

Saltfork Craftsmen Artist-Blacksmith Association

September 2016



World Champion Farrier and Blacksmith, Austin Edens made this pair of scissors out of farriers rasp at the ABANA conference in Salt Lake City. See page 37 for a how-to article from the Blacksmith's Guild of the Potomac on making a similar pair (then you can use them to cut out the SCABA Conference registration form on Page 30!)

The 2016 Annual Saltfork Craftsmen Conference is next month!
Conference October 15th and 16th , Hands On Workshops 17th - 19th

See page 29 for Conference flyer and registration form. Remove registration form or print from the website and mail to the Secretary.
Register as soon as possible!

Find an extra bonus in your welcome packet if paid registration is received on or before:

Monday, October 10th.

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

There are a lot of activities ongoing or coming up this time of year which means a lot of announcements, forms, and follow up reports.

Even adding four additional new pages to this issue, the space filled up fast leaving less room for how-to articles. I know the how-to project articles are a favorite for most of us (including me) and I will try to include a mix of them as much as I can.

I still have a number of photos from the ABANA national conference in Salt Lake City to include in an upcoming issue. Sometimes a single photo is enough inspiration for a new project as most of us can “reverse engineer” the processes required to make something we see. Hopefully, I can fit a sampling of those somewhere in the next couple of issues.

You may have also noticed that the “Swap and Shop” section of the newsletter has been more active lately. If you have any items you would like to sell or if you are looking for something specific, let me know and I will post it in upcoming newsletters. Just please let me know when the posts need to be removed if you sell or acquire those items.

- Russell Bartling - Editor

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

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Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org



President's Notes:

Hey folks!

Here we go again! Blacksmithing is going to be getting a bit more busy. I can't believe it's already time for county and state fairs!

Seems like there are more demo opportunities than there are days ahead of us for a while. For those of you that haven't tried a demo, take it from me, they are a blast!

When I am getting ready to go demo, I always get nervous about it. I worry about everything. Do I have all the stuff I need? Will my equipment break down? Will I mess up in front of someone? Will I even be able to get a fire going? It seems like all the monsters are waiting to get me! Usually I'll notice that my palms are sweating as I'm driving to the demo location! But once I start, all the negative stuff is replaced by adrenaline I guess! I always have a great time hammering when folks are watching. I can be screwing up on a piece, and be telling the crowd that I'm screwing it up, while having a great time doing it! Usually time passes so fast that I don't even realize that I'm tired until I'm done. I guess that I'm trying to say; if you haven't tried demoing, that you should give it a try.

Our annual conference is not far away. I can hardly wait to see the demonstrators we have this year! A few years ago I did get to see Peter Ross. I was very taken with his ability to just create whatever he had a mind to. As he approaches the anvil, he reminds me of a boxer coming out of his corner after the bell rings! And he is all business when he gets to the anvil. Just watch and try to see him make an errant blow!

I've only seen Jymm Hoffman on a video, but he really showed me a better way to make a skillet that seemed to work far better than other ways I have seen folks try.

Hope you all are getting to hammer more than I have lately!

Happy Hammering, Byron



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
Byron Doner	President	6520 Alameda Norman OK 73026 byrondoner@esok.us	405-650-7520	President BOD Meeting Chair Cone Shipping
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 BOD Meeting Minutes
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Russell Bartling	Director/ Editor	70 N 160th W. Ave Sand Springs, OK 74063 rbartling@ionet.net	918-633-0234	Newsletter Editor Regional Meeting Coordinator
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Dodie O'Bryan	Webmaster	Pawnee, OK scout@skally.net	—	Website Updates Web Calendar Updates

****** NOTICE ******

At the Board of Directors meeting on March 6, 2016, the Board officially voted on some changes to some of the regional meeting dates and details. This may look familiar as it was originally published in the December, 2015 newsletter but was retracted as the Board had not officially voted on the changes at that time.

The Board officially voted to revise, beginning in 2017, the NE region meeting dates to be on the first Saturday of each month while the SE region is revised to hold meetings on the second Saturday.

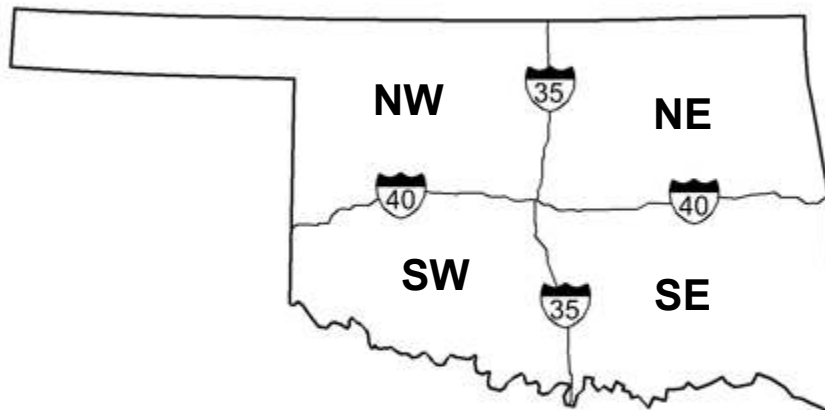
There has also been some confusion on the boundaries for each region, especially with new members. The four main regions are currently defined within the state by being separated by I35 and I40. (For example, the NW region is anything north of I40 and west of I35.) The Board has voted to maintain this boundary definition and also to refer to the regions by the labels of NE, SE, SW, and NW to more clearly match the defined region boundaries. The SW region would cover most of the areas that have referred to as SC.

The Board encourages all meetings. These boundary definitions and regional meeting dates are a suggested framework to facilitate orderly meeting scheduling, planning and promotion with a minimum of overlaps and a maximum exposure to the greatest number of members. The Board recognizes that not all meetings fit precisely within a rigid boundary definition and that members in an area may want to hold meetings on a date that doesn't match their physical region or a location other than their own region. This may be especially true in the center of state for areas that are close to the I35 and I40 boundary crossing. The Board also recognizes that special events such as shows, fairs, etc. may dictate adjustments to the meeting dates within a region.

These definitions are meant to be a simplification and clarification to the regional boundaries rather than a rigid restriction to any meeting scenario. Saltfork members all belong to one club. Regional boundaries are not intended to imply division within the club, but are intended to help spread distribution and promote monthly meetings.

Again, these changes will not take effect until 2017. If you have any comments or questions on these changes, please contact one of the Board members.

SCABA Regions



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 Ivey)
May 7 th (Open)	May 14 th (Ed McCormack)	May 21 st (JJ McGill)	May 28 th (Terry Kauk) (Cancelled)
Jun 4 th (Open)	Jun 11 th (Marshall Hager)	Jun 18 th (Ricky Vardell)	Jun 25 th (Don Garner)
Jul 2 nd (Open)	Jul 9th (Terry Taylor)	Jul 16 th (Open)	Jul 23 rd (Kelly Kilhoffer)
Aug 6 th (Open)	Aug 13 th (Gerald Brostek)	Aug 20 th (Byron Doner)	Aug 27 th (Don Garner)
Sep 3 rd (Open)	Sep 10th (Jim Carothers & Tom Nelson)	Sep 17th (Jim Dyer)	Sep 24th (Roy Bell)
Oct 1 st (Open)	Oct 8 th (Open)	Oct 15 th (Conference Weekend)	Oct 22 nd (Cheryl Overstreet)
Nov 5 th (Bill Phillips)	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)

All Regional Meetings are Free to Attend and are Always Open to Any Member or Guest...

New to Saltfork or just want to check out Blacksmithing but don't know where to start? These meetings are a great place for new members or guests who just want to see what it is all about to come network with like minded people. If you want some pointers on how to get started, there is always someone happy to help get you started hammering. And guests are always welcomed.

Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any 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. If you mail a form, please call or e-mail to verify that it is received. 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

September

SE Regional Meeting September 3rd : Open

NE Regional Meeting September 10th : Will be Hosted by Jim Carothers and Tom Nelson at the Blacksmith Shop in Pawhuska. 210 W Main St, Pawhuska OK 74056. The Blacksmith Shop is right behind the Chamber of Commerce building (south.)

In lieu of a trade item, the hosts are asking for members to make and donate a tool for the shop. If you need an idea for a tool, the SCABA Conference tool box list is a good place to start.

Morning coffee and Lunch will be provided (campfire beans and Dutch oven cornbread.) But please bring donuts and a side dish or dessert to help out.

Contact Jim Carothers 580-336-9213.

The Chamber office is in the old blacksmith's house; look for the bronze horse and farrier out front. The new blacksmith shop is directly south behind the stone house. Built in 1871, this 5-room house with native timbers and 18" thick sandstone walls was the first to be built in Pawhuska.



When the Osages were removed from Kansas, Sid Delarue, a Swiss blacksmith, was promised the house if he would come to care for their horses. Listed in the "National Register of Historic Places," the shop was attached to the rear, and since this shop was not for tools and/or farm equipment, it was smaller than those common back east. Most of the time this farrier took his tools to the horse instead of the other way around. The house was converted into a business office and is now occupied by the Pawhuska Chamber of Commerce.

SC Regional Meeting September 17th : Will be hosted by Jim Dyer and JJ McGill in conjunction with the Murray County Antique Tractor & Implement Association show. (See Flyer on next page.)

The trade item is burlap sack sewing needle.

Lunch will be on your own. The blacksmiths are invited to a free BBQ dinner given by the Tractor Association at 5 PM. Directions are 7 miles north of Sulphur on Hwy 177 then east ¾ mile on Tractor Road. If you need more information, contact Jim Dyer at 580-465-3265.



NW Regional Meeting September 24th : Will be hosted by Roy Bell at the Fairview Tractor Show.

Directions: 1 ½ miles east of Fairview on Hwy 58. Watch for signs on the north side of the road. Trade item is a candle holder. Lunch will be on your own. Contact Roy Bell at 580-309-4513.



September 16, 17 & 18 2016

Murray County

Antique Tractor & Implement Association



- Friday & Saturday Events**
Gates Open 7:30a.m.
- WHEAT THRESHING
 - HAY BALING
 - CORN SHELLING
 - SMALL GAS ENGINES
 - TRACTOR GAMES
 - ARTS & CRAFTS
 - WOOD SAWING
 - COTTON & PEANUT DISPLAYS
 - KIDDIE TRACTOR PULLS
 - VENDORS
 - SWAP MEET
 - CONSIGNMENT AUCTION
 - BLACKSMITHS
 - VINTAGE TRUCKS
 - BRACE & BIT
 - ROCK CRUSHING
 - WATER PUMPS
 - QUILTING
 - TOY EXHIBIT
 - EXHIBITOR DINNER SATURDAY NIGHT
- SUNDAY EVENTS**
GOSPEL SINGING AT 9 a.m.
TRACTOR PULLS AT 11 a.m.

23rd ANNUAL SHOW

7 Miles North of Sulphur
on Hwy 177, then 3/4 Mile
East on Tractor Road

WATCH FOR SIGNS!

For Information, Call
(580) 264-0500
or
(580) 622-6611
(580) 369-8362
Vendor-Arts & Crafts
or
Mail to:
M.C.A.T.I.A.
P.O BOX 1051
SULPHUR, OK 73086



Admission \$3.00 Per Person
Under 16 & Over 60 FREE
\$5.00 Registration Fee for ATV's & Golf Carts

October

SE Regional Meeting October 1st: Open

NE Regional Meeting October 8th: Open

SC Regional Meeting October 15th: CONFERENCE WEEKEND!

NW Regional Meeting October 22nd : Will be hosted by Cheryl Overstreet at the Route 66 blacksmith museum shop in Elk City.

The trade item is a Fall Item. Lunch will be provided but bring a side dish or desert to help out. Contact: Cheryl Overstreet at 580-243-8278.

Ed and Brian Brazeal Hammer Workshop (*Cancelled*):

The Ed and Brian Brazeal hammer and hot cut hardy making workshop that was scheduled for the third weekend in September (September 17th) has been cancelled.

Ed and Brian will be reportedly going to Kenya for around 6 months to teach blacksmithing at an orphanage there. They should have some interesting stories when they return.

If you submitted a deposit and need to get it returned or have other questions, contact **Ed Brazeal** directly at **918-506-3438**.

Demo Opportunity: Stockyards Stampede in OKC

Hi Corny,

Wanted to ask if any of your guys would be interested in joining us again this year for the annual Stockyards Stampede? We missed you guys last year. Many people asked where you guys were.

The date is October 1st (Saturday)

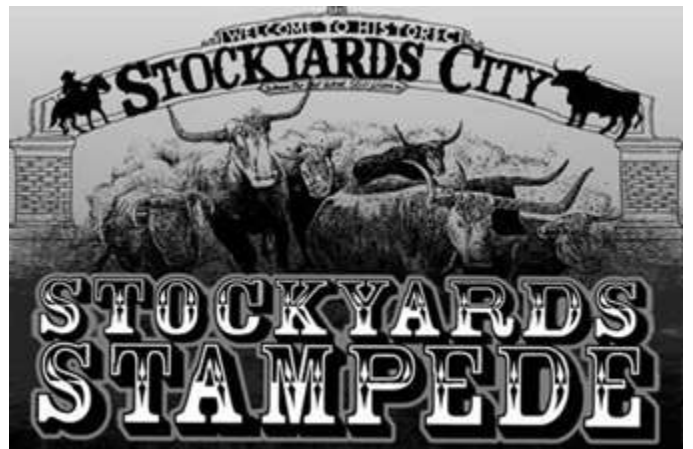
We will get underway around 10 am after the parade starts. We will feed you guys all you can eat.

I have a shaded spot picked out for as many guys as you want to bring or have come. Even if only one guy/crew can come. It will be good. You may bring items to sell or make and sell as you complete them. Oh and the place I've selected for you in the shade is on concrete. No grass fire issues that way and most likely less for you to haul.

My number if you want to call is 405-823-4164. Or just write back to me at strshp7@sbcglobal.net.

Thank you,

Bill Shipley



Workshop Schedule

Joinery Workshop (*Subject to Member Response*):

Details of the workshop are not yet defined but this would be a workshop to learn how to make simple tenon joints and corresponding fitting techniques to make a small grille or similar item. This workshop would focus on good layout and fitting techniques as well as controlled punching and drifting. The date and location are to be determined and will depend on the availability of the instructor and facility. If you are interested in attending such a workshop, please let the workshop coordinator know. If there is enough interest, this workshop will be set up. **UPDATE: So far, only one person has expressed interest in this workshop. If you are interested in a joinery workshop, please let Mandell know as soon as possible or this one will be dropped...**

Clay Spencer Tire Hammer Build Workshop (*Subject to Member Response*):

An effort is being made to put together a weekend tire hammer building workshop for sometime this winter. The exact location is to be determined. The ideal workshop size is 15 to 20 students and each student will leave with a working tire hammer. The expected cost if there are twenty students is about \$1,100 per hammer. This cost is extremely variable based on the number of students and the actual costs of materials which are purchased, scrounged, donated, etc. Clay Spencer will bring his experience along with jigs and fixtures to facilitate building a good hammer in the workshop setting. Each student will participate in building the hammers. Saltfork member Mike Hillsman will be the facilitator of this workshop. If you are interested, please let Mike know as soon as possible. If there are not enough students interested in this workshop, it may not be feasible. So please don't delay if you want this workshop to become a reality. **Contact Mike at 918-625-4891.**

Welding for Blacksmiths Workshop (*Subject to Member Response*):

If you have never welded before or if you have been "farm" welding most of your life but would like to take your skills to the next level, then this hands on workshop may be for you. If you want to have greater confidence in the strength and beauty of your welds, then this workshop may be for you. The exact details including date and location are to be determined but it will probably be held sometime this winter. Location will depend on interest level and location of the potential students so respond early if you would like to attend this workshop. The intent is for the workshop to be led by a blacksmith trained in pressure vessel welding but the course will cover basic stick welding and oxy-acetylene welding/cutting that would be used in day to day blacksmithing and fabrication work. The expectation is that students will leave the class with a better understanding of correct electrode selection, welder polarity, techniques, etc. for mild and high carbon steel stick welding as well as proper use and settings for the oxy-acetylene rig. While this is a basic one-day crash course, there are a number of experience based tips and techniques that will help you get the most out of your welding and cutting equipment. Stop wondering if your welds will hold and stop grinding them down to hide a less than pretty bead deposit. **Let Mandell know if you would like to attend this workshop as soon as possible!**

Have an idea for a workshop or class? If you have an idea for a workshop that you would like to attend (or teach), please let the workshop coordinator know so that details for time and place can be worked out.

Workshops After the SCABA Annual Conference: There will be hands on workshops by the demonstrators following the 2016 SCABA Annual Conference. Refer to the conference information elsewhere for details...

Mandell Greteman is the SCABA Workshop Coordinator.

Contact Mandell at 580-515-1292.

mandell01@windstream.net



ANTIQUE AGRICULTURE FESTIVAL

**OCTOBER 7,8,9
2016**

Come experience nineteenth-century agriculture and heritage farming on a historic 1850's farm.

- DEMONSTRATIONS
- ENTERTAINMENT
- FOOD • SHOPPING
AND MORE!



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918-456-2751



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Oklahoma State Fair 2016:

Can you believe another year has rolled around a little faster than the last one? The Oklahoma State Fair is quickly approaching and just around the corner. Saltfork Craftsmen has been asked again to demonstrate in the "Frontier Experience" area on the northeast side of the fair. We are honored to get to help with this event again this year and look forward to hearing from you. We would love to hear from any of our club members who have worked in the past or are new to the club and interested in demonstrating this year. **The Oklahoma State Fair runs Thursday, September 15 thru Sunday, September 25. Demonstration times are 10:00- 6:30pm.** Some of you might want to come earlier or even stay a little later! We will set-up on Wednesday, September 14 about 9:00 in the morning and tear down about 7:00 pm on Sunday, September 25. You will be given a gate pass and parking pass to get in for each day you are scheduled. Please contact Richard's wife Michele since his work schedule is busy and his computer skills are minimal 😊

The Oklahoma State Fair has provided us a hotel room, but it must be occupied most of the time during the course of the fair, or it will be forfeited the following year. The hotel room will be assigned on a first come, first serve basis but we will also consider distance traveled. Weekends are the easiest to fill, if you are retired or have a flexible work schedule could you possibly demonstrate during the week? We would like to save the weekend for those with tighter work schedules. We want everyone who would like to demo to get the opportunity to do so. Please consider one, two or even more days. We will have 2 forges set up and going. We have asked for 4 people each day to help cover forging, tables, break relief and answer questions from the fairgoers. It gets too crowded with more than 4 people. Even if you could only work a partial day, please let us know.

State Fair rules for Salt Fork Craftsmen to demonstrate are:

Try to dress the part of an early time period blacksmith (NO Ball caps, NO tennis shoes, NO t-shirts.)

NO ALCOHOLIC drinks around demonstration area

NO Visible plastic ice chests (You can bring one and leave yours in the trailer, the club provides water)

Richard and Michele can be contacted at 405-324-2017 or her cell phone 405-550-9850 (text messages are ok).

Saltfork Craftsmen Blacksmith						
Oklahoma State Fair 2016 Schedule						
Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
			14	15	16	17
			Set Up 9:00-??	Richard Blasius	Tony Cable (Carol)	Tony Cable (Carol)
18	19	20	21	22	23	24
Tony Cable (Carol)	Anthony Griggs Richard Blasius	Richard Blasius	Anthony Griggs Richard Blasius	Richard Blasius	Anthony Griggs Richard Blasius	
25						

I'll try to explain what this all about.

This exchange of hand made tongs would be like school kids (at least when I was in grade school in the 1950's) drawing names to exchange gifts at Christmas time. This idea is not new or original to me; the folks on AnvilFire's Slack Tub Pub have done this a time or two in the past. In the two years that I remember this happening through AnvilFire, there were about 12 to 15 people involved each time. I have four unique pair of tongs from participation in the past exchanges. One of these was made by James Joyce out on the west coast and one by Jim Gerlinski from Canada. I have two nice tongs made by SF member Mark Carter. I've always found this fun to participate in. Making tongs is good forging practice.

Don't worry that you are not an expert tongs maker. At first, I was concerned that my hand made tongs would not be good enough for an AnvilFire international exchange. There are a couple of mistakes in the learning pile under my work table, but all worked out OK. The experienced smiths that got the tongs I made were quite pleased with them.

I have chosen 3 Kings Day as the latest mailing day for the tongs; that would be January 6th, 2016. By choosing the 3 Kings date (the 12th day of Christmas), you would hopefully have some time over the Thanksgiving, Christmas, and New Year's holidays to get your tongs made. And if you needed help, there would be time for that as well. There is a good how to make tongs article on the Shady Grove Blacksmith Shop web site. http://www.blksmith.com/tong_article.htm . Most of the beginning smith's books have tongs lessons too. Don't be afraid to ask for help.

And yes it's OK to mail out your tongs as soon as you get the recipient's address.

As noted above, I am offering to keep the list of those wanting to participate; do the random drawing of names (computer program) ; and to notify each participating member whom to send his or her tongs to. And yes, I plan to make a pair also.

Here are the rules:

- 1) You must register with me your intent to participate in the Christmas Tongs Exchange on or before Monday, December 19th. 10 PM that Monday evening will be the cutoff time. Your registration can be done by e-mail, phone call, text, or US Mail. E-mail is really best for me, but any of the others are OK too. I will need your mailing address along with your registration to participate.
- 2) Tongs can be any style you choose as long as they are blacksmith made. Use of electric welding and other modern techniques is OK. Tongs can be made from round bar, flat stock, etc. They can be steel or other suitable (strong) material such as Titanium, Nomakesit, Unobtainium, or Flexstiffinite.
- 3) Be sure to steel stamp or engrave your tongs with your touch mark, name, or initials and the date they were made.
- 4) I will notify you by Tuesday, December 27 as to whom to send your tongs to.
- 5) All tongs are to be sent out no later than 3 Kings Day – January 6th. US Mail or your favorite service such as UPS, etc. can be used. Personal delivery is OK too. You are responsible for the cost of shipping your tongs.

That's about it. Let's have some fun with this again.

Jim Carothers
9501 Frontier
Perry, Ok 73077-9225

frontiershop@wildblue.net best contact
580-336-9213 home land line – evenings are best for this number
580-307-5152 cell (text OK) – usually on

Tulsa State Fair 2016 Demo Opportunity:

The Tulsa State Fair begins at the end of this month and Doug Redden is coordinating demonstrators. If you would like to demonstrate and sell blacksmith made items at the fair this year, contact Doug to schedule a time and work out getting a parking pass or other details. This year the Saltfork booth will be listed on the website and on the fairgrounds map.

Contact Doug at 918-230-2960 or Doug.redden2@att.net

Tulsa State Fair 2016 Schedule

Sunday	Monday	Tuesday	Wednesday	Thursday	Friday	Saturday
2-Oct	3-Oct	4-Oct	5-Oct	6-Oct	7-Oct	8-Oct
9-Oct						

Scholarships Available...

If you are signed up for one of the hands on workshops following the 2016 SCABA Annual Conference, there is scholarship money available for Saltfork members in good standing.

This money is there to be used to help members gain exposure to educational events and application for a scholarship is easy. The scholarships can be used to offset the costs for workshop registration and meals.

Go to the Saltfork website, complete and submit the application form (available in both Microsoft Word and Adobe PDF format):

<http://www.saltforkcraftsmen.org/Scholarships.shtm>



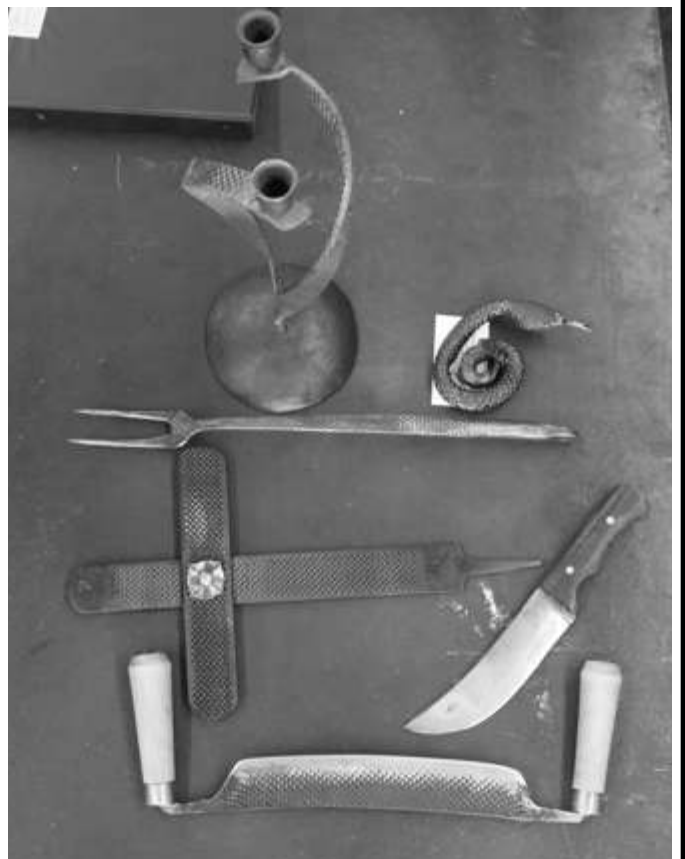
Around the State...

NW Region July Meeting: The NW region meeting was held at the Elk City Old Town Museum Blacksmith shop hosted by Kelly and Teresa Kilhoffer on July 23. There were fifteen in attendance and considering the hot weather that was a good showing. The big doors and large shop





fans keep it cool enough in the shop area and two forges were going most of the day.



Trade item was something made from a horse rasp and the were six very well made creations.

Rory Kirk made a very nice draw knife ,Dorvan Ivey a big turning fork,Roy Bell made a big ol' knife,Terry Kauk impressed us with a small rattle snake. Mandell Greteman created a very nice looking cross with some amazing rivet work. Don Garner worked up a wonderful double candle holder by splitting a rasp. These guys are very talented and always a treat to see them work. Very inspiring.

Hot dogs on the grill with homemade chili, pork and beans and all the fixin's along with great sides and some good pie.

Two new members joined and one spent most of the day with us.

Thank you to all who showed up and special thanks for all who pitched in with lunch.

This was our first time hosting and we really enjoyed it.

Kelly & Teresa Kilhoffer *(Photos by the Gretemans.)*

SE Region August Meeting: No meeting was held in August.

NE Region August Meeting: The NE Region August meeting was held by Gerald Brostek at his shop in Okmulgee. There were over 35 people in attendance and the hot weather was a little less brutal during the meeting. Gerald has an amazing home and shop setup showing the results of a lot of attention, organization and hard work. In spite of the hot weather, the extra shade kept the forging area very comfortable.

There was a large selection of tailgate items for sale in front of the shop and lining one side of the driveway.

The trade item was anything you wanted to make and Gerald contributed his first item ever made - a candleholder made from 1965! Other trade items included a chili pepper, a railroad spike knife, and a



set of eating utensils.

Several smiths demonstrated some basic forging techniques and then assisted some new members and guests who did some forging of their own. Two





very young smiths kept busy working on axe heads, one from a ball pein hammer and one from a truck leaf spring, with the occasional assistance of Gerald Brostek as advisor and striker.

Gerald gave some of us a quick tour of his house to see some amazing items that he has made over time (maybe there will be room for a gallery of pics in another newsletter.)

Hats off to the head chef, Dallas, for cooking a delicious lunch of beans and cornbread with all kinds of sides and desserts including fresh cantaloupe. And thanks to all who brought something.

Thanks to Gerald for hosting and to everyone who attended a great meeting. - Editor
(Photos by Editor.)

SC Region August Meeting: Was held by Byron Doner at his shop in Norman:

I should start off with apologies to all the women who came to have a good time, but instead got put to work along with my daughter Darian (April) helping out with getting the food all ready, so we

could all eat. My wife had gotten sick on Friday, and was on her way to the annual 4H banquet that we always attend, when "it" hit her and she had to HURRY back home! She spent most of the night running back and forth to the restroom, and stayed in bed during the meeting, as well as all of



Saturday. TMI? A big Thank You to all who helped out and made the meeting a success! And another Thank You to LaQuitta for making me an anvil shaped birthday cake! It was a very pleasant surprise indeed!

I counted up everyone on the sign up sheet and came up with 33 folks. I did not get a count on the trade items, but there were a bunch!

Thanks to you all for coming! - Byron

(Photos by the Gretemans.)



Boy Scout Merit Badge Workshop:

Saturday August, 6 SCABA members: Tracy Cowart, Danny Cowart, Phillip Wall and Chris Hughes met at about 7:00 am. and started setting up the the forges to help 12 Boy Scouts get their Metal Merit Badge.



It was raining steady all day and everyone and everything got wet until we moved most of it into Jason's Iron Decor shop.



All the Scouts finished their requirements.

- Dan Cowart

Anvil Restoration Demo (July 30th):

Saturday July 30th, an anvil restoration demo was held at Ed McCormack's shop in Okmulgee. There were about twenty in attendance including a couple of new members who signed up at the demo.

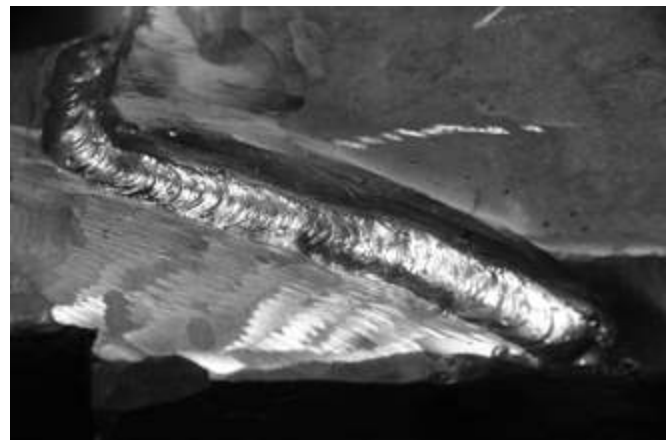
The anvil was a damaged Peter Wright marked 1-0-15 (127 Lbs.) The hard steel face was broken just behind the step with a large corner piece missing (somewhat like a plow share anvil) and the edges had large chips on each side. For the demo, there wasn't enough time to repair the entire anvil



so the work concentrated on the front part of the face.

The first step was to grind the weld area to prepare it for solid welds. The bad area was ground to expose clean wrought iron up to the solid part of the remaining face and the boundary was cleaned up to remove all rust and any de-laminations. Then the anvil was preheated with a propane weed burner aimed at the side of the body. The burner was turned down during welding but kept in place until welding started putting enough heat into the anvil to keep it hot.





It was pointed out that making small repairs to a hard face with hard surfacing rod would probably require more careful preheating to around 400 degrees F. Welding the base layer with 7018 made the preheating less critical since the welding process would add a substantial amount of heat.

For welding, a base layer on the wrought iron was deposited using 5/32" 7018 electrodes. The welder was a Lincoln Electric Idealarc 250 set on 175 Amps and DC Positive I believe. Ed McCormack, Mandell Greteman and Bill Phillips started out welding while observers took turns watching with the extra hoods. Later, several spectators took turns laying down a few passes while the more experienced welders gave tips to improve the work.

The target was to run stinger beads that were a maximum of 1 1/2 times the width of the rod used. And successive passes were alternated to start on opposite sides of the anvil. It was pointed out that starting the weld, the rod is colder and the deposit is usually thicker requiring more grinding. Alternating helps to maintain a flatter surface on average.



Changing the angle of the electrode can affect the way the material is deposited during the weld. Holding the electrode at a shallower angle builds up the weld more while holding the electrode more vertically causes the weld deposit to spread out more.



process to repair and anvil with any significant damage.

After the 7018 layer was complete on the area being worked for the demo, a hard surface layer was deposited on top. There are numerous hard surface rods available but Railbuild 540 was used for this demo. Each hard surface rod should have its own data sheet explaining any particulars for preheating, welder settings and post treatment if any.



After the first 7018 pass, the slag was cleaned off and multiple passes were laid in the same way to cover the first layer. Then some grinding was done to flatten the surface before the next layer was laid down. Most of the repair proceeded this way, weld-grind, weld-grind, etc. It is a labor intensive



There are hard surface rods for abrasion more than impact and some of them are prone to check when cooling (which doesn't matter much for abrasion resistance) so determine the characteristics if you purchase rods for a repair. And they tend to be expensive. It is helpful when welding up the edges of the anvil to angle it to keep most of the rod deposit where you want it to minimize grinding and wasting too much expensive rod.

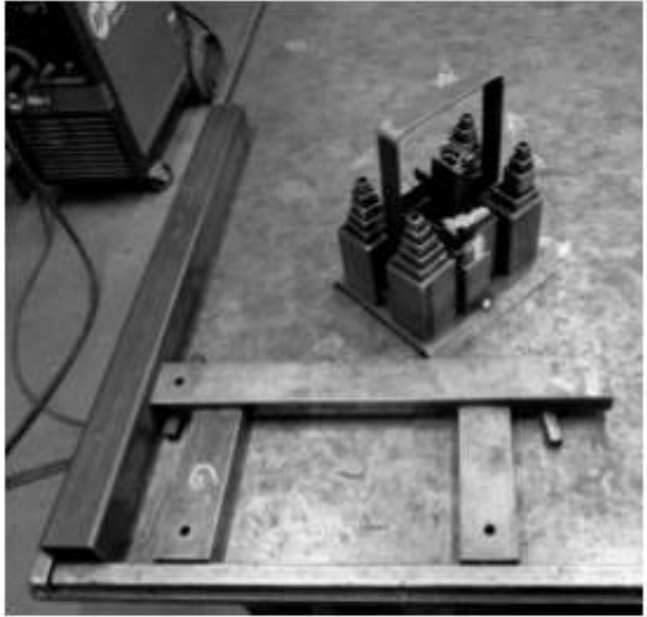
Though it is more a matter of aesthetics than performance, it was pointed out that on small spot repairs, the hard surface rod would leave a chrome look at the repair area. If the whole face is resurfaced, the look would be more consistent and less noticeable. The 7018 rod would bore closely match the original anvil material.

The best approach is to grind frequently all along during the welding process to maintain as flat a surface as possible. It is easy to start running uneven and it can make the grinding process very, very labor intensive. Grinding frequently to make small changes makes it easier to hold to a flat surface level and control the weld deposits in the most efficient way. Since the anvil was not completed during the demo, we did not get a chance to verify how the repairs impacted the surface hardness or rebound of the anvil but it was definitely looking better and more usable.



Although the anvil was not completed at the demo, it was a good demonstration to many of us who had not attempted to repair an anvil before. The task of anvil repair is not one to be taken lightly in terms of time needed. Once the work is begun and the anvil is heated, it can take many hours to complete a big repair. - *Editor*

Shop Tips:



Doug Thompson's build/shim kit

Build System: This idea comes from the Arizona Artist Blacksmith Association, *The Anvil's Horn* Newsletter, July 2016.

This system by AABA member Doug Thompson is a handy carrying rig that holds various sizes of precut stock. The stock includes nested pieces of square tubing and other useful metal pieces that can be used as shims and spacers for laying out welding projects, etc.

Have a bunch of small pieces of soapstone? Here is a fun forging project and a solution from the New England Blacksmiths, Winter 2016 Newsletter:



Introduction to Bladesmithing

By Anthony Griggs



The Bill Moran School of Bladesmithing is located in Washington, Arkansas. It is 8 miles north of Hope, Arkansas. Washington is the center of a lot of history. The entire town is a State Park. The town was established in the



early 1800s. It was the capital of the Confederate States at the end of the Civil War. But for those of us that enjoy a forge and anvil this is where James Black forged a knife for Jim Bowie.

There are only about 7 knives at this time that are known to be made by James Black. James Black was originally an apprentice silversmith in Philadelphia before moving to Washington, Arkansas and setting up a blacksmith shop. His shop has been rebuilt by the Arkansas State Parks with a smith who puts on demonstrations on occasion. James Black did not mark his knives but the distinctive way he made his knives have allowed historians to be able to identify his knives. Some of his knives are on display at the Arkansas Knife Museum at Little Rock, Arkansas.

If you are seriously interested in making a forged knife you need to consider this school or any of the American Bladesmithing Society (ABS) schools. There are 4 ABS schools in the United States, one in Belgium, and one in South Africa.

The ABS was the creation of Bill Moran who was one of the last few knife makers that only forged their knives. (About 12 knife makers.) So to keep this art from dying he pulled together the few makers left and started gaining support for a way to teach this dying art. And so the ABS was started. As a side note Bill Moran is credited with being the first to learn how to re-make Damascus. This has been a lost art and in 1973 at the Knife Guild Show in Kansas City, Bill Moran unveiled 8 Damascus knives made by him. This created a much needed interest in forged knives and in 1976 with the help of Bill Moran, Don Hastings, Bill Bagwell, and B.R. Hughes the ABS was started.

With a slow but continuous interest the ABS was able to start a school and in May of 1988 the Bill Moran School of Bladesmithing was built in Washington, Arkansas. This was the first ABS school.

To say I enjoyed the school is an understatement. You can learn so much. The 2 instructors I had hold a Master Smith rating in the ABS and were from Oklahoma as well. I

had met both on former occasions. This added a closer relationship also.

The class was full. We had 10 students for the 2 weeks. There were students from Washington State, Maryland, California, Arizona, Texas, Oklahoma, Louisiana, Missouri, and Arkansas. All had an interest in knives and forging even though 2 or 3 of them had never forged anything before attending the school and by the third day some of them could barely lift their hammer arm or hold anything due to blisters. But that did not stop them. And by the second week they were doing a very good job.

These schools are 2 weeks, hands on instruction. It is not just sitting in a classroom. There are a few short classroom sessions in the morning. The instructors were excellent. They were humorous, factual, and answered any questions you might have. I would like to thank the Saltfork Scholarship Foundation and its directors for approving my request for help in attending this school.



The Shop

I have tried to be as supportive as I can to this club. I will be hosting the South Central Meeting on November 19, 2016. So God willing and the creeks don't rise, please come. Here I can better help anyone who might have questions



Looking Inside the Forge

about forging a knife or the normalizing and heat treating of them.

Included are some pictures of the school and some of the James Black knives at the museum in Little Rock, Arkansas.

This article would have been prepared sooner except my computer crashed and I broke my right shoulder in April.



I will be donating a knife for the Conference auction in October, 2016.

So until then, everyone take care. (Don't fall off any ladders!)

- Anthony Griggs

The 20th Annual

Saltfork Craftsmen Artist Blacksmith Association Conference

October 15th & 16th 2016



Featuring Live Blacksmithing
Demonstrations by:

Peter Ross

&

Jymm Hoffman

Murray County Antique Tractor Assication Show Grounds:

7 miles north of Sulphur on Hwy
177, ¾ mile east on Tractor
Road. Sulphur, OK

Conference Schedule



Friday, October 14th

Conference setup starting at 8:00 am.

Saturday, October 15th

Registration opens at 7:00 a.m.
Demonstrations 8:00 am – Noon
Lunch break Noon – 1:00 p.m.
Demonstrations 1:00 – 5:00 p.m.
Dinner 6:00 p.m.
Drawing for toolbox 7:00 p.m.
Auction 7:00 p.m.



Sunday, October 16th

Registration Opens at 7:00 a.m.
Demonstrations 8:00 – 11:30 a.m.
Lunch Break 11:30 – 12:30 p.m.
Demonstrations 12:45 – 4:00 p.m.
Cleanup and teardown 4:00 p.m.



Remove registration form or print
from the website and mail to the
Secretary. Register as soon as
possible!

***Find an extra bonus in your
welcome packet if paid
registration is received on or
before***

Monday, October 10th

20th Annual Saltfork Craftsmen Blacksmithing Conference

Registration Form
October 15th & 16th, 2016

Please Print Clearly

Name: _____ Spouse Name: _____

Address: _____

Phone: _____ E-Mail: _____

Membership required for attendance.

Charge for non-members is \$10 for membership until March 31, 2017

	Number	Cost Each	Total
Conference Registration Fee (One Per Family)			
Saturday & Sunday (per family)		\$55.00	
Saturday Only (per family)		\$35.00	
Sunday Only (per family)		\$35.00	
Membership Until 03-31-17 for Non-Members		\$10.00	
Meals			
Weekend Meal Pass (2 lunches and 1 Dinner per person)		\$25.00	
*Family Classes on Saturday			
Saturday Morning: Drop Spindal Spinning		\$25.00	
Saturday Afternoon: Scrapbooking		\$35.00	
Beaded Bracelet or Earrings		\$10.00	
Fold Form Bracelet		\$45.00	
*Family Classes on Sunday			
Sunday Morning: Copper Etching		\$35.00	
No Sew Christmas Ornament		\$ 5.00	
Braided Linnen Necklace		\$20.00	
Total Payment Enclosed			

Make checks payable to Saltfork Craftsmen ABA.

Only one family Registration Fee (family members only) required per household.
(All meals and all material costs for Family Classes must be paid).
Saltfork Craftsmen T-shirts will be available at the conference.

Murray County Antique Tractor Association Show Grounds:
7 miles north of Sulphur on Hwy 177, ¾ mile east on Tractor Road. Sulphur, OK

Mail this form with full payment to:
Teresa Gabrish
PO Box 18389
Oklahoma City, OK 73154

All adults attending the conference must sign this disclaimer. Parent or legal guardian must sign for minor children.

Disclaimer: I understand that blacksmithing can be a dangerous endeavor. I understand that my safety is my responsibility. I understand the need for eye and ear protection; I will provide and utilize the necessary safety equipment for all activities. The Saltfork Craftsmen ABA, its officers and members are not responsible for my well-being. Registration for the Conference indicates my agreement to these terms.

Signature: _____ Date: _____

Signature: _____ Date: _____

Peter Ross

" My experience studying historic ironwork has kept me interested in using hand methods and solid basic hand skills. I prefer this to making jigs and elaborate tooling, and can generally make most pieces using just my standard cross pein hammer and a few pairs of standard tongs. To me this is much more satisfying and more engaging, and I like the results much better too! "

I got my start in Blacksmithing at the age of 17 when I took a class at a local museum (it was taught by Steve Kayne). We learned to make a simple hook the first night, and on subsequent nights made many more. After a few months of working in a homemade forge in the garage I began volunteering at a nearby historic village. There was a real shop and an older man who knew the basics. We made hardware, fireplace tools, and farming tools for the village using antiques as models. The pieces immediately got a thorough testing by the other staff, which helped me get over the romance of creating something by hand.

After a couple of years at art school, I worked a year for a smith named Dick Everett in East Haddam, CT. We made museum quality reproduction hardware for historic buildings and repaired antique ironwork. Dick gave me a big push towards understanding old ironwork. After that, I opened my own shop on Deer Isle, ME. where I worked for 4 years.

In 1979, I moved to VA to join the blacksmith shop at Colonial Williamsburg. Two years later I was promoted to Master of the shop. My job entailed producing hundreds of articles for the ongoing restoration and museum programs while

trying to re-develop 18th century methods in a historic setting. I also trained a number of apprentices. It was this combination of goals that gave me the greatest insights into hand work and the environment of hand technology. These have shaped my aesthetics and thoughts about the role of the craftsman in modern society.

In 2004 I moved to North Carolina and again opened my own shop. Since then I have been busy making reproductions of antique hardware for historic buildings, both private homes as well as those open to the public.

Over the years I have been a frequent demonstrator at local and national blacksmith conferences, and have taught many classes at various schools.



Jymm Hoffman

James A. (Jymm) Hoffman has a Bachelor's Degree in Museum Studies from Salem College,

(now Salem-International University,) Salem, West Virginia, and has been a full time blacksmith from 1981 to 1988 and from 1990 to the present, specializing in museum quality reproductions and custom orders. Items range from cooking utensils and fireplace equipment to architectural hardware, lighting devices, and tools. He continued his business on a part time basis from 1988 to 1990, while working at Old Fort Niagara, Youngstown, New York, as the Interpretive Programs Manager. He was listed in the 1993 "200 Best Craftsmen" issue of *Early American Life*, and again in 1996, 1997, 1998. In the June 2008 issue of *Early American Life*, he was also one of the featured blacksmiths in the article "Handmade Nails."

When Jymm is not working in his shop in Ambridge, Pennsylvania, he can be seen throughout the northeastern and midwestern parts of the United States at various craft shows and historical re-enactments demonstrating his art with an authentic reproduction of an 18th. century traveling forge. He also offers hands on instructions for those interested in learning the blacksmith's trade.

Jymm has been an instructor at Touchstone Center for the Crafts near Farmington, Pennsylvania, on numerous occasions. He was also chosen as one of four featured demonstrators for their first "Hart Moore Hammer In" in 2002, as well as demonstrating for other regional blacksmith conferences. In 2002, 2003, & 2004, Jymm received a grant to teach an apprentice with the Apprenticeship in Traditional Arts Program from the Pennsylvania Council on the Arts, a state agency in the Governor's Office of the Commonwealth of Pennsylvania, in partnership with the Institute for Cultural Partnerships, as well as a grant for a

Fellowship in 2005. He also recieved a grant in 2004 from the Pennsylvania Rural Arts Alliance to teach "at risk kids" at Pressly Ridge At Ohiopyle, Pennsylvania.



Family Classes:

Scrapbooking Class:

Hassie Moiser is offering a scrapbooking class for Saturday Afternoon. All materials will be provided for this class. Cost of the class is \$35.00

Jewelry Classes:

We have four accomplished jewelry artists offering a range types of jewelry classes.

Beaded Bracelets/Earrings:



Mecca Waite will be teaching a basic beaded bracelet or earrings class on Saturday afternoon. Price of this class is \$10.00 each with a limit of 10 students.

Form Fold Bracelet:

Teresa Gabrish is offering a fold formed bracelet.



\$45.00

Wax Linen Necklace

Mary Chris Gibbons from Dallas Texas is offering a wax linen necklace class. She will provide all the materials for a necklace. Class cost is \$20.



Drop Spindle Spinning

Kate Wolven is offering a Drop Spindle Spinning



Learn to spin wool into yarn using a Drop Spindle instead of a spinning wheel. \$25.00 for the class. The kit is available for purchase for \$15.00

Conference Information

Registration forms are available at www.saltforkcraftsmen.org or by contacting Teresa Gabrish at (405) 824-9681 or email tgabrish@gmail.com.

Please submit form with payment made payable to Saltfork Craftsmen.

Pre-Registration is required to allow for an accurate meal count.

Availability of meals will not be guaranteed to those registering day of the conference.

Cost

Registration (Per Family)

Saturday & Sunday	\$55.00
Saturday Only	\$35.00
Sunday Only	\$35.00

There are limited opportunities for dining in the Sulphur area. We have arranged for Saturday Lunch, Saturday Dinner and Sunday Lunch to be prepared on site. Lunches will be stews and dinner is BBQ. Meals for both days is \$25 per person. It is strongly urged that you register early so that we have a good count for meals.

Conference Location and Lodging:

The conference site this year is the Murray County Antique Tractor Association show grounds north of Sulphur, OK. The location is 7 miles north of Sulphur on Hwy 177 then east ¾ mile on Tractor Road.

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.

Thanks to SCABA Secretary Teresa Gabrish for putting the conference flyer together.

- Editor

2016 SCABA Conference Toolbox

The 2016 SCABA Conference is almost here! Please consider donating an item for the Conference Toolbox. The attached list is only a suggestion of possible items and a way to track the items for a more well rounded collection of tools. Feel free to make (or purchase) anything you think is appropriate. Think about tools and items you would like to win and it will probably be a good item. Any donation is appreciated but hand made tools will generally be more cherished by the box winner.

Tickets for a chance to win the box will be available up until the drawing at the auction on Saturday night. If you will not be able to attend the conference and want a chance to win the tool box while supporting the club, tickets may be purchased from the Secretary (Teresa Gabrish.) Tickets are \$2.00 each.

This year's box is an original design made and donated by Don Garner. He did an excellent job. The box is made mostly of pine with a hickory handle. There is a bottom section that is removable for storing measuring tools, finishing wax, etc. The bottom tray is held on to the main box by a unique locking system. Don hand made all of the hardware for the box except for the pyramid head screws.

Please consider donating an item to support this annual tradition!



2016 Saltfork Conference Tool Box

Suggested Items	Provided
Tool Box	Yes
1 1/2 lb. cross peen hammer	
2 1/2 lb. cross peen hammer	
Rounding hammer	
Handled hot cut	
File flat bastard cut	
File, half-round bastard cut	
Farrier's Rasp	
Hacksaw	Yes
Rivet backing tool for 1/4"	
Rivet setting tool for 1/4"	
Rivet backing tool for 5/16"	
Rivet setting tool for 5/16"	
Rivet backing tool for 3/8"	
Rivet setting tool for 3/8"	
Scribe	
Center Punch	
Center Finder	
Dividers	
Tongs	
1/4 V-bit	
3/8 V-bit	
1/2 V-bit	
Scroll pliers	
Soapstone and holder	Yes
Abrasive block, small piece of grinding wheel	
Chisel, Large	
Chisel, small	
Metal folding ruler 24" or 72"	
Ball tool (round blunt nose punch)	
Hand held spring swage for tenons	
Hand held swage for necking down	
Set of monkey tools (1/8", 3/16", 1/4")	Yes
Adjustable square	
Bending forks	
Flux spoon	
Flux	
Twisting Wrench	
Hot cut hardy	
Hot slit chisel	
Bolster plate	
Finish wax	
Fire Tools	
Shovel	
Rake	
Poker	
Multi Square	
Nail Header	Yes



2016 SCABA Conference



**Hands On Workshops October 17, 18 and 19th
with Peter Ross and Jymm Hoffman After the Conference**

**** UPDATE ****

Workshop Openings: The Peter Ross workshop is currently full but there are some openings now available in the Jymm Hoffman workshop. Hoffman projects are still to be determined but may include skillet and shovel making, candle chandelier and musket tool. Participants are first come, first served and must call or e-mail Doug Redden to register. Contact Doug to check on the status of any remaining positions or to get on a standby list. Doug's e-mail:

Doug.redden2@att.net

This is an amazing opportunity to receive hands on instruction with instructors of this caliber.

Forging Stations: Participants must provide their own (or arrange to borrow) safety gear and forging stations including anvil, forge, vice, and basic forging tools such as hammers, tongs, chisels, and punches etc. Specific tooling requirements for any tools that will not be provided will be made available before the workshops. A limited number of forging stations can be made available if you are flying in or do not have your own forging equipment. This equipment will be made available on a first come first served basis. If you are not attending the workshops but have a Saltfork swage block with a stand you wouldn't mind loaning, it will help out. Contact Doug Redden to coordinate.

Workshop Cost: Cost for a workshop is \$300 per student. Three meals per day for each of the three workshop days will be available at cost. The food will be purchased wholesale and workshop participants will be able to split the actual food cost. The expected cost will be around \$30 for the three days. Registration fee will need to be paid in full within 21 days of registration or you may lose your place in the workshop. Cancellations will be accepted for a 50% refund up to September 19th. After that, the registration fee will be non-refundable. Send registration fee to the Secretary, Teresa Gabrish.

Scholarships: There are scholarship funds available to cover up to 50% of the cost of the workshop and meal cost. This money is available to Saltfork members in good standing. Refer to the scholarship application on the website if you wish to apply.

If you have registered for the workshops, additional details will be provided as available.

If you have any questions, contact **Doug Redden at 918-230-2960.**

Making Scissors

By Mike Briskin

Here's my process for making scissors. Feel to free to improve on it is you see fit – I'm sure there's plenty of room! I'll try to describe the steps as clearly as I can, but before you start, find a pair or three of scissors and examine them closely. Most conventional scissors are pretty similar in form, even though they come in different shapes and sizes. There's not much point in trying forge the cheap new scissors with flat stamped blades and plastic handles, so don't examine those.

I start with two pieces of steel. I've been using 4" pieces of coil spring stock about 5/8" in diameter, which makes a medium-size pair of scissors. That's what the dimensions in this article will be based on. For simplicity, I'll just describe the operations on one of the bars, but you should work both at the same time and keep them as similar as possible (like tongs, the two halves of scissors are identical, not mirror images).

The first step is to taper one end of the bar – this gets some of the heavy drawing out of the way before the more delicate operations. I start the taper at the middle of the bar, and bring the end down to about 1/4" square. Don't go much further than this or you may find that you don't have enough material at the tip of the blade.

I then start the handle by slot punching the other end. I use a punch about 3/4" wide and set it about 1/4" in from the end. Try to keep the punch centered in the bar, but this isn't especially critical. Once I have the slot punched, I forge the sides most of the way back in to make it easier to handle the piece later.

Next, turn the piece 90 degrees and fuller just below the slot. The fuller establishes the sloping shoulder at the top of the blade. The fuller I use is made from a piece of 9/16" diameter lug wrench; I guess that makes it a 9/32" fuller. Looking down on the piece before the first hit, the end of the slot should be about 1/8" beyond the body of the fuller. I drive the fuller in about half-way, leaving about 1/4" of material. This will become the shank at the bottom of the handle.

After this, I form the angled step at the base of the handle shank using half-facing blows over the far side of the anvil. To do this, I first mark 45 degree angle across the anvil face with a combination square and soap stone. To make right-handed scissors, the mark



should cross from near left to far right (you could make left handed scissors by using the opposite diagonal). I align the piece with this mark, with the punched slot and most of the fullered notch extending beyond the far side of the anvil, and the notch facing toward the anvil. I set the material down until about 3/16" or a little less remains at the base of the step. If you've done this right, the notch and the step should meet to form an inverted vee across what will be the top of the blade.

Next, I forge the blade to profile and thickness. I keep the thickness approximately constant from the step to the blade tip; the profile should start to taper maybe an inch below the notch, and form a point at the tip (unless you want round-nosed scissors). The inner side of the blade (the one with the step) needs to end up flat, so I work with that side against the anvil to avoid hammer marks. I do not bevel the blade at this point.

Now its time to turn back to the handle. I drift the slot to 1/2" and then 3/4", and then start working it over the horn to expand it further to form the handle. At the same time, you'll need to rotate that handle around the notch. This is a little difficult to explain, but if you look at a pair of scissors, you'll see that the handle extends to the side of the blade opposite the shoulder. At this stage in the process, though, the handle will be mostly on the side with the notch -- the wrong side. The best way I've found to address this is to slip the handle over the horn, and, holding the blade horizontal with tongs, hit the down on the shank with the cross peen. You'll probably have to do some tweaking to get the handle properly aligned.



Once the handle is drawn out and roughly aligned, I round up the cross section using the horn and the face of the hammer. Go gently here – it's easy to get cold shuts on the inside of the handle. It's okay to leave some file work for later. I then tap handle into final shape and alignment. In the end, the inside portion of the handle should align

with the center of the blade, but I leave the handle slightly toward the outside of the scissors at this point.

After this, I bevel the blade. The bevel goes on the same side of the blade as the handle is now on. On most scissors, the bevel ends in a little step a just below the pivot. It's hard to forge this little step without dinging up the flat side of the blade; I just get as close as I dare with the face of the hammer and file the step in later. Remember, they call them "shears" for a reason – you're not looking for a knife edge. I forge the cutting edge down to about half of the original thickness of the blade. The blade will curve into a banana; just turn it on edge and straighten it back up.

No matter how careful I am beveling, the bottom (inside) of the blade always seems to become convex. This is not what you want. I flip the blade over, set it on a block of wood, and carefully go down the center with my cross peen. Make sure you stay away from the edges. This forces the center down and makes the blade flat or a little concave. I then flip the blade back over and flatten it against the anvil. This is an important step, and I'll take two or three heats if necessary to get the blade as flat and straight as possible.

Once the forging's done, I anneal the blade. There are probably better ways, but I put it back in the forge, shut the forge down, and plug up the vents with a little kaowool. The softer you can get the blade the better, because this will make it easier to tweak it cold if you didn't get it quite straight.

Once the blade is cool, I go to a 60 grit belt on my grinder. I generally clean the step at the bottom of the handle a little with a file, then grind the shoulder on the opposite blade down to match. Once I have the joint meeting up properly, I clean up the blade profile, making sure the tips match with the blades closed. I grind the cutting edge to a 75 degree included angle. At this point, I also file in the little step at the top of the bevel, and then grind the length of the bevel smooth. I also clean up the handle as necessary – a half-round file works well inside the loop.

As I suggested before, if the scissors are going to work right, the inside of the blade needs to be perfectly flat (or slightly concave). I can't achieve this by grinding against the platen, and with a 5" contact wheel, my grinder isn't really suitable for hollow grinding. The only way I've found to make the scissors work right is to grind the blade lengthwise on the contact wheel, using the crown of the wheel to relieve the center a little (or at least compensate for my imprecision).

If I find a kink or twist in the blade as I grind, I correct that cold. You'll notice that, viewed on edge, most scissor blades curve slightly toward each other; I put this curve in after grinding. Usually just holding the handle, resting the tip on the workbench, and tapping on the center of the blade will do the trick.



Once the grinding's mostly done, I drill and tap for the pivot screw. I've been using 10-32 screws with slotted flat heads. Just don't get carried away with making the blades identical and drill clearance holes on both sides! With the screw in, I test the scissors on cloth. If the cloth doesn't shear cleanly, the inside of the blades almost certainly isn't flat. Back to the grinder.

Once I'm happy, I clamp the scissors in the vise with the screw still in, heat the shanks with a torch, and adjust the handles so they meet properly. (Remember, I left them slightly outside the center line before – this keeps them out of the way when fitting up the scissors.) I also like to run the torch around the rest of the handles to scale them back up where I filed and ground.

I then remove the screw and (when I remember) coat the inside threads with white-out to protect them. With that done I heat the blades individually and quench them in oil, then temper to straw or bronze over a hot block. I heat and quench the entire blade, mostly because I like the burned oil finish this leaves on the handle. I try to temper the handles back pretty soft, though.

After the heat treat, I go back over the blades with a 400 grit belt and test the scissors again, flattening the inside of the blades more if necessary. When everything's right, I adjust the screw to be just a little loose, grind the end flush (I use a small carbide burr to avoid grind marks on the surrounding metal), and center punch the end to spread and lock it. It's important to leave the screw a little loose because it tends to upset and tighten when you punch it. I try to spread it enough that it won't turn on its own, but not lock it so tight it can't be adjusted later.



This article is re-printed courtesy of the Blacksmith's Guild of the Potomac Newsletter, September/October 2009 - Editor

SCABA Shop and Swap

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. 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.

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 (SCABA Member)
Piedmont, OK
Cell Phone: 405-630-7769
Call or Text



4" Post Vice (Very Good): \$125



Peter Wright Anvil 80 Lbs: \$400

Continued...

For Sale (Continued from Previous Page):



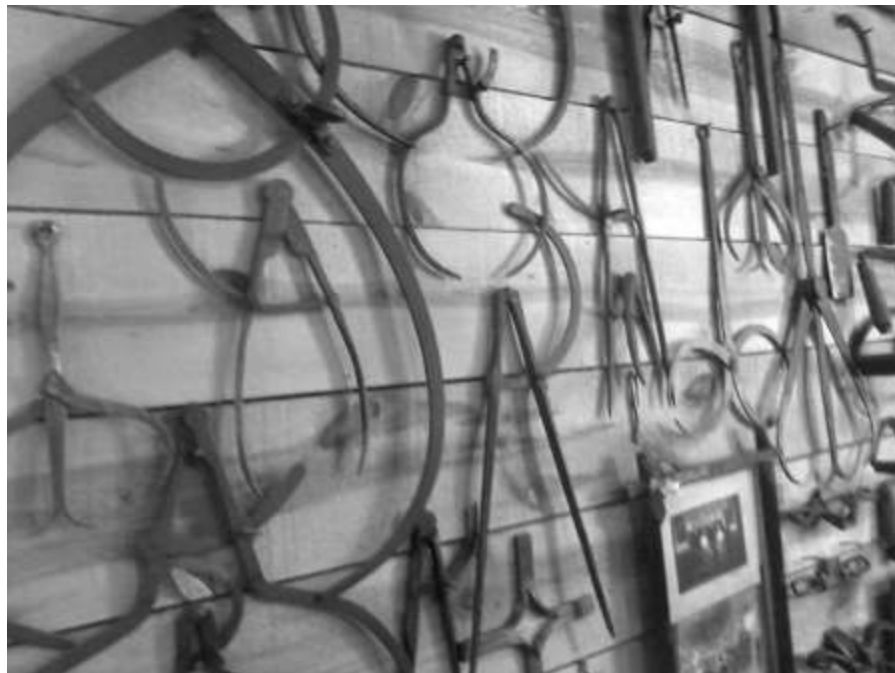
Stanley Planes, many sizes all in working condition. Starting at \$25



Pre-Civil War Wood Working Tools. Starting at \$20

Contact:

Craig Guy (SCABA Member)
Piedmont, OK
Cell Phone: 405-630-7769
Call or Text



Antique Blacksmith Made Tools. Starting at \$25

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)

For Sale:

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

Antique bellows \$425

Sheet metal roller \$175

Sheet metal shear \$175

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.



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...)

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 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.

NW Region Coal Pile in Thomas:

Don Garner now has a new pile of club coal available for sales to SCABA members. The shop is at 23713 E 860 Rd in Thomas, OK. (One mile west, then one mile north of Thomas.) Contact Don at 580-661-2607 to arrange details for purchases.

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.

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

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.



Wanted:

Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or

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, 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, P.O. Box 18389, Oklahoma City, Ok. 73154



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.
P.O. Box 18389
Oklahoma City, Ok. 73154

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