the cathedral conducted by master blacksmith Nol Putnam. The photography is superb and the text captures the essence of the art form as only a master of the trade with a talent for writing could do. It includes major works and a sampling of detail.*

*From the early stages of planning the book it was intended to have a CD-based complete illustrated inventory, including the major gates and grilles with more detail, and all the railings, door hardware, light fixtures, statues and plaques. It includes all metals, distinguishing those that are wrought iron. Sit back and enjoy the wrought iron of the cathedral from the most magnificent gates to the most humble hinge strap or railing in 2,284 photos."*

James Pittman is a retired physician who provided both general and specialty tours at the cathedral for ten years. Over these years he has been photographing every aspect of the cathedral art. The original intention was to have better resource material available to his fellow docents. He has produced a book and CD on the 721 carved boss stones, a CD based atlas of the stained glass windows, a CD based virtual tour of the cathedral, and several virtual specialty tours, none published for sale to the public. The wrought iron DVD has been five years in the planning and production, and is available for \$25.00 from Dr. Pittman, 6824 Derby Run Way, Gainesville, VA 20155, or on Amazon at: [http://www.amazon.com/s/ref=nb\\_sb\\_noss?url=search-alias%3Daps&field-keywords=Beauty%20in%20the%20Shadows%20Pittman](http://www.amazon.com/s/ref=nb_sb_noss?url=search-alias%3Daps&field-keywords=Beauty%20in%20the%20Shadows%20Pittman)

## 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

## Club Coal

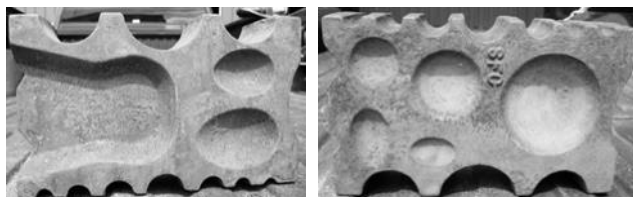
Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces The coal is \$140.00/ton or .07 /pound to members. **No sales to non-members.**

**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:  
(home) 918-245-7279 or (cell) 918-639-8779  
Please text his cell phone number if you would like to make arrangements to get coal.

**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. (Anything larger than 3X is considered special order and will take up to 2 weeks and will be at extra cost.)**



## 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 Secretary/Workshop Coordinator 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 Secretary/Workshop Coordinator 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, OK 73541

Non Profit Organization  
U S Postage Paid  
Oklahoma City, Ok  
Permit #2177

Address Service Requested

