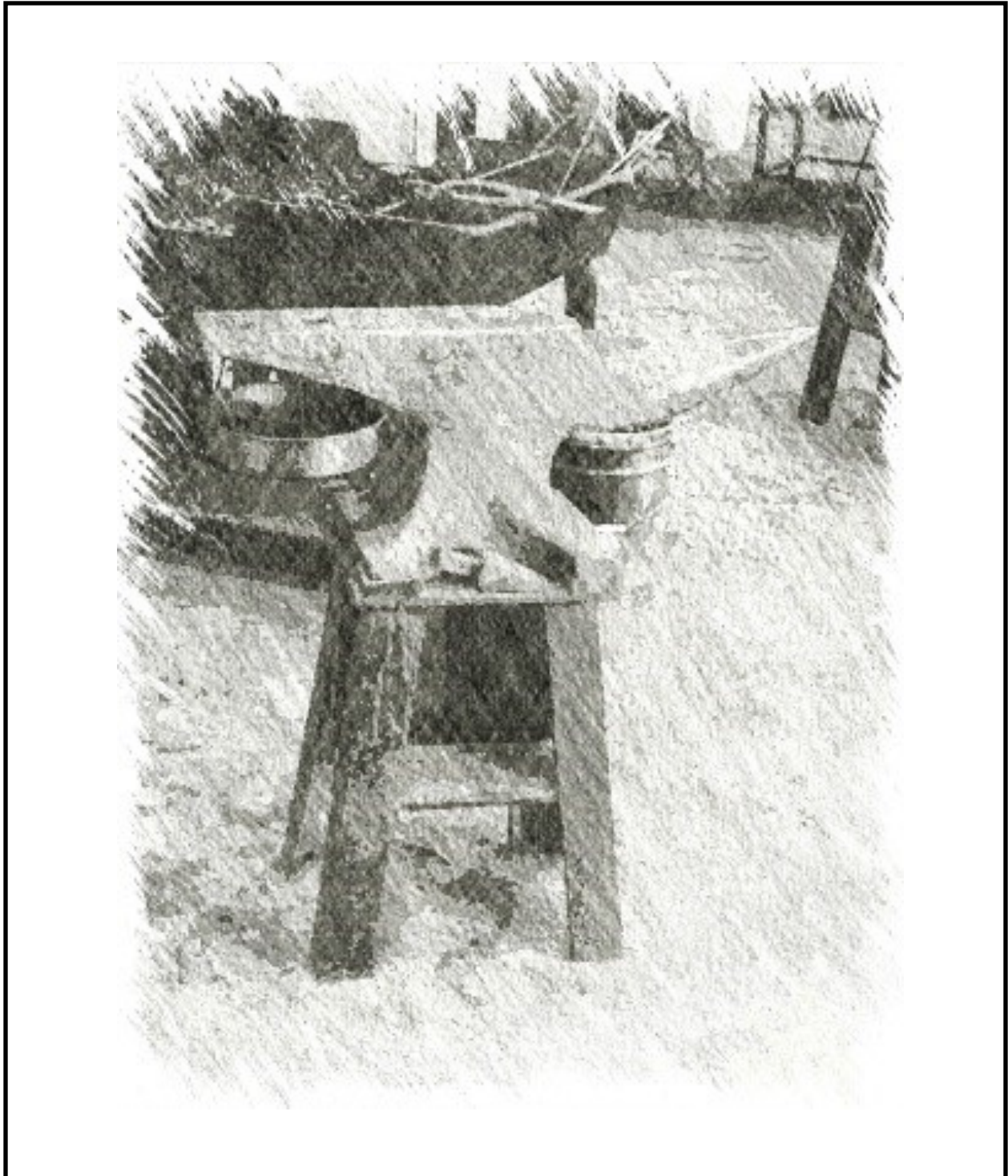


# Saltfork Craftsmen

## Artist-Blacksmith Association

January 2015



# Saltfork Craftsmen Artist-Blacksmith Association Officers and Directors

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## Editors notes...

This is my first newsletter as your new editor! I am still learning the publishing software and how the systems are set up but Diana has been very helpful in getting me off to a good start.

I have learned what all Diana had to do behind the scenes to get the newsletter published for the last 12 years and I can say she deserves many thanks. Even more so when you consider the other work she has been doing in addition to the newsletter. Diana will still be the Secretary and will now be fulfilling the role of Workshop Coordinator as well. That role will include coordination of Regional Meetings so meeting forms will still be sent to her. Regional Meeting reports can be sent to me for inclusion in the newsletter. Our final deadline for submitting to the printer is the morning of the 23rd of each month. In order for Regional Meeting reports, etc. to make it in that month's newsletter, I really will need to receive the information at least by the previous day if possible.

I am still working to get access to all of the available materials from other sources to include in our newsletter. Generally, these are going to be articles re-published from other ABANA affiliate newsletters. But I would also encourage anyone who has something to share to write an original article. When I first became a SCABA member, I was immediately impressed by the amazing talent of the membership. Odds are, you probably have a how-to project, shop tip/technique, special jig or fixture, or other relevant information that would be of great interest and benefit to the other members. It doesn't have to be fancy or even any specific length. Sometimes great information is only a single pic and a few lines of description. And, I would be glad to help organize a rough draft into final form if you like, including any pictures or rough hand drawn sketches.

I am very excited to fulfill the role as editor and I am looking forward to some great issues ahead. I welcome any comments, suggestions or ideas you may have anytime along the way.

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)

**Secretary notes..**

It is the start of a new year and although memberships don't expire until March 31st it is time to start reminding you to get them in the mail. In the next few weeks you will be receiving a reminder by mail if your membership expires in March 2015. If you don't get the reminder it means that you are still good for another year.

This is also an election year. The four board members that will be up for reelection are Mark Carter, Bill Kendall, Byron Doner and Mandell Greteman. If you are interested in running for the board and are a member in good standing then let the Secretary know that you want to be on the ballot. If you would like to write an article of introduction to the membership then get it to Russell Bartling our new Editor. If you are on the board and DO NOT wish to be on this year's ballot please let the Secretary know ASAP.

Hope you have a Happy Start to this New Year. -Diana Davis

**2015 Workshop and meeting schedule:**

It's January and the beginning of a new year. Many of you may not have given any thought about what meetings you want to attend or host but those of us that have the responsibility of keeping track of them have already been hard at work. The NW region has all their meeting dates filled and have even set up workday/play days in each of the months with a 5th Saturday.

**NW region workshop/play day schedule:**

**January 31st –Play day hosted by Bob Kennemer at the Elk City Museum**

**May 30th– Workshop—Hammer Class– Elk City Museum**

**August 29th– Play day– hosted by Don Garner at 23713 E. 860 Rd.**

**Thomas, Ok. 580-661-2607**

**October 31st– Workshop– pattern welded steel by Gerald Brostek at the Blacksmith Shop at the Elk City Museum Complex.**

If you are interested in attending either a play day or workshop in the NW Region please contact Bob Kennemer or the host of the event. Regular monthly meetings are always open to anyone that wishes to attend.

Now the rest of us need to get on the ball and get those workshop ideas into the Workshop coordinator, Diana Davis, so she can get them set up and in the newsletter.

Diana not only keeps track of the workshops but the monthly meetings. 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. All you need to do is find a location that is big enough for the number of students you have along with the necessary equipment. There are four forges and other necessary equipment available for a SCABA instructor to use in the teaching trailer. So you can limit the class to four or get other members involved in the class or have the students bring their equipment. It is always good to learn on the equipment that you own. 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)

## President notes:

Each month I experience something called writers block. This month however, I think I have Blacksmith's block. It seems I can't make anything happen! I'll start on something, then decide that's lame, and throw it down. Or just as I start, someone will call, or walk in. After several interruptions, I sometimes get the time to hammer, but instead, I sit and brood about all the distractions, and end up wasting even more time!

As Christmas gets closer and closer, (I wrote this a few days before Christmas) the pressure is really on to produce ironwork. Folks wanting us to make things so they can mark someone off their list, along with the things we wanted to make to take care of our own lists. You would think that I'd be hammering like there was no tomorrow. But it just will not come! I expect other people have these kind of problems too. I know that I have seen other people at meetings that wanted to hammer but were just kind of bashful, or afraid that they might mess up in front of someone. I know that I certainly have been guilty of that very thing. Most folks just need a little push, or a little guidance.



When I first got interested in blacksmithing, I would load all my stuff, and go to a meeting. Usually everyone would be already hammering when I got there. I would park my truck, and then just stand around and watch others hammer. One day, as I pulled up, Max Scrudder told me;" Korny you back that truck up, and unload it! You're hammering today boy!" I did, and had a good time, just as I always do when I beat on the iron. I'm sure Max had no idea how much he helped me that day. Thank you, and I miss you Max!

Since then, I have tried to pay this forward. I have tried to give folks that little push that they needed, and I hope that you will do the same. For those of you who didn't know Max, he was a wonderful Blacksmith who helped a lot more people than just me. In writing this, I'm hoping to help other people to keep from locking up as I have. I really envy those people, who will go ahead and try, while knowing, that they might mess up.

Well, I have about two days to make things for about seven people so I guess I should stop babbling and get to work.

I hope everyone had a Merry Christmas, and a very prosperous new year!

- Byron

## **Regional meetings:**

### **January meetings**

- ⇒ SE Regional meeting. (Jan 3rd) open
- ⇒ NE Regional meeting (Jan 10th) open
- ⇒ SC Regional meeting (Jan 17th) open
- ⇒ NW Regional meeting will be hosted by Gary Seigrist at the Route 66 Museum Blacksmith shop in Elk City. Lunch is provided, bring a side dish to help out. Trade item is an animal from a horseshoe. If you need more information you can contact Gary Seigrist at 580-243-8228

### **2015 meeting dates....**

<u>SE Region (1st Sat )</u>	<u>NE Region (2nd Sat )</u>	<u>SC Region (3rd Sat)</u>	<u>NW Region (4th Sat)</u>
Jan.3rd	Jan 10th	Jan. 17th	Jan 24th Gary Seigrist
Feb. 7th	Feb. 14	Feb. 21st	Feb. 28th Bob Kennemer
March 7th	March 14th	March 21st	March 28th Mandell Greteman
April 4th	April 11th	April 18th	April 25th Monte Smith
May 2nd	May 9th	May 16th(JJ McGill)	May 23rd Terry Kauk
June 6th	June 13th	June 20th(R. Vardell)	June 27th Don Garner
July 4th	July 11th	July 18th	July 25th Gary Seigrist
August 1st	August 8th	August 15th	August 22nd Dorvan Ivy
Sept. 5th	Sept. 12th	Sept. 19th	Sept. 26th Roy Bell
Oct. 3rd.	Oct. 10th	Oct. 17th	Oct. 24th Cheryl Overstreet
Nov 7-8 conference	Nov. 14th	Nov. 21st	Nov. 28th Mandell Greteman
Dec 5th	Dec. 12th	Dec. 19th	Dec:26th (Merry Christmas)

Meeting hosting form can be found on page 15 along with membership application form.

## **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 Baily 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*

## Around the state...

The November Meeting for the North West Region was hosted by Mandell & LaQuitta Greteman at their shop in Foss, Okla. There was a great turn out the meeting even though it was a little cold and foggy that morning but cleared off after lunch 30 members was on hand . There was some amazing item for the trade item. The trade item was coat items made from a horse shoe. Everyone enjoyed sharing their idles and tell story's around the fire. They keep the forges going all day . After lunch Mandell showed how to melt aluminum and make a casting in sand is was a small anvil. Lunch Fry Fish and all the trimmings and a big Thank you for the wonderful deserts that were brought. We would like to say " Thanks to everyone that came and a Big Thank You to the lady's that



help with the food and the clean up.

The Greteman's



NE: No meeting was held in December.

SE: No meeting notes available.

SC: There were five candle holders traded at Linda and Larry Mills' meeting on December 20th. We were all glad to see Ron Lehenbauer, who had drove himself down. He's getting better folks! -Byron



Here's hoping you made it on the naughty list last month...

...after all, who doesn't love coal?!!

Happy New Year!

Looking Back...

Following are How-To Articles in the SCABA Newsletter for the last three years looking backward from the current date...

## SCABA Newsletter How-to Article Index - 2014

Dec	Bornholm Belt Buckle Channeling Blacksmiths of One Thousand Years Ago Herb Chopper Christmas Tree
Nov	Reindeer Shoe Tree Ornament Dutch Oven Lid Lifter Shop Tip – Cleaning Scrolls – Jim Carothers How to Form a Fork with Two Tines
Oct	How to Start a Forge Fire Blacksmith Equipment and Tools Forging a Rectangular Pass Through
Sep	Sticking Sticky Tommy Bag Tongs
Aug	Etching Wrought Iron Leaf Napkin Ring Live Up to Expectations.....Work at a Snail's Pace
Jul	Moose Hook
Jun	Clay Pot Hook Pineapple Twist – Diana Davis Sketch Book Blacksmithing Videos from PBS The Woodwright's Shop
May	John McLellan's Simple Tongs
Apr	Wooden Wagon Wheel Work Owl – Diana Davis Sketch Book Bill Fugate's Collar Jig
Mar	Making the Patrick Pelgrom Tongs Bottle Opener Building a Forge From a Water Tank Workhorse Pick-up Tongs
Feb	David Knight Broom Handle – Jim Carothers Equal Length Leg Bending Fixture – Jim Carothers Mini Torch Forge Hummingbird Heart Trivet Heart & Scroll Hook
Jan	Traditional Chest Part 2-Aubrey Washington Frame Joint Handy Vice Tooling Shop Hacksaw

## SCABA Newsletter How-to Article Index - 2013

Dec	Christmas Ornament Hanger Reindeer Shoe Tree Ornament Iron Candy Canes Ringing in the New Year (Bells) Shovel Blank – Ricky Vardell A Poor Man’s Version of the Smithin’ Magician Strike While the Iron is Hot (Starting and Tending Your Fire) Sectional View of Blacksmithing Fire
Nov	Forging Wrenches Traditional Chest Part 1 – Aubrey Washington 3-D Snowflake
Oct	Rivet Tool How to Attach a 6” Machinist Vice to Your Anvil Cap Lifter Dutch Oven Lifter
Sep	A Chalk Board in Your Shop – Jim Carothers Bag Tongs Thread the Needle Handle A simple Leaf Bending Angle Iron
Aug	Forge Welding – ABANA Controlled Hand Forging
Jul	“Toe Stools” A Glass Act Cutoff Storage solutions Cup Hook Calla Lilly
Jun	Japanese Hosta Sprout John Graham’s Forging a Pair of Open Jaw Tongs
May	Dutch Oven Lid Lifter Chain Making the CoSIRA Way
Apr	Texas BBQ Fork Camping Gear Trivet of the Month – Friedrich Style
Mar	Forging Leaf on Rod (or Bar) Tool Making for Anvil, Power Hammer, Treadle Hammer, and Hand – Part 3 Cow Bell
Feb	18 <sup>th</sup> Century Tasting Spoon Heart & Scroll Hook Tool Making for Anvil, Power Hammer, Treadle Hammer, and Hand – Part 2
Jan	A Forged Rosette Christmas Ornament Hanger Lantern Brackets

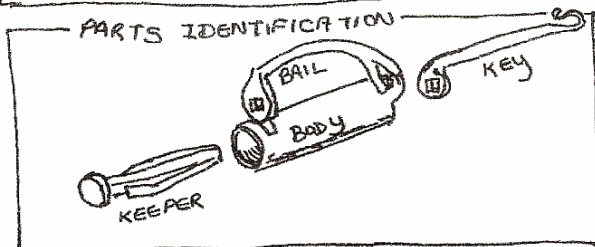
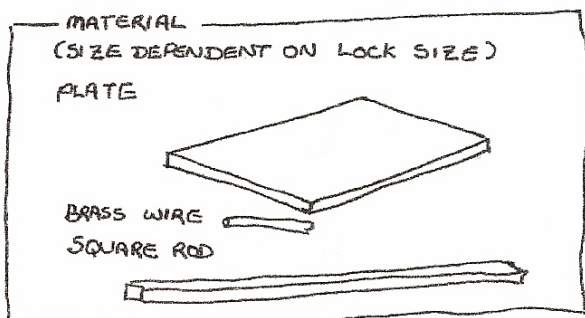
## SCABA Newsletter How-to Article Index - 2012

Dec	Taking the Slack Out of a Rivet Joint – Jim Carothers Tom Nelson Wall Hooks Tips From a Friendly Fire Roasting Spit
Nov	Fabricated Crosses – Don and Myrtle Shunk Holiday Candle Holder
Oct	Oak Leaf Boot Scraper Bill Morris Napkin Rings
Sep	Wagon Wheel Bender – Other Uses Tree Hook Wedge Joint Rivet Cutoff Tool – Jim Carothers
Aug	BBQ Grill Brush Pitchfork – Diana Davis Sketch Book Toolholder – Diana Davis Sketchbook
Jul	Beginners Corner – The Ribbon Scroll Feeding the Army – Two Tine Flesh Fork Angle Iron Garden Trowel
Jun	Upsetting Vice Patinas On Copper Forge a Pepper Cooking Tongs
May	The Ring Thing – Part 3 Flat One Sided Dolphin Leafing Jig
Apr	The Ring Thing - Part 2 Kinyon Simple Post Vice Kinyon Post Vice-Another Version The Crimping Stake Wagon Wheel Bender – Other Uses
Mar	The Ring Thing – Part 1 Outdoor Thermometer Stand – Gerald Franklin Forged Leaves
Feb	PMC Clay – Diana Davis Oak Leaf Boot Scraper Cooking Pot Tripod Two Dimensional Bear's Head Powdered Ferric Chloride Heart Hook
Jan	Heart Hook Forge a Pepper From a Good Hammer to a Great Hammer

## VIKING LOCK

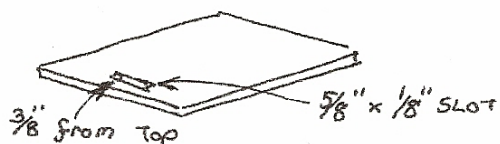
DEMONSTRATOR: ELMER ROUSH

ILLUSTRATOR: JIM GUY



## FORM BODY

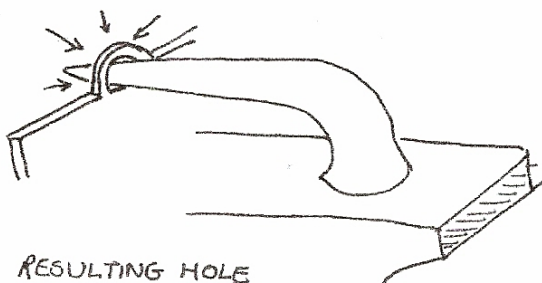
PUNCH SLOT FOR BAIL



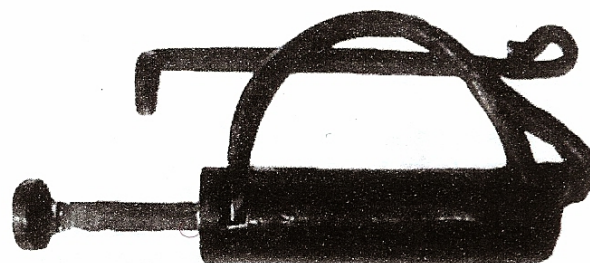
DRIFT OPEN



FORM ON BICK

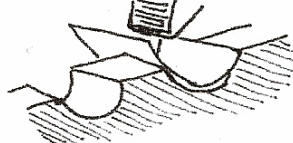


RESULTING HOLE

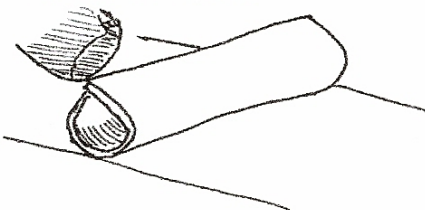
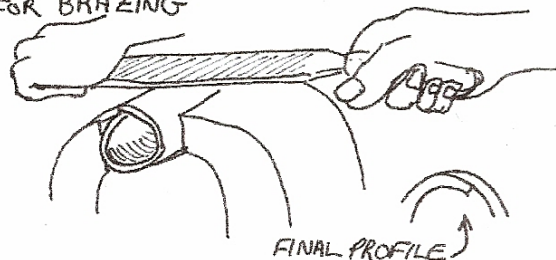


FORM BODY INTO CYLINDER

START CURVE IN SWEDGE BLOCK

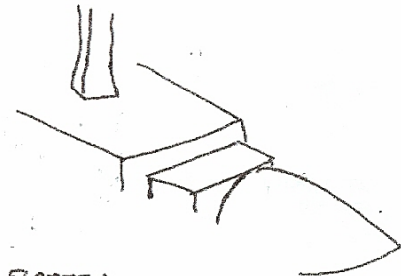


ROUND ON ANVIL

FINISH ROUNDING USING  
A METAL CYLINDER AS A MANDRELCLEAN UP JOINT IN PREPARATION  
FOR BRAZING

# FORM BAIL

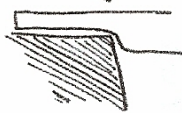
UPSET END OF SQUARE BAR



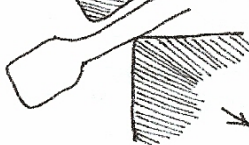
FLATTEN



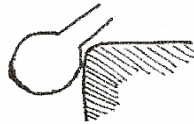
THEN HALF FACE BLOWS



FULLER OUT NECK



THEN ROUND END



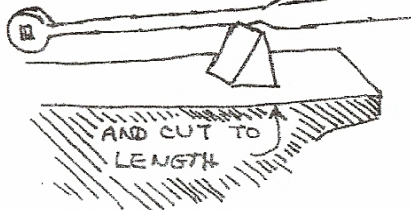
PUNCH SQUARE



THEN DRIFT TO SIZE OF KEEPER

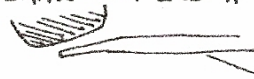


ROUND SHAFT OF BAIL



AND CUT TO LENGTH

DRAW OUT END A LITTLE



THEN FORM EYE



FIRST BEND

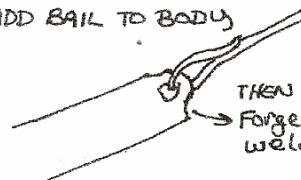


SECOND BEND

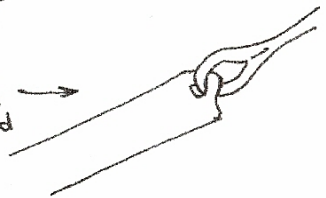


SHAPE UP EYE

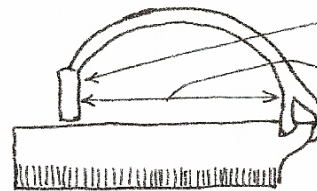
ADD BAIL TO BODY



THEN FORGE WELD



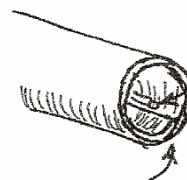
BEND BAIL TO SHAPE



BEND END TO BE PERPENDICULAR TO BODY WHEN CLOSED

LENGTH MUST FIT SIZE OF BODY

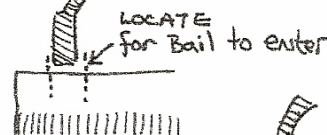
BRAZE BODY SEAM



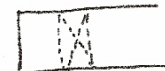
LAY BRASS WIRE ON SEAM  
SPRINKLE BORAX ON TOP  
HEAT UNTIL BRASS MELTS  
(THEN REMOVE FROM HEAT IMMEDIATELY!)

CAPILARY ACTION WILL CAUSE BRASS TO FLOW INTO THE SEAM.

CUT SLOT WITH HACKSAW

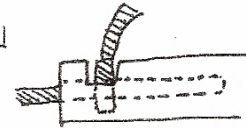


LOCATE for Bail to enter



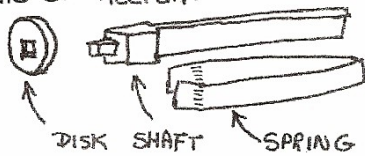
First cut "X" then sides then clean up with FILE

THEN ALIGN SO BAIL, KEEPER AND KEY WILL BE STRAIGHT



## FORM KEEPER

## PARTS OF KEEPER:

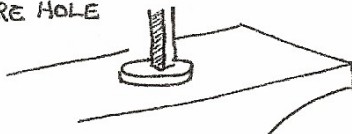


PUNCH DISK FROM  $\frac{3}{16}$ " THICK MATERIAL

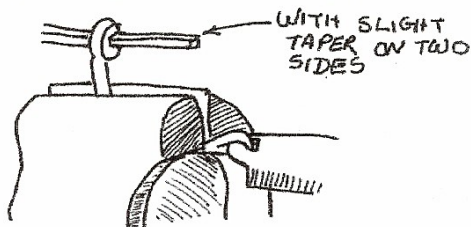
PACK COALS DOWN, PLACE DISK ON TOP AND KEEP SIGHT OF IT!



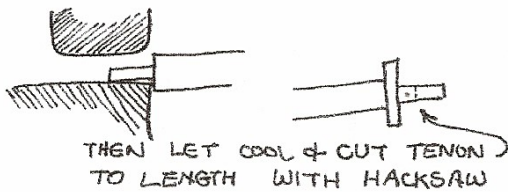
PUNCH SQUARE HOLE



FORGE SQUARE SHAFT TO FIT BAIL



FORM TENON ON END



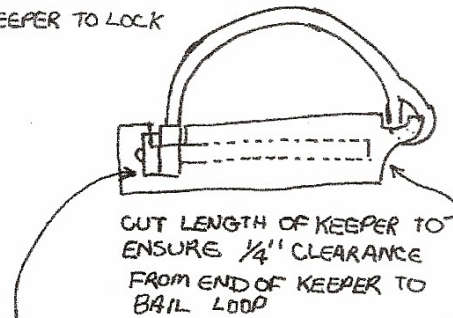
HEAT AND SPREAD TENON



SQUARE DISK TO SHAFT

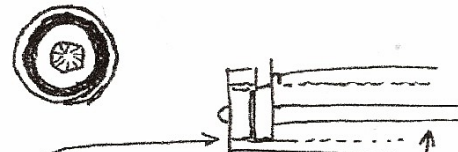


## FIT KEEPER TO LOCK



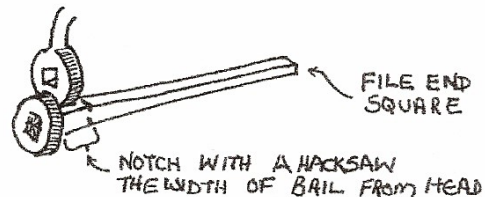
WANT KEEPER TO REST AGAINST THE BAIL, BUT NOT BIND ALONG ITS LENGTH

FILE DISK UNTIL CLOSE FIT TO BODY INTERIOR

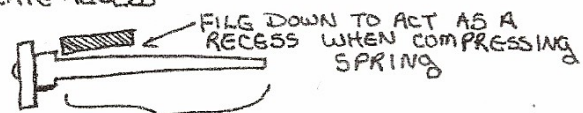


FINAL FIT SHOULD HAVE KEEPER FLUSH WITH END OF BODY, AND SHAFT EXTENDING DOWN THE CENTER OF BODY

PREPARE KEEPER FOR SPRING



CREATE RECESS



SPRING LENGTH TWICE THIS

FORM SPRING



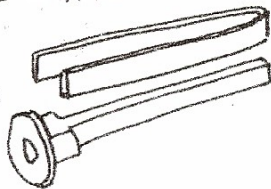
FORGE AS THIN AS YOU CAN, THE WIDTH OF THE KEEPER TO THE LENGTH NEEDED ABOVE.

CAN USE 1045 STEEL FOR THIS (WHICH IS PROBABLY ALL THE VIKINGS HAD)

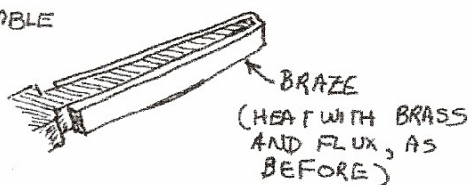
### TEMPER SPRING

BRING TO CRITICAL TEMPERATURE  
AND QUENCH. (IT'S ALL YOU  
HAVE TO DO FOR 1045 STEEL)

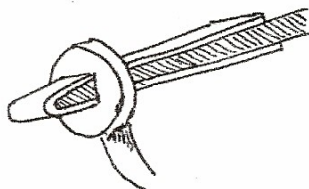
### FOLD SPRING



### ASSEMBLE



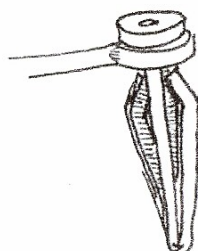
### FILE TO FIT BAIL



### ADD SLIGHT TWIST TO END OF SPRING



### ENSURE KEEPER LATCHES TO BAIL



MAKE KEY

### NECK DOWN



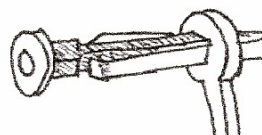
### FORM KEY END



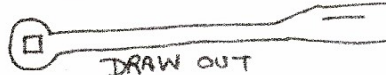
### PUNCH SQUARE HOLE



### DRAFT TO FIT KEEPER



### FORM HANDLE



DRAW OUT

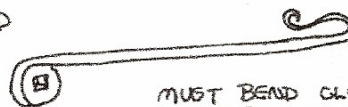


CUT TO LENGTH & TAPER



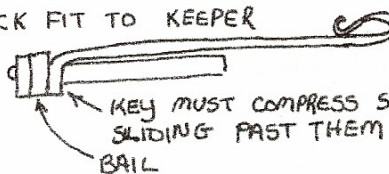
CURL & TWIST TO TASTE

### BEND



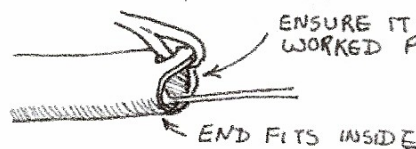
MUST BEND CLOSE TO HOLE  
TO ENSURE CLEARANCE WHEN INSERTED

### CHECK FIT TO KEEPER



KEY MUST COMPRESS SPRINGS WITHOUT  
SLIDING PAST THEM  
BAIL

### FIT TO LOCK BODY



ENSURE IT CAN BE  
WORKED PAST BAIL

END FITS INSIDE



### Treasure Chest Padlock

A pirate's treasure chest with forged hinges, hasp, and reinforcing straps would look a little odd with a Master Combination Lock on the front. Never having forged a padlock I started by looking through blacksmithing books for examples. Few were found and those I did find gave no clue as to their internal workings. I was able to look at a few antiques that Tal Harris has in his possession which helped. Peter Ross was kind enough to provide a sketch of a padlock that was recovered from a ship that sank in the Delaware River in 1759. Needing a period lock I decided to reproduce the one sketched by Peter.

All the pieces other than the pins were made out of mild steel. The pins were made out of large soft iron rivets. The first item to make is the key as this becomes your pattern and test piece. All other parts are made to the scale of the key. See the sketch for how the key was made. In fact, the sketches should give you all you need to build your own lock.

The front and back plate were cut from 16 gauge steel as was the side piece that goes all the way around the lock. The front and back plate are held together with pins with the side piece acting as a spacer. The holding pins around the edge of the lock were made out of soft iron each with three tenons, one holds the side plate, one holds the front plate and the third holds the back plate, see diagrams. The side tenon was made first then both ends were forged. An alternative method of making the pins is shown in the diagrams. Lots of file work and tests were made to get the right spacing. Rivet the pins to the side piece first and use this as a gauge as to where to drill the holes in the front and back plate. I did it in reverse and had a heck of a time getting things to fit.

If you use them the internal wards are pinned to the inside of the front plate. The key is used as your gauge for making and the placement of the wards. The wards must be finished and attached before the lock is assembled. Also the sliding key hole cover needs to be finished and attached before you assemble the lock.

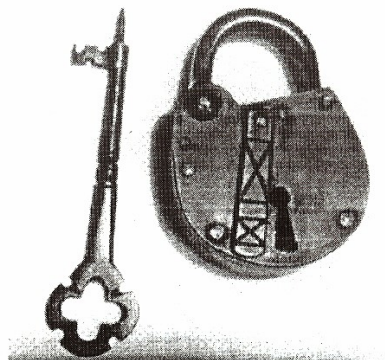
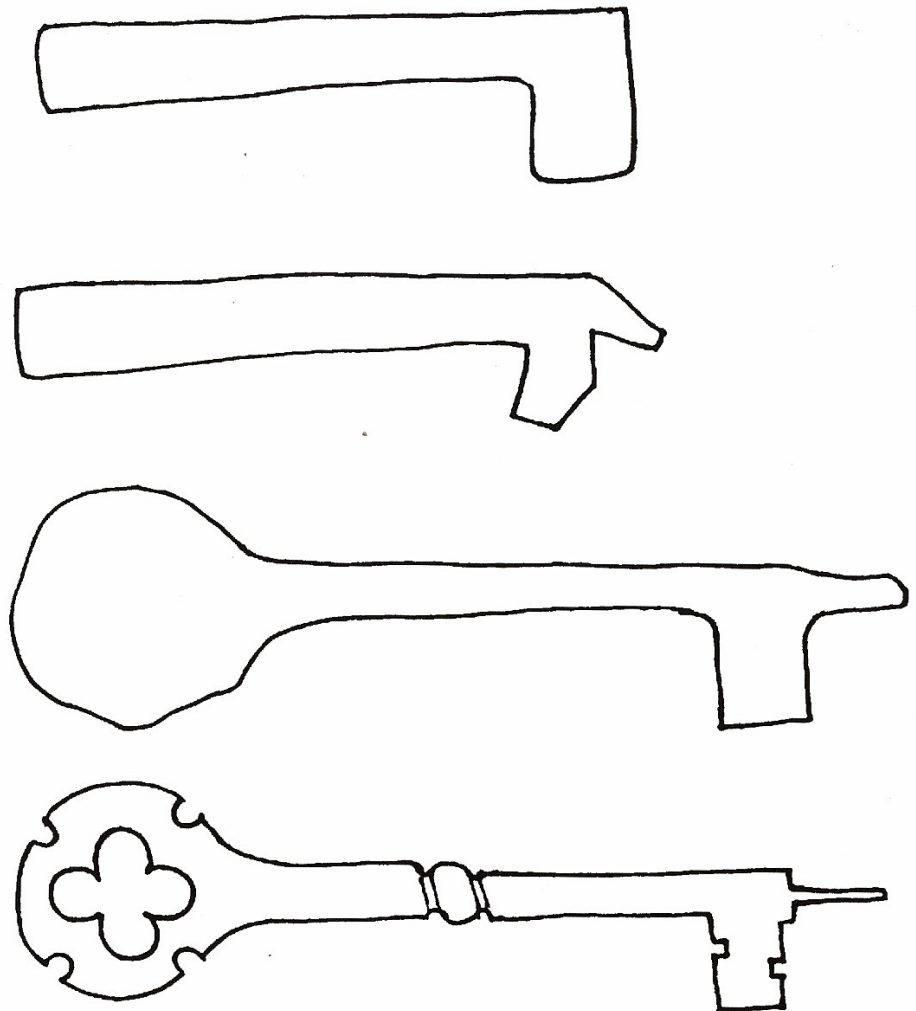
The sliding internal bolt is attached to the inside of the back plate with two yokes that are pinned to the back plate. These yokes need to hold the sliding bolt centered between the front and back plates. The placement of the yokes is important so that the bolt does not go to far in either direction and fall out once the lock is assembled. Again the key is used to check the bolt's operation before the lock is assembled. Lots of dry assemblies, file work, and more assemblies are required before you head over the final rivets.

The curved hasp rod was forged and added to the lock after the lock body was assembled. Think ahead as you work. Don't rivet things together before you check what comes next. It is a lot of work to drill out a rivet and remake a pin, I know. Good luck on your own lock. I think I'll try the next one out of wrought iron and let it antique outside for a few months. I'd like to hear if anyone knows of a good book that details the internal workings of old locks.

Doug Merkel

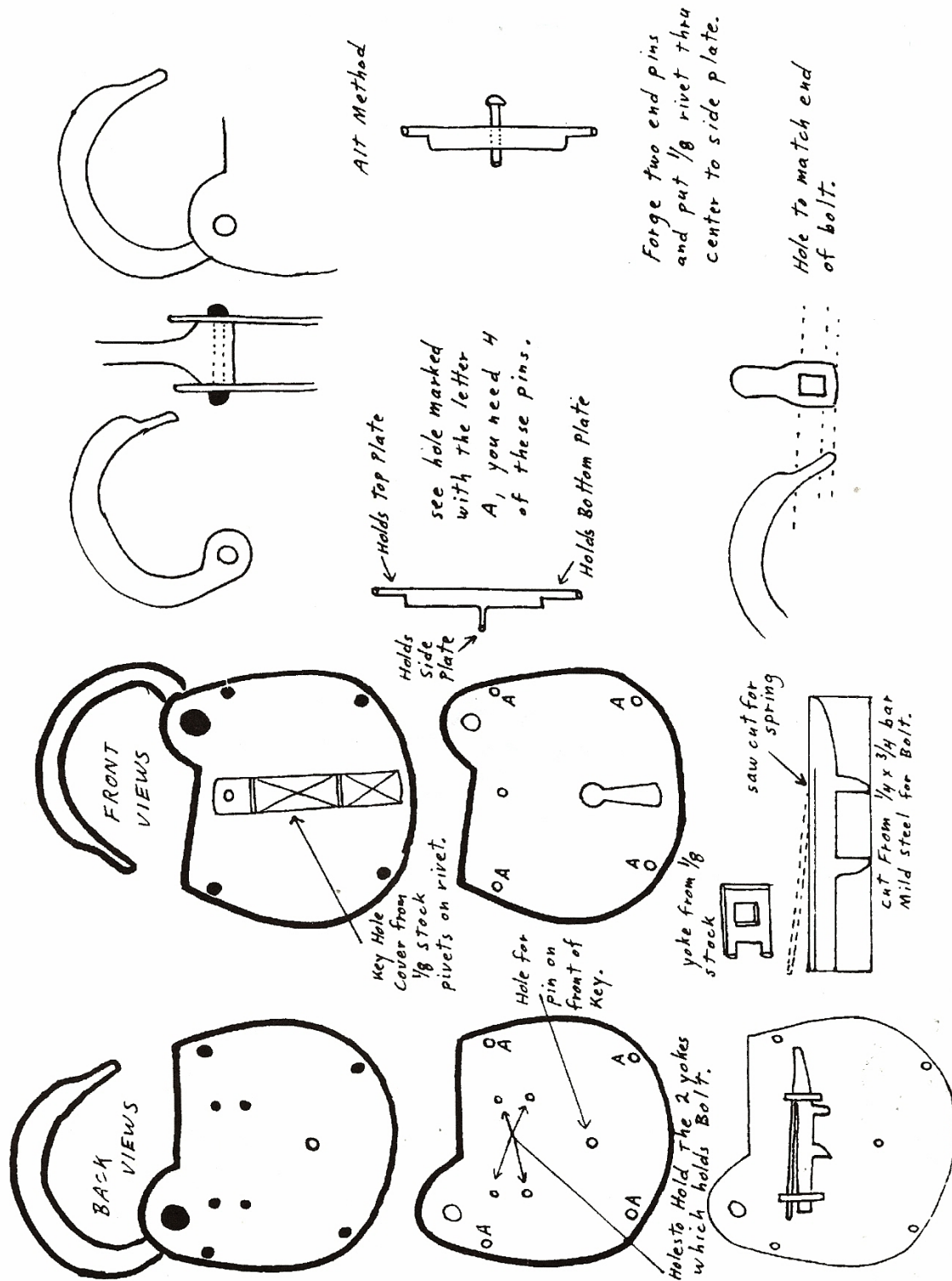
Reprinted from The Ocmulgee Blacksmith Guild Chapter of ABANA newsletter.

**North West Blacksmith Association**



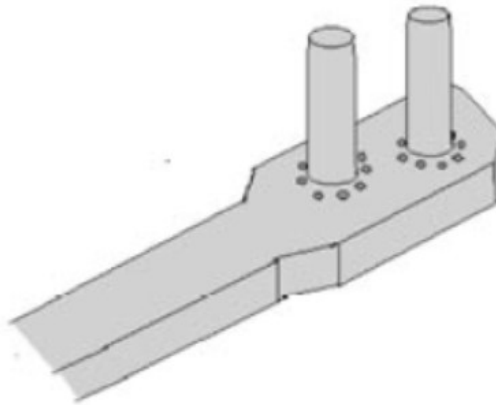
**North West Blacksmith Association**

page 27



## A Quick Scroll Wrench

Jim Bequette [j.d.bequette(at)gmail.com]



- 1) Start with a piece of flat bar suitable for the size of the wrench needed (I used 3/4" x 1/2" for my last one). Dress the corners of the bar.
- 2) Punch or drill two holes for the prongs. Make sure there is adequate material on the side walls of the holes. I used 7/16" diameter.
- 3) Forge a taper on the end of some 7/16" round stock for the prongs. When you calculate the length be sure to account for the thickness of the handle material when you decide on the length.
- 4) With the prongs in place take a heat and use a center or ball punch to punch a number of dimples around the base of the prongs. Place them close enough to the prongs so the material grips the prong tightly.
- 5) Dress all sharp edges.

This tool can be forged quickly with minimal tooling and works well. I place my dimples in an alternating pattern (12 o'clock, 6 o'clock, 9 o'clock and so forth). You can draw the handle out or leave it full. I find it convenient to leave it full so I can lock it securely in the vise when needed.

### *Editor's note:*

*Jim told me that you can put a spot of weld on the back side, but it really isn't necessary. He has had prongs bend and the places crimped by the punch marks held them tight. Bob*



## Light up Your Pipe by Jeff McCrady

ABA (Appalachian Blacksmith Association) held their annual Fall Conference in October and our friend and demonstrator, Jeff McCrady, donated an interesting candlestick to their auction. The design shares a medieval look as well as a contemporary style as well as a rustic flare. The added texture can reflect your particular interest and style.



### Materials:

3/4 " Black Iron Pipe, the rustier the better if you want texture! Start with a section pf pipe between 10-16" long.

(How could you not give this project a try!!!)

### How to:

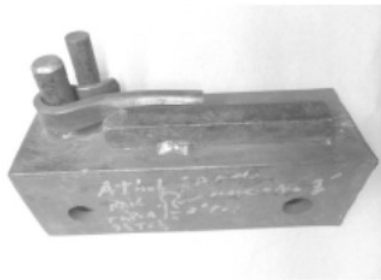
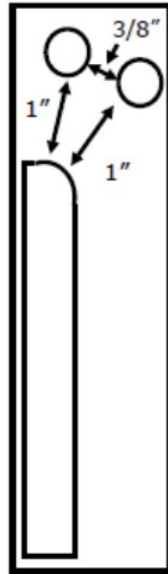
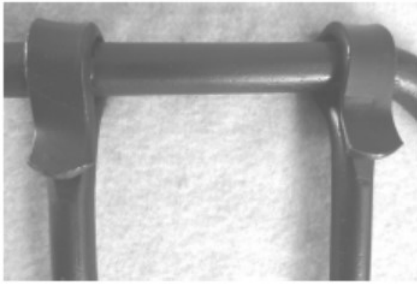
1. 1" from the end, neck back pipe with a smithin' magician or use an anvil. You can also make dies for your power hammer to neck down the pipe.
2. Come back down 1/2" and neck again for "bulb" underneath candle cup.
3. Take about 4" and forge out to about 6" and square it up. It will pucker a bit but as Jeff says, "That's the beauty of it".
4. Once it is in the square shape, measure off approximately 10-12 inches and slit it up the center on top only.
5. Peel it open using pliers, wedge it open, whatever you need to do to open it up!
6. Then start at the bottom and hammer the edged in.
7. Texture, add rivets for detail, embellish it with your choice of design.
8. Use a decorative nail or screw at the top.
9. Bend up cup as the final step . Prior to this step, the candle cup can be use as a convenient handle and you work through this project.





### A Way to End it All! By John Steel

This simple technique to terminate a picket can be applied to a number of projects, not just railings. It is a unique embellishment to add and fun to make. You need to make a jig to fit your material. We used 5/8" round for this railing, but you can adjust your tooling accordingly. Use a piece of angle iron and weld on two round pins. Both can be 5/8" or the size of the top bar on the fence. Pins need to be 2 times as high as the square bar w/radius corner on the jig. Space them 3/8" and 1" from square bar. Start by heating to a bright red and draw out 2" to achieve 3 1/2" tapering from the original bar size to 1/4" on the end, maintaining original bar width. Bend about 1" about 30° forward and the remaining amount backward as shown in photo.

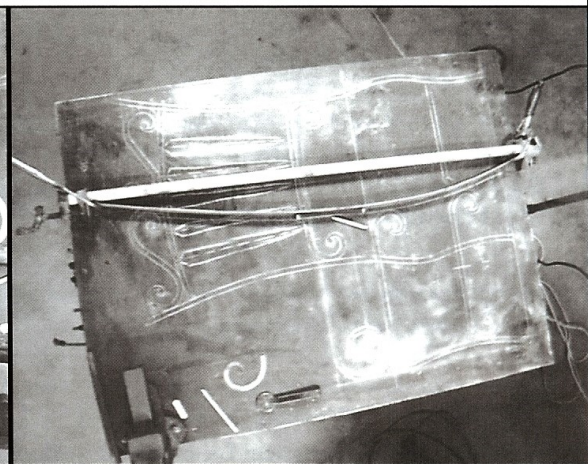
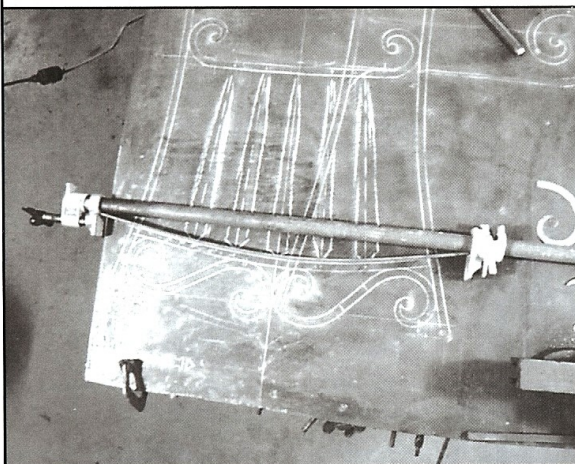


The square bar welded to the angle is to keep this picket in line with the center line of the top bar on the fence.

### COOL TOOLS

#### Smooth Curve Jig by Clay Spencer

You don't have to go to Lee Valley for a smooth curve jig. Here are two photos of 2 curves I did in 2005 while making a couple of chairs in my shop in Murphy, NC. A length of 1/4" x 1" and a pipe clamp will do the job.



### Across

1. The part of the tongs where the rivet goes.
2. A tapered tool around which metal is shaped, i.e., axe eyes
4. I.e., 'Bick'
5. The last two numbers in a steel's AISI classification are the percentage of '\_\_\_\_\_' content.
10. White marking tool very popular for blacksmiths and metal workers
11. To heat to critical temp and hold before slow cooling to soften steel
12. Simple measuring device consisting of a wheel and a handle
13. Iron with a distinctive grain and no carbon content
16. Tapered steel punch used to open up holes to correct size
18. The type of coal most often used by blacksmiths, aka 'soft' coal
20. What modern blacksmiths use most instead of wrought iron
21. The pipe that feeds air to the forge firepot
24. To make a section larger, or what it is to your spouse when you buy another 'necessary' tool
25. '\_\_\_\_\_' first. (Or second or third as Lorelei Sims quipped at the 2014 SCABA Conference).
26. Round hole in an anvil good for punching holes over
28. Tool with a recessed shape or the act of driving iron into such a recess

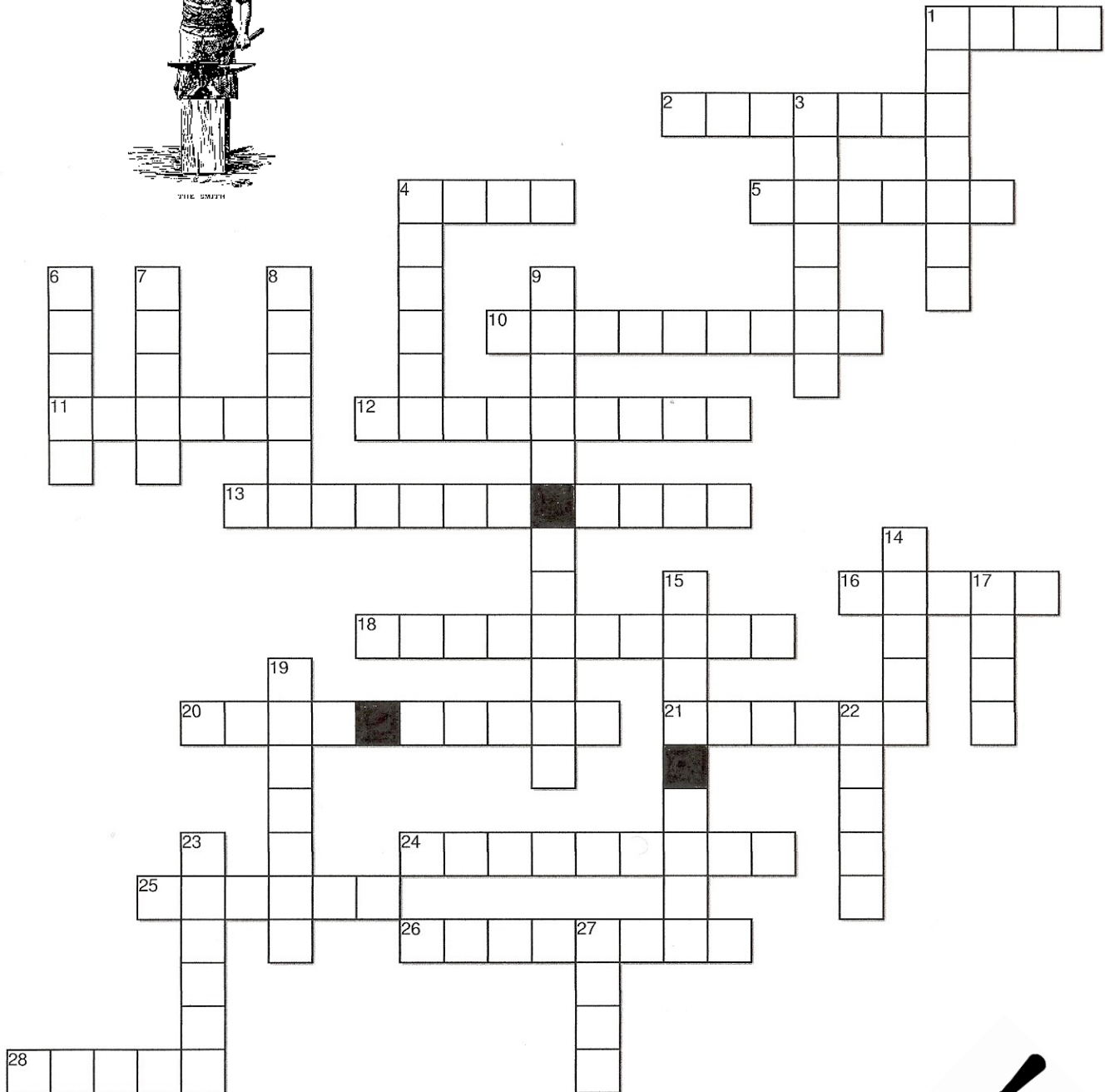
### Down

1. Air delivery device usually made of wood and leather. Also what some blacksmiths do when they unexpectedly grab hot iron - he '\_\_\_\_\_.'
3. Stretching out and reducing cross section. Also what you should always start a complicated blacksmith project with.
4. A tool used to form the top part on nails or bolts, etc.
6. Simple flux and/or household cleaner
7. Correct name for Tong 'Handles'
8. Rounded edged tools used to isolate a mass. Also what you are after eating a second helping.
9. Modern tool that takes the place of the extinct creature sometimes referred to as a 'striker'
14. Salt water quench
15. A major work holding tool designed to hold up to the rigors of blacksmithing operations
17. Prevents oxidation when forge welding
19. Undesirable byproduct at the bottom of a firepot. Named for its characteristic sound when struck.
22. A mechanical means of joinery using a pin with an enlarged head set on each end
23. Any tool that is made to fit into the square anvil hole. Also partner in comedy team Laurel and "\_\_\_\_\_." (The longer of two possible spellings.)
27. Coal with the impurities removed by heat, nearly pure carbon



# Blacksmith's Terminology

Complete the crossword below



**Answers**  
**Across:** 1-Boss, 2-Mandrel, 4-Horn, 5-Carbon, 10-Soapstone, 11-Anneal, 12-Traveler, 13-Wrought Iron, 16-Drift, 18-Bituminous, 20-Mild Steel, 21-Tuyere, 24-Upsetting, 25-Safety, 26-Pritchel, 28-Swage.  
**Down:** 1-Bellows, 3-Drawing, 4-Header, 6-Borax, 7-Reins, 8-Fuller, 9-Power Hammer, 14-Brine, 15-Leg Vice, 17-Flux, 19-Clinker, 22-Rivet, 23-Hardie, 27-Coke

## 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 o Mike-Marideth@sbcbglobal.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.**

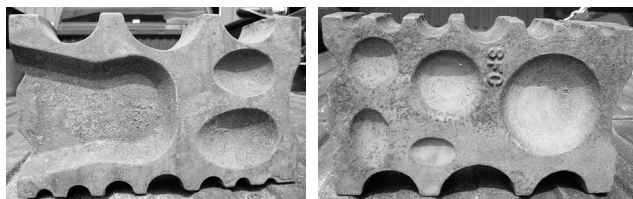
**NW Region coal pile is located in Douglas, OK.** If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of \$10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence 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.

**Show your pride in SCABA**  
**License plates for \$5.00 each.**  
**We have a few caps for \$10.00.**

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.

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.  
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Sand Springs, OK 74063

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