

# Saltfork Craftsmen Artist-Blacksmith Association

January 2016



Peter Ross Box Jaw Pliers Demo from the 2015 Southeastern Region  
Blacksmith Conference in Madison, GA  
(Thanks to the Alex Bealer Blacksmith Association)  
(Page 26)



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Artist-Blacksmith Association  
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**Editors notes...**

This issue marks my first full year as editor. And it seems like that year has just flown by. One side effect of having a recurring monthly deadline is that the time really seems to go by too fast. But I really enjoy doing the newsletter even though it does get pretty hectic at times trying to dodge my "real job."

I am still on a continuing learning curve as far as exploring the best way to get it done and the best way to do the layouts, etc. I appreciate the comments from those of you who have given me feedback.

There is only a limited amount of material available from other sources to include in the newsletter and it really helps when members submit items to include, articles on projects, photos and write ups for meetings that I cannot get to, etc. I really appreciate all of you who seem to do just that on a recurring basis.

You may have noticed that I have tried to include more material in each issue but that will only be sustainable as long as there is material available to fill the pages. I really don't want to reduce the newsletter if I don't have to but it depend, at times, on what is available from other newsletters and what we can produce as original articles from Saltfork members.

Most of us don't really like to write and I know it is a stretch to ask for members to submit original articles. But we have a lot of members who have skills or tips worth sharing. It seems like the best way to get that info on paper is in a demo form if I (or someone else who is willing) can be there to capture the photos and take notes. That material can easily be turned into an article that works well for the newsletter. So if you have an idea of something you like to do or if you plan to do a demo at a meeting, please let me know.

A lot of our members are pretty humble about their skills. But it would be a great service to the blacksmithing community at large if you are willing to share something you like to do. It may seem self evident to you but there is always somebody who would stand to gain if you share even simple ideas and techniques.

Looking forward to another good year!

- Russell Bartling - Editor

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

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**Visit our Saltfork Craftsmen Website:**  
[www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org)

## President's Notes:

Hello Smiths and Artisans of various kinds!

It's hard to beat forging weather like this in Oklahoma. What a fantastic time to spend at the forge being creative and productive. Lately I've been spending more time organizing, cleaning, and making a few jigs that will help with future projects.

One of my jigs is pretty simple and always makes me money. It's a jig for dinner triangles. Doesn't take much and triangles have always been a good seller for me. Gordon Williams says if you put a cow head on them they'll sell even faster.



Let me take just a minute here to help clear up a little confusion in the last newsletter. We've been approached by several folks asking if the dates for the NE and SE regions can be changed. The newsletter should have said we we're asking for input, and not that the decision had already been made. It was a communication error between board members and no one was trying to dictate to anyone else how the club is run.

The regions described are what I told Doug when he called me. I said the boundaries are I-40 and I-35, because.... that's what I thought they were. Many people who've been around longer than I have chimed in with some very good information about the development of the SE and SC regions and the difficulty with getting meetings in the newsletter if a region has the first Saturday of the month. Some have said it would be better to keep the first meeting open for classes and workshops, and others have more ideas. We're just looking to see if the folks in those regions would like to do what was proposed. It's an idea that's just being kicked around so please keep your ideas coming and let us know what you think.

Now back to fun stuff! Have you ever made a story board? Some may be thinking what's a story board? Is that the board that was used on you when you were telling stories as a young'n? Nope, it's not... Yay!

A story board is a board with step by step examples of a specific process. An example would be of all the steps it takes to make a Cristoff Fredericks Cross:

- Step 1, blank piece of 3/8" steel 3" long
- Step 2, saw a line from point a to point b
- Step 3, saw a line from point c to point d
- Step 4, etc., etc., until the last example is a finished Cristoff Fredericks Cross.

You then hang it on the wall so others can see what it takes to make it with an example of each step, bring it to meetings, and it's also good to display when you are doing public demo's.

I hope everyone has a Merry Christmas and a Blessed New Year!

- David

## Division of (Volunteer) Labor

It's been suggested that we need to clarify who does what in terms of the Saltfork Board members and other positions of responsibility. This list is an attempt to expand on the definitions of these roles to help in getting the right person when needed. Please keep in mind that everyone on this list gives their time on a volunteer basis and this list may change, expand and evolve over time:

<b>Name</b>	<b>Position</b>	<b>Address</b>	<b>Phone</b>	<b>Duties</b>
David Seigrist	President	P.O. Box 163 Hollis, Ok 73550 dseigrist2004@yahoo.com	580-381-0085	President BOD Meeting Chair Help Where I can
Doug Redden	Vice President/ Conference Chair	2050 E. 410 Rd. Oologah, Ok. 74053 Doug.redden2@att.net	918-230-2960	Vice President Conference Chair Librarian
Diana Davis	Secretary	23966 NE Wolf Rd. Fletcher, Ok 73541 Diana.copperrose@gmail.com	580-549-6824	Secretary Club Membership BOD Meeting Agenda BOD Meeting Minutes
Teresa Gabrish	Treasurer	P.O. Box 18389 Oklahoma City, Ok. 73154 tgabrish@gmail.com	405-824-9681	Treasurer
Mandell Greteman	Director/Workshop Coordinator	Rt. 2 Box 130 Foss, Okla. 73647 mandell01@windstream.net	580-515-1292	Workshop Coordina- tor
Bill Kendall	Director/Swage Blocks	1756 E. 59 <sup>th</sup> St Tulsa Ok. 74105 wwkendall@aol.com	918-691-2173	Swage Block Ship- ping Quotes Swage Block Ship- ping
Terry Jenkins	Director	222 N. Washington Blanchard, Ok. 73010	405-476-6091	
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Russell Bartling	Editor	70 N 160th W. Ave Sand Springs, Ok 74063 rbartling@ionet.net	918-633-0234	Newsletter Editor Regional Meeting Coordinator
Dodie O'Bryan	Webmaster	Pawnee, Ok scout@skally.net	—	Website Updates Web Calendar Up- dates

# Workshop Schedule

**Jan 30 – Beginning Blacksmithing Workshop:** to be held at the Route 66 Blacksmith Shop in Elk City. More details will be provided in next month's newsletter. Class size is limited so it is encouraged to sign up as soon as possible. Contact Mandell to register.

**Jan 30 – Beginning Blacksmithing Workshop:** to be held at Bill Kendall's workshop in Tulsa. Instructors will be Doug Redden and Tracy Cowart. Lunch will be provided. Cost will be \$30. More details will be provided in next month's newsletter. Class size is limited so it is encouraged to sign up as soon as possible. Contact Doug Redden to register.

**There has been some discussion of offering another hammer making workshop. The date and location has not yet been determined but somewhere in the NE region is a possibility. Final location will depend on interest level and availability of the necessary equipment. The next fifth Saturday would be April 30th so this is the most likely date. If you would be interested in attending a hammer workshop, please let Mandell Greteman or Doug Redden know as soon as possible.**

**Mandell Greteman is the SCABA Workshop Coordinator. Contact Mandell at 580-515-1292.**

## 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*

## **\*\*NOTICE\*\***

Diana is handing over the job of keeping track of the monthly regional meetings to me. It seems to work best combined with the newsletter editor job.

If you plan to host a monthly meeting, please send your information to:

Russell Bartling  
918-633-0234  
rbartling@ionet.net  
70 N 60th W Ave.  
Sand Springs, OK 74063

E-mail is the most convenient for me, followed by phone, then by regular mail. But whatever method works for you is fine.

Thanks!

# \*\*\*\*RETRACTION\*\*\*\*

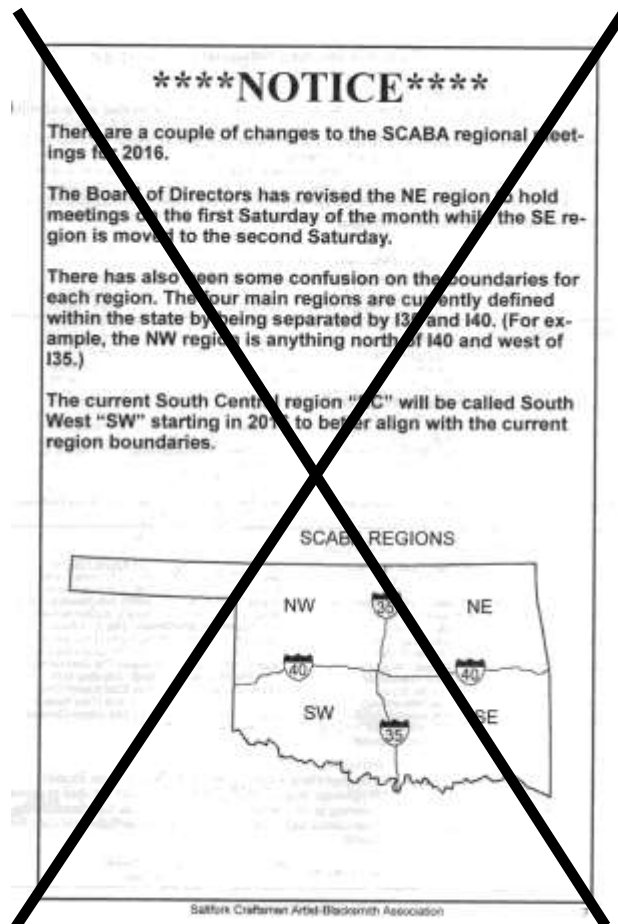
On page 7 of the December newsletter, there is a notice of a regional meeting date change and a map which was intended to clarify the existing region boundaries. It turns out that information was not actually ready for prime time. That communication does not reflect a cohesive direction of the entire Board (which was an erroneous assumption on my part.)

The existing regional meeting dates prior to that notice will remain in effect. The SE region meetings and the NE region meetings will not swap Saturdays. The South Central region will still be called South Central and not South West. The existing regional boundaries are not actually clearly defined by the I35 and I40 demarcations. That map was actually intended to clarify what was thought to be the existing boundaries, not to convey a change. However, that map can be ignored.

In short, until further notice,

**NOTHING HAS CHANGED FOR ANYBODY ANYWHERE.**

I believe the intent of that communication was to facilitate having meetings, not to hinder them. If you are interested in hosting a meeting, I would encourage you to go ahead and do so. - *Editor*



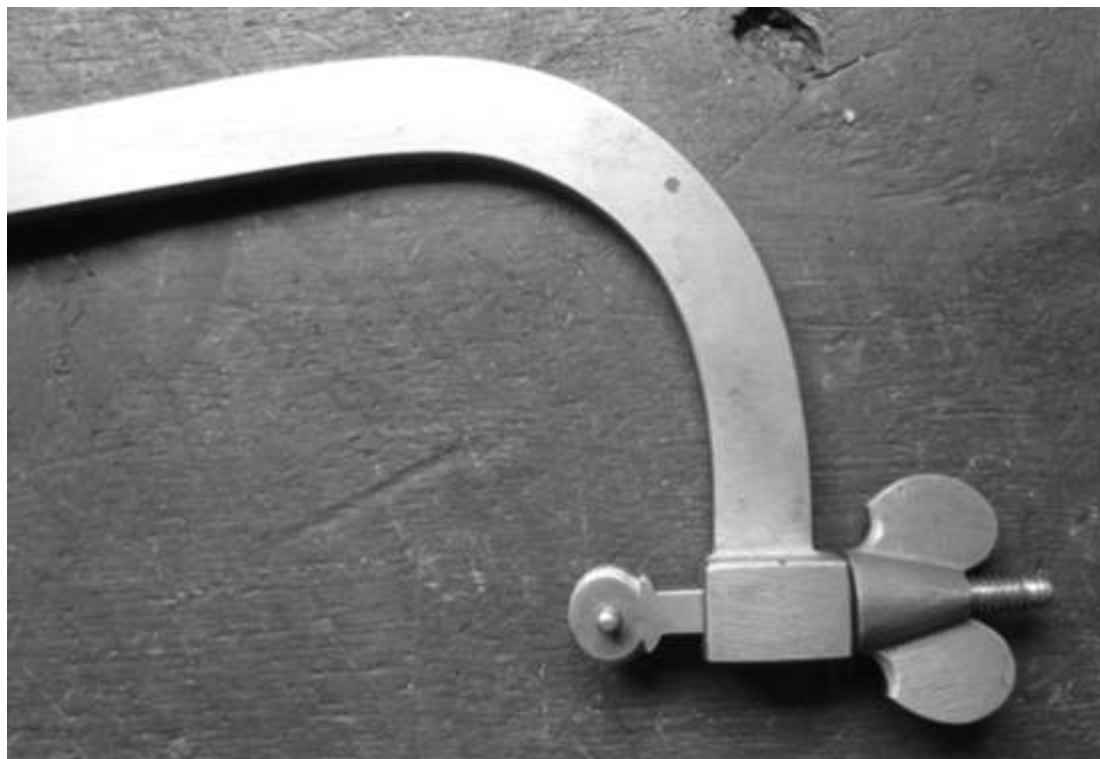
## Apologies to Terry Kauk...

I misread Terry's last name on the 2016 handwritten meeting form and misspelled it not once but multiple times in the December newsletter. Including the front page of all things. I am sure he is too polite to say anything about it but I discovered that error when I saw his name printed elsewhere.

The correct spelling of Terry's last name is Kauk not Kaulk as I had it.

I normally try to keep up with name spellings by cross checking against a membership list but didn't do that here. Sorry Terry! Won't happen again. - *Editor*

**2016 Peter Ross Workshop:** Doug Redden has been in communication with Peter Ross and Jymm Hoffman about potential projects for the after conference hands on workshops in 2016 (See the December newsletter for more info.) He sent me these two pictures of a possible hacksaw project by Peter Ross to show the kind of project that might be available in those workshops...



# REGIONAL MEETING DATES

## 2016 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.2nd (Open)	Jan 9th (Open)	Jan. 16th (Open)	<b>Jan 23rd (Monte Smith)</b>
Feb. 6th (Open)	Feb. 13th (Open)	Feb. 20th (Open)	Feb. 27th (Bob Kennemer)
March 5th (Open)	March 12th (Doug Redden)	March 19th (Open)	March 26th (Mandell Greteman)
April 2nd (Open)	April 9th (Open)	April 16th (Open)	April 23rd (Dorvan Ivey)
May 7th (Open)	May 14th (Open)	May 21st (JJ McGill)	May 28th (Don Garner)
June 4th (Open)	June 11th (Marshall Hager)	June 18th (Ricky Vardell)	June 25th (Terry Kauk)
July 2nd (Open)	July 9th (Open)	July 16th (Open)	July 23rd (Kelly Kilhoffer)
August 6th (Open)	August 13th (Open)	August 20th (Open)	August 27th (Don Garner)
Sept. 3rd (Open)	Sept. 10th (Open)	Sept. 17th (Jim Dyer)	Sept. 24th (Roy Bell)
Oct. 1st. (Open)	Oct. 8th (Open)	Oct. 15th (Conference)	Oct. 22nd (Cheryl Overstreet)
Nov 5th (Open)	Nov. 12th (Dan Cowart)	Nov. 19th (Anthony Griggs)	Nov. 26th (Cory Spieker)
Dec 3rd (Open)	Dec. 10th (Open)	Dec. 17th (Open)	Dec:24th (Merry Christmas)

Fifth Saturday Fun Day - Dec:31st (Mandell Greteman)

The meeting hosting form can be found on the last page along with membership application form. Russell Bartling will now keep track of 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 please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the hard copy form in as soon as possible.

-Russell Bartling 918-633-0234 or [rbartling@ionet.net](mailto:rbartling@ionet.net)

## Regional Meeting Schedule

### January

- SE regional meeting January 2nd: Open.
- NE Regional meeting January 9th: Open
- SC Regional meeting January 16th: Open
- **NW Regional meeting January 23rd:** Will be hosted by Monte Smith at 8848 N. 2010 Rd, Hammon, OK 73650. The trade item is a horseshoe. Lunch will be provided but bring a side dish or desert to help out.  
From Hammon, go 7 miles north on HWY 34 to E0880 Rd (There is a Moorewood Baptist Church sign) then turn west and go 3 miles. Turn south and go 1/2 mile to the entrance on the east side of the road.  
Monte Smith 580-497-6015.

### February

- SE regional meeting February 6th: Open.
- NE Regional meeting February 13th: Open
- SC Regional meeting February 20th: Open
- **NW Regional meeting February 27th:** Will be hosted by Bob Kennemer at 1201 Lynnwood Dr., Elk City, OK 73644. The trade item is a Tomahawk. Lunch will be provided but bring a side dish or desert to help out.  
Bob Kennemer 405-225-1878.



## Around the State....

**SE: South East Region December Meeting:** No regional meeting was held for the SE region.

**NE: North East Region December Meeting:** The NE region December meeting was hosted by Charlie McGee at his home north of Sand Springs. There were about 30 people in attendance. Due to a conflicting basketball tournament, I only made it to the meeting as it was about to wrap up so I didn't get any photos of the trade items or many of the attendees. - *Editor*



**SC: South Central Region December Meeting:** No regional meeting was held for the SC region.

**NW: North West Region November Meeting:** The NW region November meeting was hosted by Mandell Greteman at his shop in Foss. Due to an icy weather event affecting a large part of the state, the only person who was able to show up to check it out was Gary Seigrist. He said he spent almost a couple of hours getting his truck thawed out. The Gretemans wanted to express their gratitude to Gary for braving the bad conditions. There was a lot of ice on the roads and power outages so it is probably best that most of us stayed home for this one...



*-Editor*

## Calling All Movie Stars From Doug Redden..

At the March 12th NE Region meeting, a film class from Rogers State College will attend to film blacksmiths for a class project. The class will shoot and edit the film and Saltfork will get a copy of the film for the library. It is not known at this time how many cameras will be used for filming.

So if you are interested in participating as a subject in the film or just watching the fun, this may be a meeting you will not want to miss...

*- Editor*





# Blacksmith Classes Offered by Indian Capital Technology Center:



**STILWELL CAMPUS**  
 918-696-3111 / 866-696-3111  
 Route 6 Box 3320 / Stilwell, OK 74960

STL

**NEW! Intro to Blacksmithing** 15 hrs/\$45+

Learn to forge tapers, make punches, punch holes with punches made. Students will learn how to safely and properly light and maintain a forge fire. Students will be trained in the safety of forging as they make and use punches, chisels and hole drifts.

01/25 – 02/22 M 6:00P-9:00P STL

**NEW! Blacksmith Scrolls & Collaring** 6 hrs/\$25+

Learn and perform safety practices to forge tapers in mild steel and make scrolls with them. Students will learn to calculate stock length for collaring scrolls together and how to make collars.

02/29 – 03/07 M 6:00P-9:00P STL

**NEW! Forge a Fire Place Rake** 18 hrs/\$55+

Learn and perform safety practices to forge a fireplace rake from 1/4" x 3/8" mild steel.

03/21 – 04/25 M 6:00P-9:00P STL

**NEW! Forge a Hot Cut Hardie & Hammer** 24 hrs/\$65+

Learn and perform all safety practices to forge a Hot Cut Hardie for an anvil used to cut bar stock. Students will learn to forge a rounding hammer used for forging as well as learn to grind and heat treat the hammer. Students will make their own hammer handle, wooden wedge and steel wedge.

04/02 – 04/16 Sa 8:00A-4:30P STL

**NEW! Forge Welded Bundle** 9 hrs/\$35+

05/02 – 05/16 M 6:00P-9:00P STL

**NEW! Forge a Patch Knife** 6 hrs/\$25+

05/03 – 05/05 T/Th 6:00P-9:00P STL

Doug Redden forwarded this information to me to include in the newsletter.

The Indian Capital Technology Center is offering new blacksmithing classes at their Stillwell campus.

Doug verified that the classes are to be taught by Ed and Brian Brazeal.

If you are interested, you can obtain their complete catalog online at

[www.ictc.com](http://www.ictc.com)

Or contact the Stillwell campus at the number included above.

*-Editor*

# LEARN HOW TO MAKE YOUR LITTLE GIANT POWER HAMMER WORK HARDER THAN EVER!

Please join us for the 24TH annual Little Giant Rebuilding Seminar! Although we did pass ownership of Little Giant to our machinist Roger Rice in 2013, Sid Suedmeier will continue teaching the rebuilding class at his shop at 420 4th Corso in Nebraska City.

We carry on the tradition of our good friend Fred Caylor of teaching how to make Little Giants run well and hit hard.

The 2½ day class is a hands-on format. You will help transform a 25 LB Little Giant hammer from functional but sloppy condition into a well tuned, quiet, hard working hammer. Sid Suedmeier, former owner of Little Giant, will share all his knowledge and experience gained from working with Fred and from 24 years of repairing and rebuilding Little Giants.

An old style 25 LB Little Giant will be rebuilt during the class, and a new style machine will be on hand to demonstrate proper assembly and adjustment of both styles.

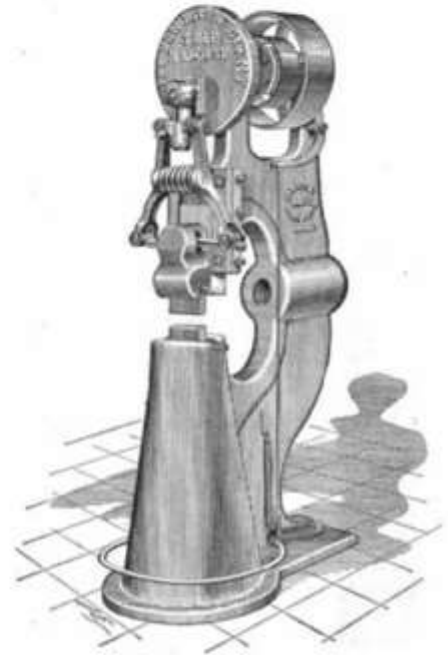
The class is held in Sid's shop in historical Nebraska City, Nebraska. The city has a wide variety of cafes, outlets (including Pendleton Woolen Mills), antique and gift shops, orchards, wineries and museums.

No experience is required to attend this class. Past classes have been comprised of students, retirees, artists, welders, doctors, farriers ...anyone who wants to learn will benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop.

If you are in the market to buy a power hammer, this class will make you an educated shopper. If you already own a Little Giant, or any other brand of power hammer, this class will teach you how to get the best performance possible.

The class costs \$95, refundable up to 7 days prior to the class; advance registration is required. We limit each class to 25 participants. The classes start at 9 AM sharp on Friday, and usually ends by Saturday evening. The schedule runs Sunday until noon in case we encounter any exceptional problems in rebuilding, and to answer remaining questions.

When we receive your registration, we will send you a city map, along with travel and hotel information. Airports are located in Omaha (45 miles north), Lincoln (50 miles west) and Kansas City (125 miles south).



**AN ADDED BONUS THIS YEAR** will be a discounted price on the Little Giant Rebuilding DVD set that we had filmed several years ago. Regular price is \$95; it will be offered to class members for \$50. One set per class member.

**IF YOU HAVE A LITTLE GIANT, THIS CLASS IS FOR YOU!**

## MARCH 11-13, 2016 REGISTRATION

NAME: .....  
BUSINESS NAME: .....  
STREET ADDRESS: .....  
CITY: ..... STATE: ..... ZIP: .....  
PHONE (Work): ..... PHONE (Home): .....  
E-MAIL ADDRESS: .....

**PAYMENT**

Check Enclosed     Visa     MasterCard     Discover     American Express

NUMBER: ..... EXPIRATION DATE: .....

<b>POWER HAMMER INFO</b>
BRAND: .....
SIZE: .....
SERIAL #: .....

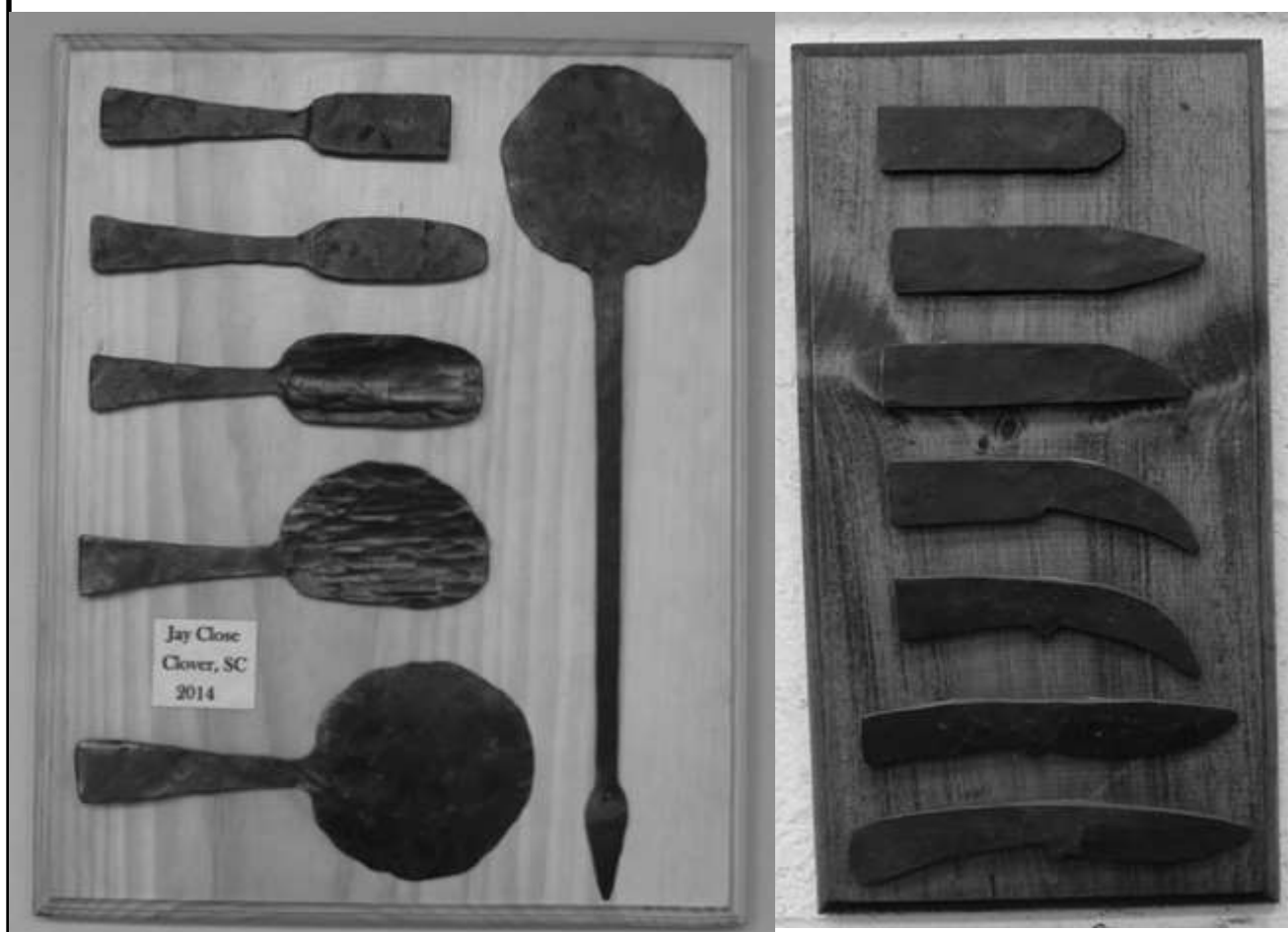
Please call or e-mail if you have any questions, or prefer to register by phone. You can reach us at 402-873-6605 or SidsShop@windstream.net. Suedmeier Enterprises, 420 4th Corso, Nebraska City, NE 68410.

# Story Board Gallery...

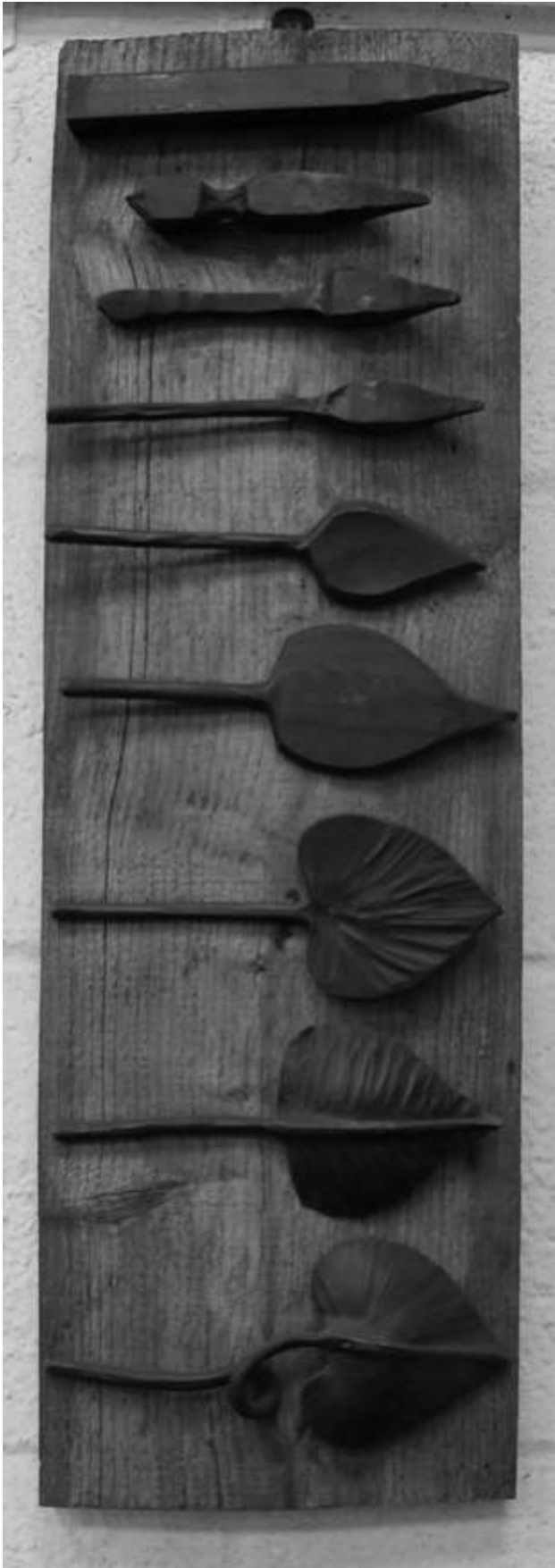
After reading David Seigrist's President's notes for this month, I thought I would include some examples of the story boards he mentioned. At the end of September, I made a trip to the New England School of Metalwork for a class with Jeffrey Funk. I got a lot of information to share when I get time to properly organize what I learned in the class.

These story boards, sometimes also called "progress boards" by some, were in my collection of photos and I wasn't sure if anyone would be interested in them until I read David's comments.

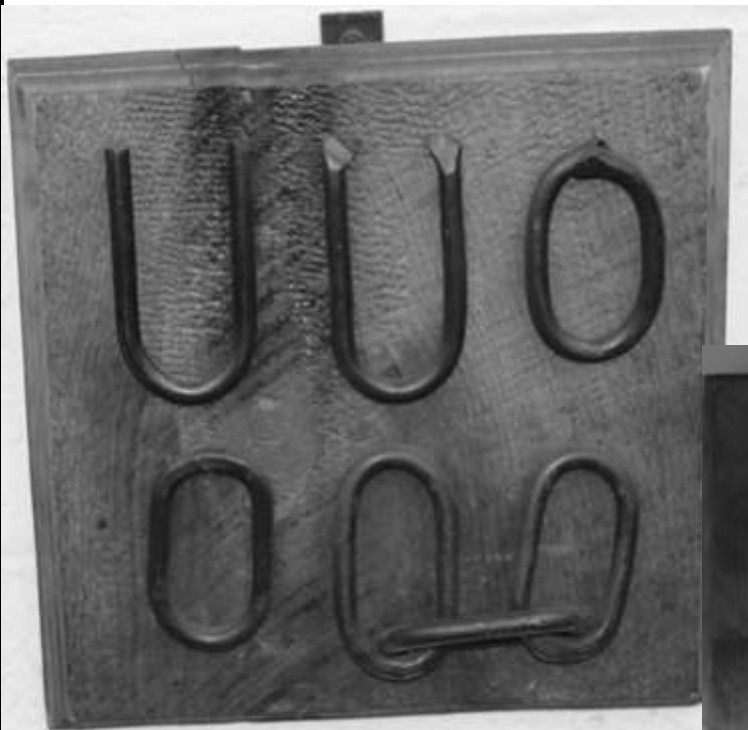
These were on the shop wall and in the administrative office. Most of them have no text other than possibly the person who made the pieces and that is one of the interesting aspects about them. They illustrate the major steps without words so that the concept of making some item can be understood almost at a glance. If you study these, you can learn a lot if these projects are new to you. There were others that included more examples than progressions and I am not including them now. But these examples represent some easily understood steps in a few different projects...



# Story Board Gallery Continued...



# Story Board Gallery Continued...

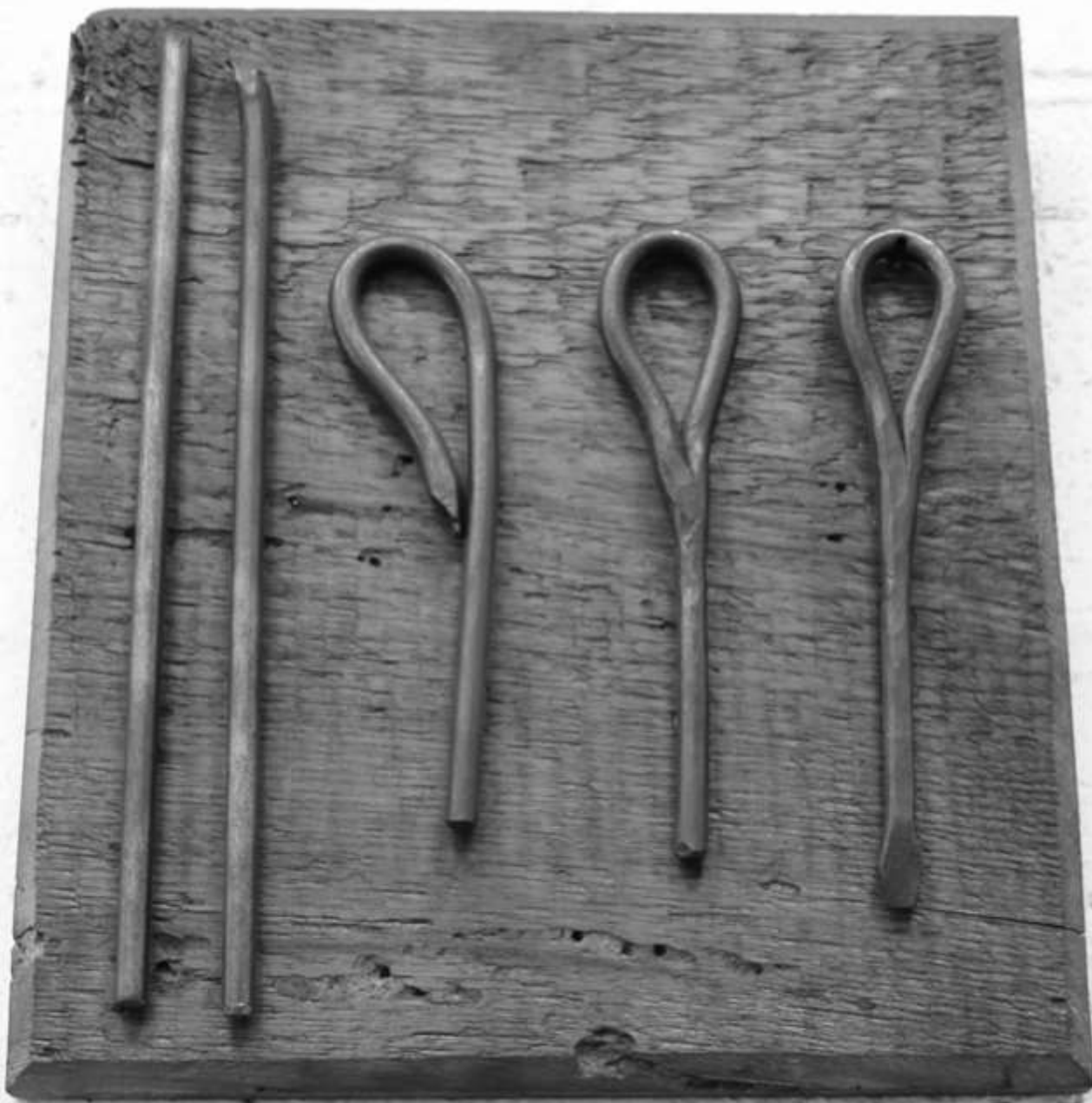


# Story Board Gallery Continued...





# Story Board Gallery Continued...

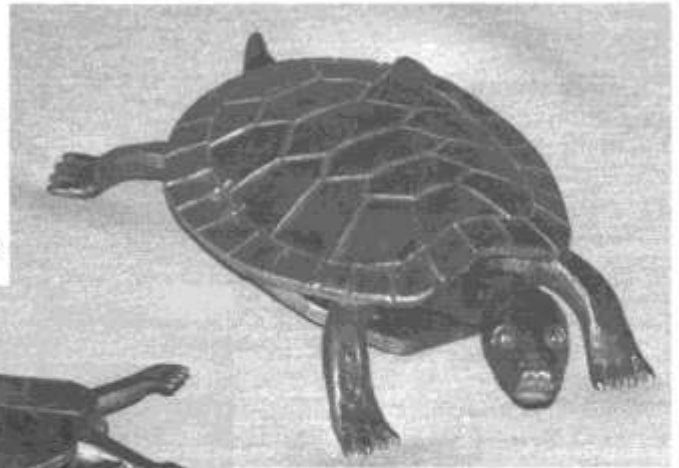


## Robb Gunter's Turtle

from Edgewood New Mexico  
demo at 1990 SOFA Quad State Round Up  
Following the demo this was written up by Jim Robarr  
drawings by Jim Robarr

A great project write-up  
edited for space in 2006, for MABA's The Upsetter

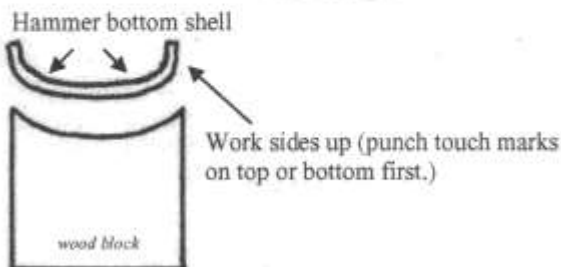
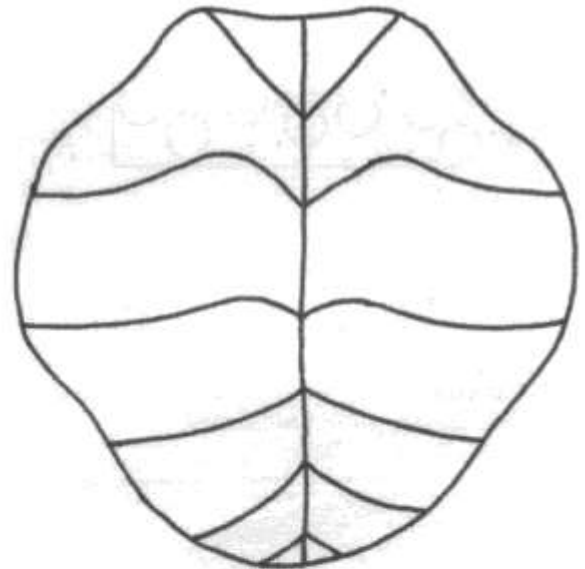
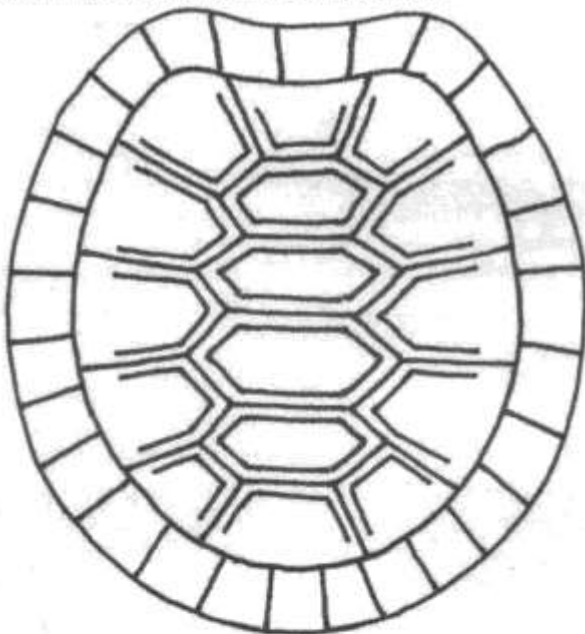
Note: This turtle, forged by Pam and Steve Manning in the beginning of 2005 is their interpretation from a copy of the original 4 page article. Pam and Steve received a "kit" as an Iron-In-The-Hat item put together by Dave Jonas, a MABA member. The project write-up packaged with the pieces already cut out were ready to be forged. (A fun IITH idea.)



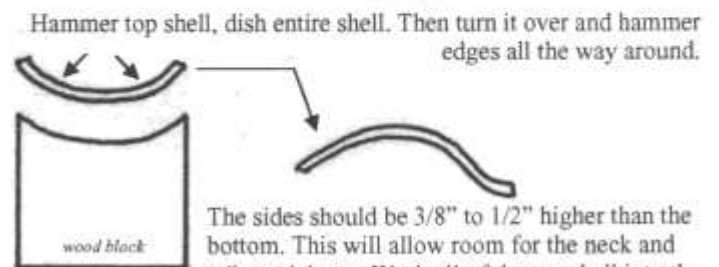
Photos by Steven Spoerre

Jim Robarr wrote:

During our last meeting, some of our members wanted more info on the "Robb Gunter turtle". Here goes! Robb was a guest demo at the "Quad State Round up" in Tipp City, OH (1990). He said his son had a small turtle for a pet, which gave Robb the idea to make one. To start out Robb used 10 ga. for the top and bottom shell. 11 or 12 ga. would work well also. Cut out stock and trace pattern onto shells. Use a small soft edge flat punch to mark in scales on shells. Now is also the time to put your touch mark on the bottom or top if you want.

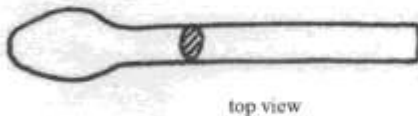
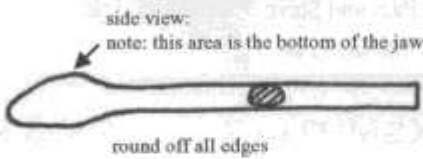
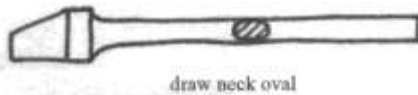
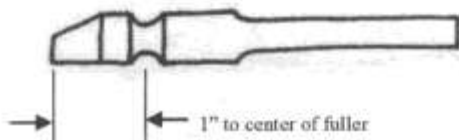
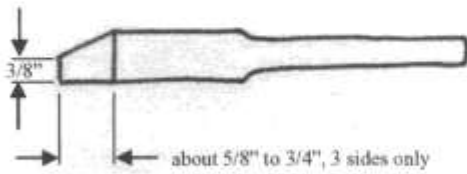
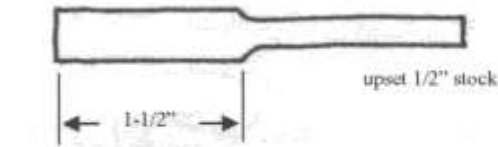


Using tongs on the tail and/or neck area, work up the sides of the bottom shell.

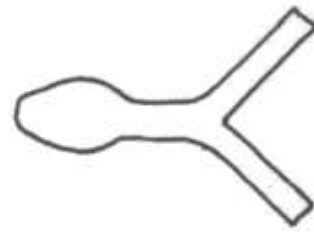


The sides should be 3/8" to 1/2" higher than the bottom. This will allow room for the neck and tail to stick out. Work all of the top shell into the hollow of wood. Flip over and hammer the edge flat (use brass or soft hammer here). Leave about 1/2" to 3/4" recess in top shell.

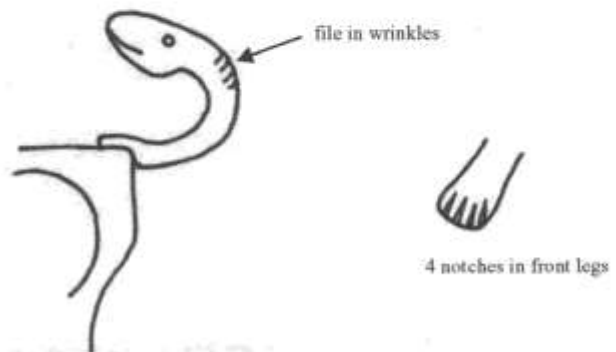
For the head use 5/8" or upset 1/2" square stock. This should be about 1-1/2" long. Now forge 3 sides with a short taper. About 1" from tip of nose fuller all 4 sides and forge to an oval shape 2" to 2-1/2" for the neck area. Forge (lightly) head to rounded off shape.



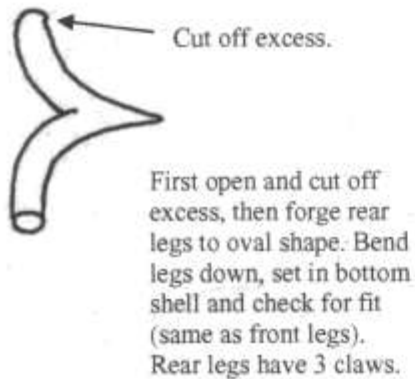
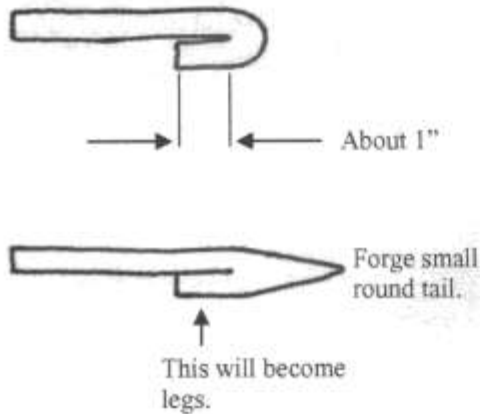
Split neck and forge legs to oval. Bend both legs down. Now fit to bottom shell and cut off excess stock on legs. Use your own judgment here.



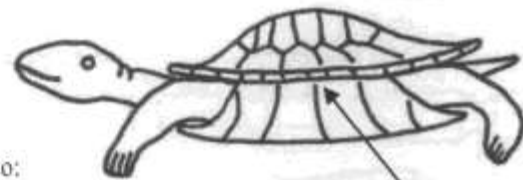
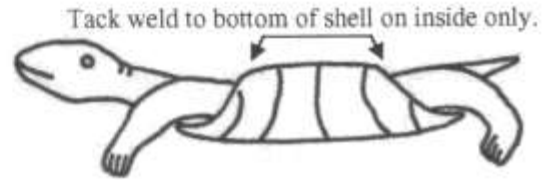
File "wrinkles" in neck. Pinch toes (claws) and file in 4 notches for claws. Now punch eyes, nostrils and file or punch in mouth.



Use 1/2" square or round stock for tail and rear legs.



When all parts fit, tack weld together on inside only (to hide any ugly welds). Now set top shell on and weld underside of said shell. Clean, wire brush and oil as needed. Robb said (if memory services me correct) he sells the turtles for \$80. My 4 year old son has dragged his all over the house!!



Clean & oil.  
Special Thanks to:  
Robb Gunter from  
Edgewood, NM

MABA editor's note: In real life different kinds of turtles can have 3-4 or 5 toes. The Manning's checked out a reptile book and picked a turtle that had a relatively flat bottom shell to use as their model. They also simplified the top shell pattern.  
Dave Jonas suggests you glue a copy of the shell pattern onto your steel and chisel the lines through it. Pam and Steve Manning said this worked great for their turtle.

*Article courtesy of the Michigan Artist Blacksmith Association - Editor*



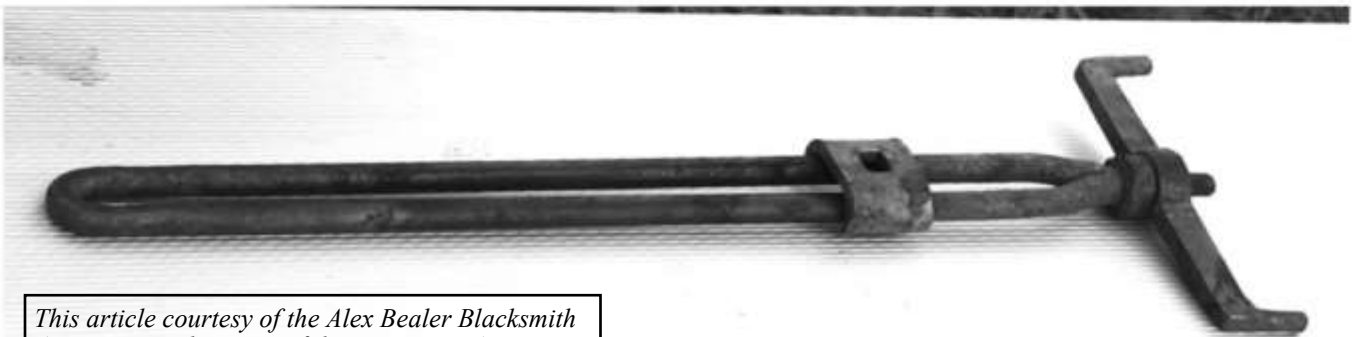
**Peter Ross - Blacksmith's Helper Demo at 2015 SBA Conference.**

**THOMAS BOUCHER.**

Friday afternoon, Peter Ross began a demonstration on how to forge a blacksmith's helper. He was to finish the demonstration Saturday morning, however I was only at the conference on Friday. The helper he was demonstrating was a variation on the one in the image to the left. The solid part of the leg was moved to the lower portion of the leg and the slotted portion was moved to the top of the leg. The reason for this change was to keep the locking handles stationary as the leg was adjusted.

A blacksmith's helper is a good way for a smith to demonstrate his skills. Peter had designed a rather nice one, but it's more elaborate than it needs to be. The one that he decided to demo for us was a much simpler construction, based on a piece that he found in a warehouse, dating to around 1880's-1910's.

He began with stock that appeared to be about  $1\frac{1}{2}'' \times 1\frac{1}{2}'' \times 12\frac{3}{4}''$  for the three feet. Each of the feet was tapered and rounded out for about 6" on one end. Once they were cleaned up, and the tapered and rounded ends transitioned well, he stacked them to be faggot welded. Since the material was not square, two were stacked and the third was stood next to them (Fig. 1). A piece



*This article courtesy of the Alex Bealer Blacksmith Association. This issue of the Hammer's Arc is a special edition from their 2015 annual conference and includes several great articles from the Peter Ross demos at the conference - Editor*

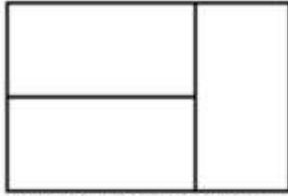


FIG. 1 SHOWS HOW PETER GROUPED THE THREE PIECES TO BE WELDED TOGETHER. A PIECE OF WIRE CAN BE USED TO HOLD THEM IN PLACE.

of wire can be wrapped around the bundle to help hold them together until they are properly welded.

Once the feet are joined, scarf the end, as well as the end of the lower part of the leg or stem. Peter said that he does not take his time to make his scarf super clean and tidy. As long



FIG. 2 - PETER SHOWS THE COMPLETED WELDS.

as the centers hit first and the end is feathered out, they are good enough for him.

The stem should be three times the width of the round bar used for the upper, adjustable, portion of the leg and about 20" long. After welding the stem to the feet, punch and drift a square hole about an inch or so from the top of the stem. Repeat this process about 10" down as well. These two square holes will be for the carriage bolts that make the top of the leg adjustable.

Peter says that making a carriage bolt can be tricky. Everything must be under control. The shank size must be consistent and match the size of the threading dies. The shank must also be straight and square to the head. The square portion of the shank must be wider than the threaded portion as well.

To head the bolt, make a bolster using the same drift that you used to put the holes in the stem portion of the leg. Begin to taper out the parent stock of the bolt so that it will fit into the bolster. Offset the bar, while you taper, so that you form shoulders. These shoulders will keep the bolt from sliding through the bolster and will aid in the heading process. Break the corners of the top of the bolt, before heading it



FIG. 3 - CLOSE UP OF THE FINISHED CARRIAGE BOLT.

in the bolster. He did not show us the filing and cleanup or threading process for the bolt, but it should be easily figured out.

Once thing to note about this carriage bolt, and the ones produced during the 18th century, is that there is a much longer portion of the bolt that is square and unthreaded compared to modern carriage bolts.

The nut and handle are made as one piece. Peter showed us two ways that the handle can be forged.

The first method of making a handle was to isolate a square portion at the end of the stock. Peen the isolated area sideways to flatten it out and widen it without much change in its length. Octagonalize and round out the isolated area. Punch out a hole in the center of the isolated area. Cut off the handle from the parent stock and octagonalize it. Round out the lower portion of the handle leaving an octagonalized section below the nut. Offset the nut from the handle so that it can easily be grabbed when pieced together on the leg (Fig



FIG. 4 - OFFSET THE HANDLE FROM THE NUT.



FIG. 5 SHOWS THE TWO METHODS OF SHAPING THE NUT. ALTERNATIVE METHOD ON THE BOTTOM.

4). At a low heat, drift the hole large enough to be threaded with the corresponding tap for the carriage bolt.

The alternative method has you scarf the end of the bar and fold it over and welded it upon itself. Use a pin in the eye of the nut to retain the shape of the hole. The rest of the handle is forged and shaped as the previous method is finished out.



FIG. 6 - THE FINISHED LOWER PORTION OF THE LEG.

**\*Edit** - The bottom left image at the beginning of the article was taken by Linda Holmes-Rubin. It is a photo of the upright made at the second demo, which I was not present at. There is no write-up on its demo, but hopefully you can figure it out from the image.

# Heart Wall Hooks

Jim Carothers - December, 2105

I've been making these heart wall hooks for several years; good demo piece and they sell very well.

Fearing that I might lose my "pattern part", I took the time today to work up a sketch.

I make them with a simple pig tail end and also with a fish tail scroll.

Howard (member of the Central States Metal Artisans) made the one with the penny end – (Photo 1.)

(Continued on next page...)



Photo 1: Heart Hook with Penny End



Photo 2: Heart hook With Pig Tail End by Tom Nelson



Photo 3: Heart hook With Fish Tail Scroll End

## Heart Wall Hooks (Continued...)

### Forging Instructions:

**Material:** 3/8" square hot rolled steel bar (A-36) x 9" long

#### **Layout per the sketch:**

3" long band saw cut on center

2x drill thru 5/32" dia.; counter sink front side; deburr back side

**Twist:** Put your favorite twist about 1" long below the lower mounting hole.

File or grind the back side of the twist flat so that the hook will sit flat against the wall.

**Arms:** Heat and bend out into a wide Vee; draw out and taper to about 4-3/4" long. Check to make sure both arms are the same length

**Heart:** Close up the arms (check for equal lengths). Heat, spread, and form into a heart. The 4-3/4" long arms will make a nice heart about 3" wide.

**Hook:** If you want a penny end or a fish tail scroll end, leave about 1/2 to 3/4" of the full bar to make that detail. Set that 1/2 to 3/4" down on the far edge of the anvil. Draw out the bar above this shoulder into a long taper up to near the end of the twist.


If you want a simple pig tail end, draw out the bar from below the twist to a long taper. For the hook and pig tail as shown at about 1-5/16" inside diameter, it takes about 3" of drawn out length.

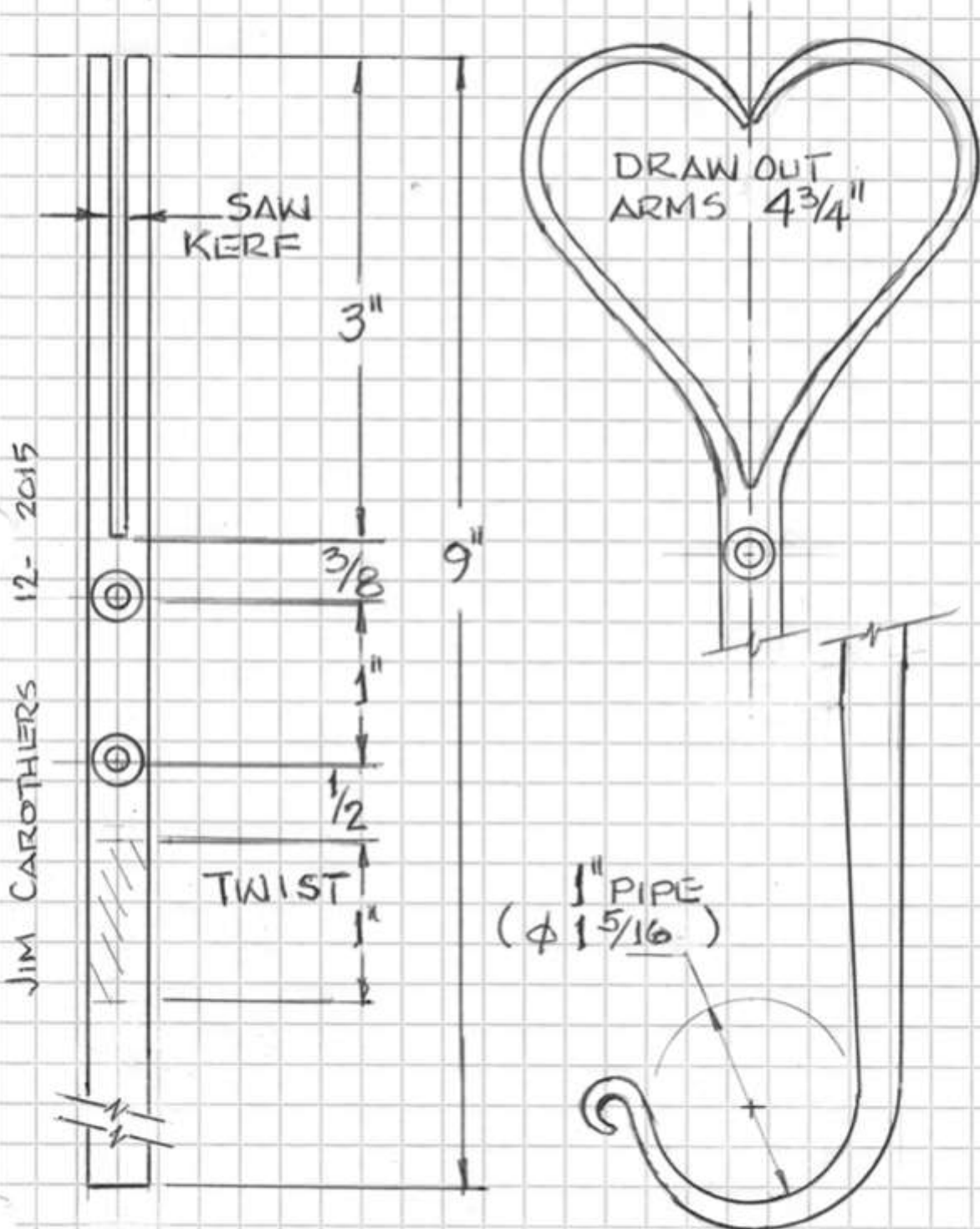
**Touch Mark:** A good place to put your touch mark on this piece is on the back side between the two mounting holes.



# Heart Wall Hooks (Continued...)

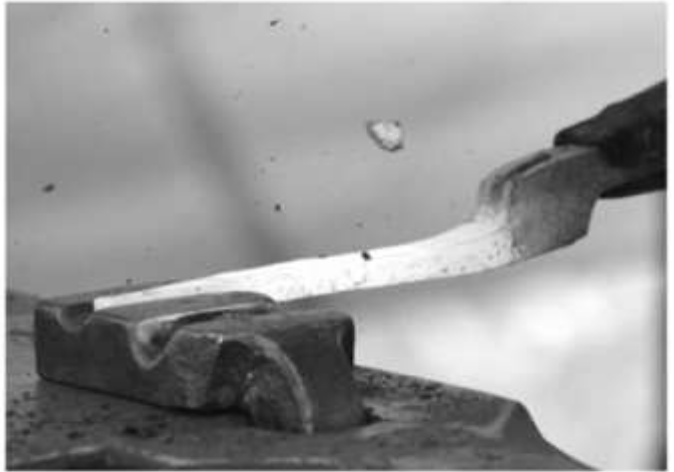
## HEART WALL HOOK

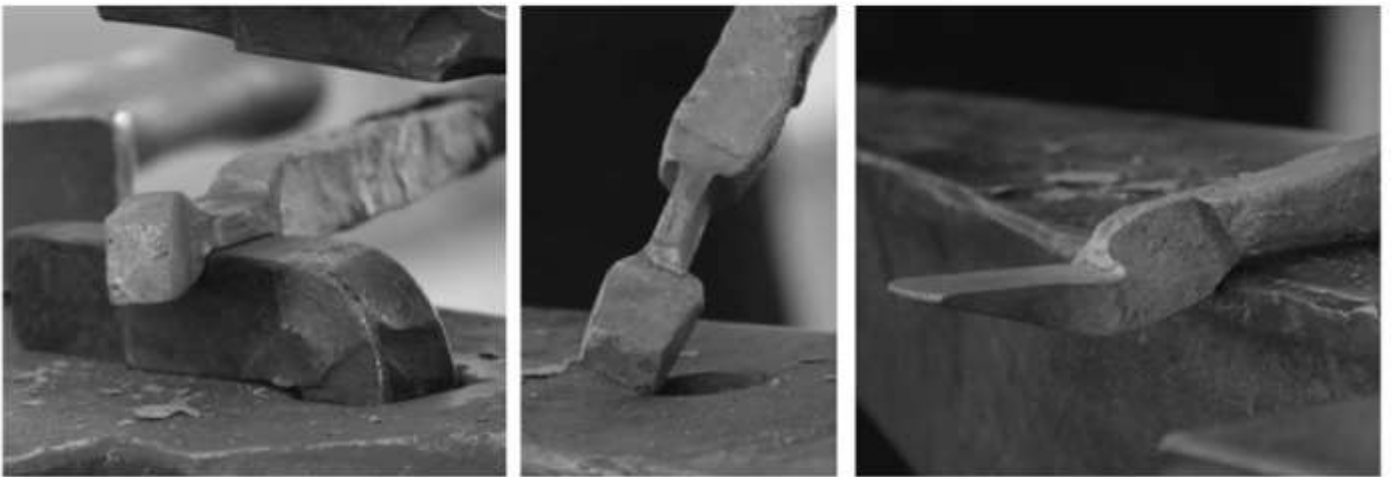
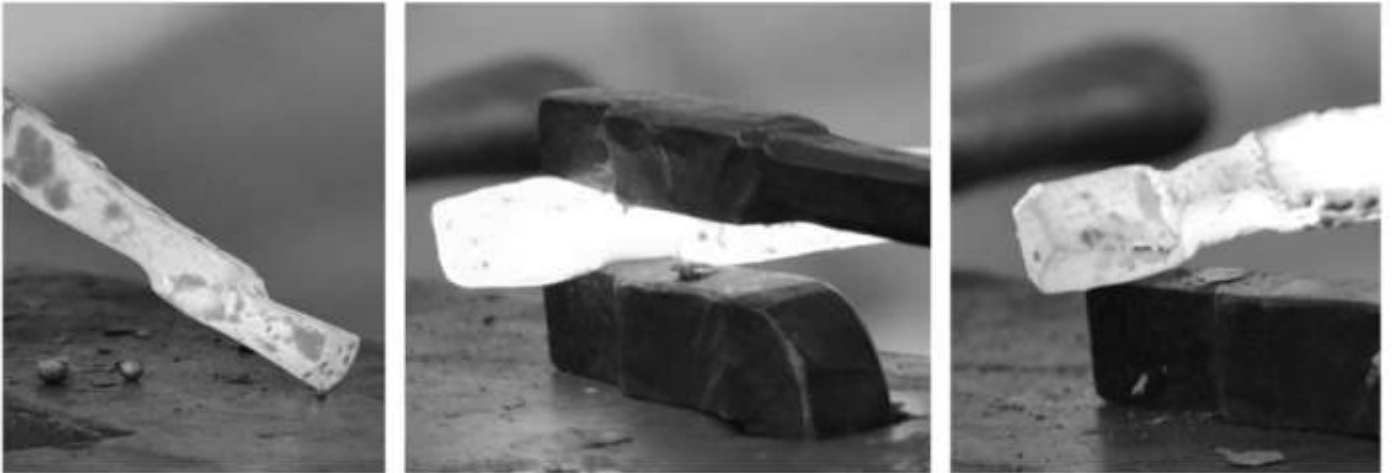
  $\frac{3}{8}$ " SQR



# PETER ROSS PLIERS DEMO

PHOTOS AND DEMO NOTES BY JIM GUY







*This article courtesy of the Alex Bealer Blacksmith Association. This issue of the Hammer's Arc is a special edition from their 2015 annual conference and includes several great articles from the Peter Ross demos at the conference - Editor*

Day 2  
Peter Ross  
Pliers

Box Joint Pliers

May 16



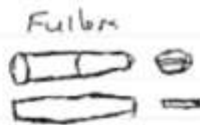
Tooling

- must fit each other  
specialized fullers  
DRIFT for slot width  
must match fuller

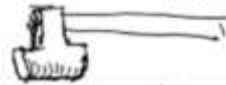
why Box Joints? —  
when twisting, prevents  
Racking of Joint



Slit punch  
DRIFT



Round bottom fuller



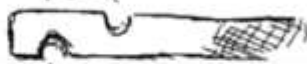
Round Swage (for handles)

Materials

1/2 x 1 mild steel

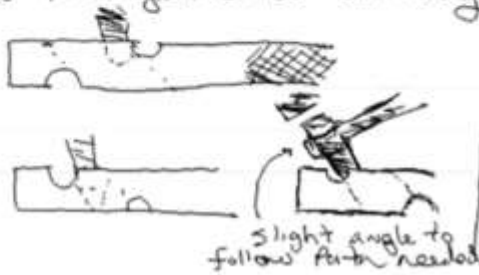
Slotted Leg

Fuller less than 1"



1/2 the width of Bar

cut slit (slitter is 1/16" wide)  
will make a offset cut  
so that you chisel vertically



Slight angle to follow Arch needed

Process over/under



Slit & Drift this  
area  
will lengthen the  
Jaw



will be slightly  
smaller than  
Finished Jaw

Drift &  
fin. Fuller  
must match  
this

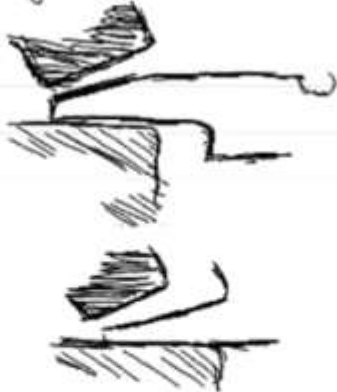
DRIFT



continue from both sides until cleaned up & the DRIFT passes THRU.



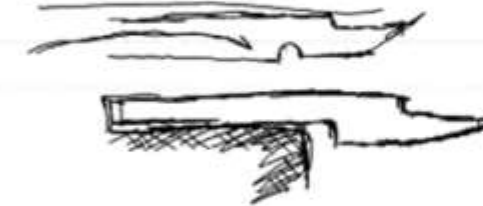
Forge Jaws



cut off bar



Draw out Rins



shape Rins



inside is flat outside round

Other half

- start with the same material used for the other half.
- Forge it square (biggest square you can get)

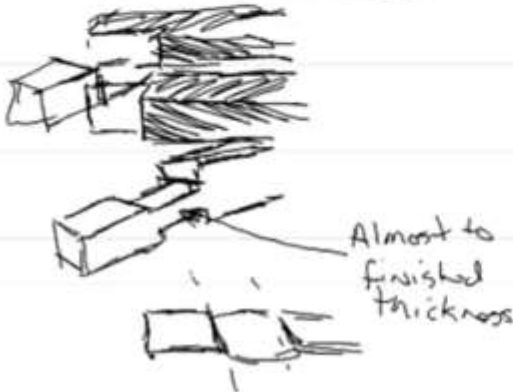


Forge Double off set.



Fuller

narrow fuller to start



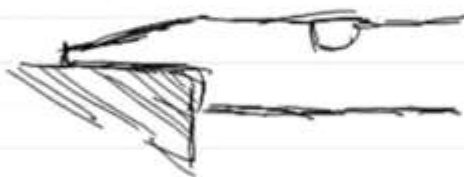
fuller @ angle

switch to larger fuller & finish

first fuller spreads it this more works the sides



Forge Jaw



cut to length



Draw out Peins square

Swage Round



to fit

square



file edges & face of bolster.

(NOTE: it's not a perfect fit, yet)

ASSEMBLY

Heat slot half



← may have to  
faced off parts  
of other half



Fit one hot, one cold

Heat of clears up shape



start separating

Bend in  
initial Reins on vice



Finish Bending Reins

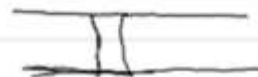


Pin the jaws

use 1/4" pin  
use same steel as  
for the jaws

- The pin is not holding the jaws together.
- it's just a pivot pins
- needs shear strength not tensile strength

- instead of counter sinking  
use a Renner to create  
tapers on both sides





Pins  
center punch.  
can really be anywhere

Drill  $\frac{1}{4}$ " Hole



Remove both sides

Rivet





**Mike LaMarre September Meeting Demonstration.**

THOMAS BOUCHER.

Mike LaMarre hosted the September meeting, at his shop, to show us chiseling and chasing techniques that he learned in Ernie Dorill's European motif class. Mike was able to take this class with the help of an ABBA scholarship through the John C. Campbell school.

Pictured above is the door knocker that Mike started working on in class and later completed in his home workshop. He took 4th place at the Madison Conference this year in the Peoples Choice Award.

For his demonstration, Mike walked us through the steps of making a rosette that was an element in a larger piece that was designed in the 1930's by Samuel Yellin.

He first showed us a simple technique of "blistering" the steel. This technique gives a nice finish. He figured that it is good up to about 3/16" plate. The larger the material gets and you risk burning up the underside before

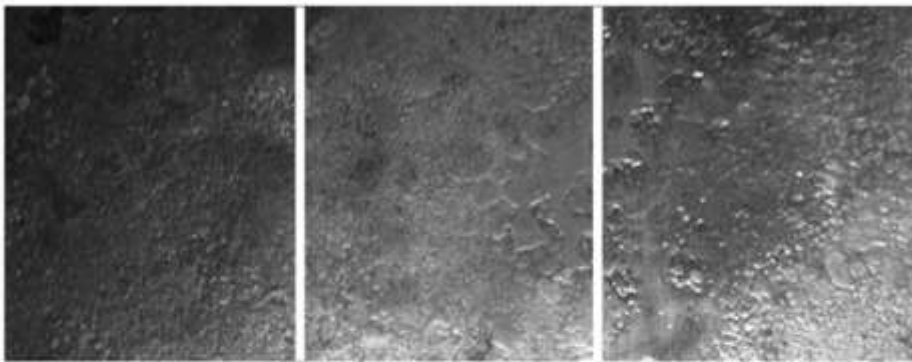


FIG. 1 - BLISTER STEEL WITH VARIOUS FINISHES APPLIED. FROM LEFT TO RIGHT IS: OUT OF THE FIRE WITH NO TREATMENT, SANDED WITH SANDPAPER, POLISHED WITH A WIRE BRUSH.

blistering the top. You need a clean fire with a lot of air pumping through it. Place your material on top of the fire. When you get an orange heat black spots or blisters will start to form on the top surface. Scrape off the scale while the material is still warm to clean off the surface. Let the piece air cool and use 80 grit sandpaper to take off the remaining scale.

Mike was working from a pattern that



FIG. 2 - GLUE YOUR PATTERN DOWN TO THE MATERIAL AND MARK THE CENTER POINT, AN 'X' STARTING POINT AND YOUR TOUCH MARK

was applied to the surface of the plate. Cut out the pattern and stick it down using a liberal amount of rubber cement. The pattern really only needs to hold for the first pass. Mark the center of the rosette while it is still flat as well as marking an 'X' as your starting point and your touchmark. It is much easier to put your touch mark on it now. The 'X' starting point gives you a good reference point in the event that your focus is taken away while starting your first pass.

To transfer the pattern onto the material you need a chisel and two butchers. Mike, and the rest of his class, made tools using S7. Grind the tip of the tool to its rough shape. Heat the steel to a dull red and quench all but the last half inch in water until it ceases to vibrate. The heat in the unquenched section should be enough to draw down the temper into the heat. Polish the tip of the working end on a wheel.

The majority of Mike's working was done with the employ of his treadle hammer. You do not need to hit these tools very hard to make a mark. However, there is a high possibility of crushing your hand under the hammer.

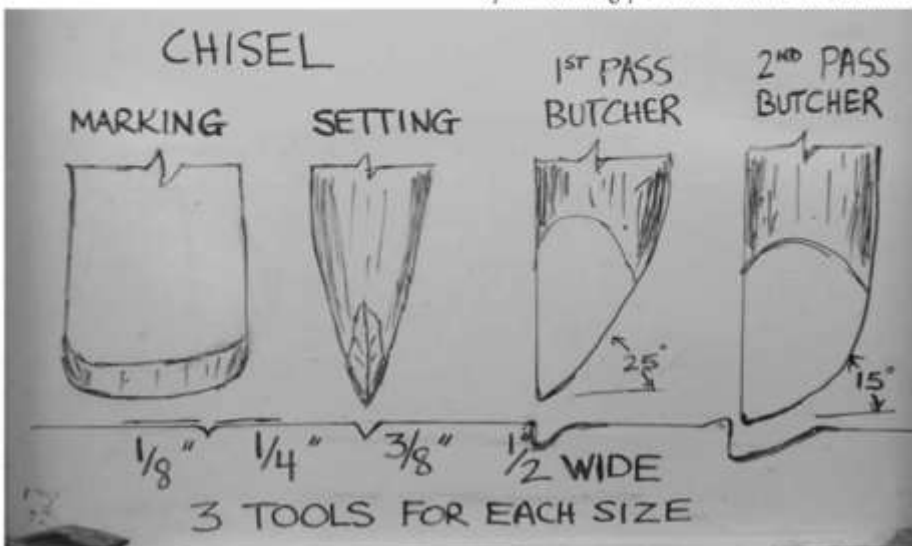


FIG. 3 - ILLUSTRATIONS MIKE HAD DRAWN ON HIS WHITEBOARD EXPLAINING THE 3 TOOLS NEEDED. NOTICE ON THE BUTCHERS THAT THE MATERIAL BULGES OUT A LITTLE ON THE INSIDE TOP EDGE OF THE CREASE.



FIG. 4 - MIKE ATTACHED AN 'L' SHAPED STOP TO THE TOP OF HIS TREADLE HAMMER THAT STOPS IT FROM COMING DOWN AND CRUSHING HIS HAND.

Because of this, Mike explained how he put a simple safety stop on this so that he can never crush his hand.

Mike took his first pass transferring the design onto the surface of his plate and then took four more passes to set it in almost cutting through on the outer lines. His final pass was to cut out the waste material. To do this he finds it easiest to rough cut the outside of it on a Beverly shear so that the waste material has room to fall off when it is removed. He also puts a saddle on the anvil of his treadle hammer to protect the face, just as you would on your anvil.

Issues arise where lines intersect in the design. Run past the intersection, with the chisel,



FIG. 5 - MIKE AT WORK CUTTING OUT THE ROSETTE.

to make sure the lines do cross on the outside corners. Once the waste material is cut off, file up the edges to clean off the rough barbs. Use a half round file to really clean crotches.

Mike decided that he wanted to accentuate the back of the pedals. This is easiest to do now while it is still flat. Flip the piece over and chisel a groove down the center of the pedals. This detail will be present when the pedals get curled over later on.



FIG. 6 - MIKE CHISELED A DETAIL DOWN THE PEDALS TO ENHANCE THE DESIGN.



FIG. 7 - MIKE MADE A SAMPLE PIECES SHOWING THE MARKS LEFT BY EACH OF THE TOOLS.

The butchers are used to further flatten out the design in areas to give more depth and volume.

Next heat the rosette up, (*per each larger pedal*) to a red/orange heat. Using a ball punch and a wooden block, in place of the bottom anvil on his treadle hammer, he gave some shape to each of the larger pedals. First strike the center and then one hit on each side bulging it out. Sand it using 80 grit sandpaper again.

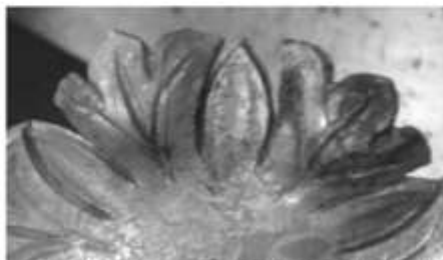


FIG. 8 - THE LARGER PEDALS BULGED OUT USING A BALL PUNCH AND WOODEN BLOCK

Drill a hole in the center of the rosette and file it square. This will be for the bolt to fasten it to something later. Mike prefers to use carriage bolts rather than slotted screws. The carriage bolt allows for more design on the head and you are not limited by the slot. Make sure to get steel and not galvanized bolts. Sand off the numbers on the top of the head.

Mike made a tool for his post vise to aid



FIG. 9 - THE UNDERSIDE OF MIKE'S HEADING TOOL. AN OLD PIPE FITTING TOOL WITH FLANGES WELDED TO THE TOP

in decorating the heads of his carriage bolts. He took an old pipe fitting tool and welded a flange on each side to rest on the top of his vise. You can use two pieces of angle iron to make the same tool. Tack-weld the two pieces together with a business card between them and drill a hole in the center. Grind off the tack-weld and you will have a heading tool.

After designing the bolt head, throw it into



FIG. 10 - SAMPLE DESIGNS THAT MIKE HAS PUT INTO A FEW CARRIAGE BOLT HEADS.

the fire to darken it up some. Sand the top to shine up the high spots. If the underside of the head is not flat from chiseling, file off the high spots so that it is flat again.

Using a large dowel (*Mike used a ladder rung*) flatten out the center of the rosette.

Another tool that Mike made was a bolster



FIG. 11 - FLATTEN OUT THE CENTER OF THE ROSETTE USING A LARGE DOWEL.



FIG. 12 - MIKE'S BOLSTER SITTING IN THE HARDY.

to pop the smaller pedals up about 60 degrees. Make sure to make the edges of the bolster thin enough to accommodate for the adjacent bent pedals to straddle it.

After bending out the pedals, sand off the points and take off any burrs and sharp rough spots. Use a thin pair of pliers to curve over the tip of the pedals. Then continue to bend them over further back. Make sure to leave enough space open to be able to slip the carriage bolt through. Throw it back into the fire to darken it up again.

Apply a dab of super glue to the underside of the carriage bolt head. This is why the underside needed to be flat. Place the bolt through the rosette and spin it a few times to find the most pleasing configuration of it before sticking it down. Slip a large nut down over the bolt threads as a spacer, and lock it down with a nut that fits.

The pedals can now be closed down further over the bolt using a hammer to lightly tap them in. Stick the bolt through the pritchel hole and use a punch to push the center of the rosette down further.

Mike likes to finish off his rosettes with a coat with lacquer, but you can treat them as you like.



THE FINAL PRODUCT. PHOTO BY MIKE LAMARRE.

## Helpful Shop Suggestions



### Vise Prop.

THOMAS BOUCHER.

If you have seen the Peter Ross DVD on forging a compass, then you are familiar with his vise prop. If you are not familiar with this tool, you should be. This ingenious tool solves the problem of having something that is shaped in a way in which it swivels in the vise jaws as you try to file or cut it. In the case of Peter's DVD, the compass that he is trying to file is tapered on all four sides and cannot be fully secured in the vise. He takes out a prop that he has mounted to his work bench that assists in supporting the second side of the compass so that it cannot swivel downward.



I recently forged and installed one for myself. I thought that I would share a picture of it so that others might get an idea as to how they might make one, if they so wish.

The prop consists of a slotted arm that allows for adjustment of height and distance from the vise jaws. At the top is a support arm for the piece being worked can rest on. It is mounted to the work bench by a mounting plate that can accept a thumb screw to allow for tightening the prop when you get it positioned appropriately.

It is quite a simple tool to forge, but the payoff of having it is very useful.

### Vise Wedges.

THOMAS BOUCHER.

Another nifty tool to use in your vise for holding onto objects similar to the pieces I described in the Vise Prop suggestion is a set of wood wedges. I learned of this jig in my class last June at the New England School of Metal Work.

The work piece can be wedged between two pieces of 2x4. The bottom one left as is and the top one cut with an angled top. A metal bracket with an angled top is fit around the 2x4s and holds the object in place. The whole jig is then secured in the jaws of the vise.

A picture can be seen below illustrating how a compass is secured. A secondary piece was placed under the tip of the compass to level it out for filing.

I recently made one and the piece I was trying to work on was really digging into the pine 2x4 on the top. You may want to try using a hardwood, or gluing a strip of hardwood onto the pieces of pine. I plan to do so, but have not done so at this time.

Article courtesy of the Alex Bealer Blacksmith Association - Editor

## SCABA Shop and Swap

### For Sale:

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

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

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

### For Sale:

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

Contact Larry Roderick at 940-237-2814

### Wanted:

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

## Club Coal

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

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

**NE Region coal location: Charlie McGee** has coal to sell. He lives in the Skiatook, Oklahoma area. His contact information is:  
(home) 918-245-7279 or (cell) 918-639-8779  
Please text his cell phone number if you would like to make arrangements to get coal.

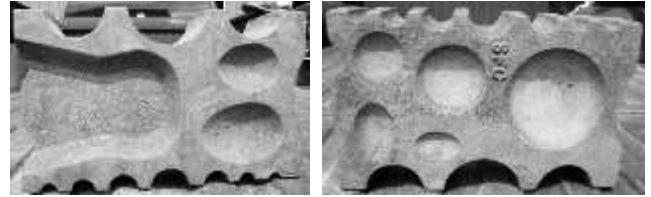
**S/C region coal location:** Club coal is now available at Norman at Byron Donor's place. Call Byron to make arrangements to come by and get coal.

SCABA swage blocks

\$150.00 plus shipping.

(Same price to members and 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 still have some of last year's SCABA t-shirts available while the supplies last. They are a grey pocket "T" with the SCABA logo on the pocket. Contact Diana Davis for information.**



# The SCABA Shirts are now available with a bold new look...

The latest SCABA T-shirts are now available with a new custom design by a professional artist. We also have new long sleeve denim shirts now available with the same new design. Each shirt has the main design on the back with the SCABA logo on the front pocket. T-shirts are available in black and grey. Denim shirts are \$25 and T-shirts are \$15 (plus shipping if applicable.) If you would like to purchase shirts, contact Doug Redden (918) 230-2960:



# SCABA Membership Application

January 1, 2016 to March 31, 2017

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, 2017

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

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

## Saltfork Craftsman Regional Meeting Hosting Form

Region SE NE SC 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 Regional Meeting 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 confirmation by e-mail or postcard.

A form must be filled out for each meeting.

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

An online form is also available on the website in the top banner of the Calendar Tab:  
[www.saltforkcraftsmen.org/Calendar.shtm](http://www.saltforkcraftsmen.org/Calendar.shtm)

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

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

Address Service Requested

