

Saltfork Craftsmen Artist-Blacksmith Association

May 2015



Gerald Brostek was the winner of the forge welded ring contest at the 2015 SCABA Annual Picnic. The trophy was made by Mandell Greteman.

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Editors notes...

It was great to get a chance to visit with everyone at the 2015 Annual Picnic. I am still trying to put some faces with names so it was a great place to see a lot of people at one time and I was glad to be a part of it.

It was a fun day even though I never actually touched a forge or a hammer. If you have not been to the Elk City Blacksmith Museum, it is really something to see. This was only the second time I have been down there but it is definitely worth the drive. They have just about anything and everything related to blacksmith tools. A lot of my stuff is usually somewhat worn out or homemade so it is good to see what some of those old tools were supposed to look like in near new condition.

Several people had some good ideas for the newsletter and I really appreciate those comments. One comment I heard more than once was that members really like to see the meeting notes and photos from monthly meetings. Another comment from some members was that they would like to see more on some of the items produced at the monthly meetings more than just a single photo in the newsletter. I have to agree. Many times, there are really interesting trade items or just items made at the meeting that really would be great subjects by themselves. I know it can be hard to take photos during forging but it would be something that many members would like to see.

Another comment was that we are getting a lot of new members so even some basic information on forging topics or how the association works would be helpful to many. Specifically mentioned were the iron in the hat and peoples choice at the Annual Conferences and how the monthly meetings work including trade items. This probably is common knowledge to many who have been members for years but is not the case for new members. I will try to do a better job of incorporating that type of info in the future.

Please keep the comments coming!

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

President's Notes:

We have lost another one of our original 13 members. Those of us who knew Levi Rutledge, can attest to the fact that Levi was a very good blacksmith. He was also a member of many Farriers clubs. He was 81 years old.

I rode with Bill and Diana Davis to the funeral. Ron Lehenbauer rode with Jim Carothers and they got there right after we did. Gary Gloden was already there and I believe there was one more guy from Saltfork but I did not know his name.

The funeral was in Woodward at the livestock auction barn. I know that may sound a little strange, but that is where Levi went to cowboy church. There were dozens of sketches that Levi had done on napkins on a table in the foyer-way, as well as some of Levi's forged items close to his casket with the flower arrangements.

At the cemetery, Levi was placed in a wagon, that was pulled by his own mules to the gravesite, his final resting place. I could just picture Levi's smiling face as he was riding in that pine casket, that really looked good in that wagon. It was a very fitting service that I found more pleasant than a lot of the funerals I've been to. We will miss you Levi.

On a lighter note, I've been told by Steven Knisely, that a city councilman who has helped us in the past with a fire Marshal at the medieval fair, wants to make a documentary film about us blacksmiths.

I sure had a good time at the picnic this year. Got to see a lot of people that I hadn't seen in a while, and also missed seeing some of you that didn't get to come. I really must commend the northwest bunch for putting on a great picnic! Don't know about everybody else, but I felt they did a better job than I have in the past at my place!

It was great to see so many folks participate in the forging competition. There were 10 entries, and after judging, number seven was the winner. That ring turned out to be Gerald Brostek's. After taking a look at the forge welded rings, I sure was glad that I didn't have to judge them, because there were several that were very well done!

Happy hammering to all!

- Byron



In the April newsletter, I had included a short item on an elephant head made from angle iron. This was reprinted from the Phillip Simmons Artist Blacksmith Guild "On the Anvil" Newsletter. I got an e-mail from Jim Pigott with the Mississippi Forge Council letting me know that he thought this was done by Lyle Wynn in Mississippi. One of the pitfalls with sharing information among the different newsletters like we do is that sometimes the original source or the backstory gets left out. We want to give credit where credit is due and thanks to Jim for pointing that out. And thanks to Lyle for an interesting idea. By the way, Jim said he was doing some extended work in Elk City and ran into Bob Kennemer at the Blacksmith Museum. He was not only impressed with the museum, he said he was invited to the monthly meeting at Foss. He said he was really looking forward to attending and feeling right at home! - Editor

From the Secretaries desk..

I would like to thank everyone that has sent in your membership renewals. Especially those that renewed for more than one year. For those of you that have not sent it in yet, better get it in. The May newsletter will be your last.

With the first 30 days of our fiscal year and our annual picnic behind us and the installation of newly elected board members taking place at our upcoming board meeting scheduled for May 24th at 2:00 PM at Byron Doners place, it is time to start planning for our annual events. David Seigrist is our chairperson for the Conference. If you would like to help out, or have suggestions that might make our conference better, contact David or attend one of the planning meetings that will be announced in upcoming newsletters. Richard Blasius is in charge of organizing the workers for the State Fair that is in September. Contact Richard if you would like to work during the 11 days of the fair.

Our Conference will be in Norman, Okla. Again this year. One thing that will be different is that Teresa Gabrish will not be teaching any classes on Saturday. The first day of the conference it too confusing for her to do registration and classes. Anyone that would like to teach a family class on any subject can contact the secretary and we will help get it in the planning. If you liked the stain glass or dutch oven cooking and would like to do more of that type of class, let us know and we will see if they will come back this year.

One of the ideas that has been discussed for the conference is having a day prior to the conference (Friday) with hands on workshops. We would use Thursday as set-up day and then have workshops on Friday. This would give us a chance to test both sound and video equipment prior to Saturdays opening demonstrations. What we need from the membership is input as to whether there is enough interest in having workshops on Friday? Would members be willing to come to Norman a day early to attend workshops and if so what kind of workshops do we need? I think one of them should be a Basic Beginning Blacksmithing Workshop, but after that what do we want? We could have 3 or 4 workshops offered during the day. These would not be demonstrations but hands on, get your hands dirty, make something, workshops. We would need a good number of members willing to pay for the workshop to justify the extra day rent on the building. Think about it, but not too long, and let us know so we can get the building rented the extra day and get the workshops and instructors set up. These workshops may be taught by Saltfork members. If you have attended a school and feel confident in your knowledge of the subject and would be willing to teach a workshop on the Friday before the conference, contact the secretary.

Just FYI. We have 349 members on our roster at this time. Of those, 130 have not renewed their membership. We still have 5 of the original 13 members still with us.

Stay safe...Diana Davis
SCABA Secretary

Results of the Election Ballots Received:

There were 48 ballots received:

Byron Doner - 46 votes
Mark Carter - 17 votes
Mandell Greteman - 40 votes
Bill Kendall - 36 votes
Chuck Ogden - 16 votes
Doug Redden - 26 votes

The Members voted to the Board are:

Byron Doner
Mandell Greteman
Bill Kendall
Doug Redden

Installation of new board members will be at the next board meeting May 24th at Byron Doner's.

Demo Opportunity:



CHISHOLM TRAIL HISTORICAL PRESERVATION SOCIETY, INC.

P. O. BOX 850021
YUKON, OKLAHOMA 73085
www.chisholmtrail.org

REMINDER.....REMINDER.....REMINDER!!!

CHISHOLM TRAIL FESTIVAL JUNE 6, 2015 1001 GARTH BROOKS BLVD. YUKON, OKLAHOMA

The Chisholm Trail Historical Preservation Society and the City of Yukon combine efforts to celebrate the history of the Chisholm Trail and the old west during the first weekend in June. We are gearing up for the 2015 Festival and hope you plan to join us! Grounds will open June 4 for reenactors and vendors. You are welcome to come early and set up. Chamber of Commerce Breakfast will be at 8 a.m., Friday, June 5, in front of "Olde Towne". Dinner at 6:30 for all of our reenactors and volunteers. Festival hours are 9-6 on Saturday. Lunch will be provided.

We missed seeing some of you last year and look forward to renewing old acquaintances in 2015! This year we will remember J. W. Parker, one of our founders and certainly a Chisholm Trail Historian for many years. Parker Station was J. W.'s post during the Festival and he will be missed.

Brochures and applications for reenactors and crafters are available on the website – or if you need copies, let us know! We are anxious to hear from you!

Traditionally we have time to visit and catch up after the close of the Festival on Saturday night! Hopefully you can stay with us Saturday night but if you must leave before Sunday, grounds will be open at 7:00 p.m. on Saturday night to bring your vehicles in to the camp site.

JOIN US IN YUKON, OKLAHOMA

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

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*

Upcoming Board Meeting:

There will be a meeting of the board on Sunday, May 24th starting at 2:00 P.M. at President, Byron Doner's shop in Norman, Oklahoma.

Everyone is welcome. If they want to bring an issue before the board they need to contact the Secretary and be put on the agenda. The main agenda item is the election results and installation of officers.

Diana Davis

SCABA Secretary

Regional Meeting Schedule

- SE regional meeting May 2nd (Open)
- **NE Regional meeting May 9th** Will be hosted by Ed McCormack at his home in Okmulgee at 15100 N.270 Rd. (see map.) His trade items is a small anvil and lunch will be served but help out by bringing a side dish..
- **SC Regional meeting May 16th** Will be hosted by JJ McGill and Jim Dyer at the Antique Tractor Complex in Sulphur. (7 miles North of Sulphur on Hwy 177, then 3/4 miles east on Tractor Rd.) The trade item is a campfire cooking (long handle utensil.) The Tulsa boy scouts will be there again this year. Lunch is provided, bring a side dish to help out.
- **NW Regional meeting May 23rd** will be hosted by Terry Kauk at his home in Leedey, Ok. at 8411 N 2080 Rd. About 2 miles south of Leedey, go east at the intersection of Hwy 34 and Hwy 47. Go two miles east from the intersection, then 2 miles south, then 2 miles east, then approximately 1 1/8 miles south. Look for a two story brick house with tan shop north of the house. Trade items is anything made from a horseshoe. Lunch is provided, bring a side dish to help out.

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)

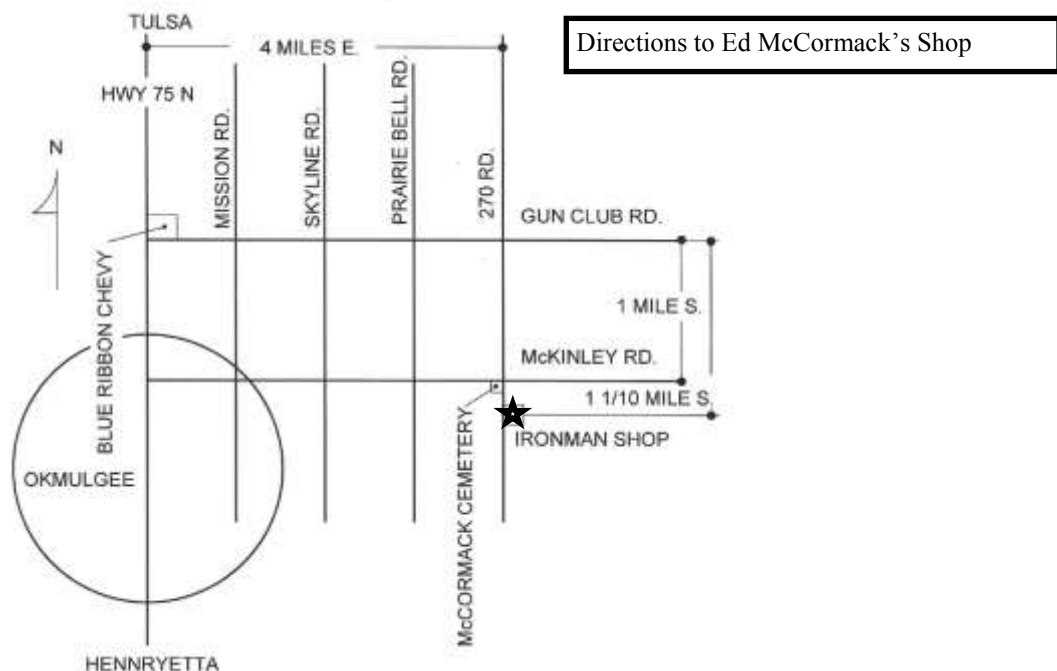
SC Region (3rd Sat)

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.





Founding member of SCABA Remembered:

Levi was one of the original 13 "Founding Fathers" of SCABA. He will be missed...

Harold "Levi" A. Rutledge

Born: June 04, 1933

Died: April 01, 2015

Harold "Levi" Alvin Rutledge, 81, of Woodward, passed from this life on April 1, 2015. Levi was born to Henry and Tina Rutledge in Woodward on June 4, 1933. He was reared and educated in Woodward schools, graduating with the class of 1952. After graduation Levi joined the Army, serving with honor from July of 1953 to June of 1955, before transferring to Army Reserve at Tinker Air Force Base. On June 29, 1955, Levi married the love of his life, Shirley Ann (Herman) in Laverne, OK. To this union, three children Jackie, Johnny, and Jesse were born.



Levi was a true cowboy through and through. He would often joke that he should have been born 100 years earlier. He worked as a farrier (horseshoeing), blacksmith, craftsman artist in blacksmithing, and cowboy storyteller (when he wasn't busy with his own farm/ranch). Levi attended the 1000 Hills Ranch "Cowboy" Church. He was also a member of the Saltfork Craftsman Artist Blacksmith Association, The Cowboy Storyteller Association of the Western Plains, The Cimarron Cowboy Association, Tri-State Professional Horseshoer's Association, Kansas Farrier's Association, Oklahoma Farrier's Association, Texas Farrier's Association, Brotherhood of Working Farrier's Association, and a Master Farrier.



In addition to his parents, Levi was preceded in death by his wife Shirley Ann Rutledge, daughter, Jackie Lynn Rutledge, granddaughter Jaclyn Rutledge, great grandchildren Victoria Knisley, Michael Knisley, and Joseph Knisley, and two brothers, Henry Jr. and Billy Rutledge.

Survivors include Levi's two sons, Johnny Lee Rutledge of Newton, KS, and Jesse Lane Rutledge and wife Billie of Turpin, OK; two grandchildren, Brandy Hunter of Cheyenne, OK, and Jodi Rutledge of Wichita, KS, great grandchildren, James Rutledge, Isabell Flores, Gabriel Flores, Penny Knisley, Abby Knisley, Addy Porter, and soon to arrive Elisha Levi Hunter, eight brothers Albert, Leroy, Bernie, Herbie, Louis, James, Jakie, and Ralph Rutledge, two aunts, Ruby Trent and Mary Dean, and numerous, nieces, nephews, other relatives, and friends.

Funeral services were held at 10:30 AM on Monday, April 6, 2015 at the Woodward Livestock Auction Building (900 Lakeview Dr) with Pastor Beau Hague of 1000 Hills Ranch Church presiding.



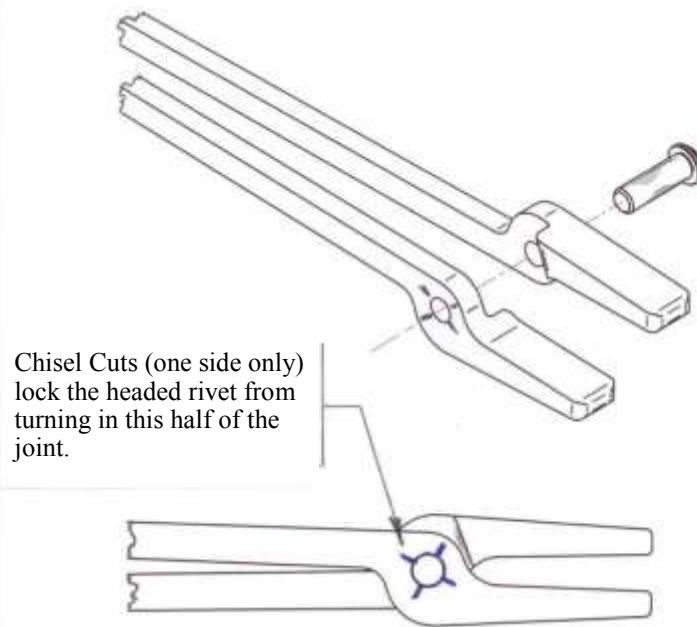
Levi helped to get me get into Dutch oven cooking and with my first lessons in making horseshoes. My horseshoes do not actually fit anything; they are horseshoe shaped objects (HSO's) – good for a public demo unless there is a real farrier in the group.

Levi made really good tongs; I'm fortunate to have a pair or two he made for me.

Several years ago, Levi showed me a tip to take about half the slack out of the tongs' riveted joint. A small chisel or an old star drill (hand concrete drill) is used to cut small notches at the outside of a hole in the joint. It is best to make these cuts on the side of the tongs that will have the rivet headed. These notches prevent the headed rivet from rotating in that side of the tool.

Notching other single riveted joints, such as the legs connected to a campfire cooking trivet, works nearly as well as a square rivet in preventing unwanted rotation. For the trivet legs, chisel cut both the ring and the legs; heat and forge both ends of the rivet.

- Jim Carothers



Around the State....

NW: North West Region March 28 Meeting: The March meeting for the NW region was hosted by Mandell Greteman at his shop in Foss, Okla.

There was a nice turn out for the meeting the weather was outstanding. About 30 members arrived to enjoy the day. There were 3 new member that came and jumped right in on learning the trade.



The trade item was a Fish Hook. There were 8 made and drawn for. There were two forges going all day in making a wide variety of items. Some even enjoyed just watching others and telling stories. Lunch was Smoked Pork Loin and all the fixins, with all sorts of salads and wonderful deserts. We would like to say "A Big Thank You" to everyone that came .

- The Gretemans



Around the State (continued)....



NE: Northeast Region April Meeting: The April meeting in the northeast was hosted by Doug Redden and was held at the Will Rogers birthplace ranch. There was a good turnout for a cool day. The trade item was anything made from a horse shoe and some nice items were made. Not only did we have blacksmithing demoed but I gave Gerald Franklin a short flint knapping lesson. You never know what can happen at one of these meetings! I want to thank everyone who came out and invite everyone to the June meeting at the same location. Lunch will be goulash. - Doug Redden

SE: No meeting was held in April.

SC: No meeting was held in April.

2015 SCABA Annual Picnic:

The Saltfork Craftsmen Artist -Blacksmith Association's Annual picnic was held Saturday April 18, 2015 at the Route 66 Blacksmith Shop at Elk City Museum Complex . There were about 80 members that were on hand to enjoy each other's company and stories.



There were 10 members that competed in the forging competition using the coal forges to make a ring out of three eights rod, forge welding the ring. There were some first time forge welders and they did a very good job.



Thanks to everyone that competed and THANKS TO EVERYONE for supporting SCABA picnic. We had a beautiful day for the picnic. There were four vendors present so there was plenty to look at. Elk City gave free passes to the museum and merchants finished some free gifts.

2015 SCABA Annual Picnic (Continued...):

For the meal, hot dogs, hot links, polish sausages and home made Chili were served. The club members brought wonderful salad and deserts and all the other fixings to go with the meat.



Thank You to everyone for what they brought to go with the meal and for helping out. A BIG THANK YOU to everyone that helped put this together for such a great turn out. - The Gretemans



2015 SCABA Annual Picnic (Continued...):



There were a lot of people sharing forges to get their competition rings done. With so many people in the shop, the work flow went surprisingly smooth.

Young Payten Cole (in the blue T-shirt) got a lot of help making various items including a candle holder with Ricky Vardell and a horseshoe heart with Diana Davis. - Editor



2015 SCABA Annual Picnic (Continued...):



There were a few tailgate items for sale (I don't think Korny ever did sell though).



P.K. Overstreet and Teresa Gabrish had their jewelry tables set up.

Thanks to the ladies that managed the lunch spread. All the food was spread over 5 or 6 tables and they did a great job feeding a pretty large herd. - Editor



2015 SCABA Annual Picnic (Continued...):



David Seigrist made a chain swage out of sucker rod (AKA "the thing I need to make to make the other thing I need to make.")



When it came time to judge the forge welded rings, Gerald Franklin was quickly called into service as the first judge. I was honored but reluctantly agreed to be the second judge as I had glanced at some of the rings and I knew it would not be

easy to pick the winner. Each ring looked to be a serviceable forge weld and all were nearly perfect circles. The main judging criteria were defined as the forge weld quality and how well the rod held the original dimension all around the ring - especially at the weld. Each ring had an anonymous number tag to eliminate any bias. We were able to slowly cull through the 10 entries and unanimously came up with the final two. We almost wore those two out picking them up and setting them back down. Somebody offered us a micrometer since we were taking a long time but we finally agreed on the winner which was Gerald Brostek's. He was the winner of the great looking trophy made by Mandell Greteman. - Editor



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Storage for Your Punches & Chisels

Jim Carothers

This year I was able to attend the Central States Metal Artisans (CSMA) annual spring blacksmithing conference at the Haysville, KS shop. Pat McCarty (Washington, MO) was the demonstrator and did a great job. As stated in the CSMA May Newsletter, "The stuff I learned in the first 30 minutes was worth the price of the whole weekend."

I noticed right off that Pat was very well organized for demo work. That included having metal precut for his projects, tooling organized for each project, and transportation of his material and tooling. One item that caught my attention almost immediately was his simple box of punches and chisels (Photo 01).

For years I have used a Bucket Box brand roll-up tool pouch (Photo 02) to hold my punches and chisels. It works and the pouch has held up pretty well to sharp edges and a few embers. But, it takes up a lot of space, and it seems I am spending extra time looking for the tool I want. I knew I had to make a Pat type tool box for my own use.

In the photo of Pat's tool box, notice the tooling sockets in the bottom of the box; those are short lengths of 1" square tubing tack welded together. Pat had access to fall off material from a local fab shop. I did not have scraps of 1" tube around the shop, but did have several sizes of scrap EMT (electrical conduit). EMT is also about the least expensive tubing that you can buy if you don't have scraps or a friend with scrap tubing. I used 1/2", 3/4" (mostly) & some 1" EMT for my tooling sockets (Photo 03). These were cut to 2-3/4" long except for the pencil tube that is 3-1/2" long.



Photo 1



Photo 2



Photo 3

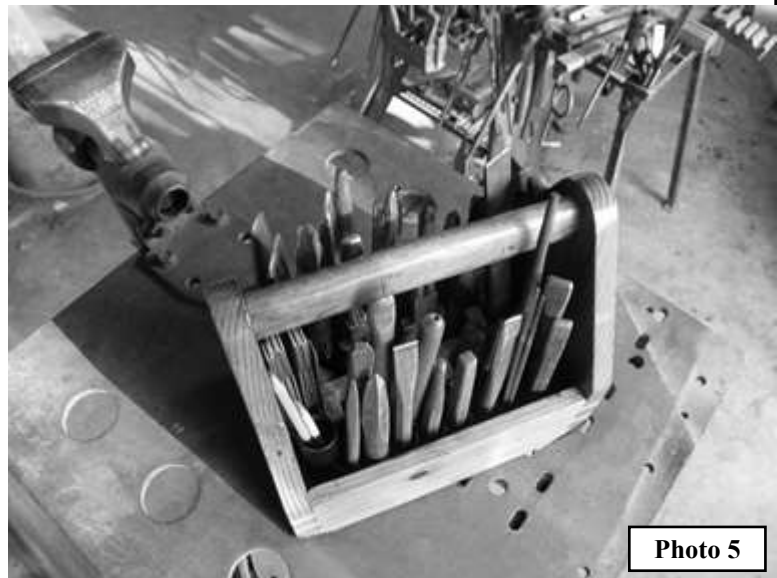
Storage for Your Punches & Chisels (Continued...)

EMT is a plated product and produces nasty fumes when welded. I clamped the tubes down to my welding table in patterns to fit my box and tack welded them together with a fan blowing on my back. Small tack welds are plenty to hold the tubes together. The welded assemblies are loose in my box, though they could have been epoxy glued in place.

Don't make your tool box too big. The one shown here is basically 6 x 9" inside with 3-1/2" tall sides. When filled with tools as shown this box weighs 26 pounds (Photos 4 & 5). I used finger joints just for practice (I also make reenactor's boxes). You can simply screw and glue up a box out of 1-by lumber from the store.

To gain a little finger room around the handle, I put a 1/2" thick divider board down the center. That also allowed me to make the small rectangular pockets for my folding ruler, hot cuts, and some other tools. My handle is recycled from a broken ax.

Again, thanks goes to Pat for a great demo and taking his time to share the craft.



"Curliques" - Items made from stock sizes of steel on jigs and then stick welded together and covered with black paint that earn the workers less than a dollar an hour in the third world and the reason working blacksmiths can't make a living. Pronounced – curly cue. Sometime referred to as cut and paste ironwork.

- Jim Carothers

SOUTHWESTERN IRONWORKS ANNUAL TAILGATE SWAP MEET

SATURDAY MAY 16, 2015 - 7:00 AM TILL —

302 W. COLLEGE

GUTHRIE OKLA

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

CONTACT INFORMATION:

**DAVID KING (405)348-0476 CELL 426-0476
BOB PADDACK (405)634-8353 CELL: 642-5243**

Simple Green Substitute for Super Quench Formula:

If you are not familiar with Robb Gunter's Super Quench formula, there is a lot of information from various sources, especially the internet, describing its theory and use in detail. Basically, it is a heavy brine solution with a surfactant and anti-bubbling mechanism built into the formula. It is intended for use on mild steels to get a much greater degree of hardening than would ordinarily be possible with low carbon steels. Some people swear by it.

It is not intended for steels with high carbon content and will supposedly damage them due to the aggressive quench. And, it is not a replacement for using tool steels where that is appropriate but is meant to be a way to stretch more performance out of mild steel. It would probably be a good way to harden the working end of mild steel swages, for example. To use, the steel is brought to critical temperature (around 1,550 degrees F - the point where a magnet will no longer stick) and quenched. No tempering is necessary.

One of the ingredients is Shaklee Basic and can be hard to find. Simple Green is listed in some sources as a substitute but the quantity is usually not given. Simple Green is usually easy to find locally. Dale Dixon contacted Simple Green to see if it can be substituted and to get the correct formula. He wanted to share their response with us:

Dear Dale,

Thank you for contacting Simple Green and for your interest in our products.

Although Simple Green All Purpose Cleaner and Shaklee Basic do not share exactly the same properties, they are similar in function. For SuperQuench the following has been recommended at http://magichammer.freeservers.com/robb_gunter.htm.

Robb Gunter's "Super Quench:"

5 gal water

5 lb Salt

32 oz Dawn (blue) dishwashing liquid (28 oz if it says "concentrated" on the label)

8oz Shaklee Basic I or 7oz UNSCENTED Jet-Dry or other surfactant (like Simple Green) of appropriate quantity for 5 gal mix (wetting agents)

The quantity of Simple Green would be about 4 oz. per gallon of water. Shaklee Basic is considered a super concentrate, so it will take more Simple Green than it would Shaklee.

I hope that this information helps. If you have further questions, please do not hesitate to contact me directly via reply email or at the number below. I'm available Monday thru Friday from 8 - 5 Pacific Standard Time.

Thank you again for your inquiry.

Sincerely,

Theresa Provolt

Customer Service and Business Support Manager

*p. 562.795.6091 *f. 562.795.6091*

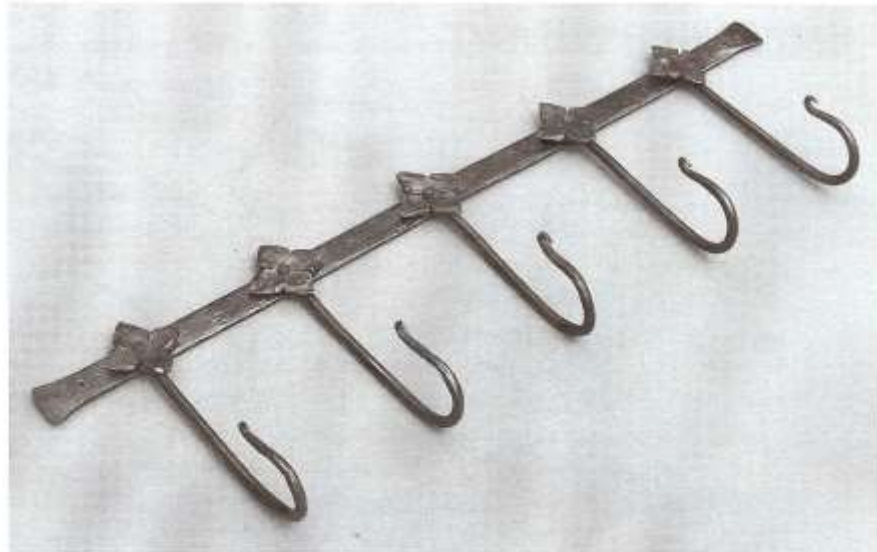
tprovolt@simplegreen.com



5-Hook Coat Rack

By Mark Gordier,
a MABA member

Pictures and project write-up by
Steven Sporre



Mark is twelve years old and has been blacksmithing with his uncle Mike Gordier for the past 6 months. This nice beginner's project took them about two and a half hours to make.

The back plate is 19" long and is made from 1/8" x 3/4" flat stock. The back plate is textured with a ball peen hammer and the ends of the bar are flared. The mounting holes are drilled 16" on center, to match wall stud spacing, and there are 3-1/2" between the five rivet holes for the hooks.

The hooks are made from 7" of 1/4" round stock. An inch of one end is tapered to a point and the opposite end is flattened so it's 1/4" wide and slightly less than 1/8" thick. The point is rolled over the anvil and the hook is formed around a 1-1/4" diameter mandrel. Drill a hole in the center of the flattened end for the rivet to go through. Mark did a good job getting his hooks all the same shape.

The flowers are made from 1/8" x 1-1/4" flat stock, cut in 1-1/4" lengths. Cut a slit with a band saw (or hack saw) at the center of all four sides, and then open with a wedge. Dish the flowers slightly with a ball peen hammer and work the edges a little to texture them. Drill a hole in the center of the flower for the rivet.

To determine the length for the rivets, put one through the flower, the hook and the back plate and add 1-1/2 times the rivet diameter beyond the back plate. Place a flower and a hook on a trimmed rivet, put the rivet-end through a back plate hole and peen the rivet flush with the back of the stock. Peen the rivet nice and tight so the hooks can not rotate.

Clean and wire brush the coat rack, then finish with a spray lacquer.

Nice project Mark and Uncle Mike. Thanks for sharing!

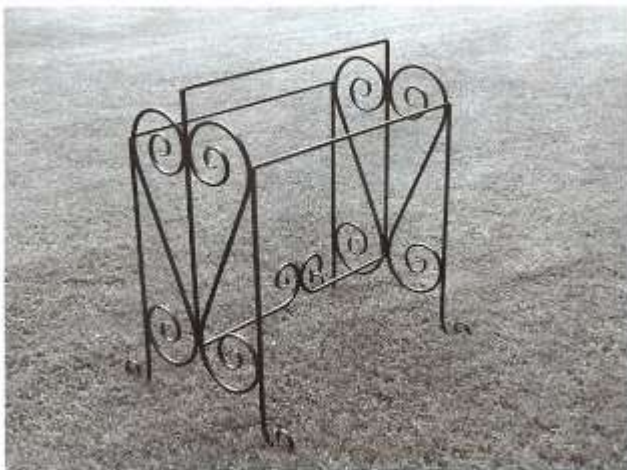


Quilt Rack

Now that summer is here, that nice warm quilt isn't needed on the bed anymore. Instead of folding it up and putting it in the linen closet or cedar chest, why not display that decorator spread or family heirloom on a hand forged quilt rack.

Notes and photos by-

Steven Spoerre, a MABA member



The quilt rack I made has 3 quilt bars, 30 inches wide, with 8 inches between them. The rack will hold a large quilt, comforter or multiple smaller pieces. The rack stands 34 inches tall and is 24 inches deep. The stock lengths were calculated for the scrolling jig I made, and will need to be adjusted for the jig you use.

3/8" square stock

13 – 1/8 or 3/16" diameter rivets at least 1-1/2" in length
9' of 1/2" inside diameter, clear, flexible tubing

1 – Middle bar, straight length 122"

2 – Leg bars, straight length 96"

4 – End scrolls, straight length 49"

Maintaining a 3/8 inch width, draw a rectangular taper from 5 inches of material out to 8 inches, on all 14 ends. Adjust the leg and scroll pieces, by trimming or drawing more out, so their lengths all match. Break the sharp corners along the tapers.

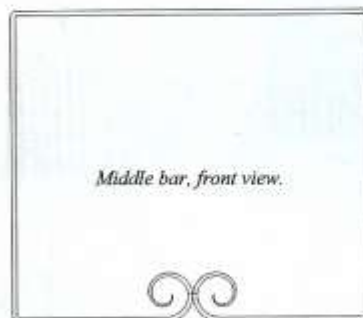


Using a scrolling jig, make the 4 scrolls so they fit into an 8 by 26-3/4 inch rectangle and match each other.

End Scroll

Mark bend lines 15 inches to both side of the center point of the middle bar along one of the sides that was tapered. Place bend marks on the leg bar pieces, 15 inches from the center point. Because the legs are going to be bent/formed perpendicular to the rack, the marks need to be placed on the side that maintains the 3/8 stock thickness. As a check, lay the 3 pieces next to each other – the 6 marks should form 2 straight lines. Make any corrective adjustments now.

Make all 6 bends (cold or hot) using the same set-up and bending techniques, so that the 3 pieces all have the same width.



Middle bar, front view.

Starting with the middle bar – mark off 25-1/2 inches from the existing bends and bend the ends toward each other at these points. When this is done, the tapered ends will overlap in the middle of the piece. Because the decorative scrolls

are small, heat the overlapped area and form the 2 scrolls one right after the other. Adjust them so they are symmetrical, and just touch when the top, bottom and sides are perpendicular and square. Check the diagonal, corner to corner, dimensions – if they are the same, the piece is square. After any/all adjustments are made, mark the point of contact between the 2 scrolls, drill a hole in each then rivet them together. In order to have room to head the rivet one of the scrolls can be bent out of the way or an off-set rivet header can be used.

Heat and scroll the ends of the leg bars so they have a similar shape as the 2 scrolls in the middle piece.



Leg bars, front view.

Side view.

Piece together one end of the quilt rack on a layout table with the tops of the leg bars close to the upper tangent point on the 2 end scrolls and the bottom of the middle bar close to the

lower tangent point on the 2 end scrolls (see photo). Because the 3 quilt bar pieces will be standing up off the table, clamping a couple of bars between the upper ends will stabilize them. Locate and mark the 6 points of contact between the 2 scrolls and the 3 quilt bar pieces. Drill the 12 holes for the rivets in the 5 parts, making sure the holes are centered and straight through each piece.

Temporarily attach the quilt rack end together tightly with bolts and nuts through the rivet holes, flip it over and layout the other end. Again check that all pieces are square and parallel and that the attachment points are similar to the other end. Mark and drill the 12 holes on this side. Tag or mark all joints so that the same pieces go back together at the final assembly.

To assemble, start by riveting 2 end scrolls to one side of the middle bar, using a backer tool mounted in the vise and an off-set heading tool, flip it end for end and do the other side. The 2 leg bars can be attached to the scrolls using the backer tool and either a standard rivet set or a ball peen hammer. When all the rivets are drawn down tight, the last adjustment is to make sure all 4 scrolled feet touch down at the same time. If not, locate the "short" leg by placing a level along and across the quilt rack bars and using a bending fork make the final adjustments to the problem leg.

Wire brush, prime and paint the quilt rack. After the paint is completely dry, cut the clear, flexible tubing so the full length of the 3 bars is covered. Slit the tube along its length with an Exacto or utility knife and push it over the bars the quilts will be laying on. The tube just adds extra protection so no finish ever comes in contact with the often valuable quilts.

Finally, a small length of clear flexible tubing can be placed on the bottoms of the legs if the quilt rack will be on flooring that can get scratched.

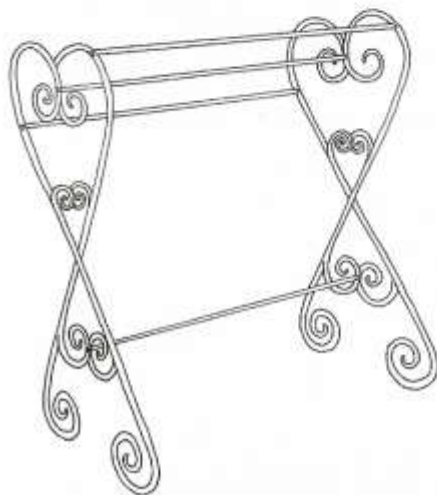


Quilt Rack

By George Blair, a MABA member

This quilt rack was made to display the quilts made by his wife, Paula.

It is made from 3/8" square stock and is 26" wide and 15" deep. The 3 bars are set at different heights so 3 quilts can be viewed at a time. The back bar is 36" tall, the center bar is 32" tall, and the front bar is 28". The bottom supports are 6" above the floor and the majority of the ends have a very pleasant scroll and leaf forged from the parent stock.



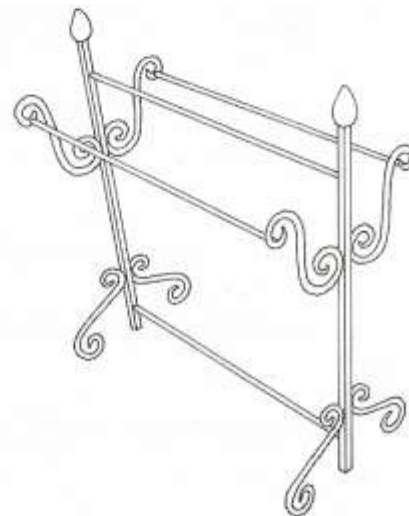
Examples of other nice quilt rack designs.

<<

This quilt rack was seen at the 2006 ABANA conference. The sketch came from a photo out of The Anvil's Chorus—New York State Designer Blacksmiths newsletter, Fall 2006.

>>

This quilt rack by Danny Parsons was sketched from a photo in the Appalachian Area Chapter of Blacksmiths March/April 2005 newsletter.



Quilt Rack: Taken from the Jan 2000 Forge Fire

Parts List:

- 2—Wood Dowel Rods 3' 6" X 1 1/4"
- 2—1/2" Square 3' 6" X 1 1/4" for cross bars
- 2—1/2" x 1" x 3" for sides
- 4—1/2" x 1" x 16" for top and bottom pieces
- 4—3/16" x 2" Wood Screws, round heads
- 8—3/16" x 1" Rivets

A. Top Cross Bars

1. Start off by forging scrolls on each end of the bars. Start about 1" back
2. In the middle, drill a 1/2" hole in both pieces.
3. Finish the 1/2" hole with a 1/2" square drift.
4. Drill 3/16" holes for the wood dowels and the side uprights.

B. The feet

1. Start 1" from the end of each rod and forge a penny.
2. Take a center punch and mark 2" from the foot.
3. Forge a taper from the punch to the foot.
4. Drill and drift the hole for the bottom cross bar.
5. Drill the holes for the sides.

C. Cross Bars

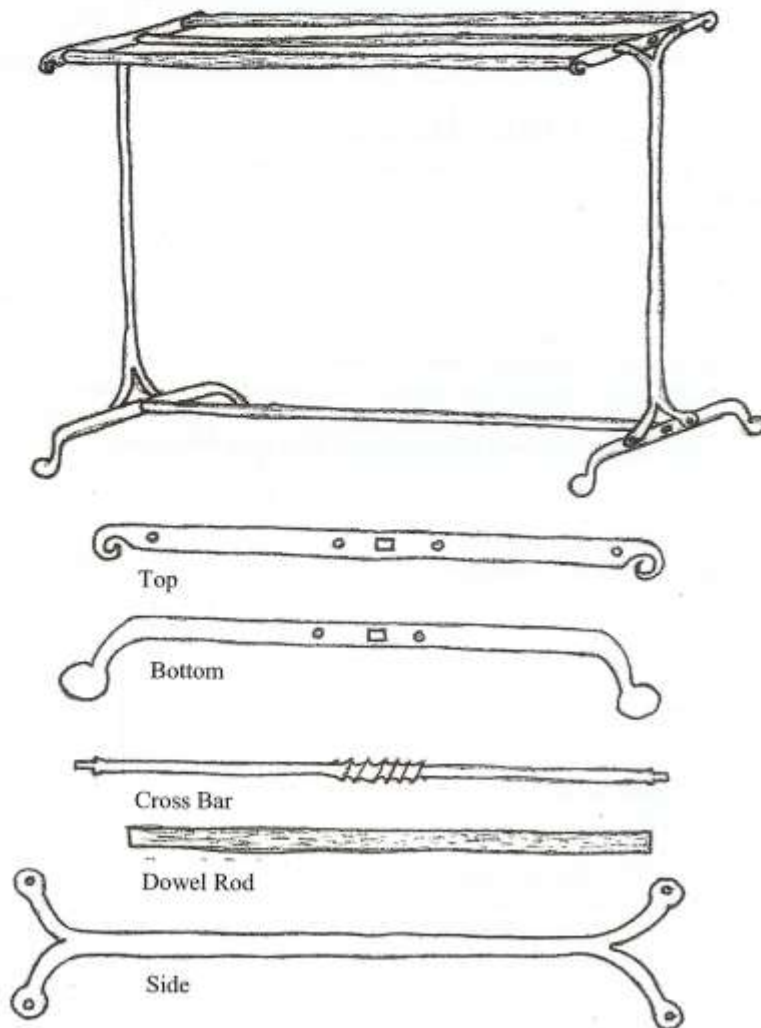
1. Upset each end and forge a tenon on the ends.
2. In the center, twist to your liking

D. Sides and Uprights

1. Split each end back about 3". You could saw this.
2. Forge a small penny foot on each split.
3. Taper to the penny feet from the split.
4. Spread the ends to line up with the holes that you drilled.
5. Drill holes in the feet.

E. Assembly

1. Put the two ends together by using rivets.
2. Put the cross bars in, and upset tenons.
3. Drill pilot holes in the ends of the wood dowels.
4. Use wood screws to fasten wood dowells in place.



Kurt Fehrenback
Indiana Blacksmithing Association

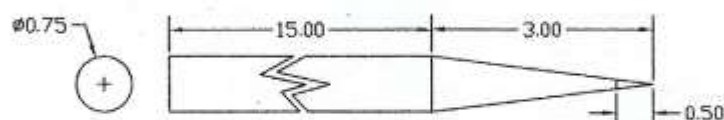
Folding a Lead Spoon

Project by Jim Stuart, a MABA member

Photo by Tim Lange



Before you can start on your lead spoon you will need to hammer out a mandrel. Start out with a piece of 3/4" diameter by 16" long bar. Hammer out a 3" long taper and then cut the first 1/2" off.

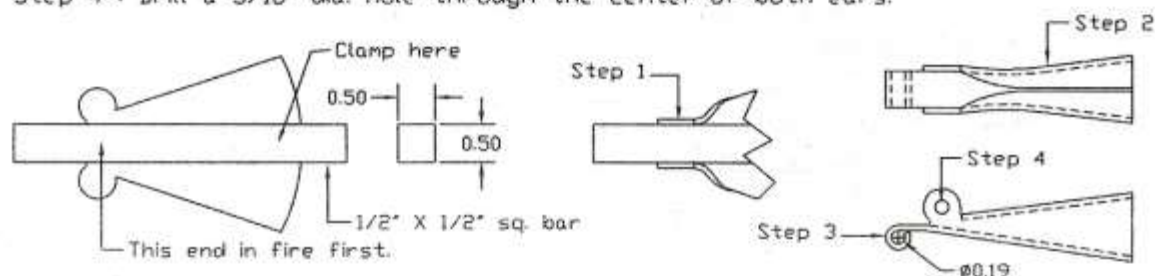


Step 1 : Down the center of your handle blank clamp a piece of 1/2" square bar. Place the end of the handle blank in to the fire, with the sq. bar on top. After the end takes on a red heat place in vice and hammer the two ears around the 1/2" square bar.

Step 2 : Place the handle blank back in to the fire. Take on a good heat and then hammer the opposite end around the mandrel.

Step 3 : Take on a good heat and form the stop around a piece of 3/16" round bar.

Step 4 : Drill a 3/16" dia. hole through the center of both ears.

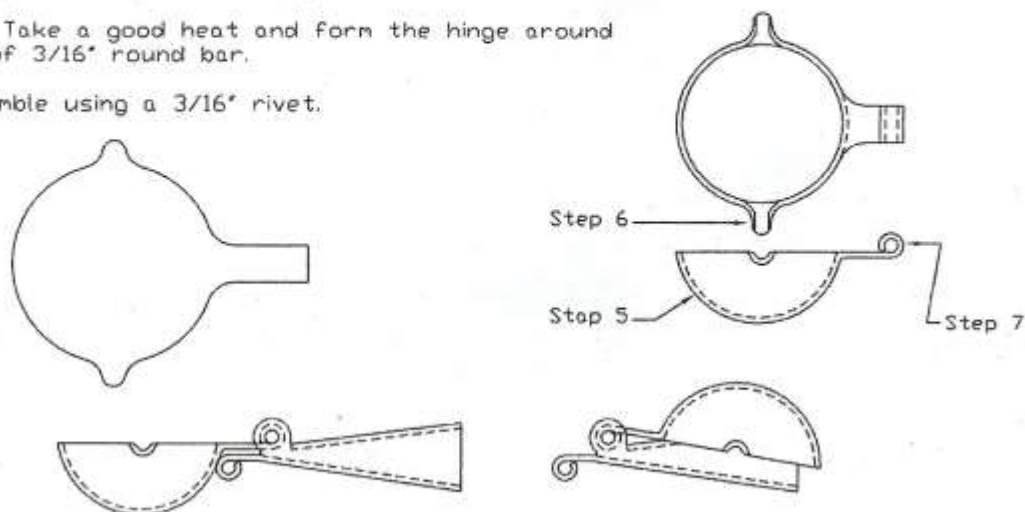


Step 5 : Take a good heat and hammer the bowl shape in to the spoon blank. This can be done with a swage block or a wood block with a bowl shaped impression and a ball peen hammer.

Step 6 : Take a good heat and form the pore spout in to the spoon blank. This can be done with a swage or a wood block with a small half round or a v shaped impression and a cross peen hammer.

Step 7 : Take a good heat and form the hinge around a piece of 3/16" round bar.

Now assemble using a 3/16" rivet.





Get a Handle on It!

Did you ever need a project you could forge in a quick amount of time? Allen Kress, from Alabama demonstrated at David Hutchison's, Annual Gitchner Memorial Hammer-In this January. He offered a wealth of information and projects. Allen demonstrated this project and it could be your next favorite! You hardly need any directions, it is almost self explanatory! Allen is also known for the dies he sells at SOFA!



Materials: 4X4X1/4" tubing, cut a thin "slice", approx. 1/4", heat and flatten, twist & shape!

Third Hand

Ted McNett

I saw this simple third hand in a Mark Aspery You Tube video and decided to make one. I was working on fireplace tool sets that were 28 inches long. This really made it simple to split the tab to attach the shovel pan as well as slit and drift the tool stand upright for the cross bar. I used 5/8" round because it fit my pritchel hole well but 1/2" would have worked as well. It should pivot easily in the pritchel hole. Since it pivots in the pritchel hole you can adjust the distance needed to support your work piece. The bar in the pritchel hole is about 4 inches long, the first leg is about 8 inches away from the anvil, and 12 inches along the anvil with a large scroll end to prevent anything from sliding off. The support bar is even with the face of the anvil.

8 HAMMER & TONG Mar/Apr 2015

Blacksmith Guild of Central Maryland



Reprinted from the Blacksmith Guild of Central Maryland
Hammer & Tong
Mar/April 2015

Quick Projects – Spring Fuller

Gerald Franklin

The spring fuller, in various sizes, is a necessary tool for smiths who work alone. This version is simple and quick. It requires only one size of material since the hardy shank is forged as part of the tool.

I used 3/8" round for the example in the photographs. You will probably want to make a set of these in different sizes

Start by cutting about 29 or 30 inches of the desired sized round stock.

Take a heat and fold the piece one third the way from one end. Tighten this bend so it closes against itself but don't flatten the sides.

Turn the piece 90 degrees and take another bend about 2 1/2 inches from the first bend. Again, tighten the bend but don't over forge it. You will now have a "squarish" mass that will serve as the hardy shank when the piece is finished.

If this mass is too big for the hardy hole, forge it to size. For a mass that is close to size for the hardy hole, you can carefully forge the sides with a good heat. If the mass is considerably bigger than the hardy hole, e.g. you have 1" plus of mass to fit into a 3/4" hardy hole, weld the mass so that it doesn't separate as you draw it down.

If the mass is too small to fit the hardy hole, spread the bends with a chisel until you get a good fit.

You should now have what amounts to a hardy shank with two vertical legs sticking up. Put the shank in the hardy hole (or clamp it in a vise) and bend the short leg 90 degrees. Then bend the long leg to 90 degrees and bring it back up in a curved shape to form the top of the fuller.

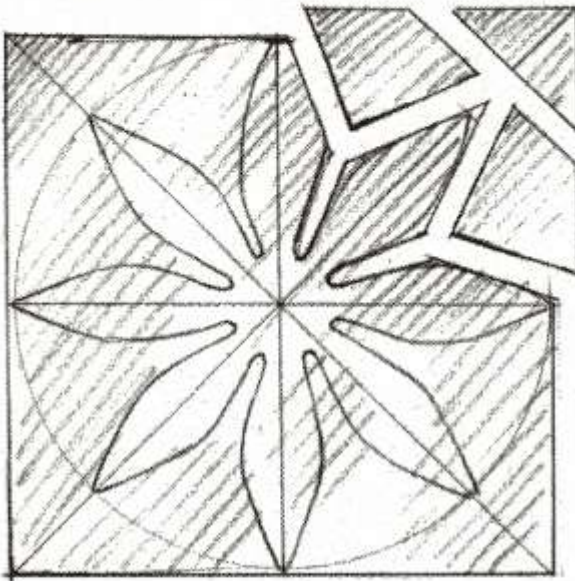
These bends should be made with the legs aligned with the axis of the anvil so that they will be aligned with each other when you finish.

You want the top leg to stick out about an inch beyond the bottom leg. This gives you something to pry against to open the tool with the hot material that is to be fullered.



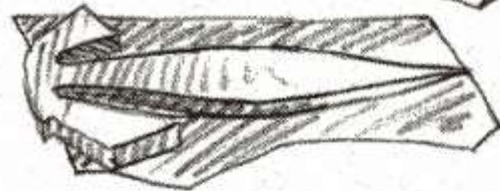
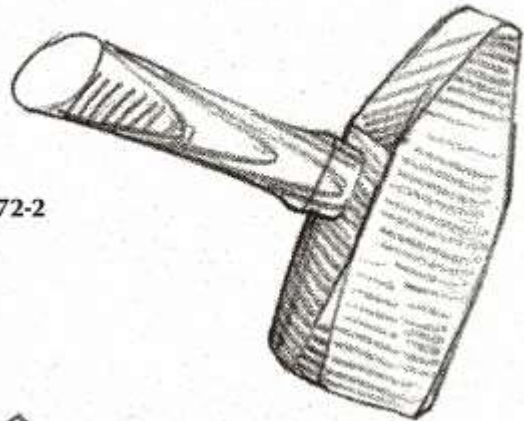
DOOR KNOB

172-1



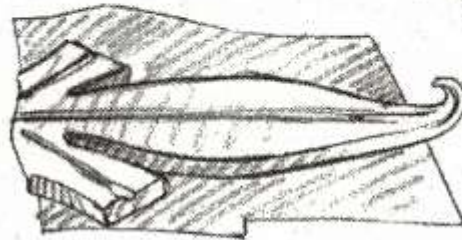
LAYOUT PATTERN ON 6" x 6" x 1/8" PLATE.
CUT AS SHOWN OR CUT WITH PLASMA OR
LASER CUTTING EQUIPMENT.

172-2



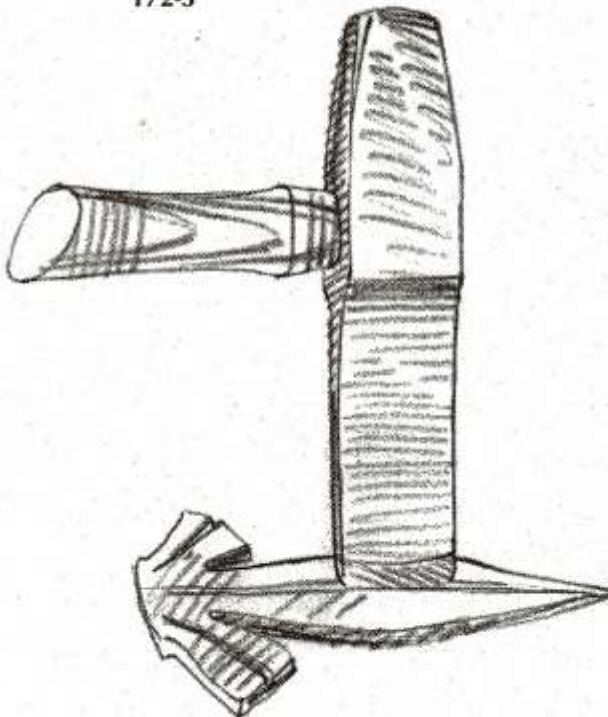
TAPER THE TIP OF EACH LEAF TO A POINT.

172-4



SCROLL THE END OF EACH LEAF.

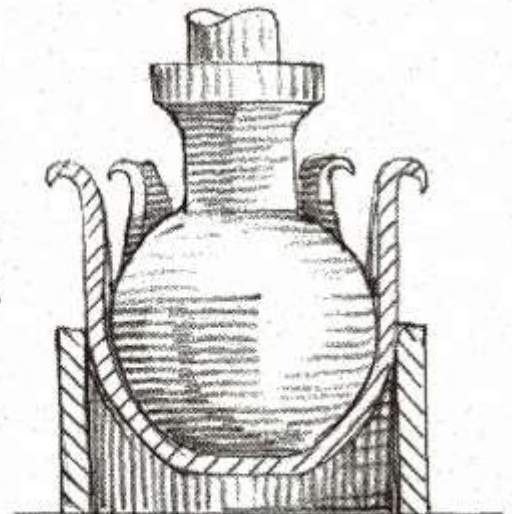
172-3

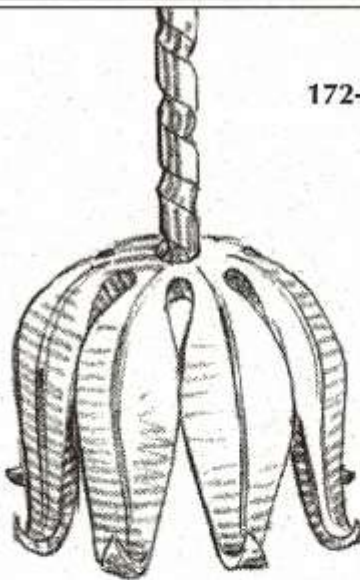


GROOVE EACH LEAF.

172-5

SINK THE
PATTERN IN
A 2 3/8" I.D.
RING WITH A
BALL
SWAGE OR
2" TRAILER
HITCH BALL.



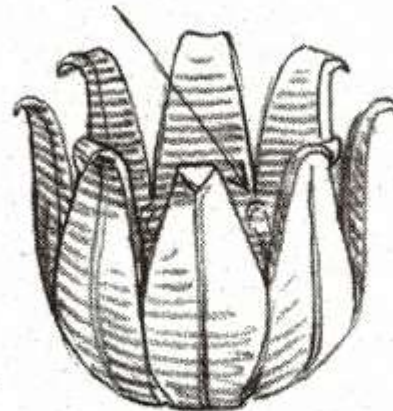


172-6

DRILL A 5/16" HOLE IN THE CENTER OF THE PATTERN.

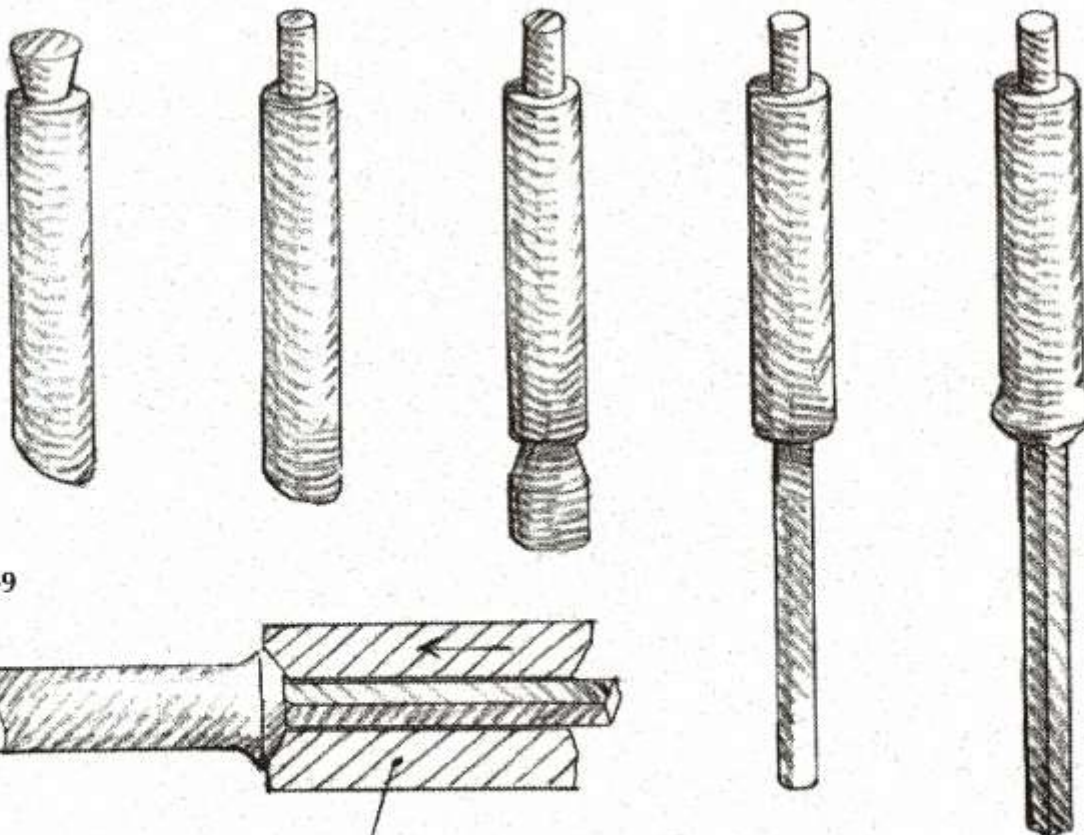
172-7

TACK WELD THE LEAVES TOGETHER INSIDE THE FORM.

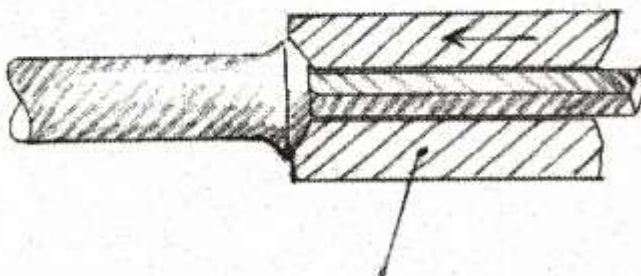


172-8

FORM TENONS ON EACH END OF PART B (SEE 84-1—84-7). THE SECTION OF THE LOCK SPINDLE IS DEPENDS ON ITS USE.



172-9



MONKEY (SHOULDERING TOOL) WITH COUNTER-SUNK OPENING FOR UPSETTING END OF PART B.

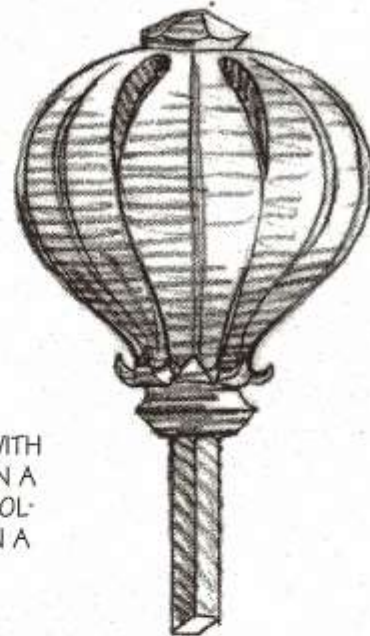
172-10

SET RIVET



HEAT EACH
LEAF WITH A
TORCH AND
BEND INWARD.

172-11

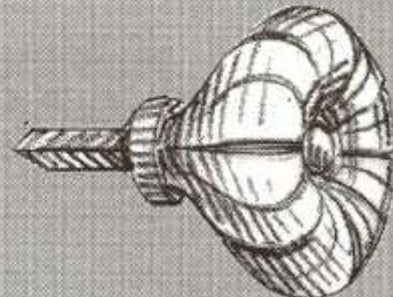
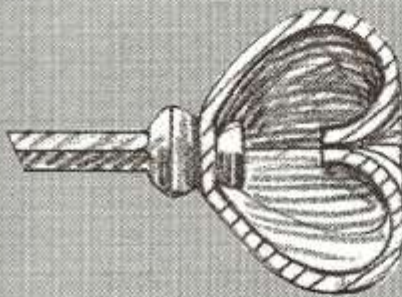
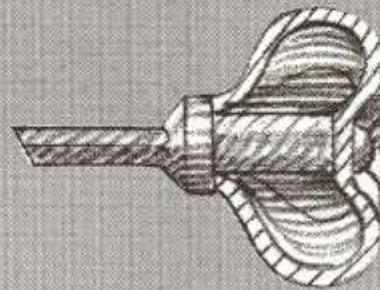
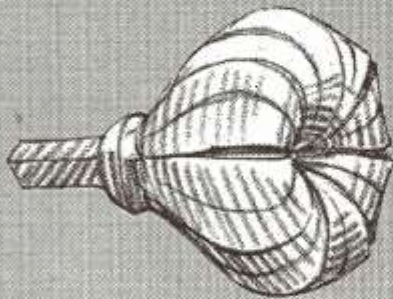


SET RIVET WITH
THE STEM IN A
MONKEY TOOL-
CLAMPED IN A
VISE.



Doorknob by Otto Schmirler
This version has 10 leaves instead of
eight

VARIATIONS



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Copies of the Blacksmith's Journal are still available at www.blacksmithsjournal.com

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

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

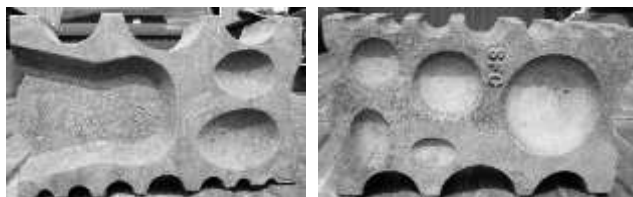
Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces The coal is \$140.00/ton or .07 /pound to members. **No sales to non-members.**

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

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