

Saltfork Craftsmen Artist-Blacksmith Association

May 2016



Byron (Korny) Doner was the First Place winner in the leaf forging competition at the 2016 SCABA Annual Picnic.

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Editors notes...

The article on sharpening rasps in this issue reminded me of a story I heard in elementary school, third grade I think. It was one of those deceptively powerful stories that stuck with me ever since. Here is the essence of that story:

One time a large and powerful woodsman challenged another less endowed woodsman to an all-day wood chopping contest. The challenger worked very hard, putting all of his natural strength to work and stopping only for a brief lunch break.

The other man had a leisurely lunch and took several breaks during the day. As the day pressed on, the challenger's ego began to swell. Working constantly, he was certain to have chopped far more wood than his lazy competitor.

At the end of the day, the challenger was surprised and annoyed to find that the other fellow had chopped substantially more wood than he had. "I don't get it," he said. "Every time I checked, you were taking a rest, yet you chopped more wood than I did."

But you didn't notice," said the winning woodsman, "that I was sharpening my axe when I sat down to rest."
- (Source Unknown)

So what does this have to do with blacksmithing?

Well, hot iron is a little like a sharp axe while not-quite-hot-enough iron is like a dull axe. I see people all the time continue to hit their iron after it has cooled too much. How do I know that it has cooled to much? Because last time I did exactly the same thing as they are doing, my arm felt like it was going to fall off. I was getting in a hurry and trying for "one more hammer blow" before "stopping" to reheat. I learned real quick that reheating is not "stopping" it is sharpening the saw, so to speak.

Hammering "cold" iron is hard on you and not sustainable. Now I naturally spend more time heating but the hammering is easier and I get more done with each blow. And the iron seems to understand what I want better when it is hot. It somehow seems more agreeable.

Now if I could stop staring into the fire...

- 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



Iron-In-The-Hat: SUPER DRAWING!

Exciting news for those local affiliate chapter members who will be attending the July 2016 Salt Lake City conference! In addition to the daily Iron-In-The-Hat drawings, there will be a Saturday night SUPER DRAWING that will consist of the following items:

- The MARK InLine Treadle Hammer by Meyer Machine Tool Company;
- BAM Box: filled with *Signature Tools* by Pat McCarty; and
- TFS Single Horn 100 lb anvil by Delta Mustad.

For those members who will be unable to attend the conference, tickets for Iron In The Hat will be available thru your local affiliate chapter. Each chapter will be receiving 100 tickets for sale. Ticket prices are \$1.00 each. Upon request additional sales tickets can be obtained thru the ABANA office.

Participants do not have to be present to win. At the winners' request, shipping arrangements (paid by winner) can be made.

As you are aware, all proceeds from the Iron-In-The-Hat are used by ABANA for Affiliate member scholarships.

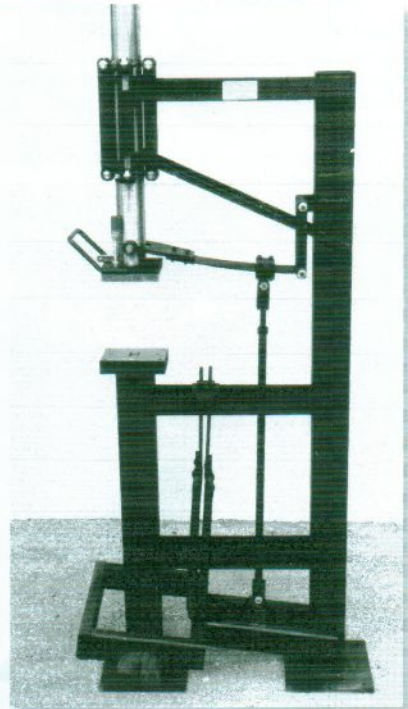
The Iron-In-The-Hat fundraiser is key to the success of our scholarship program. It provides the necessary funds to help educate and train scholarship participants and enhance blacksmithing. By

including all ABANA Affiliate members in our SUPER DRAWING, we can make our 2016 Conference the most successful scholarship program yet!

Please encourage your members to participate!

Thanks!

~Len Ledet



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Doug Redden has obtained tickets for the Iron-In-The-Hat SUPER DRAWING at the ABANA Conference.

If you would like tickets, contact Doug. Tickets are \$1.00 each and you do not have to attend the conference to win the drawing.

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:

Name	Position	Address	Phone	Duties
David Seigrist	President	P.O. Box 163 Hollis, OK 73550 dseigrist2004@yahoo.com	580-381-0085	President BOD Meeting Chair Help Where I can
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Bill Kendall	Director Swage Blocks	1756 E. 59 th St Tulsa OK 74105 wwkendall@aol.com	918-691-2173	Swage Block Shipping Quotes Swage Block Shipping
Terry Jenkins	Director	222 N. Washington Blanchard, OK 73010	405-476-6091	
Byron Doner	Director Cones	6520 Alameda Norman OK 73026 byrondoner@esok.us	405-650-7520	Cone Shipping
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Dodie O'Bryan	Webmaster	Pawnee, OK scout@skally.net	—	Website Updates Web Calendar Updates

Workshop Schedule

June 4th - Power Hammer Tools and Techniques Workshop: There is a workshop being planned with Rick Dyer at his shop in Tulsa (adjacent to Bill Kendall's shop) to demonstrate power hammer tools and techniques. This will be more of a demonstration workshop/class rather than hands on but, for insurance purposes, all attendees **MUST** be SCABA members or must join during the class. *Details to follow...*

September ?? - Possible Hammer and hot Cut Hardy workshop with Brian and Ed Brazeal: Doug Redden is talking with Brian and Ed Brazeal to work out a possible hammer and hot cut hardy workshop sometime in September. Location would most likely be in the Stillwell, OK area and possibly the Stillwell Park. This workshop would be to make a hammer and hot cut hardy in the Brian Brazeal style. Doug is checking interest level at this time prior to firming up the workshop details. If you are interested in attending, please let Doug know as soon as possible. 918-230-2960 or Doug.redden2@att.net.

Mandell Greteman is the SCABA Workshop Coordinator.

Contact Mandell at 580-515-1292.

mandell01@windstream.net

From the Secretary...

If you have not paid your dues for 2016, this will be your last newsletter. Contact information for unpaid memberships will be dropped from the membership list as of May 20th. - Diana Davis, Secretary

Why Not a Color Newsletter???

From time to time, the question comes up about whether we could produce the newsletter in color instead of black and white. If you view the newsletter online, the difference color makes is striking - especially with pictures that show glowing hot iron. So it is natural to wonder about color for the printed version.

Our commercial printer, Tony Cable at OU Printing Services, does an *outstanding* job of producing the black and white newsletter very economically and super fast. However, to change to a color newsletter would increase the cost more than tenfold and add to the production time. This would be true for any printer. The cost of color is simply not economical without drastically increasing membership costs and potentially reducing the number of issues per year.

So for now, the best bet for color is to view the newsletter online. And, online there is the added benefit of being able to zoom in to see more detail. - *Editor*

2016 REGIONAL MEETING SCHEDULE

SE Region (1 st Sat)	NE Region (2 nd Sat)	SC Region (3 rd Sat)	NW Region (4 th Sat)
Jan 2 nd (Open)	Jan 9 th (Open)	Jan 16 th (Open)	Jan 23 rd (Monte Smith)
Feb 6 th (Open)	Feb 13 th (Bill Kendall)	Feb 20 th (Open)	Feb 27 th (Bob Kennemer)
Mar 5 th (Ronnie Smith & Bill Phillips)	Mar 12 th (Doug Redden)	Mar 19 th (Bruce Willenberg)	Mar 26 th (Mandell Greteman)
Apr 2 nd (Open)	Apr 9 th (Brendan Crotty)	Apr 16 th (US Cavalry Association/Chuck Ogden) SCABA Annual Picnic!	Apr 23 rd (Dorvan Ivy)
May 7th (Open)	May 14th (Ed McCormack)	May 21st (JJ McGill)	May 28th (Terry Kauk)
Jun 4 th (Open)	Jun 11 th (Marshall Hager)	Jun 18 th (Ricky Vardell)	Jun 25 th (Don Garner)
Jul 2 nd (Open)	Jul 9 th (Terry Taylor)	Jul 16 th (Open)	Jul 23 rd (Kelly Kilhoffer)
Aug 6 th (Open)	Aug 13 th (Gerald Brostek)	Aug 20 th (Open)	Aug 27 th (Don Garner)
Sep 3 rd (Open)	Sep 10 th (Jim Carothers & Tom Nelson)	Sep 17 th (Jim Dyer)	Sep 24 th (Roy Bell)
Oct 1 st (Open)	Oct 8 th (Open)	Oct 15 th (Conference Weekend)	Oct 22 nd (Cheryl Overstreet)
Nov 5 th (Open)	Nov 12 th (Dan Cowart)	Nov 19 th (Anthony Griggs)	Nov 26 th (Cory Spieker)
Dec 3 rd (Open)	Dec 10 th (Open)	Dec 17 th (Open)	Dec 24 th (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. E-mail is the most convenient for me but you can also phone in the information if you prefer. The sooner the meeting is scheduled, the more time there is to get the word out to potential attendees.

-Russell Bartling 918-633-0234 or rbartling@ionet.net

Regional Meeting Details:

May

SE Regional Meeting May 7th: Open

NE Regional Meeting May 14th: Will be Hosted by Ed McCormack at his home/shop in Okmulgee at 15100 N 270 Rd, Okmulgee, OK, 74447. (See Map)
The trade item is a knot.

Lunch will be provided but please bring a side dish or dessert to help out.

SC Regional Meeting May 21st: Will be hosted by JJ McGill at the Murray County antique tractor show grounds location. This meeting will host Boy Scouts from Tulsa. About 65 Scouts are expected plus Leaders and Parents. Any smiths that would like to help out educating and working with the young Scouts are greatly appreciated.

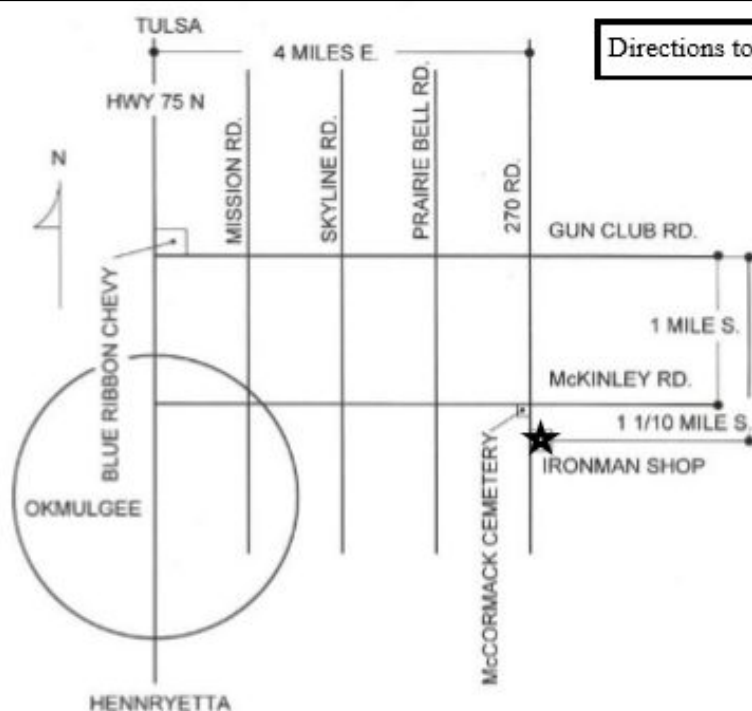
The trade item is a “multi-tined hot dog roasting fork with a twist” (one intent being to show the young Scouts how the tines could be formed as well as a simple twist.)

Lunch will be provided but please bring a side dish or dessert to help out.

Directions: 7 miles north of Sulphur on Hwy 177 then east $\frac{3}{4}$ mile on Tractor Road. Contact JJ McGill at 580-369-1042.

NW Regional Meeting May 28th: Will be hosted by Terry Kauk at his home/shop 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 2 miles east from the intersection, then 2 miles south, then 2 miles east, then approximately 1 $\frac{1}{8}$ miles south. Look for a two story brick house with tan shop north of the house.

Trade item is anything made from a horseshoe. Lunch is provided but please bring a side dish or dessert to help out. Contact Terry Kauk at 580-821-0139.



Directions to Ed McCormack's Shop

June

SE Regional Meeting February June 4th: Open

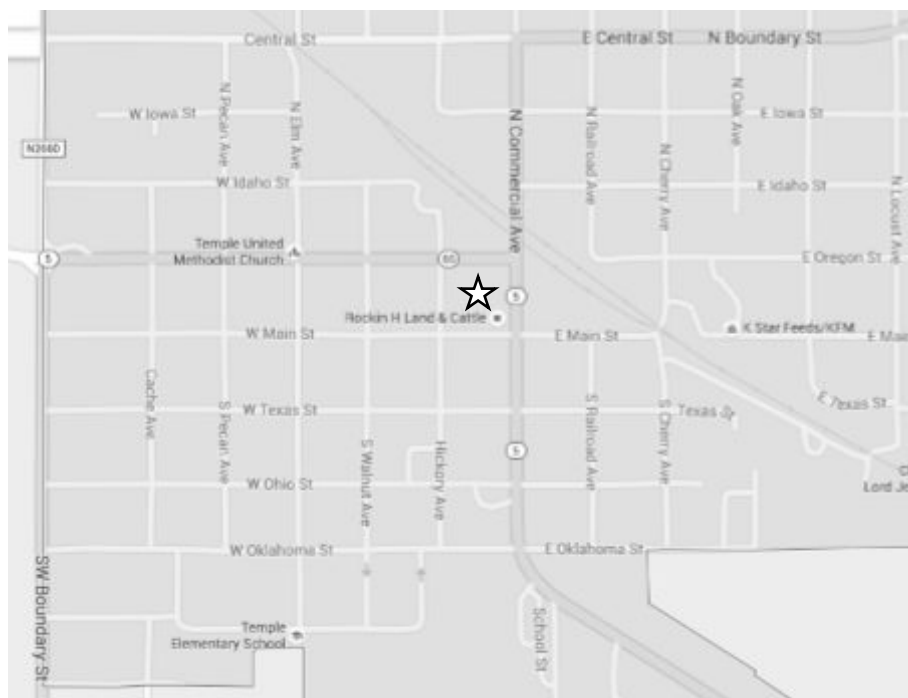
NE Regional Meeting June 11th: Will be Hosted by Marshall Hager at his shop north of Sand Springs. 5716 N Hwy 97, Sand Springs, OK 74063.

Go north out of Sand Springs on HWY 97 about 7 miles. There is a sign on the west side of the highway in the shape of a goat that says "Kids For Sale."

The trade item is anything camp related. Lunch will be provided (pit barbecuing a pig) but bring a side dish or desert to help out. Anything that goes with BBQ. There is a swimming pool available if it is hot. Contact: Marshall Hager 918-245-1291. Hlacles@aol.com

SC Regional Meeting June 18th: Will be hosted by Ricky Vardell at his shop in Temple OK. The shop is located in the block southwest of the intersection of Hwy 65 and Hwy 5 (N Commercial Ave) in Temple.

Lunch will be provided but bring a side dish or desert to help out. The trade item is a drive in hook with a leaf. Contact: Ricky Vardell 580-512-8006. Rickyv.vardell@gmail.com



NW Regional Meeting June 25th: Will be hosted by Don Garner at his shop at 23713 E. 860 Rd. In Thomas, OK. Directions: Go one mile west, then one mile north of Thomas.

The trade item is an adjustable candle stand. Lunch will be provided but bring a side dish or desert to help out. Contact: Don Garner 580-661-2607.

Saltfork Craftsmen Artist Blacksmith Association

Board of Directors Election 2016

There are **three** director terms expiring this year.

The following list includes the nominations for election to the three positions. You may choose from three candidates on the list or write in another candidate who is a member in good standing. Please vote for a total of **three** positions. Only one ballot per household.

VOTE FOR THREE:

☐ Russell Bartling, Cleveland OK

☐ Dan Cowart, Wann OK

☐ Terry Jenkins, Blanchard OK

☐ Chuck Ogden, Yukon OK

☐ David Seigrist, Hollis OK

☐ Other: _____

Please fold and tape this form closed or place in an envelope and mail the completed ballot to the Vice President, Doug Redden:

Saltfork Craftsmen 2016 Ballot
C/O Doug Redden, Vice President
2050 E. 410 Rd.
Oologah, OK 74053

You can also hand deliver your completed ballot to any of the Board members.

Deadline for receipt of your ballot is **May 31st**.

Ballots will remain sealed until opened by a group of Board members at the next Board meeting or group gathering where multiple Board members are assembled.

STAMP

Saltfork Craftsmen 2016 Ballot
C/O Doug Redden, Vice President
2050 E. 410 Rd.
Oologah, OK 74053

Around the State...

NW Region March Meeting:

The NW region March meeting was hosted by Mandell Greteman at his shop in Foss, OK on March 25th.



There were over 30 in attendance, some from eastern Oklahoma and Arkansas. The trade item was a nail pulling bar and there



were about fourteen fine examples of different sizes.



There were several forges going all day long and while many worked on the trade items, Mandell helped some young smiths work on forge welded tomahawks.



A large spread of pot roast and many sides and desserts was enjoyed by all and Terry Taylor showed off his chuckwagon skills

NW Region March Meeting (Continued...)

making Dutch oven biscuits and peach cobbler during the meeting.



NW Region March Meeting (Continued...)





Thanks to all who attended and helped to make the meeting a success...

- The Gretemans's

Lock smithing skills are just another subset of blacksmithing. Really... No, really... they are!

(Photos by LaQuitta Greteman and Editor)



Around the State...

NE Region April Meeting:

The April 9th NE regional meeting was held at the home of Brendan Crotty. There were 30 people in attendance, with several being



new members or potential members. The trade item was an all metal knife and we had four entries. A hot lunch of King Ranch Chicken was served at noon with side dishes

NE Region Meeting (Continued...)



and desserts. The weather was perfect and folks stayed well into the afternoon hammering!

- Brendan Crotty

SC Region April Meeting/ 2016 SCABA Annual Picnic:

The SC Region April meeting was held at historic Fort Reno in El Reno, OK and hosted by the US Cavalry Association in conjunction with the 2016 SCABA Annual Picnic. There were about members and guests in attendance.

The forges were set up in an old brick barn on the west side of the site. Thanks to



Byron Doner and Mandell Greteman for bringing and setting up the anvils and forging equipment. It was a windy day but the rain held off for the entire duration of the picnic. There were several tailgate items just outside the forging area.



The trade item for the regional meeting was any kind of latch - sliding, hook and eye, etc. There were about nine very interesting examples provided.





Lunch was held in the Chapel building north of the parade grounds. Lunch was grilled hot dogs with chili and several side



items and deserts. Thanks to Bar-S foods for donating all of the hot dogs.

Mandell Greteman was coordinator for the forging competition which was forging a leaf from a pre-cut blank. The competition was kept a secret until the picnic. Mandell provided chisels for all the participants and





some used their own chasing tools. Forging went on all morning and continued after lunch. There were sixteen really good leaf entries in the competition from participants of all age levels. Congratulations to all of the participants who all did a fantastic job on their leaves in front of a “live audience.”

Russell Bartling and Terry Taylor were selected as the judges. Judging the leaves was not easy but the final selections were “unanimous.”

Byron Doner won First Place with the cleanest chisel chasing, edge and stem preparation, leaf curvature, and finish.





Brahk Hadick won Second Place and Lloyd Turner took Third. The First Place trophy was made by Mandell Greteman and the US Cavalry Association donated prizes for First, Second and Third place.



Thanks to everyone who attended the meeting/picnic and helped to make it a success.

- Editor

(Photos by LaQuitta Greteman and Editor)

Poppies for Belgium

Gerald Franklin

Quite some time ago, before I got hurt and wound up on crutches for three months, I agreed to provide fifty poppies for a memorial project in Belgium. A good video on how they are made can be found at <http://www.ypres2016.com/design/making-the-poppies/>.

Several ABANA affiliates around the US have agreed to do a share of the required number of poppies for the memorial. The designers require a total of 2016 poppies to be placed at the base of the memorial.



As I said, I've been laid up for a while so when I got back on my feet (1 ½ feet, not two), I enlisted the help of some of the Saltfork brethren. Byron Doner has been instrumental throughout the effort in helping to make the required tooling. He also agreed to let us use his shop for the group effort

that we just did. Byron, Bruce Willenberg, Dale Dickson, and Tim Jones fell in to man forges and power hammers to get the bulk of the work done in about 3-4 hours. I am grateful to those guys for their help and to the Saltfork board for agreeing to pay for materials and shipping. The poppy blanks were cut out by Bill Kendall in his T-Town Metal Men shop in Tulsa. He did a great job in a short time.





The photos can't give a feeling for the amount of work that was accomplished in such a short time. Please take the time to go to the website above for a good idea of what the project is all about and to see how much work is involved in making the poppies. - Gerald Franklin



Ypres 2016 is the international event organized to commemorate the people who fought and died in World War I (1914 - 1918). Ypres is a site in Belgium where some of the heaviest, bloodiest battles of WWI were fought. The memorial will be a tall Poppy Centograph which will be surrounded by fields of iron poppies made by blacksmiths from all over the world. The Belgium Guild of Blacksmiths and the British Artist Blacksmith Association are working with other partners and sponsors to design and build the memorial. For more information visit:

www.ypres2016.com

- Editor



Young Blacksmith Wins Science Fair Award

Saltfork member, Brendan Crotty, a Home Schooled 8th grader from Muskogee took part in the Oklahoma State Science and Engineering Fair, April 1, 2016, at East Central University in Ada, Oklahoma. Brendan's research project was "Comparative Study of Insulating Materials for a Gas Forge".

He earned First Place in the category of Energy, Transportation, and Engineering, Division II. Brendan also earned a Broadcom Masters invitation. Brendan qualified for the state fair with his participation in the 50th Annual Regional Science Fair held in Muskogee on March 2. At the regional fair Brendan earned First Place in Engineering Division II, Third Place Overall Division II, Most Promising Exhibit in Engineering Design and Principle, and an invitation to Broadcom Masters, a national science and engineering competition for the top 10% of middle school science fair winners.

Basically Brendan's project was making 6 different mixes and comparing them to a commercial Kaowool. He did a test for heat loss and how fast the metal heats inside the forge. Beyond this info, science fair rules dictate that he cannot share more as he is continuing the project next year. After next year's fair he can publish his findings.

Brendan has been a member of SCABA for 2 years.

- Jennifer Crotty



Interesting Website: Francis Whitaker Video

<http://www.video.unc.tv/video/2365018833>

A 30-minute archive edition of the Folk Ways series from UNC TV: "Fire and Forge (Blacksmithing)" features Francis Whitaker forging at the John C. Campbell Folk School in Brasstown, North Carolina.

(Aired on University of North Carolina TV on March 10, 1997)

Courtesy of May 2016 issue of "The Anvil's Horn" Newsletter of the Arizona Artist Blacksmith Association.



Pioneer Day/ Preparedness Seminar

Saltfork Members:

Hello Everyone:

It's been a few years, and we still have people calling and asking about it...So, here it is. We are planning another Pioneer Day/ Preparedness Seminar to be held on:

Saturday, May 21

9:00 am to 1:00 pm

The Church of Jesus Christ of Latter-day Saints

117 W Blanchard (across the street from the elementary school)

This will coincide with the city of Blanchard's May Daze and the town is full of people and festivities. We will have signs around town and will heavily publicize our event. In past years, we have had several hundred people come.

I am looking for every trade, skill, talent...from mining to bee keeping, making lye soap to archery, cooking without electricity to crocheting, first-aid to food storage, and so on.

China painting, tatting, planning for death, sour dough, canning, food preservation, musket loaders, etc.

Please feel free to pass this on to anyone you know who is a prepper, a rendezvouser, or just loves to be prepared. We will have a tipi set up and have outdoor spaces as well as indoor. We will have helpers that day to help you bring in your items and set them up. We have plenty of tables and chairs so you do not need to bring any.

If you have any questions, please feel free to call me, text me, or email me. And please contact me if you can share your talent or knowledge with the community!

We look forward to another fun filled Pioneer Day!

Respectfully,
Dr. Tammy Sagastizado

Put It Away - Tammy's Tax Service
organizeworkorhome.com

405-227-0908 home office
405-788-1221 cell

Hofi Style Hold Down Tongs

Submitted by James Allcorn

I have tried some hold down methods in the past with mixed results, especially for round bar. It seems that by the time I get the bar hot and in place on the anvil with the hold down in place, find the spot and start to punch ... well, it's time to reheat the dang bar and/or the hold down slips or some other calamity occurs!

Perhaps you have better luck.

Yesterday I came across Hofi's recent take on hold down tongs for punching. I've included some pictures but basically it is a pair of old tongs held in place via the anvil's hardy and a chain to a foot bar. A picture is worth a 1000 words.



When I get time (time seems to be a commodity in short supply these days) I plan to see if I can duplicate his setup.

I've attached 4 photos but here is a link to Hofi's FB page. Lots of info there. I also like his "new" style of making tongs, something else I plan to try "time permitting".



https://www.facebook.com/profile.php?id=1823991120&sk=photos&collection_token=1823991120%3A2305272732%3A69&set=a.10204016566254171.1073742125.1823991120&type=3

- James



Induction Heater Forging

Part 2

Eric Jergensen

My heater is set up with a coil that is 1 ½" long and has a 1 ½" internal diameter. It consists of three wraps of 8mm copper tubing. It produces a short, even heat and the dimensions set the essential limits on what can be forged. I've found I can tackle a surprising variety of projects with this configuration. Let's take a look at a few.



3/8" diameter fuller for chasing made from 3/4" W1 tool steel

This shape of tool is very conducive to induction forging. I did the short taper at the fuller end with a single heat. With a second heat, I put a slight taper on the struck end. I used a third heat to set the index using a spring fuller. And a fourth and final heat to blending the index toward the fuller.

I skipped the annealing, but this is a good time to comment. Induction heating is not suited for annealing high-alloy steels. Traditional heat-and-bury (in ash or other insulator) can be done. However, getting a 7" long even heat is tricky without a 7" long coil. Annealing is much better suited to an oven or furnace designed for this purpose.

Hardening and tempering for simple steels works well. For 3/4" stock, I've found that turning down the heat dial from 800 amps (maximum heat) to about 300 amps allows me to soak the tool for a nice even heat. An induction heater heats from the outside in, so this slower heat lets the heat spread. 300 amps generally

leaves the tool slightly sub-critical, so I ease it up toward 400 amps after a bit. I test temperature with a magnet by extending a bit of tool out of the coil, leaving the heater running as I do it.

I find it more convenient to fully quench the tool rather than retaining heat for tempering. Ten seconds at about 200 amps at 1" to 1 ½" from the end adds enough heat to run the colors. After heating, I pull the tool out and stand at the bucket to watch the colors and quench.



Butcher with stops from ¾" sucker rod.

The longer taper on this butcher calls for a longer heat. I used two short heats to rough in the taper and a third longer (and cooler) heat to blend and finish it. The longer heat is achieved with the simple technique of moving the stock back and forth in the coil.

Hardening edges with a general-purpose coil is a little awkward. The sharp edge stays cooler than the thicker portions. A cherry-red edge requires getting the nearby body to an orange heat. I get better results if I bundle a bit of flat stock on one or both sides.





Box jaw tongs from $\frac{5}{8}$ " sucker rod.

Most tongs are easy to make with my coil. The $1\frac{1}{2}$ " heat is okay for jaw work. I would like a longer heat, say 4-6", for drawing out the reigns. I find that I've finished the rough drawing with quite a bit of heat to spare. Then, I'd like an even longer heat for the finishing. A longer coil would be better. However, a longer coil doesn't handle curved work as well.



Bill Epps-style candle stand from $\frac{3}{8}$ " square stock (still needs pan and adjustments)

The long heat necessary for the snub-scroll legs is pretty inconvenient. Heating more than 12" with the $1\frac{1}{2}$ " coil is a bit tedious. Fortunately bending doesn't require a very hot heat and I have jig for this bend. I managed these easily in a single heat. I did the leaves after the scroll to make it easier to put the stock thru the coil backwards in case of adjustments. This is where a short coil shines: most of the scroll will fit, though awkwardly. I also managed the collars in one heat. In a real pinch, I grab my oxy-acetylene torch.



Mark Aspery-style bottle opener from ½" square

After a certain amount of drawing out, the loop on this opener no longer fits in the coil. However, there is a region right at the end of the coil that heats pretty effectively. Watch the accompanying video for a very informative demonstration of this heating pattern.





Flux spoons from $\frac{3}{8}$ " round

Forge welding is a breeze with this induction heater. The faggot weld used to build up mass on these flux spoons was so easy I may just never use them! The key is to watch for the scale to melt. That's the key in a coal forge, too, but it's dead easy to see it in the induction heater. (Note: I recommend using #3 welding shades even with induction heat. IR cataracts are not desirable.)



$\frac{3}{8}$ " stock scarfed, heated and "stuck" - held only at the left end

Lap welds get an additional benefit. Instead of having to use a drop-tong method to start the weld, I can stick it while it's still in the coil by mashing the scarfs together. And, since holding the scarfs together helps them heat faster and more evenly, this is just a natural extension.



Welds tested to failure

My lap welds look great but are not as strong as I would like. The crumbling weld is probably unsuitable “hot short” steel. I get consistently poor results from that batch of steel. The more concerning weld is the smooth looking weld that failed right along the joint. I think I’m not getting quite enough heat to “mature” the weld. For an exposition of this idea, see this video by Denis Frechette:



<https://youtu.be/8jZDEtmDgxI>

My 3-wrap coil only obtains a low welding heat. I think a 4-wrap coil in the same 1 ½” length would obtain a high welding heat. My coil-building supplies have arrived, so expect another write-up in a month or two!



Be sure to check out this article’s companion video that shows these heating operations in more detail:

<https://youtu.be/haeYesyJhnU>



- Eric Jergensen

Hossfeld Benders...

Submitted by James Allcorn

I know a couple of SF members with Hossfelds, Jim Carothers and Richard Dyer come to mind and I have two #2's. While neither Jim nor Richard needed any help figuring out a Hossfeld, my initial experience was somewhat like the one described in the Anvil's Horn article (see Following Page). However, once I took the time to figure it out, I wouldn't be without one! I've ordered a few parts from the Hossfeld company and always found them friendly and helpful.

I keep mine set up differently. One is for bending with the pins in what I would call "regular bending" and the other has the #50B master die. For me, installing and removing the 50B die was a finger-pinching pain so with the luxury of having 2 bender setups, I can go easily to either bender. While one is bolted to the floor the other is on a movable rig with heavy casters. Its former owner had it set up to be portable and equipped with hydraulic power. They hydraulics had been removed when I got it but they left the framework. I left most of that intact finding portability has its pluses and minuses. It is convenient in that it can be loaded onto a trailer and transported to a job site or just moved to a corner of the shop where it is out of the way. The downside is that you have to hold it in place to use it so I will chain it to a heavy table, scissor lift, tractor, etc. (If the hydraulic unit were still installed it would likely be free standing.)

They probably aren't a fit for every blacksmith's shop, but I love mine. Their uses are almost endless.

One word of warning. Before using a Hossfeld, especially with an extension arm, clear your work area in case your feet slip or the work slips in the die! Assure you have a "safe" place to land. The principle of applied physics works both ways!

James Allcorn
Paris, TX

(See Anvil's Horn article reprint on following page...)

HOSSFELD BENDER

Friend or Foe?

by
Loren Tollefson

So you've gotten into this blacksmithing thing, huh? Went around to yard sales and auctions until you have enough equipment to set up a genuine shop? Your spouse's gardening shed is going to have a new look with a chimney coming out of it, and all sorts of strange noises, too. The car is now in the driveway since it's place is taken up by peat moss, sphagnum moss, and a few other mosses you never heard of.

Let's see now. You've got a forge, coal, and anvil, hammers, fullers, tongs, swage block, punches, and some new bar stock. You've read up on how to start and stoke a fire, how to draw out a rod, how to start a scroll, how to make a chisel, and on and on.... But nowhere does it say or show anything about that there horsefield bender that you picked up at auction after the auctioneer and others assured you that it was the neatest thing since sliced bread and would make your life infinitely easier. Worse yet, nobody you talk to knows anything about it!!!

Hossfeld Benders, manufactured by Hossfeld Mfg., Mankato, MN are also called Pacific Benders. They are made in two sizes, No. 1 and No. 2, No. 2 being the larger one. Basically they are made up of two U-shaped frames, one stationary and the other moveable around a pivot pin that connects the two together at the open end of the "U". A series of holes in both frames accepts pins and dies made to exert pressure on

mild steel and bend it in specific ways. All die changes are made by simply removing loose pins, not bolts, thereby making changes rapid and easy. The underlying principle behind the machine is that you are able to exert a tremendous amount of force by leverage and therefore don't have to heat the material before bending it.

I went to work in an ornamental iron shop in September, 1969 while going to college. I knew how to do a rudimentary job of welding, but that was about all. I soon learned to cut, deburr, clean, layout, and paint. But the most daunting task was learning to set up the Hossfeld. I just knew I would never pick it up. It wasn't long until I began to see the different applications, and common sense was all it took to expand my horizons. That and a boss who had used one since 1955.

Throughout My career in structural and miscellaneous, I have hired and fired a lot of people. I would at first ask a prospective welder to set up the Hossfeld to see if they were really as experienced as they claimed. Very few had even heard of one. They are more at home in small shops where fancy automatic equipment is seldom available, and expecting most welders to know how to use one was faulty on my part. I quit asking for experience in the use of one and concentrated on teaching new employees how to use one, one setup at a time. I have visited numerous other steel shops where they have a beautiful setup, complete with hydraulic power, collecting dust in the back corner. When I asked about it, invariably I was told that it wasn't worth the powder to blow it to hell or some

other variation on that saying. It always boiled down to not knowing how to use it.

When I set up my shop in Pine in 1989, one of the first investments I made was a No. 2 Hossfeld, with standard dies. With these, I am able to bend up to 3/8" by 4" flat bar to a right angle, cold. I can roll perfectly round rings of material such as 1/2 round, flat bar, square bar, or angle iron. I can make perfect eyes of any diameter using round or square bar. I can roll angle iron lip out or in to an infinite number of radii. With the standard dies I can roll tubing or standard pipe up to 2 inch without deformation.

Hossfeld Benders are available through authorized dealers. The local one is ACC Machinery, at 7th Ave. and Grand in Phoenix. In addition to standard dies, literally dozens of specialty dies are available to do such things as bending moulded railing cap sideways. It's been my experience that once you learn the basics, you can make up your own dies for very little expense. If you have a production job, or limited run production, a die purchase can be amortized very easily and with a new set, you will foresee other uses for it.

If you get one, or already have one rusting in the corner, Hossfeld has videos available to show how to set it up. These are also available through Centaur Forge. Instruction booklets are also available from Hossfeld, but it's been my experience that seeing a demonstration in person is far more desirable. Once you have seen it done, the booklets become more understandable.

*Article Reprinted from the Arizona Artist Blacksmith Association newsletter The Anvil's Horn, May 2016.
Originally printed in the Anvil's Horn May 1997. - Editor*



Keep Your Rasps Sharp And Save

By [Jeff Cota](#) posted on April 4, 2016 | Posted in [Equipment](#)

Pennsylvania farrier suggests two techniques to give your tool longer life...

Steve Teichman and his Chester County Farrier Associates crew get under about 15 horses a day. While that's great for business, it also means tools and other resources wear out quicker — especially rasps.

"If I get a week out of a rasp, you know, that's great," says the Unionville, Pa., farrier. "Some rasps, you might get a day. We were buying rasps by the case and it just got to be ridiculous."

Teichman shared a couple of techniques — a buffing wheel and muriatic acid — to get more life out of rasps.

Take Them To The Wheel

The most common and successful way to sharpen rasps is by applying compound to a buffing wheel.

"A lot of farriers are starting to do this now," says the United States Equestrian Team farrier. "You can extend the life of a rasp, I'm going to say five or six times easily. It's rare, but if you hit upon the right rasp you'll keep a good, sharp rasp for as long as 6 weeks."

Teichman uses a pair of 2-inch sewn cotton wheels on two Baldor motors. While there are a number of compounds from which to choose, he prefers white.

"It's coarse enough," Teichman says. "I experimented for the longest time. There's a product from Jackson Lea that comes in a tube, like a paste. It's like an 80-grit and that'll do an amazing job on rasps."

While many compounds are oil-based, he suggests using those that are water-soluble.

"They use it in the firearm industry," Teichman says. "I have a lot of engraving artwork from the firearm industry. They don't use any oil-based compound that you see most farriers use in their trucks, because they can't clean it thor-

Farrier Takeaways

- Using a white buffing compound on a sewn cotton wheel will dramatically extend the life of your rasp.
- A water-soluble buffing compound will provide a cleaner, non-greasy finish.
- After sharpening your rasp, apply the next coat of compound and allow it to dry on the wheel.
- Every 10-degree change in temperature doubles the rate of the chemical reaction in muriatic acid.

oughly when they're going to blue a gun barrel. So, when they're polishing, they're going to need a compound that's water-soluble. It's easy to clean so when they do the chemical treatment of the barrel, it will come out nice and blue and you won't see a greasy compound spot."

Because the compound is water-soluble, it isn't applied to the wheel quite the same.

"They're a little messy," he says. "Just coat your wheel when you're done using it. Then let it dry so that it's ready for you, let's say, the next morning. It dries on the wheel. When you buff your rasps, as you're finishing, it'll last for a few minutes on there, maybe 5 or 10 minutes. I mean, it'll throw sparks."

Typically, Teichman swipes his rasp on the sewn cotton wheel a half-dozen times.

"I don't lean on it too hard," he says. "In the beginning, when my rasp is still good, I'll just lightly do two or three passes. Since my wheel is 2 inches, it's wide enough to cover my whole rasp. As it gets duller, maybe by the end of the first week or by the second week, I might have to take a few more swipes."

When you're finished sharpening the rasp, start the process over again.

"As the wheel is winding down, touch it with the tube of compound and just re-coat it again," Teichman says, "and then just let it sit until the next day."

The result is a nice, sharp rasp.

"You will see huge savings," he says. "I mean, huge savings. This is something that will easily cut the rasp consumption down to certainly a quarter of what they were using. It's the best savings that I can pick up in the truck, at least to date."



Steve Teichman prefers to apply a white, 80-grit, water-soluble compound to a sewn cotton buffing wheel to sharpen his rasps.

Soaking Solution

Like most farriers, Teichman uses a rotation system with his rasps.

"I always keep a good, sharp trimming rasp," he says. "After my trimming rasp has gotten to the point that I don't like it, it will become my barefoot trim rasp. I always keep one that's not in as good of shape for my barefoot trims, broodmares, things like that. Then maybe it will become my hot rasp. It'll work its way down the line. By the time it's there, it's in pretty bad shape."

Over the years, Teichman has gotten away from using finishing rasps.

"I do a lot more direct glue shoes, probably 10% to 20% of my clients," he says. "So, finish rasps were an expensive commodity and not as effective."

As a result, Teichman exclusively uses a buffing wheel to sharpen his rasps. However, he maintains that the use of muriatic acid is incredibly helpful when sharpening rasps.

"Finish rasps sharpen really well chemically, because the teeth are really close together," Teichman says. "It's really super easy and if you use common sense, it's safe."

To employ muriatic acid, you can find all you need at the local home improvement store.

"I would buy a 2-foot section of 4-inch PVC pipe, put a cap on it and mount it to a board so it's standing upright," he says. "After picking up the PVC pipe, I walked over to the section that sells floor tile and I bought some muriatic acid, which is used to clean after tile and stone work."

After mounting the PVC pipe, it's time to put the muriatic acid to work.

"I would fill the PVC pipe so it will cover a rasp and plop my finish rasps in there overnight," Teichman explains. "The next morning, I would rinse them off in a bucket of water that had baking soda in them. Then, I would spray them with WD-40."

While muriatic acid is relatively safe, it's corrosive so wearing rubber gloves is recommended.

"You don't have worry about it," he says. "If you splash it on your jeans, you'll ultimately wind up with a hole in there, but it's not horribly dangerous."

Yet, as Teichman alluded to, there's a certain level of common sense that should be exercised.

"The thing to be cautious about when you're using the acid is that every 10-degree change in temperature doubles the rate of the chemical reaction," he explains. "So, you'll get 4 times the speed when using it when the temperature is in the 90s than you will when using it in the 70s."

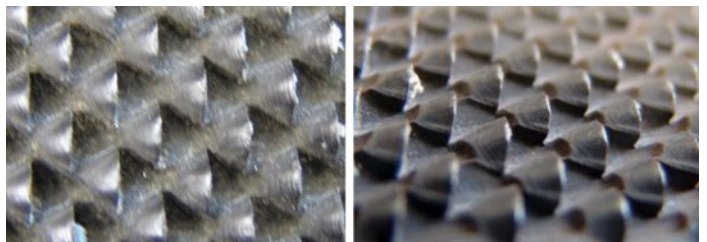
"When I'm having rasps sit overnight in August, that's considerably more chemical action on the rasp than in November when it's maybe 30 degrees out. It might have to sit for 2 days in colder temperatures. So, you're not going to get nearly the reaction of the chemicals."

When comparing the expense of buying more rasps vs. buying muriatic acid to sharpen them, you'll see a remarkable savings, Teichman says.

"It's amazing how well the product will last," he says. "The bottom of your PVC pipe will fill up with scale and junk. Then, I just neutralize it by pouring it in a bucket that contains baking soda and water. It will foam up and it'll be completely neutralized and safe to dump on the ground. It's essentially salt water. It's very safe and cheap."



Only two or three passes are necessary on a sewn cotton wheel when the rasp is still relatively new. As it becomes duller, a half-dozen swipes might be necessary.



When the teeth are damaged, no sharpening method will improve the cutting performance.

“Probably for under \$50 you can get a piece of pipe and 2 gallons of muriatic acid. That’ll last you a long time.”

Many farriers who also work in the forge are no doubt familiar with the process.

“Any of these guys who do any blacksmithing in the shop probably have a bucket of acid for removing scale from items they’re working on,” Teichman says. “It de-scales things great.”

There are situations, though, when a sharpening technique will fail to make a difference.

“If you’re really hard on the finishing rasp with things like clips and edges of the shoes,” he says, “and the teeth are damaged, nothing will fix it.”

- See more at: <https://www.americanfarriers.com/articles/8153-keep-your-rasps-sharp-and-save#sthash.tU7RMQpn.m45fCAaB.dpuf>



Thanks to local Tulsa area farrier Bill Hackler for letting us know about this article from the Farrier's Journal. It is reprinted with permission from the Editor/Publisher. Visit them online at:
<https://www.americanfarriers.com/>

This article is focused on practicing farriers but old worn out horseshoing rasps are good for hot filing in blacksmithing work. And sharpening might be a useful improvement at times. As for shoeing horses, I wish we had known about this when my dad and I used to be under horses all day. It really helps you to appreciate the little things in life like those sharp rasps the author talks about. I also wonder how well the buffing approach would work on old files.
- Editor

2016 SCABA Conference Info...

The 2016 SCABA Conference is still many months away, but it is not too soon to start planning.

Lodging:

From JJ McGill, the two lodging options in Sulphur are the Super 8 Hotel and the Chickasaw casino. This is the contact info JJ provided:

Super 8 Sulphur: 2116 W Broadway Ave, Sulphur, OK 73086, Hitesh Patel, Manager. 580-622-6500. Rates are \$65.00 per night for single, \$75.00 per night for double. Manager says start booking now.

At the casino, there is supposed to be a block rate for Saltfork. Contact the General Manager's office, Bryce Chitwood, 580-622-8100, Ext. 111. Oct. 14th and 15th rate is \$149 per night (standard is \$209). For October 15th and 16th rate is \$109 per night (standard \$149). (I am not sure how the overlap applies for October 15th.)

JJ said there are 30 RV hook ups with 110V electric only and there are a few with 220V electric and water by the food vendor area. RV hookups are \$10 per night. There is an RV dump station. There is also primitive camping and JJ said that showers are available. Contact JJ McGill if you have any questions of want to reserve any camping spots. 580-369-1042.

Workshops:

Also, as a reminder, Doug Redden has set up on site workshops with the demonstrators - Peter Ross and Jymm Hoffman - after the conference. Each demonstrator will conduct a 10 student workshop over three days following the conference (Monday through Wednesday). Participants will be first come, first served and must call or e-mail Doug Redden the morning of July 19th at 9:00 AM. Registration will not open until that time. More details on the workshops including pricing and equipment requirements as well as the registration process will be updated as the deadline approaches. If you have any questions for now, contact Doug Redden 918-230-2960.

SCABA Shop and Swap

For Sale:

I have for sale several metal working tools and machining tooling.

Antique bellows \$425

Sheet metal roller \$175

Sheet metal shear \$175

~~2 hand crank grinders \$30 each~~ **SOLD**

Little Giant tap and die set \$50

56 assorted chisels and punches. Price may vary depending on piece.

Assorted machining tooling. Price may vary depending on piece.

For pictures or questions contact Brendan Crotty by phone call, text, or email.

Phone number: 918-910-0384

E-mail: brendancrotty246@gmail.com

If calling please leave a message and I will call back.



For Sale:

Tire Hammer Plans by Clay Spencer

Send a check or money order for \$30 US to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Or send \$32 US to [Paypal.Me/ClaySpencer](https://www.paypal.com/paypalme/ClaySpencer). E-mail me at clay@otelco.net. PDFs will be e-mailed outside US. Phone 256-558-3658

Beverly shear blades sharpened

Remove your blades and send in USPS small flat rate box with check for \$41 US to 73 Penniston Pvt. Drive, Somerville, AL 35670-7103.

SCABA Shop and Swap (Continued...)

SCABA Embroidery Available

Saltfork member Larry Roderick has setup a source for SCABA logo embroidery on shirts or embroidery compatible items. Larry presented an embroidered tan Wrangler western shirt at the recent Board of Directors meeting and the quality of the embroidery is excellent. The design is based on the new SCABA T-shirt design on the back with the classic SCABA logo above the front left pocket. Your name can also be put on the right side opposite from the logo if you would like.



If you would like an embroidered shirt or other item, find an item that fits you properly and mail it to Larry.

Compatible items must be flat. Pleats cannot be embroidered.

The cost for the embroidery applied to your item is \$80 each including return shipping and handling. Heavy coats might add a few dollars more for shipping.

Mail to: Larry Roderick
500 S. FM 369
Burkburnett, TX 76354

If you have questions, contact Larry at 940-237-2814 or roderickwaterwells@gmail.com

(Photos by LaQuitta Greteman)

SCABA Shop and Swap (Continued...)

For Sale:

I have numerous old tools and collectible items of various kinds including blacksmith related tools and equipment. Too many tools to list them all.

Contact:

Craig Guy
Piedmont, OK
Cell Phone: 405-630-7769



4" Post Vice: \$125



Rare Wagon Tongue Vice: \$300



5" Post Vice (needs spring): \$135



Bench Top Anvil/Vice (1912 Patent Date): \$85

SCABA Shop and Swap (Continued...)

SCABA Library DVD's Available:

This is a partial list of the DVD titles available to members from the SCABA Library. Contact the Librarian (Doug Redden) if you would like to obtain a copy of any listed title or if you have questions on any other titles that may be available. Additional titles are listed on the website. DVD's are available for a very minimal cost to offset the blank disc and cases or sleeves. Shipping cost applies if you need these delivered by mail.

- 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

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

SCABA Swage Blocks

\$150.00 plus shipping.
(Same price to members and non-members.)
Contact Bill Kendall for more information.



SCABA Floor Cones

\$200.00 plus shipping.

(Same price to members and non-members.)

Contact Bill Kendall,
Byron Doner or Gerald
Franklin for more
information.



SCABA Shop and Swap (Continued...)

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.

Charlie has recently taken delivery of a new fresh pile of coal at his place!

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

Show Your Pride in SCABA!

License plates - \$5.00 each.

Ball Caps - \$10.00 each.

We also have coffee cups.

We still have some of the old SCABA t-shirts available while the supplies last. They are a gray pocket "T" with the SCABA logo on the pocket.
Contact Diana Davis for information.



Have an Item for Sale? Item Wanted?

If you have any items that are appropriate for Blacksmiths that you would like to list in the Swap and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have

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 gray. 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, 20 16 to March 31, 20 17

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, 20 17

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

Please provide directions or 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 conformation 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

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

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