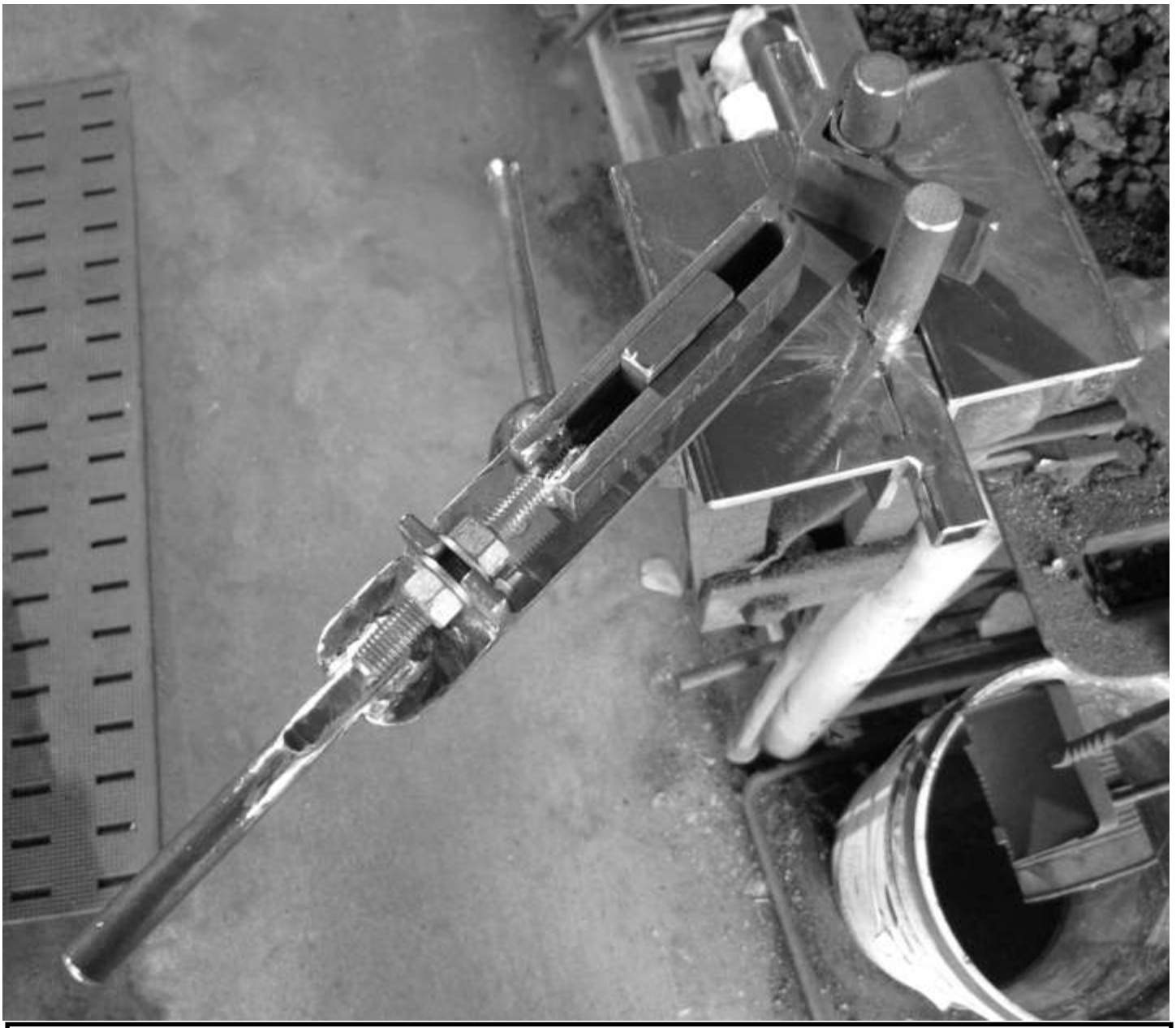
Saltfork Craftsmen

Artist-Blacksmith Association

February 2018



Adjustable Bending Fixture by Jim Carothers

(See Page 22)

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Don Garner 580-302-1845
23713 E 860 Rd
Thomas, OK 73669
Call or Text

Editors notes…

It won't be long before we turn the corner from bitter freezing cold weather and extreme hazard burn bans to mild spring days and green grass again. As always, the level of smithing activity, meetings, demos, etc. will ramp up. And a lot of interesting items will be made.

You may have noticed a "Member's Gallery" in this and last newsletter showing miscellaneous projects done by our members. Actually it has been hit and miss for some other newsletter issues as well depending on the pictures sent in to include. The member's gallery concept is one that a lot of other blacksmith organizations also do with mixed degrees of success.

If you are working on a project (or if you are watching someone work on one) that doesn't fit in with the regular regional meeting activity please consider taking a few pics to send in for the gallery. The pictures I usually receive only represent a small amount of the activity that is really happening at any given time. And most smart phone cameras have reached a point of being just fine for pics used for online viewing or printing in publications like this one.

A quick snapshot of a project, or even a tool you used to make a project, is probably more inspirational and interesting that you may realize.

- Russell Bartling - Editor

SCABA Memberships Expire in March, Please Remember to Renew for 2018/2019 if you Haven't Already.

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.

Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org

President's Notes:

Why can't we make tongs?

I hear a lot of smiths say, "I can't make tongs." I have said it myself. Those words, I think, are the biggest reason why we can't make them. I have seen all kinds of beautiful things that folks have made that must have been a lot harder to make than tongs.

Surely the first time some of these things were tried, they ended up in the scrap pile. My first Russian rose got rolled up twice, since the first time I rolled it up from the wrong end! Did your first forge weld work? How pretty was your first "S" hook? Have you ever bent the hook on a steak turner the right way on the first try? Bill Davis most likely made more than one tomahawk before he had one he was proud of. Even Peter Ross surely didn't get a perfect compass on the first attempt. Remember your first knife looking thing? Hard as it may be to believe, I am sure that Mark Aspery wasn't always incapable of hitting something in the wrong place.

So why can't we make tongs? I think it's because we tell ourselves that we can't.

I have been told that a large percentage of being able to forge weld, is believing that you can. And I believe that is right! If you try as hard to make tongs as you try on other things, then don't you think that you really can't help but to get rather good at making them? They are just like everything else we make. All it takes is practice, and believing you can.

Happy hammering! -Byron

My First Pair of Tongs!

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.

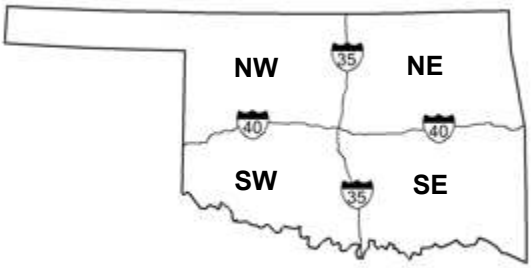
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the 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

What's My Region?

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 if I40 and west of I35.)

All meetings are encouraged. 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. Not all meetings fit precisely within a rigid boundary definition and members in an area may want to hold meetings on a date that doesn't match their physical region or at 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. Special events such as shows, fairs, etc. may also dictate adjustments to the meeting dates within a region.

SCABA Regions



The regions 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.

Safety

Blacksmithing can be an inherently dangerous exercise. There is no substitute for personal responsibility and common sense and no list of safety rules can adequately cover every situation. Every person who attends a meeting, demonstration or event sponsored by the Saltfork Craftsmen Artist Blacksmith Association (SCABA) or its members does so at their own risk and assumes all responsibility for their own safety needs. The SCABA organization, its officers, members, demonstrators, volunteers and guests disclaim any responsibility for any damages, injuries, or destruction of property resulting from the use of any information or methods published or distributed by SCABA or demonstrated at workshops, meetings, conferences or other events. SCABA recommends proper attire and safety gear and standard shop safety procedures appropriate for blacksmithing and shop work during any event where blacksmithing and other related methods are involved. Safety attire includes, but is not limited to, appropriate clothing, eyewear, hearing protection, gloves, and face shields when appropriate. It is every individual's responsibility to provide for their own safety, to determine what safety gear is appropriate for each situation and to provide, maintain and use that gear as appropriate for each individual situation.

Demonstrators Set for 2018 SCABA Conference!

JJ McGill has secured commitments for two demonstrators for the 2018 SCABA Annual Conference. This year, we will have Bob Bergeman and Pepe Gomez.

Bob Bergeman is well known for a variety of forging techniques with a focus on using power hammers.

Pepe Gomez is well known in the knife making circles for his amazing pattern welding (aka “damascus”.)

As we have done for two years now, there will be workshops with these demonstrators following the conference. More information and details will be provided when available so stay tuned!

Saltfork Has a New Librarian

Don Garner (Thomas, OK) has accepted the role of the new Saltfork Librarian. He is just now getting set up with the inventory of library DVD masters but should be up and running soon.

Please contact Don Garner if you want copies of any library DVD’s:

580-302-1845
23713 E 860 Rd, Thomas, OK 73669
Call or Text

New Saltfork T-Shirt Manager Needed

Doug Redden would like to hand off the remaining inventory of Saltfork shirts to someone else. If you are interested in helping out the club by keeping the inventory and distributing the shirts, please contact Doug Redden at 918-230-2960 or contact any Board member for help in making arrangements with Doug.

Organic Metalworking Vol. 1

by Lorelei Sims

Limited Copies Available

Lorelei Sims has a great new book illustrating her methods for organic metalworking. (See details in the October newsletter, Page 35.)

Volume 1 is first in a series of planned books on different aspects of organic forging. This is a very good how-to book heavily illustrated and has something for beginning and advanced smiths alike.

Lorelei’s methods are easy to understand and execute but the finished work is beautiful (at least hers is beautiful!) You will probably want a copy of this book in your library. I highly recommend it.

Due to continued demand, we have second shipment of this book and Doug already has many of them sold. The price of the book through SCABA is the same as the price directly from Lorelei and proceeds from sales benefit SCABA. Contact Doug Redden if you would like to purchase a copy. *- Editor*

2018 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 6th (Open)	Jan 13th (Open)	Jan 20th (Open)	**Jan 27th (Monte Smith)**
Feb 3rd (Bill Kendall)	Feb 10th (Open)	Feb 17th (Open)	**Feb 24th (Rory Kirk)**
Mar 3rd (Open)	**Mar 10th (Bruce Willenberg)**	Mar 17th (Open)	**Mar 24th (Mandell Greteman)**
Apr 7th (Open)	**Apr 14th SCABA Picnic**	Apr 21st (Open)	**Apr 28th (Bob Kennemer)**
May 5th (Open)	May 12th (Open)	**May 19th (JJ McGill)**	**May 26th (Don Garner)**
Jun 2nd (Open)	**Jun 9th (Ronnie Smith)**	**Jun 16th (Ricky Vardell)**	**Jun 23rd (Terry Kauk)**
Jul 7th (Open)	Jul 14th (Open)	Jul 21st (Open)	**Jul 28th (Chris Zornes)**
Aug 4th (Open)	Aug 11th (Open)	Aug 18th (Open)	**Aug 25th (Roy Bell)**
Sep 1st (James Shaefer)	Sep 8th (Open)	**Sep 15th (Ricky Vardell - JJ McGill - Sulphur Tractor Show)**	**Sep 22nd (Don Garner)**
Oct 6th (Conference Set up Work Day)	**Oct 13th (Conference Weekend!)**	Oct 20th (Open)	**Oct 27th (Corey Spieker)**
Nov 3rd (Open)	**Nov 10th (Bill Phillips)**	Nov 17th (Open)	Nov 24th (Open)
Dec 1st (Open)	Dec 8th (Open)	Dec 15th (Open)	Dec 22nd (Open)

2018 Fifth Saturdays:

March 31st (Beginner Blacksmithing Workshop - See Workshop Schedule)
June 30th (Open)
September 29th (Open)
December 29th (Open)

2018 Workshop Schedule

Beginner Blacksmith Workshop - March 31st (Fifth Saturday in March): To be held at Byron Doner's shop. 6520 Alameda, Norman OK 73026. Contact Mandell Greteman to register.****UPDATE** This Class is CURRENTLY FULL. To get on a waiting list CALL Mandell (Phone Calls Preferred over e-mail)**

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.

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

February 2018

NE Regional Meeting February 3rd : Will be hosted by Bill Kendall at his shop. The address for Bill's shop is 5245 South Peoria, Tulsa OK 74105. It is located behind "Anna & June's Beauty Supplies on South Peoria.

The trade item is a heart (Because it's February). Lunch will be provided but please bring a side dish or desert to help out. Contact: Bill Kendall 918-691-2173.

This is our first get together in a while so let's enjoy a good visit. If you made something neat bring it and show us what you made. Looking forward to visiting with you.

SE Regional Meeting February 10th: Open

SW Regional Meeting February 17th: Open.

NW Regional Meeting February 24th : Will be hosted by Rory Kirk at Mandell Greteman's shop in Foss, Ok.

The trade item is a five link forged chain out of 3/8" material with a forged hook on one end. *(By the way, Mark Aspery has a good video on Youtube on forging a nice looking hook. Search for Mark Aspery old school projects. He also has a good video on making chain… - Editor)*

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

Contact Rory Kirk at 580-497-6426 if you have questions.

March 2018

NE Regional Meeting March 3rd : Open.

SE Regional Meeting March 10th : Will be hosted by Bruce Willenberg at his shop located at 12250 Nelson Lane, Norman, OK 73026. Take Hwy 9 east from Norman to 120th St. Then go south 1.5 miles to Nelson Lane (old country dirt road.) Then go east 200 yards to first drive on the south. There will be signs.

The trade item will be something from the garden or orchard (apple, pepper, acorn, etc.)

Lunch will be provided (chili) but please feel free to bring a side item or dessert to help out.

Contact:Bruce Willenberg at 405-227-4547 or brskw1976@yahoo.com if you have questions

SW Regional Meeting March 17th: Open.

NW Regional Meeting March 24th : Will be hosted by Mandell Greteman at his shop in Foss, OK.

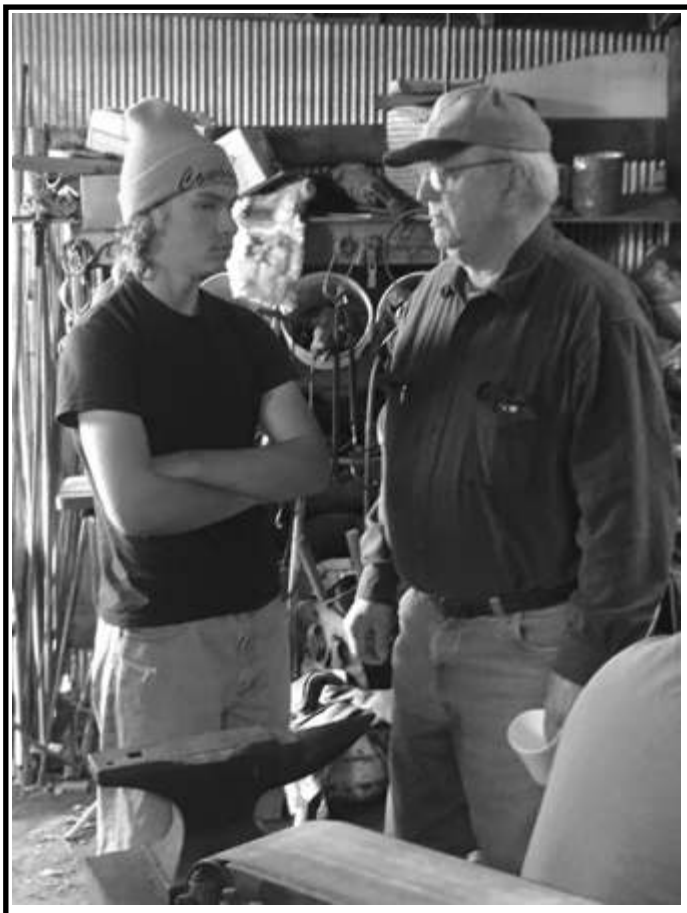
The trade item is a set of three different sized drifts.

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

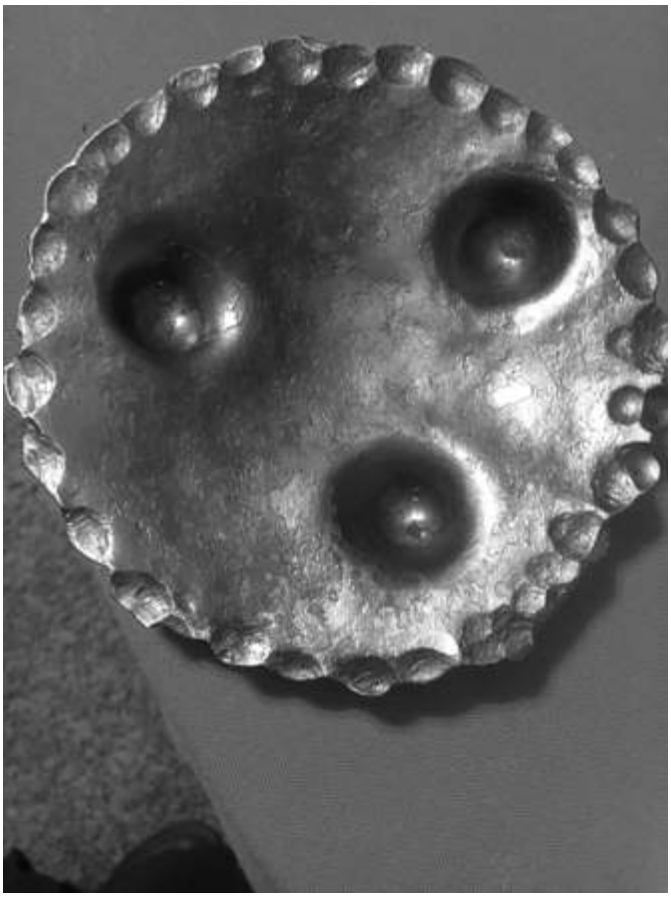
Contact Mandell Greteman at 580-515-1292 if you have questions.

Around the State…

NW Region December Meeting: The NW Region December Meeting was hosted by Mandell Greteman at his shop in Foss, OK. The trade item was a small bowl for pocket change, etc.




BLACKSMITH



Thanks to everyone who attended the meeting!

(Photos by LaQuitta Greteman)

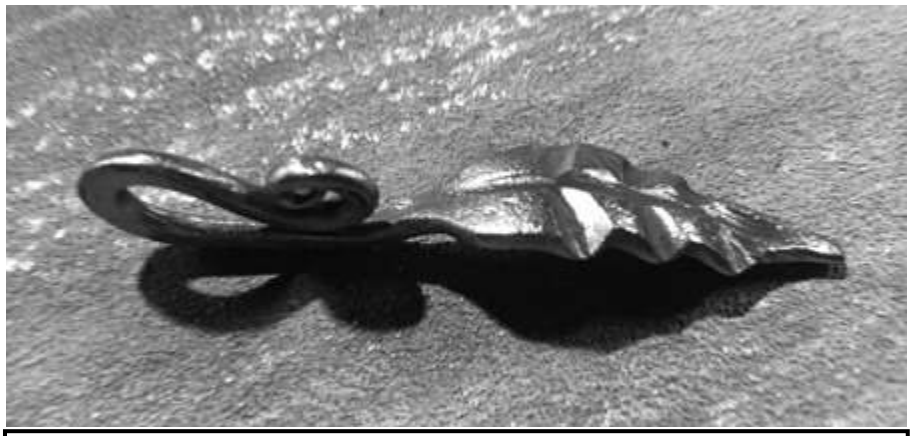
NE Region January Meeting: No meeting was held in January.

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

SW Region January Meeting: No meeting was held in January.

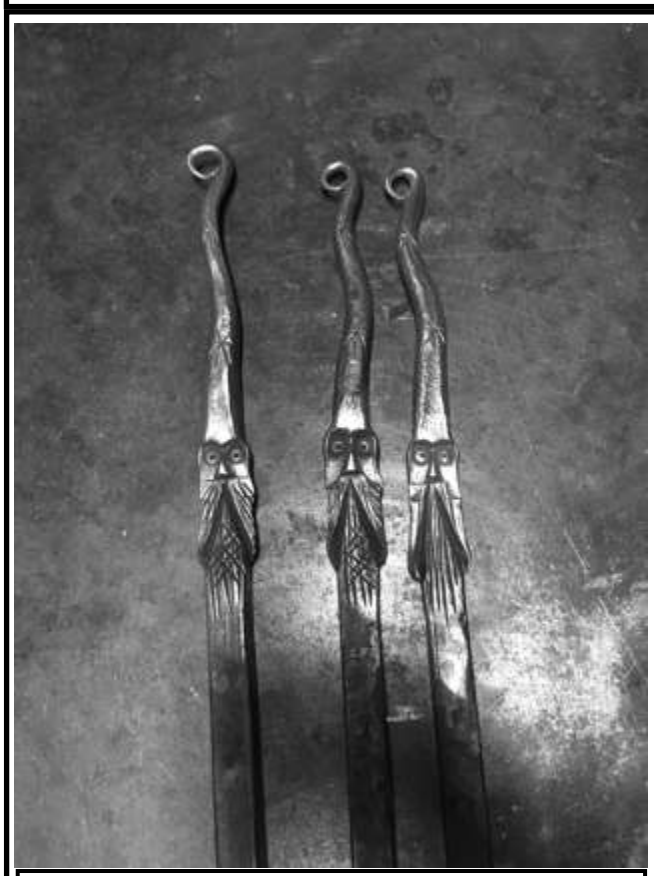
Member Gallery

Another Ornament by Rory Kirk…

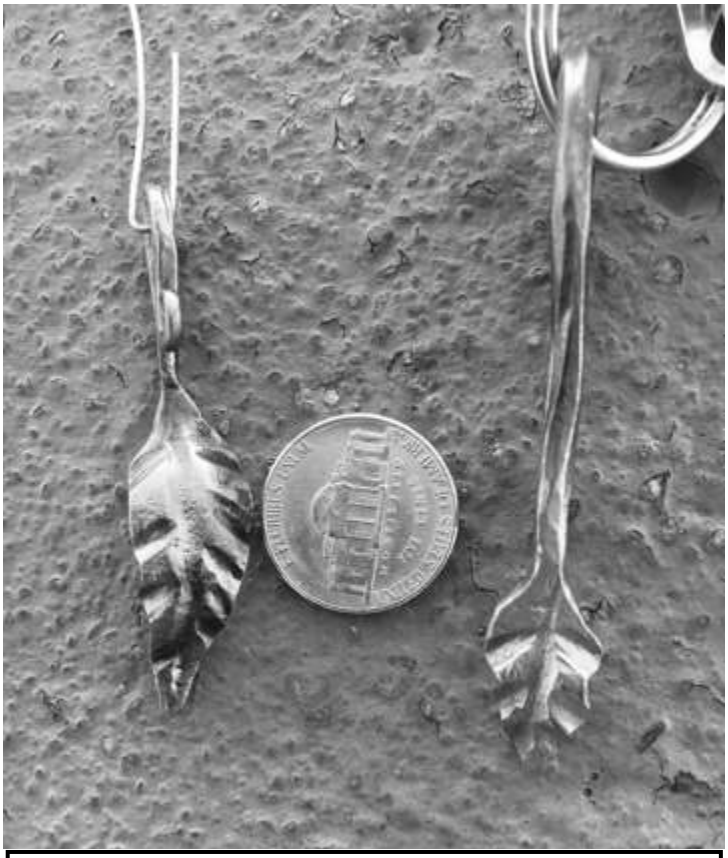


Lyle Wynn Style Leaf Keychain by LaQuitta Greteman…

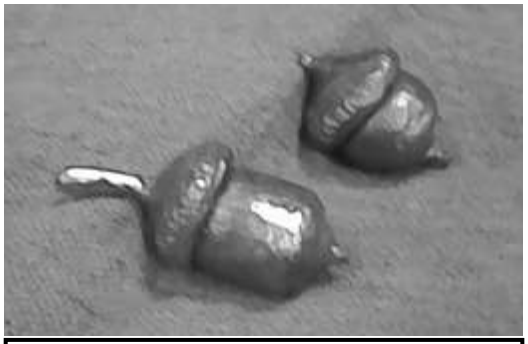
Member Gallery



More Wizard Head Steak Turners by Rory Kirk…



Small Lyle Wynn Style Leaf Keychains by LaQuitta Greteman…



Acorns by Bruce Willenberg (with Assistance from Byron Doner)…

LaQuitta Greteman at her first time learning to use the 100 Lb Little Giant…

Thanks Everyone for Sending Pics of Your Recent Projects! Keep Sending them! - *Editor*

Mark Your Calendars for the 2018 SCABA Picnic!

The Annual SCABA Picnic will be held in the southeast region this year on April 14th. Mark your calendars because the date will be here before you know it.

Bill Phillips is this year's host. The picnic will be held at Bill's shop at 14360 State Hwy 113 in Indianola, OK. Bill is working on details for a fun contest. Details to be announced. Look for more information in the March newsletter.

NOTICE! Membership Dues to Increase:

After many years of holding membership dues at the same level, the Board of Directors has voted to raise the membership dues from $20 per year to $30 per year. The increase in dues will be effective March 31st , 2018. Anyone who has already paid their dues by March 31st will not be affected until 2019. Also, anyone who has already paid for multiple years in advance will not be affected by the increase until all of their prepaid dues have all expired.

This increase is needed to cover a recent increase in printing costs per page for the newsletter and for insurance coverage costs. The printing cost increase is not related to the increased number of pages in recent issues over past issues but is related to increasing costs in the printing business in general. Our printer has done a great job of holding costs level for years and, even with the increase, is still very competitive in the market.

Even after the increase, the $30 membership to SCABA represents a tremendous value. There is hardly a better way to network with like minded people and advance your knowledge on your journey through the blacksmithing experience.

Call for Nominations:

It is time to elect new directors and/or re-elect current directors to the Board for a few positions. This year, there are three existing positions up for re-election:

Terry Jenkins, JJ McGill, Russell Bartling. Terry will be traveling and is not running again.

If you would like to nominate any other member(s) in good standing with at least one year of membership, please send in your nominations to the newsletter editor by February 23rd to be included in the upcoming ballot. Ballots will be included in the March newsletter and will include space for write in names. But for truly serious consideration, your nominee really should be in print on the ballot. The deadline for receiving ballots by mail will be announced in the March newsletter but the final day to submit votes will probably be April 14th at the SCABA Annual Picnic.

Please submit any nominations for director positions to the newsletter editor by February 23rd to be included on the ballot for the upcoming 2017 election.

Demo Request in Oklahoma City Area:

The Oklahoma Railway Museum is looking for a demonstrator or group of demonstrators for their train ride event in April. President, Eric Dilbeck, has even asked if someone would mind hosting a meeting at the event on April 7th (which actually coincides with the NE Region Saturday.) If you can demo at this event or would like to host a group of smiths, please contact Eric to make arrangements.

From Eric Dilbeck:

"The Oklahoma Railway Museum is hosting a steam engine in April for a train ride event. It is a coal fired saddle tank engine. I wanted to reach out to Saltfork and see if you would consider doing a demonstration during our event. I look forward to hearing from you."

Contact:
Eric Dilbeck
President
Oklahoma Railway Museum
3400 NE Grand Blvd
Oklahoma City, OK 73111
405.823.7986
eric@oklahomarailwaymuseum.org

Jigs & Tooling for Making a Small, Curved Lidded Chest

By Jennifer Horn, a MABA member
Photos and write-up by Steven Spoerre

Before the demonstration, Jennifer started with a slide presentation showing a variety of boxes, containers and vessels she had made and embellished. They ranged from the simple (a piece of structural tubing with a bottom welded in place and a fitted lid),

to a chisel decorated chest with hinged lid and lock made in a Tillers International class taught by Clay Spencer.

Photo by Jennifer Horn

Jennifer's demonstration showed some of the processes and jigs used for the major steps in making a rectangular chest with a curved lid. It was stated that the chest can be made without the jigs, but if more than a couple were going to be made, investing the time in jigs and tooling was advised.

The flat pattern for the bottom and four sides is first cut out of 14-16 gauge sheet metal, or again if a lot are going to be made, blanks can be ordered from a custom plasma cutter. Bevel the edges to the inside so they'll be square on the outside. Also put a small hole at the corner where the sides and bottom meet to avoid a wrinkle when they are bent.

To give the chest sides some visual interest, a coal fire scale texture was added. After the scale was removed from the blank the "outside" and bottom of the chest was sanded. Next the four bend lines were marked, and then scored on the inside of the chest, at the anvil.

The folds were made at the vise next, if the jaws are not smooth, cover them with aluminum or copper so the texture doesn't get marred. If the jaws are wider than one side of the chest, the two short sides are bent first, then the long sides, so the short sides will swing past the jaws and won't interfere with the bend.

Once folded, the sides can be squared up on the heel of the anvil and with a corner jig.

Angle iron pieces were riveted over the corners to cover up the splits between the sides. Commercial angle iron can be used, or if it's unavailable or not quite the right size, it can be made. Jennifer showed how a flat strip of stock was scored down the middle (like the bend lines were between the bottom and the sides), then folded to 90 degrees.

To add interest to the corner pieces, tooling was made to form two fullered lines on either side of the sharp outer corner of the commercial angle iron. (editor's note: the striking end of the tool didn't make it into the picture)

The legs have a flattened foot, and this jig could be used,

or the legs can be worked in the corner of the anvils step and against the anvil's side.

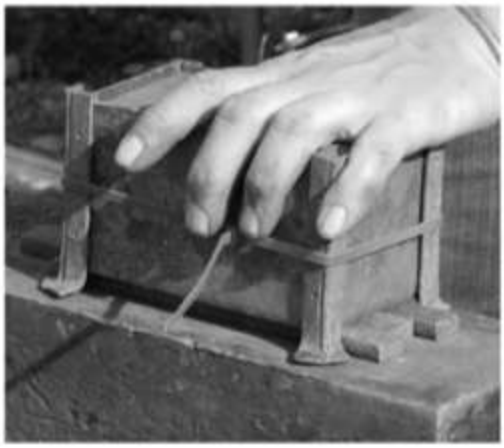
To form the curved lid, a jig was made that would push the flat piece of the lid material into a swage block feature. The piece is oversized all the way around because after the ends are flattened it will be trimmed to fit the opening of the chest.

Once the lid is curved, the jig is clamped in the vise and the lid is placed over it, a trimmed piece of pipe is then placed on top of the lid and clamped in place with locking pliers. A torch is used to heat the sides of the lid and they are beaten down against the jig. Don't worry about any wrinkles that form, just keep hammering against them until they flatten and blend into the end.

A curved piece of angle iron goes along each edge of the lid, so a jig was made to make the curve and keep the legs pretty close to 90 degrees. If the curve legs get out a bit, lay the vertical edge of the curve on the face of the anvil and tap the horizontal leg until it's parallel with the anvils face.

An insert is made to fit inside the box (with a finger access hole so it can be pulled out) so it will back up the sides when the corners are clamped to the chest.

Spacers are placed on a flat surface and under the chest bottom, then the corners/legs are tapped down to the surface so the chest will sit flat.



Mark the rivet locations on the legs at the same levels above the flat surface. Make sure that the rivet heads on the inside of the box won't hit, if they're close, stagger the locations. Remove the zip ties, drill the rivet holes, then reassemble and clamp everything back together again, placing it once again on the spacers. Transfer the leg holes to the chest sides, making sure to identify which leg goes to which chest corner. At this point the feet are on the flat surface and the chest will sit flat, but the top edges are mismatched. After its riveted together, the top will be leveled with a sander or grinder.

Rivet the curved angle iron pieces onto the curved lid, then trim/grind/sand the lid until it fits on the chest. Remember that the hinges will be mounted on the sheet metal that is inset from the corner angles, and the angle iron corners of the chest and lid will have to swing past each other. Offset or make the hinges that will allow the edges to clear, and then make a hasp and a handle to complete the chest.

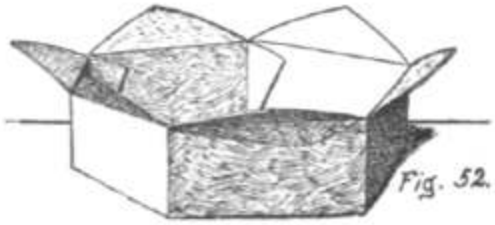
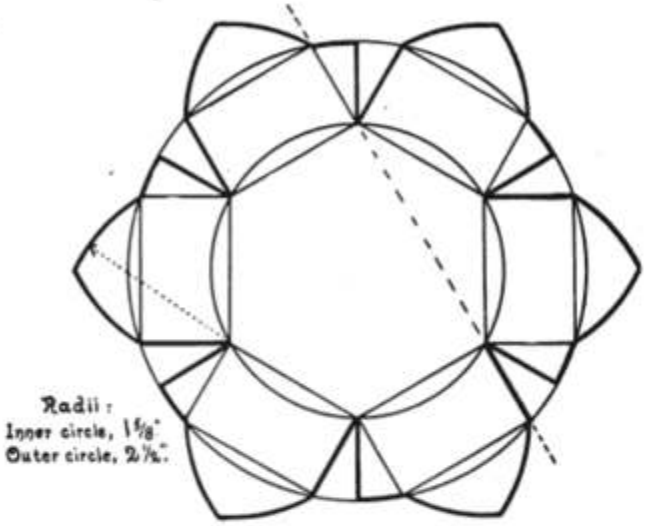


Fig. 52.



Editor's note: if you are interested in making other types and styles of boxes, there is a 1901 book available as a free download from Google books titled *First Years in Handicraft* by Walter J. Kenyon. There are patterns and sketches of the final containers, and though the projects are made for paper, they could be adapted to sheet metal and would use a lot of the techniques Jennifer demonstrated.

Fig. 75.

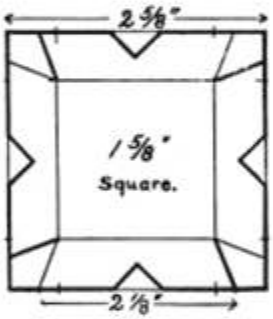


Fig. 77.

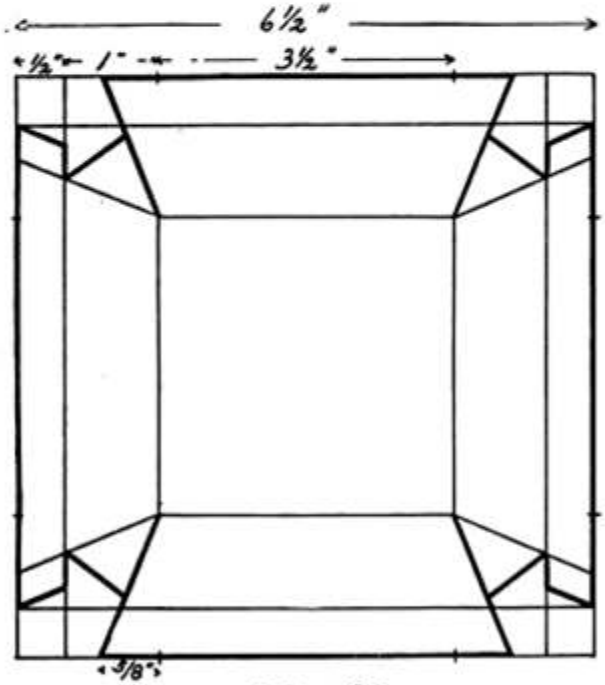


Fig. 82.

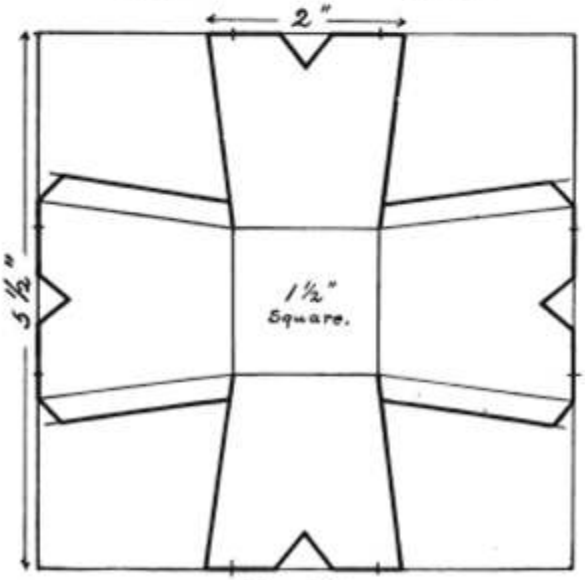


Fig. 76.

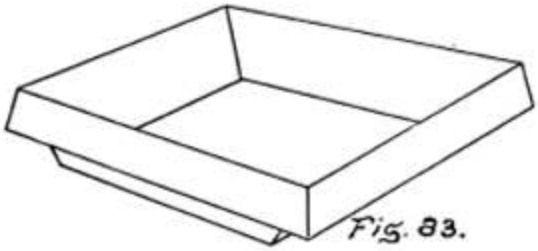


Fig. 83.

TRI CUP, MOUNTED

Figs. 56, 57, and 58.

Fig. 56.

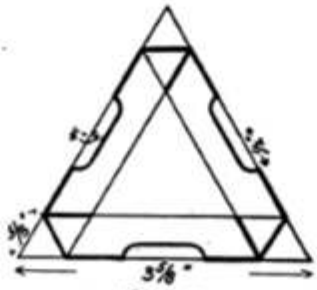


Fig. 58.

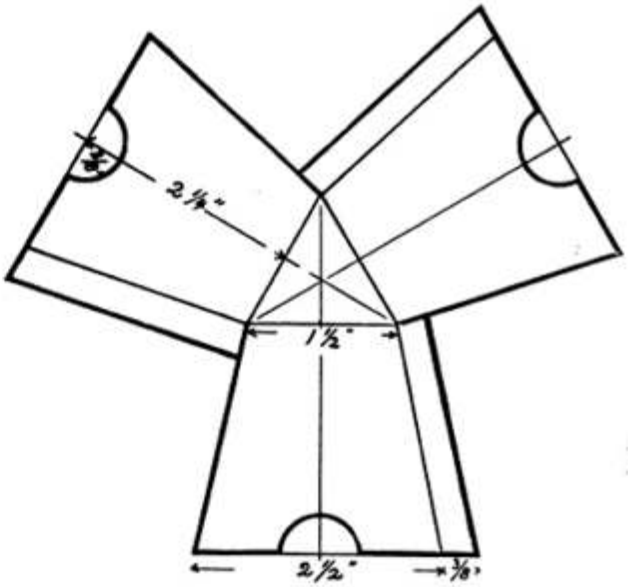
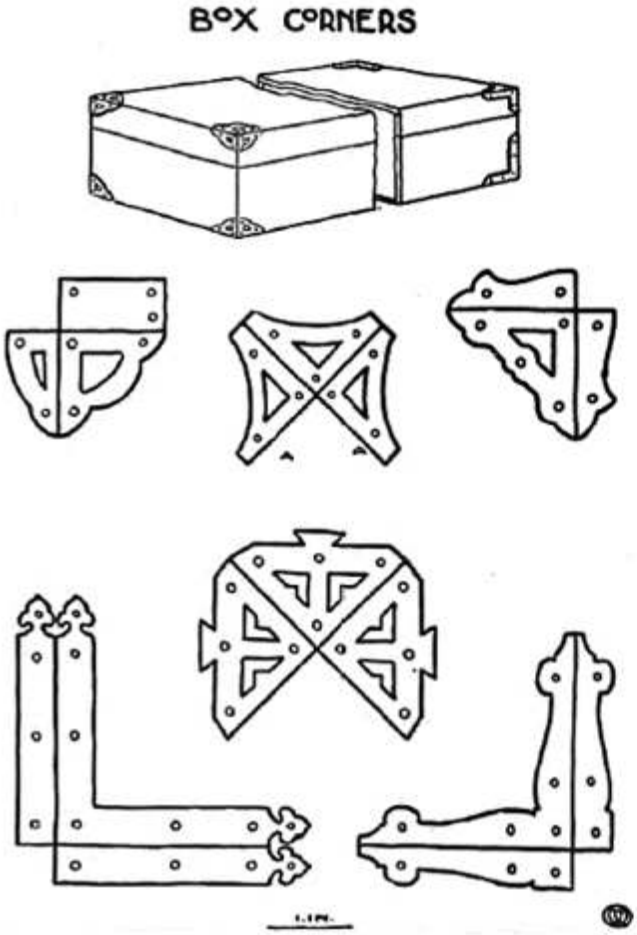
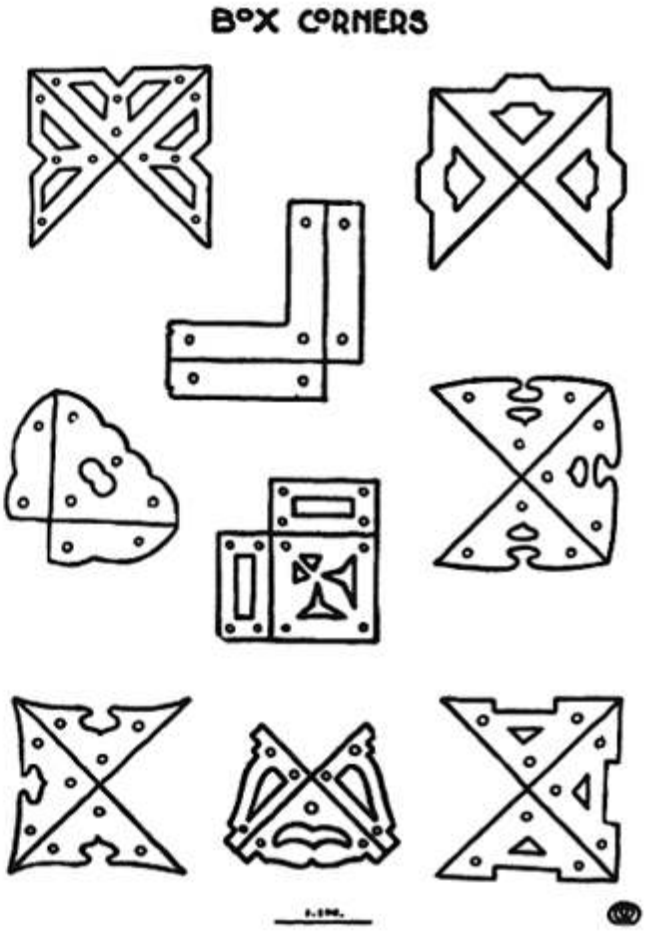
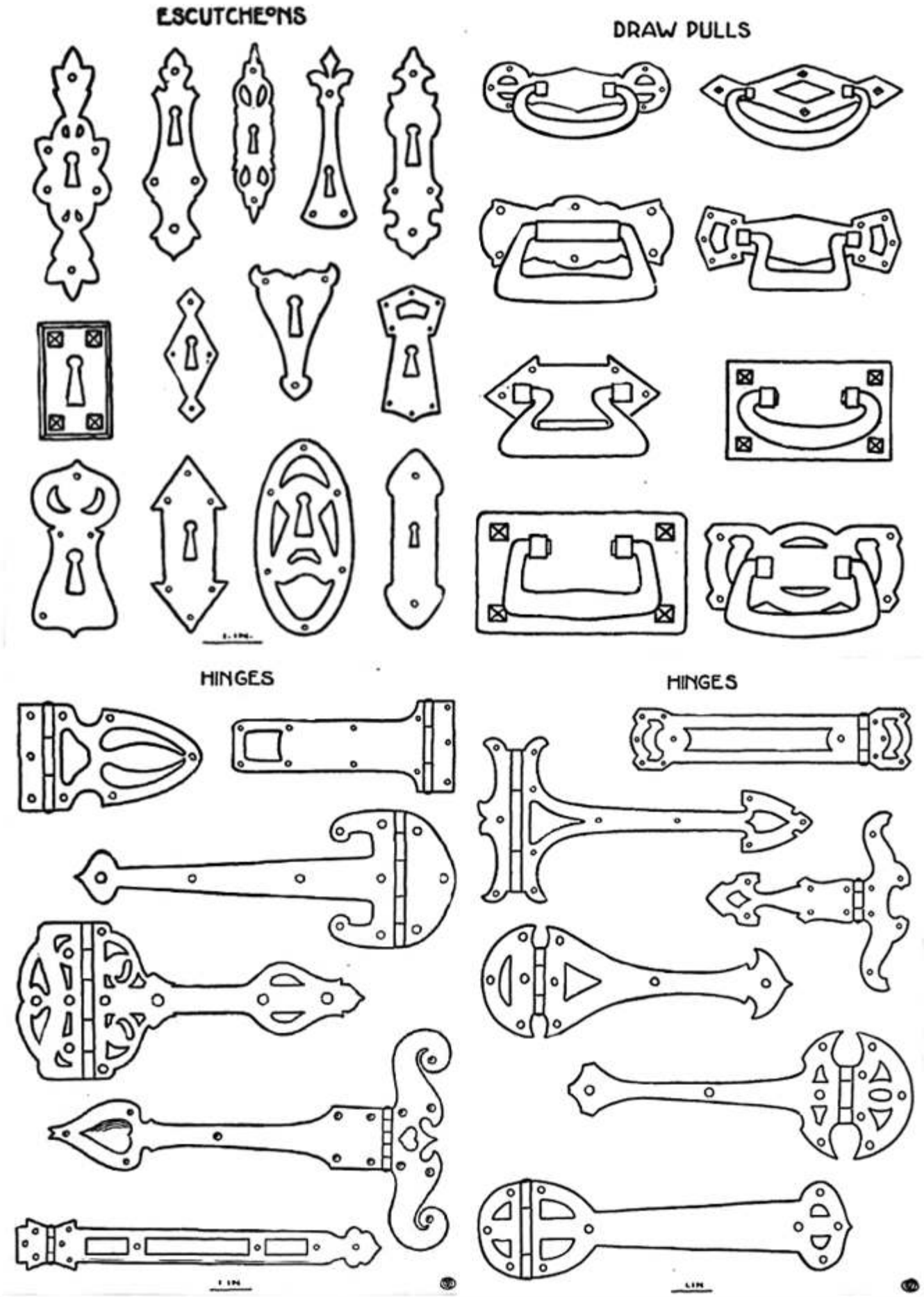


Fig. 57.

The following illustrations are from the Google book, *Copper Work*, by Augustus F. Rose
An Illustrated Text Book For Teachers and Students in the Manual Arts.
Rhode Island School of Design, Providence. 1908





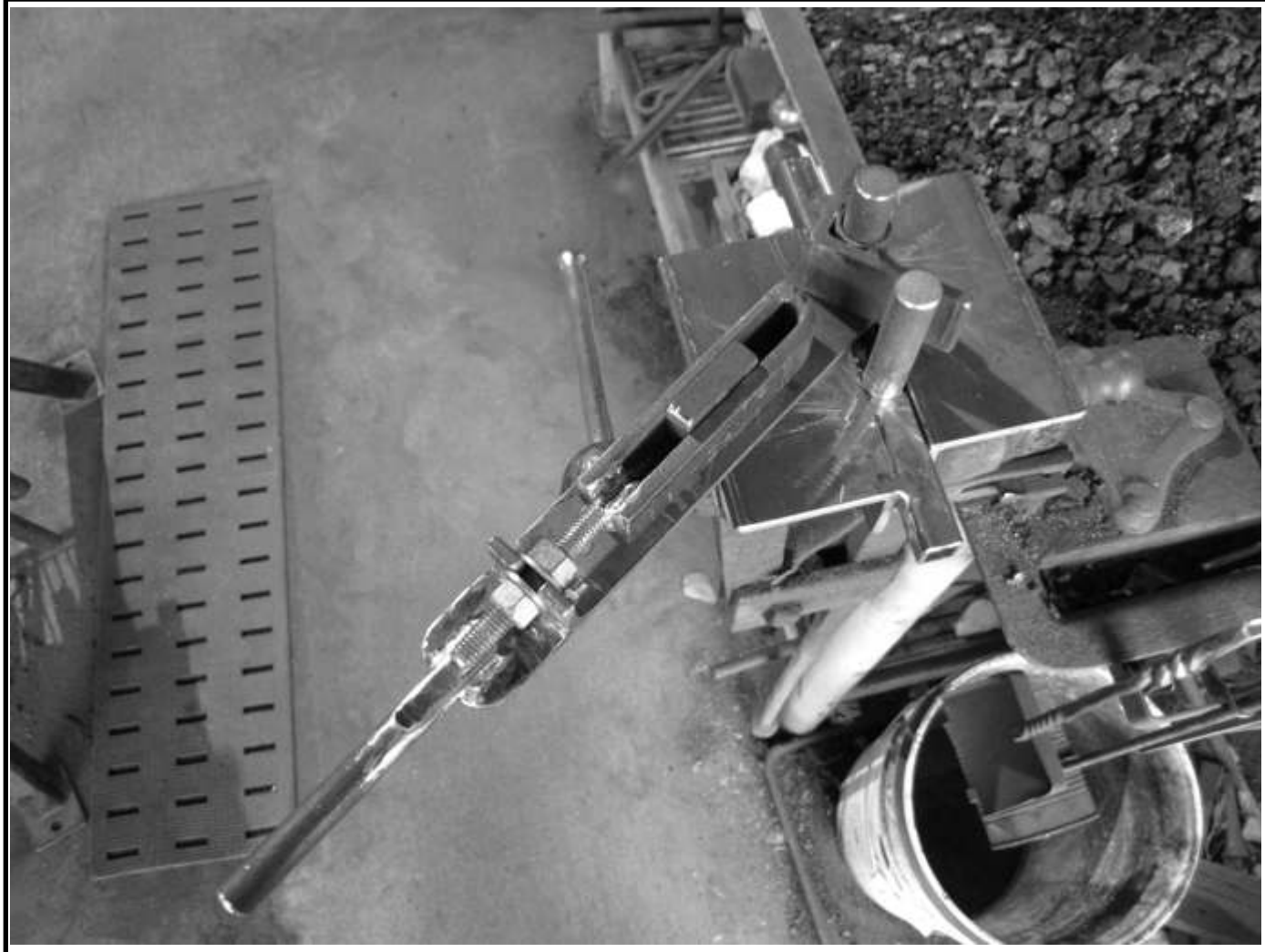


This six page article is re-printed courtesy of the Michigan Artist-Blacksmith Association, The Upsetter Newsletter, Jan-Feb 2018

Adjustable Bending Fixture

(Scrolling Pins)

By Jim Carothers 1-25-2018



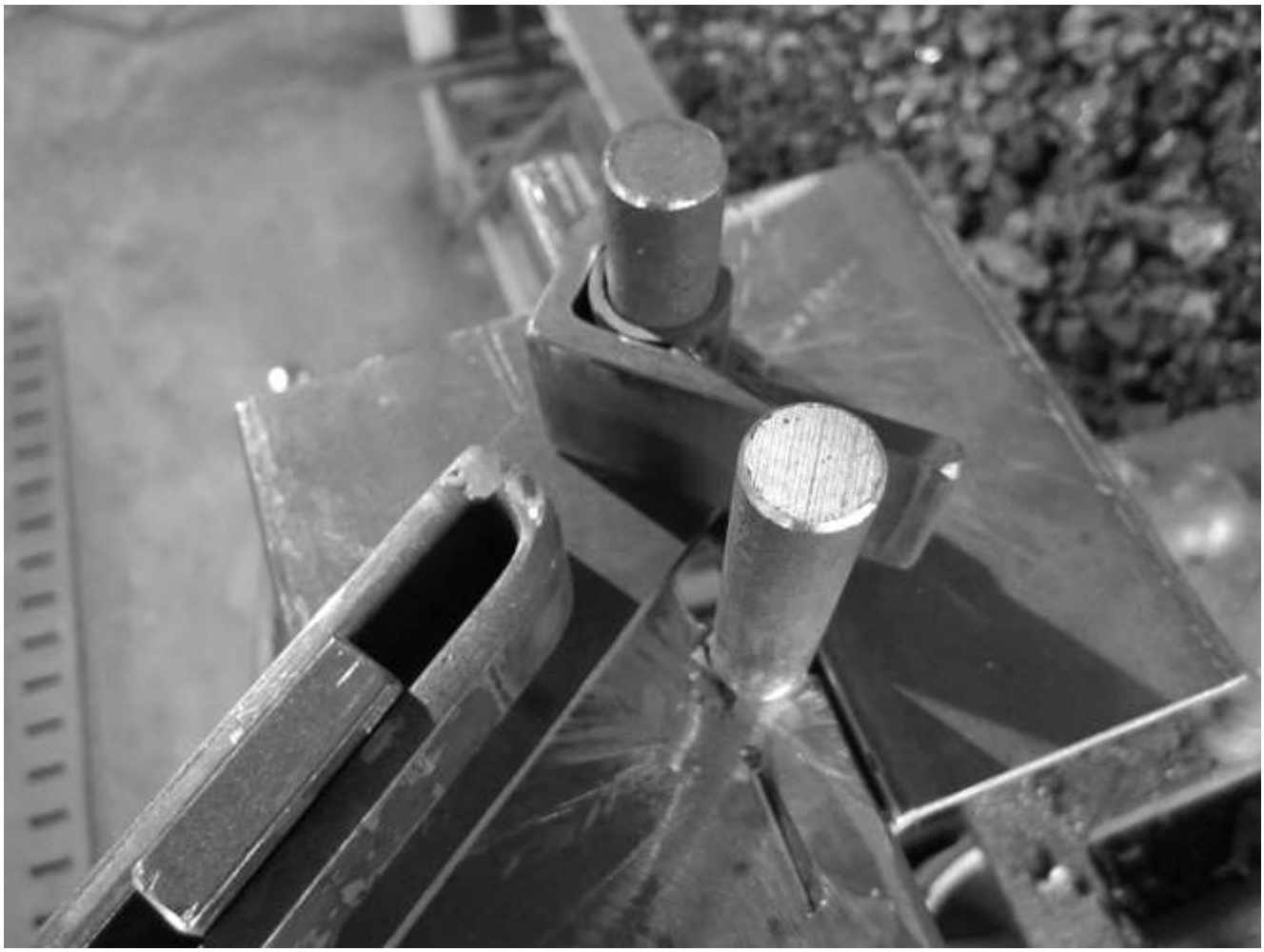
These photos show a bending fixture that allows the spacing of the pins to be adjusted to the job at hand. Like most things related to smithing, I had a good teacher for this tool – Saltfork Craftsmen member Travis Gabbard at the December 16th , 2017 meeting.

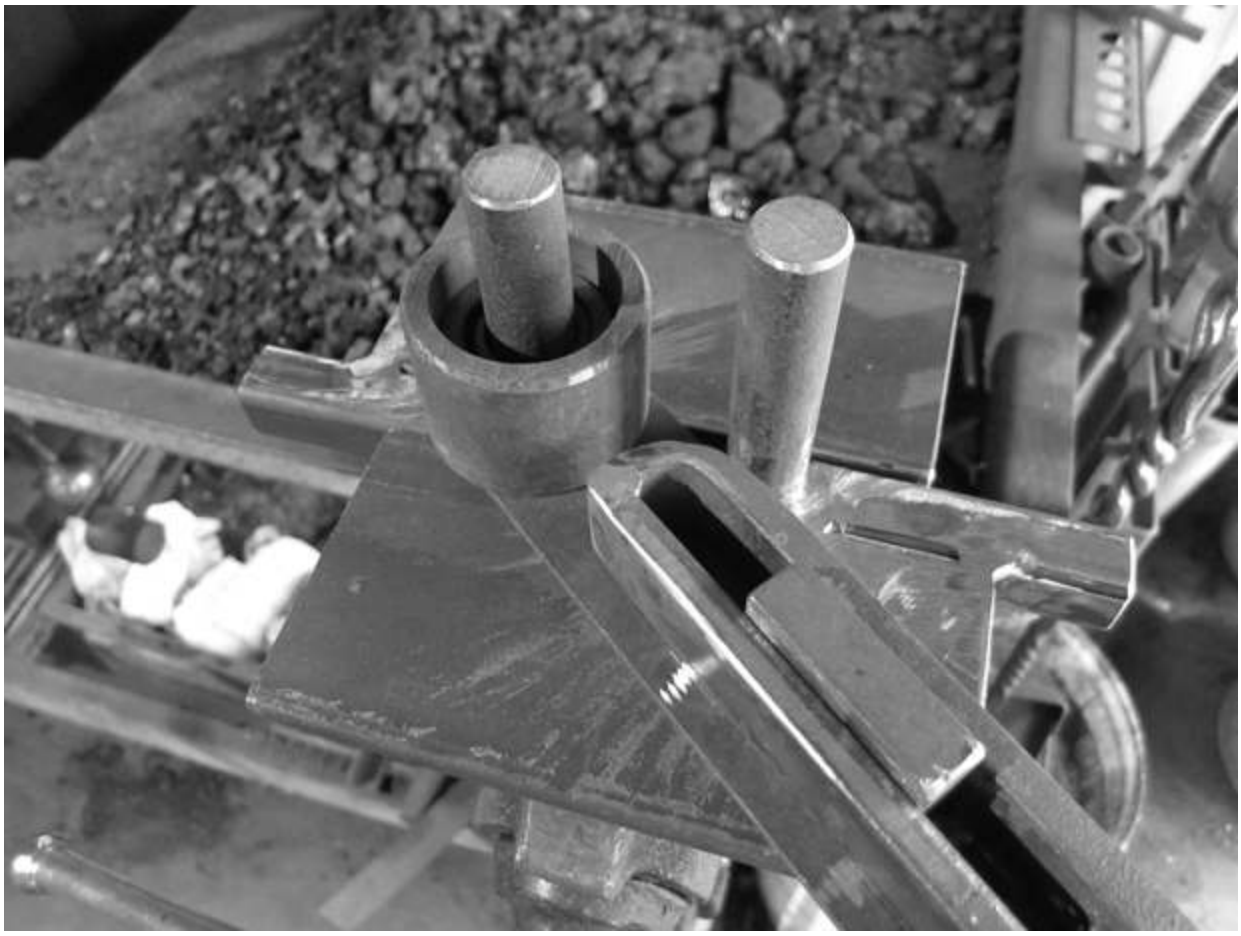
Like most of us in our home shops, I used scrap material that was on hand: angle iron 6” long for the base, 3/4" sucker rod 5” long for the pins, and 3/4" square tubing 3-1/4” long for the spacer. Note that one end of the 3/4" tubing spacer is cut at an angle to clear the weld of the pin to the angle iron base.

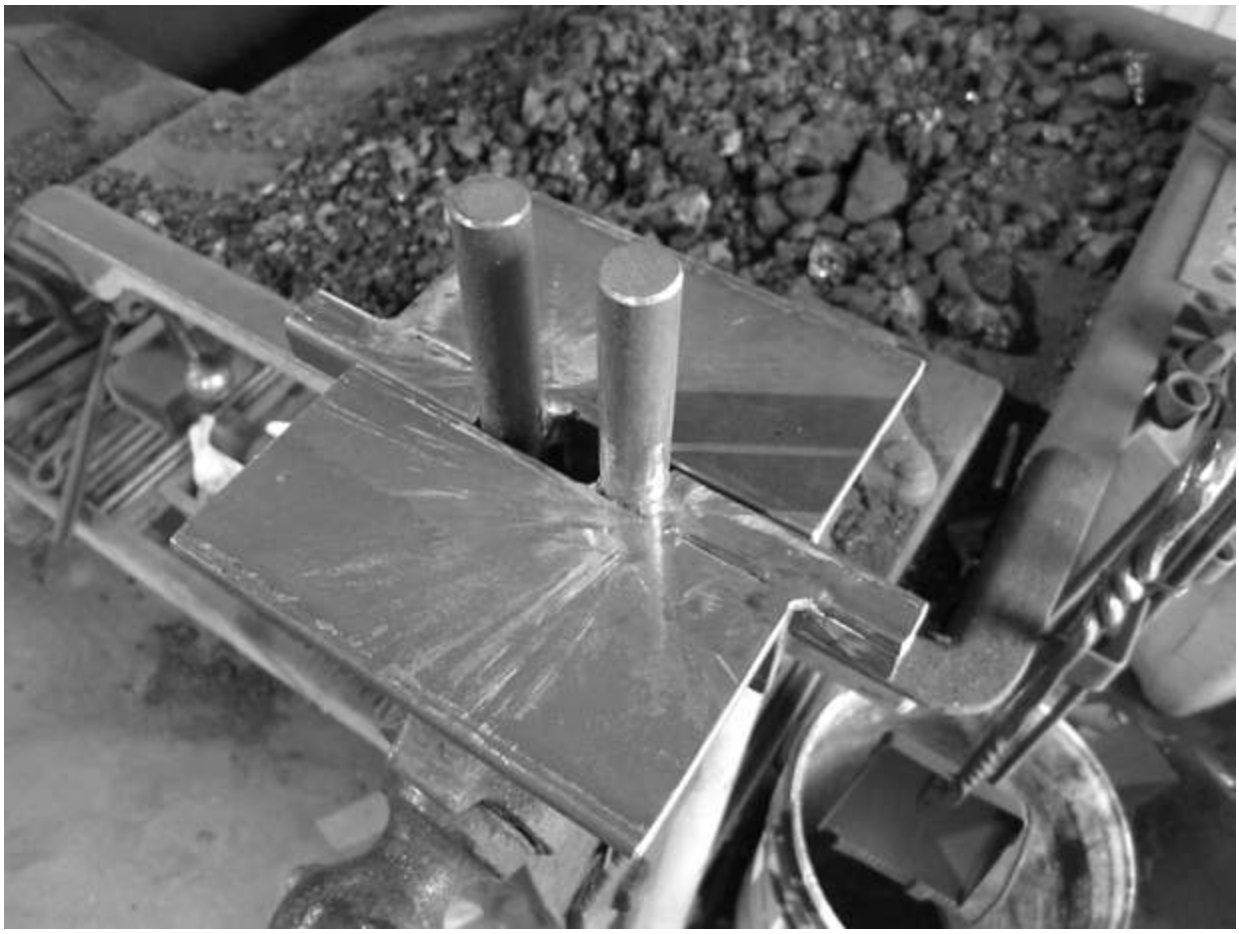
I made the tool you see here such that the pins stick up above the angle iron 3”. The dimensions shown work well with a vise having 4” jaws. If your vise has larger jaws, consider making the angle iron base longer and spacing the pins to fit.

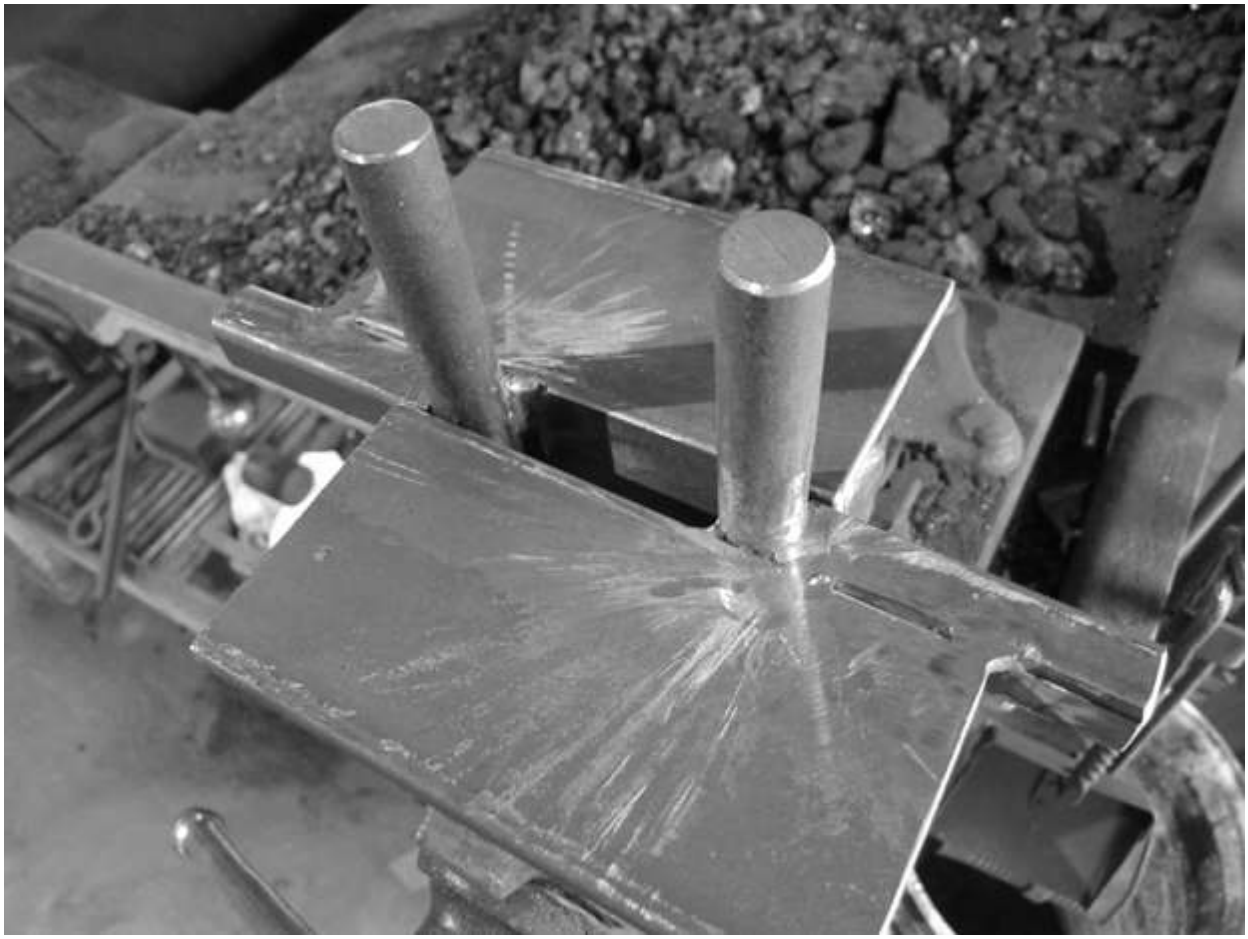
The bending handle also shown, came from old photos saved from a posting by Glenn Conner (IforgeIron) of his Easy Bender.

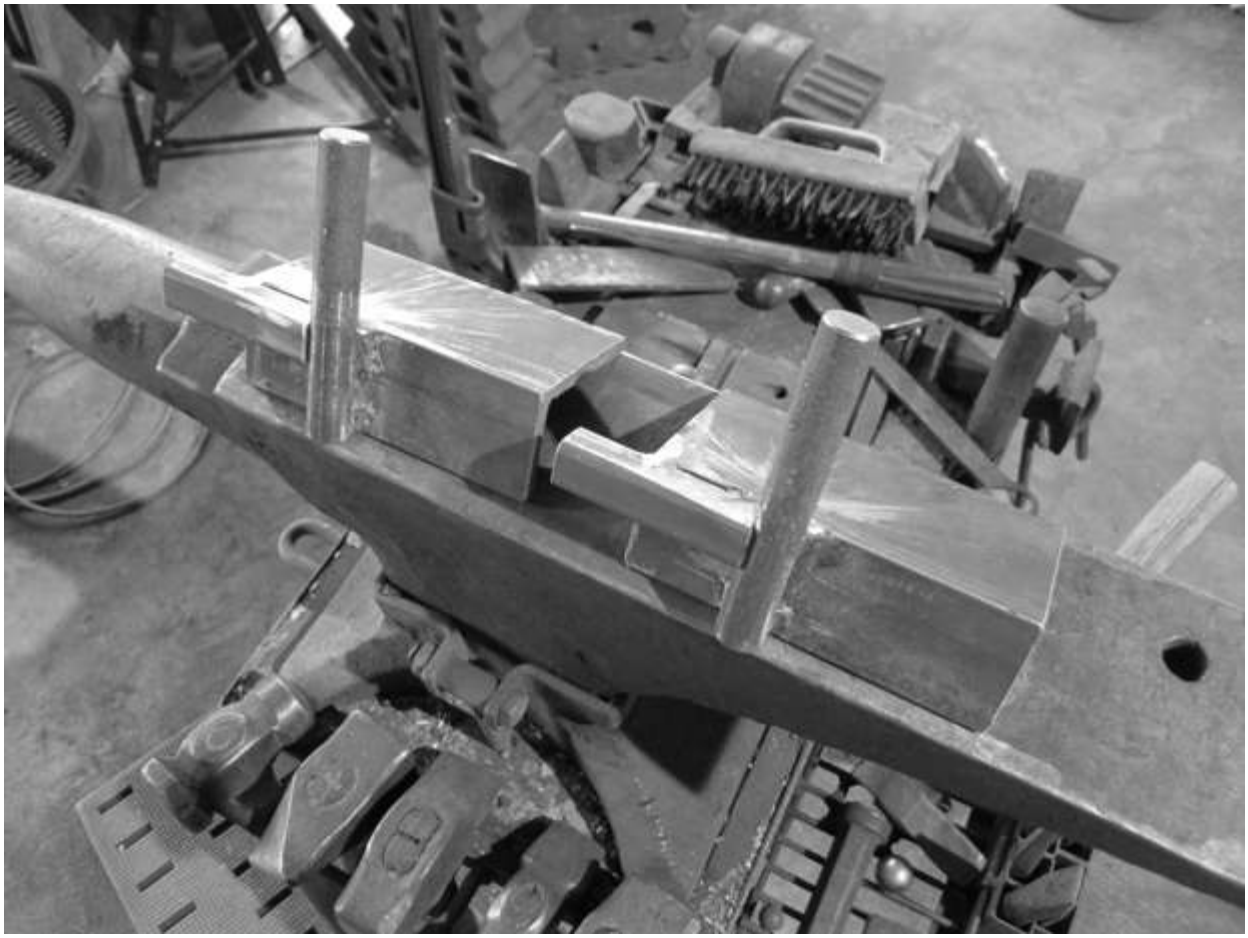
(Photos by Jim Carothers)

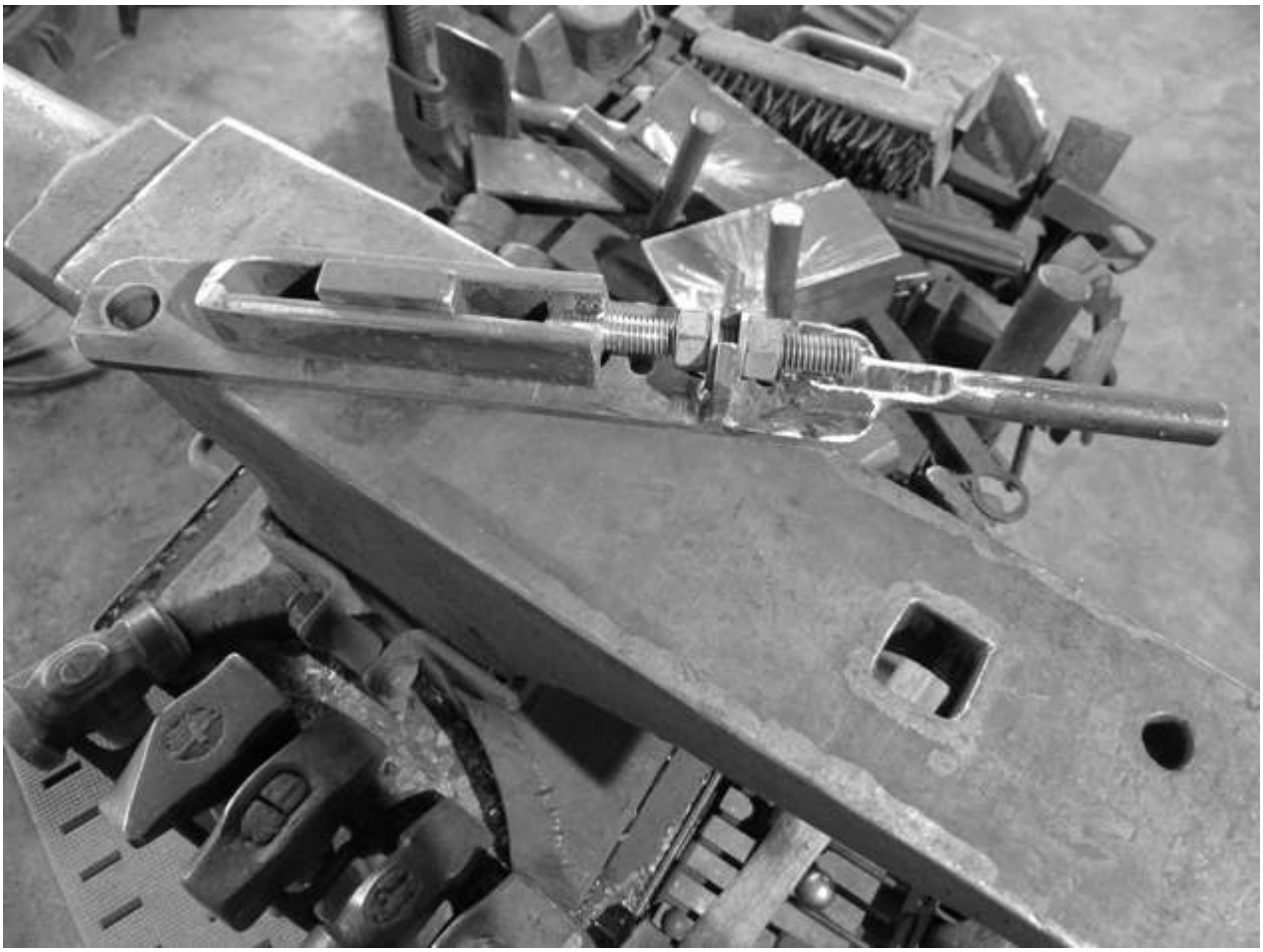


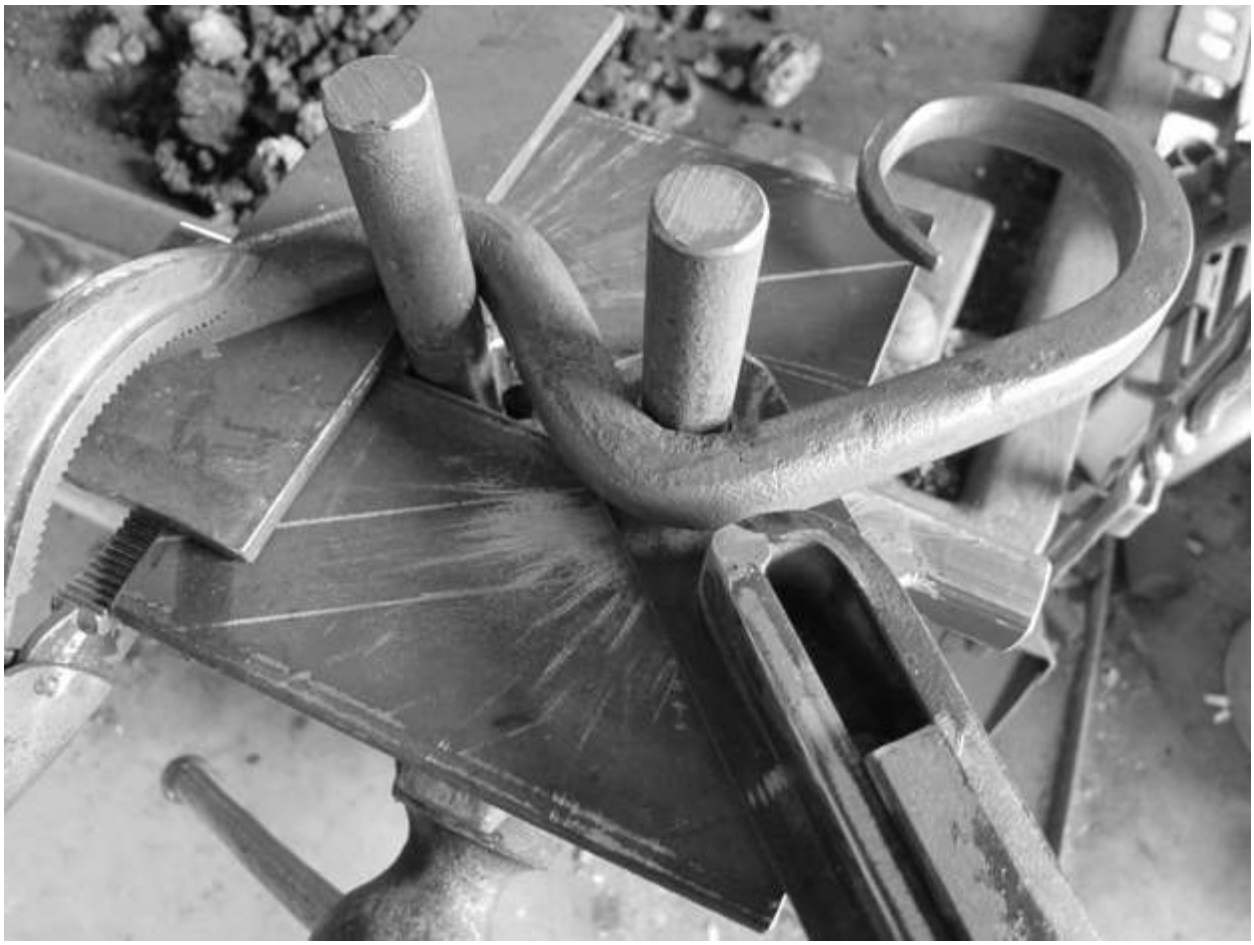


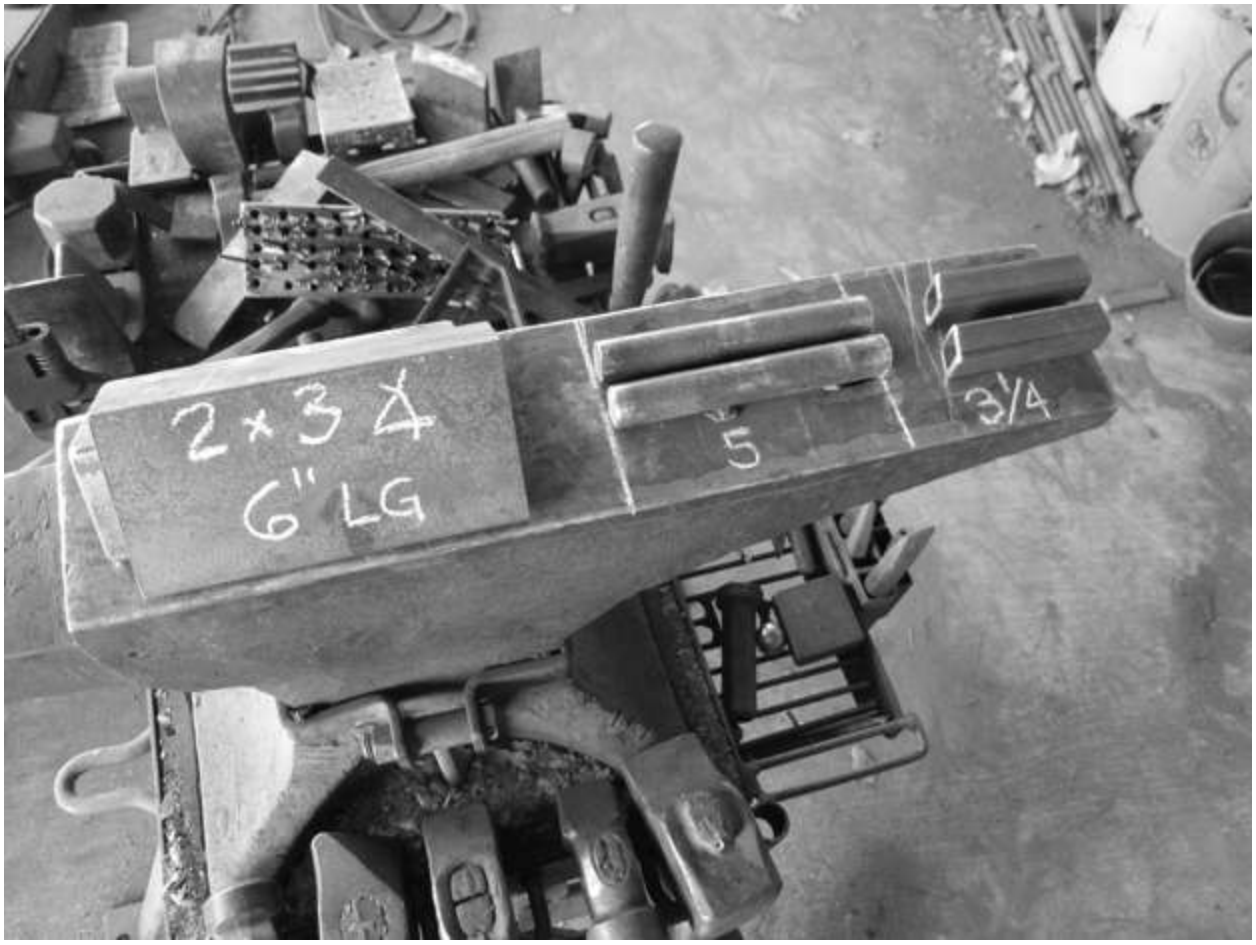








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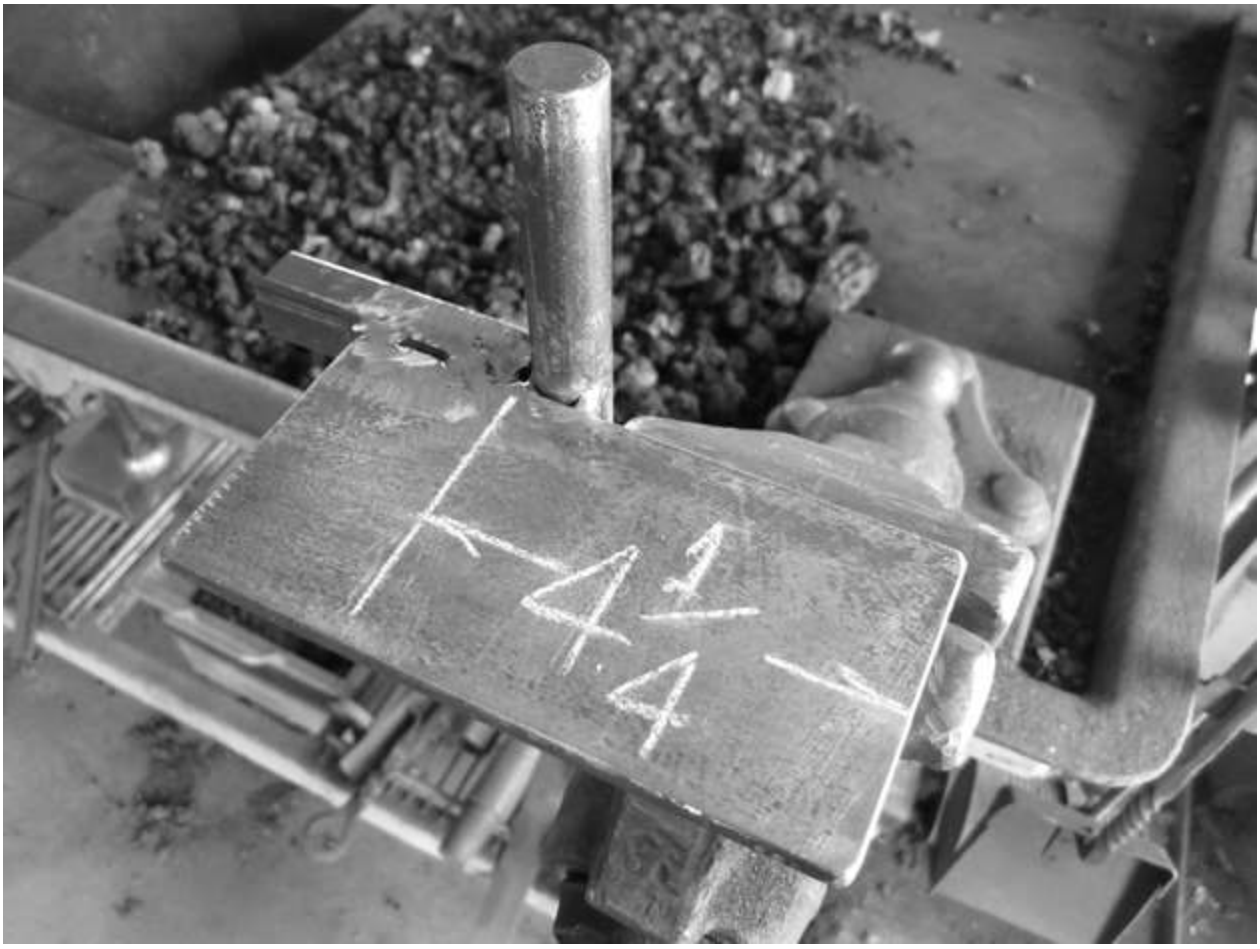
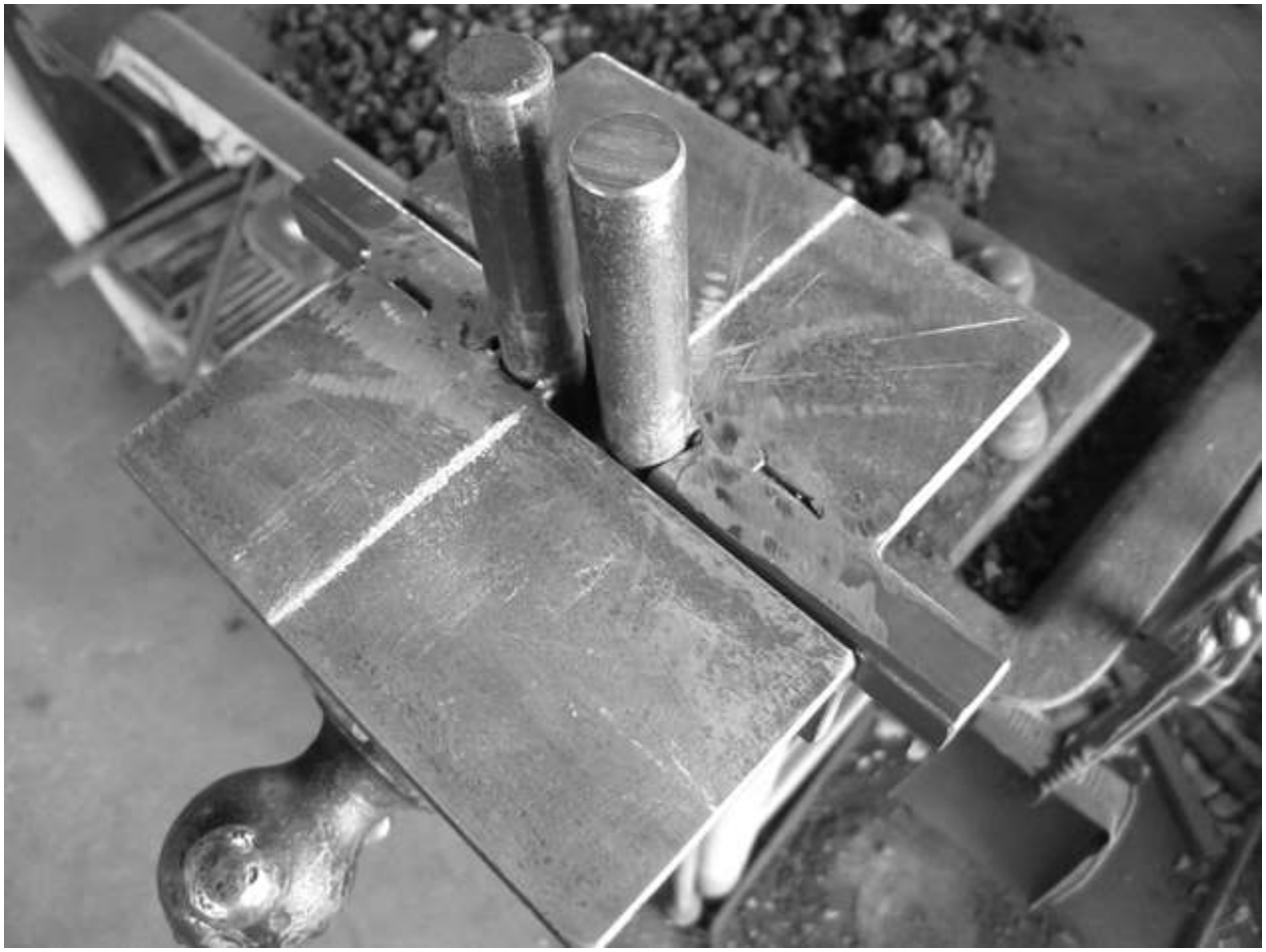
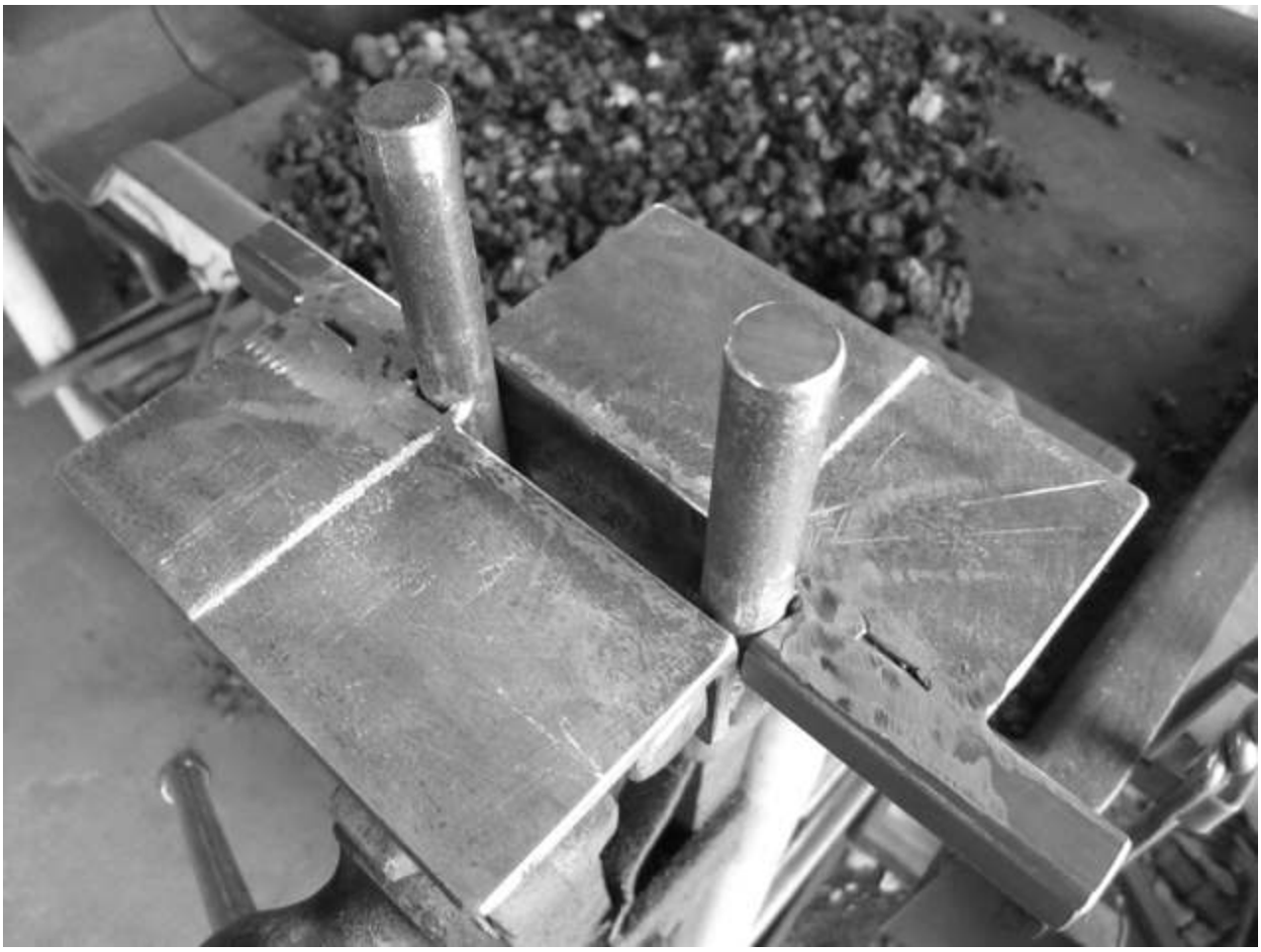






Simple Bending Jig

By Jim Carothers

As part of his demo at the Saltfork 2004 Annual Conference, Bob Patrick made a simple bending jig to make hooks for an overhead pot rack.

After watching the Conference videotape of Bob's demo, Saltfork member Tom Nelson made this bending jig out of available scrap in his shop. The bender pictured here is similar to Bob's; both produce a pothook with a "clip" to grip the potholder frame. By having a clip, the hook does not come off the frame when a pot or skillet is lifted off the hook.

Photo's One and Two show the basic bending jig with a hardy peg welded to it. The bending jig shown here is made from ¼" x 1" mild steel flat bar; the hardy peg fits Tom's anvil. The tool could also be used in a vise.

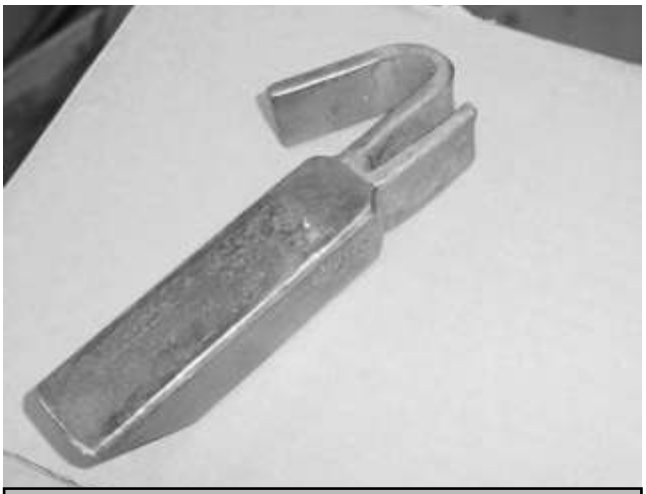


Photo 1

Photo 2

Note that the outside vertical leg of the jig (to the left in Photo Two) is forged concave. This can be done in a swage block or at the step in the anvil. Forge the concave first; that is before making the other bends in the jig. The outside leg of the jig (to the right in Photo Two) simply keeps the whole works from falling though the hardy hole.

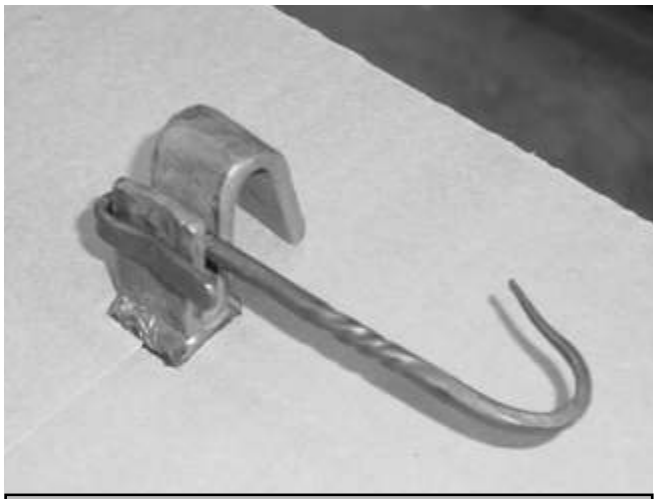


Photo 3

Photo Three shows a hook forged out, twisted to suit, and put in the jig.

Photo 4

We only had finished hooks for this article; so, you will have to imagine the loop end as being

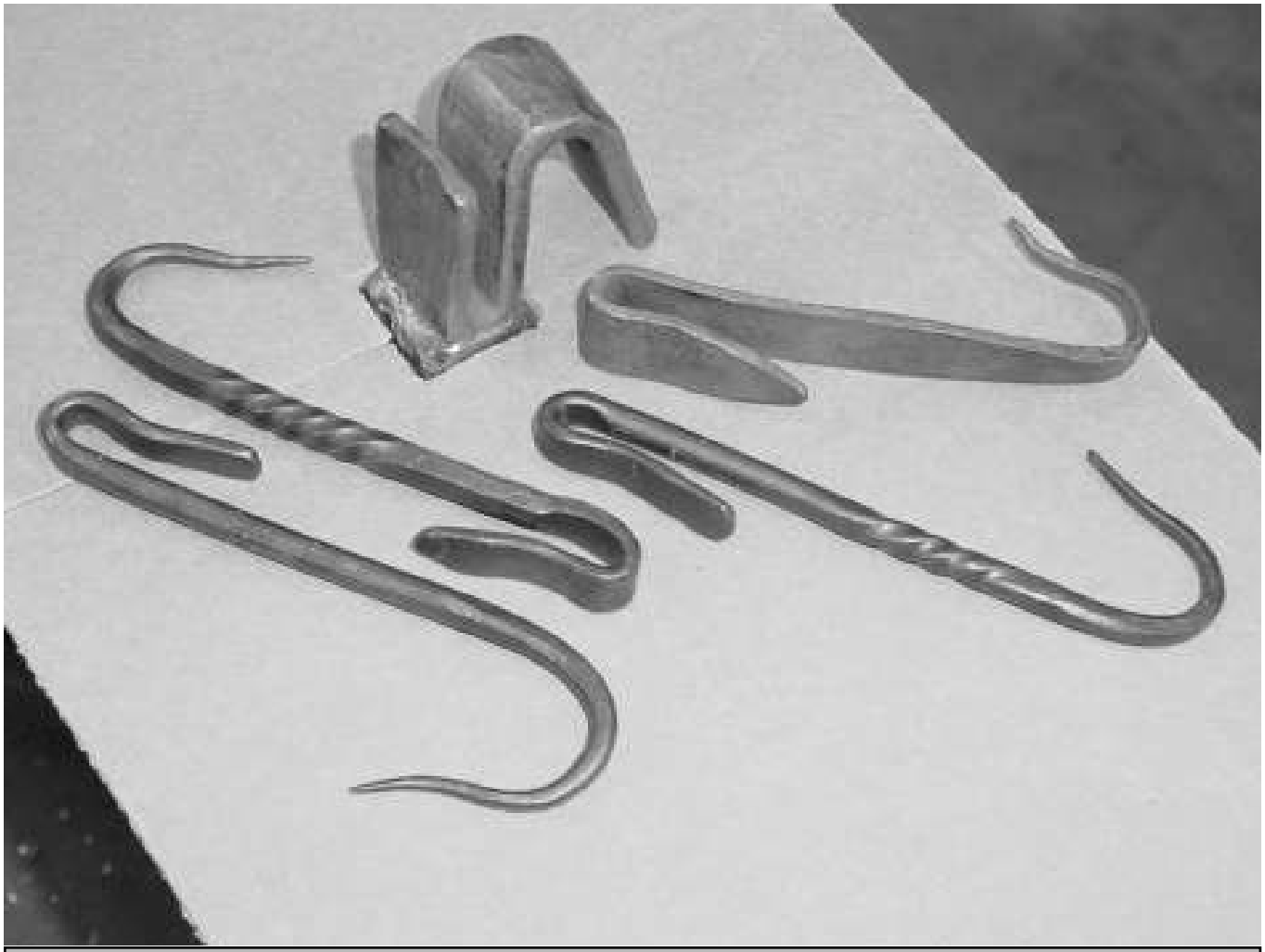


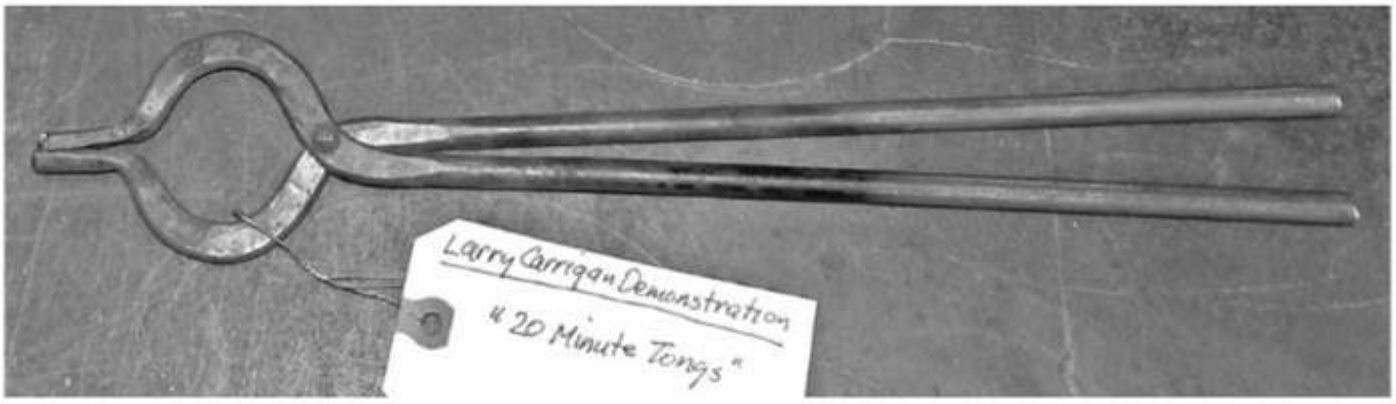
Photo 5

straight when first put in the jig. It is bent around the outside leg of the jig hot.

In Photo Four you can see the loop end of the pothook being forged into the concave leg of the bending jig.

Photo Five shows a number of pot hooks having the Bob Patrick “clip” to make sure they stay on the pot rack

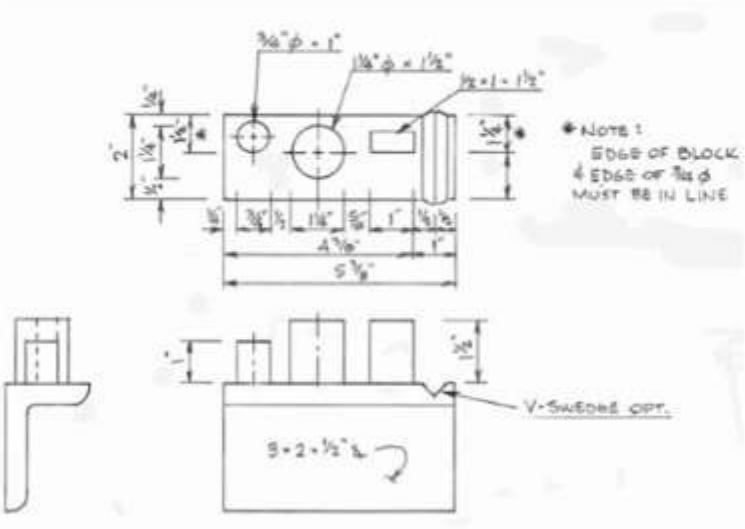
(Photos by Jim Carothers)



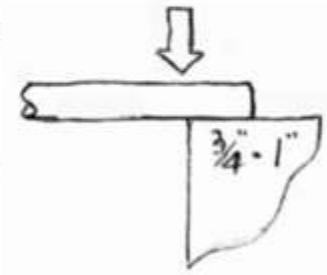
By Larry Carrigan, a MABA member

I call these "20 Minute Tongs" because that's what it takes me to make them. Depending on your skill level, it may take longer, but they are well worth the effort even if they are "Two Hour Tongs". They are lightweight and versatile and when you are packing for a show or demo, not as much to carry.

I first saw these tongs in an article in the Alabama Forge Councils newsletter, demonstrated by two members whose names I have lost, but who I gratefully thank. The article didn't go into much detail on the jig, so what you have here is what works for me. These tongs are made from two pieces of 3/8" diameter hot rolled material, 16" long. By altering the jig slightly you could use 1/2" diameter stock.

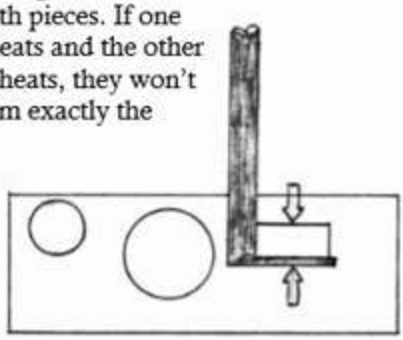


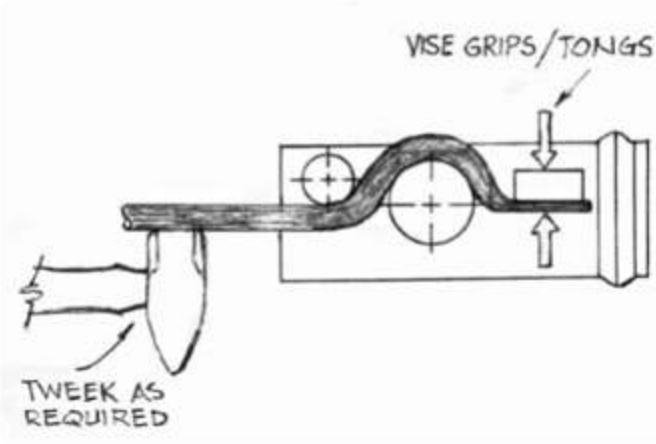
1- Use half-on half-off blows to set down 3/4" to 1" of stock on the edge of the anvil. Allow the material to spread to about 1/2" wide and 1/8" thick. Make two alike.



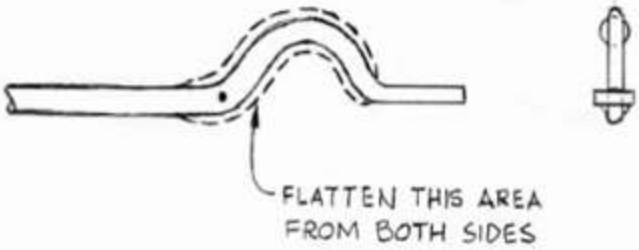
2- Turn the stock over and with the "step" up, turn down 90 degrees. This will be the tong jaws.

3- Clamp the "jaws" to the block on the jig as shown with vise grip pliers and bend to the form shown. A word about bending on a jig; you want to end up with two identical shapes, so if it takes three heats to complete the bending, then use three heats on both pieces. If one piece takes two heats and the other piece takes three heats, they won't match. Bend them exactly the same.



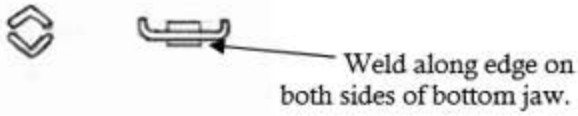


4- Flatten both halves, from both sides, as shown and locate the hinge point. Drill or punch for a 3/16" rivet.

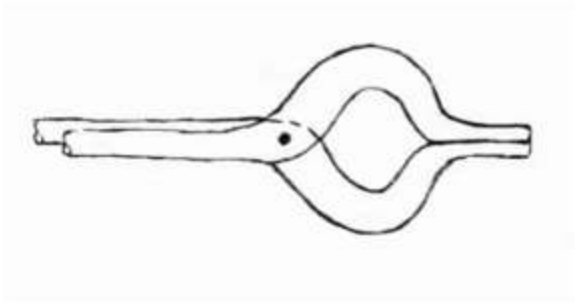


5- Flip one half over and see how things line up, adjust as necessary. Before riveting together- form the jaws.

Use a dull chisel and v-block to form a groove in one or both jaws, or whatever. I made several pairs of box jaw tongs by using 1/8" x 1" flat stock in 1/4" steps and welded them to the bottom jaw.



6- Rivet the halves together and align as necessary.



Decorative Element

By Bob Becker, a MABA member
Photos & write-up by Steven Spoerre

Special tooling needed:
- Straight teardrop fuller
- Right hand curved teardrop fuller
- Left hand curved teardrop fuller
- Ball or bull nose punch

Bob started with a piece of copper bus bar – either use what you have available or the desired size of the final leaf and rosette will determine the initial stock size. Bob also mentioned that this all can be done in iron, and that using a power hammer will get it done quicker with a lot less tired arm.

A long point was forged on the end of the bar, then fullered just behind the taper. The bottom corners of the leaf were then rounded.

Draw out the bar behind the leaf to form a stem. The length will be determined by how much winding and twisting you want between the leaf and the rosette. Fuller the parent stock at the other end of the stem, then draw out to a consistent section. Round up by going from square, to octagon, to round (SOR) but leave facets on the surface for additional visual interest. Flare the leaf by first peening along the center line, then thinning out the edges. Finish shaping the leaf end by flattening and straightening the stem.

Decorate the leaf by first fullering a line down its center, blending it at the tip and finishing with a straight teardrop fuller going into the stem. Then starting at the leaf's base, use the right and left hand curved teardrop fullers to add designs to each side of the leaf.

After the leaf is decorated, isolate the mass for the rosette by fullering approximately the stocks width beyond the stems transition. Cut the element from the bar and dress the cut edge with a file.

Round up the mass, spread it out slightly, and round up again if necessary. Let the rosette cool enough to handle. With a center punch, lightly lay out the center point and, depending on the size of the ball punch, 6,7 or 8 evenly spaced marks half way between the center mark and the rosettes edge.

Position the ball punch over each mark and drive it in to get a deep impression. You want to see deformation around the rosettes edge, as well as, within the previous punch marks.

Refine the transition between the stem and the rosette and add your touch mark.

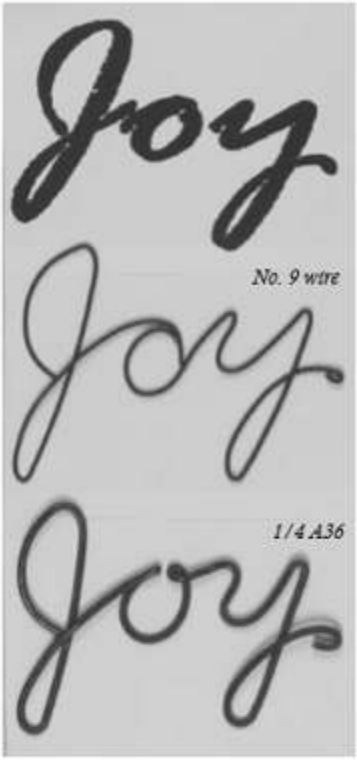
Shape the leaf by gently forming it in a cast iron forming cup (you don't want to mar the decoration), hammer into a hardwood stump or into the end grain of a chunk of wood held in the vise, to give it some depth and a natural look.

Using bending forks, the anvils horn, scrolling pliers, tongs and/or the vise, bend and twist the stem into a pleasing shape.

To de-scale and quench the copper, dip it in a solution of Ph Down (sodium bisulfide).
Safety Note: Ph Down is an acid, wear proper protection and don't breathe the vapors.

Another example of the element Bob brought to pass around.

This article is re-printed courtesy of the Michigan Artist-Blacksmith Association, The Upsetter Newsletter, Nov-Dec 2017



Seasonal Messages

By Carol and Steven Spoerre, MABA members

Carol wanted to have words that could be used on a holiday wreath or hung in place of a banner on an outdoor banner hanger. Writing the script words by hand wasn't that easy to get the kerning right, so she searched script fonts in her word processing software that looked good and could be followed with a single "line" of stock. The words Home, Love, Hope, Happy, Merry, Joy and Peace had no "t's to cross or "i's" to dot… so we deemed them easy to start with. Joy being the shortest! We also looked at separate letters. In the samples below, compare the H's in Vladimir Script and Palace Script. The second font offers a solution for our purpose for the H. Then compare the M's and we preferred the first font for the M. We checked boldness and italics also. We set up the page as landscape rather than portrait, and scaled the word to fit on an 8.5 x 11 sheet of paper using "Word Art" in the Publisher program (we didn't need them any bigger than that for our purpose). You could end up printing each letter on a page and taping the pages together for a really big word using larger stock.

Vladimir Script: Joy Merry merry Hope hope Love love peace

Palace Script: Joy Merry merry Hope hope Love love peace

Kunstler Script: Joy Merry merry Hope hope Love love peace

Rage Italic: Joy Merry merry Hope hope Love love peace

These are a few of the fonts we looked at.

The stock length was determined by unrolling a coil of lead free solder along the path needed to write the word (a piece of string would also work but moves off the path more easily). 5 inches were added to the length for a handle. Write the length of stock that will be needed on the printed word template so it won't be lost or forgotten. To learn how the material needs to be handled, annealed, non-galvanized, No.9 wire* was used. The script that was picked had tight, moderate and sweeping curves, so a variety of bending forks, jigs and scrolling tongs were needed. A machinist's tapped angle block, held in the vise, was used as the bending fork base so different sized pins could be easily moved and switched as needed. No. 9 wire can be worked cold by hand.

To trace over the word, place the printed sheet within a turn, or a step, of where the bending forks are mounted because a constant comparison between the two will be made during forming. Work on a section or area until you're completely satisfied, then move on to the next section – if you don't, going back and tweaking a previous area throws off everything between there and where you stopped. When the material doubles back on itself (like the "o" in Joy), the material was bent up, then back over tight on top of itself, so it retraced its path and didn't create a visual widening at that point.

When the word is complete, it can be left as is and painted; be further refined by heating crossovers and setting them down into half lap joints; or forging down in specific areas to widen the stock to give the appearance of being written with a quill or fountain pen. Techniques shown in an affiliate article by Jill Turman, in the 2012 July-August issue of the Upsetter, shows how to spread the material for certain effects.

Learning with No 9 wire helped. I changed what I didn't like when I used the 1/4 stock, like how the "o" transitions into the "y". With the 1/4 stock I used a localized heat to work on the tight bends.

A few examples of text/letters in iron can be found in Otto Schmirler's books Der Kunstschmied (pages 205-208) and Schmeidekunst am Haus (pages 269-270): also in the CoSIRA (Council for Small Industries in Rural Areas) book, Catalogue of Drawings for Wrought Ironwork, on page 21. By doing a Google search on the CoSIRA books title, a downloadable PDF should come up.

* The No.9 wire used was found at Yoder's Shipshewana Hardware store, in Shipshewana, Indiana. Our local hardware stores only carry galvanized No.9 wire which seems to be stiffer, and it should never be heated in the forge or with a torch because of the toxic fumes.

Randy Calhoon on oxy/acetylene setup, gas welding and plasma cutting.

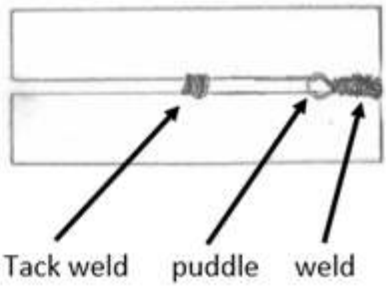
Oxy/acetylene setup

- First get the book on your torch set. Read it. At the same time pick up the free cards for your torch set that have all the information you need on pressures for cutting, heating and welding with acetylene, propane and natural gas.
- When mounting the gauges on your bottles turn the gauges up slightly. If the diaphragm fails the gauge will hit the ceiling.
- Turn the gas on slow and don't stand in front of the gauges. If the diaphragm fails on the oxygen the gauge will shoot out of its case with 2200 lbs. of pressure behind it. That's enough force to penetrate a human body.
- Set the regulator pressure with the gas flowing. The listed pressure is flowing pressure.
- Match the pressure to the tip size and the thickness of the metal listed on the free information card you get from your local welding store.
- Crack the acetylene valve, point the tip away from you and strike the lighter.
- Turn the acetylene up until the soot stops forming and the flame is still connected to the tip.
- Add a little more gas but keep the flame connected.
- Turn the oxygen up until the inner flame shrinks to a single blue flame with an outer bluish to orange flame. This is a neutral flame.
- A long white inner cone is an oxidizing flame—too much oxygen.
- Two inner flames with a light orange tip and a white outer flame near the second inner flame is a carburizing flame—not enough oxygen. The inner flame beyond the inner cone is an acetylene feather.
- The gas knobs on the torch often get bumped changing the gas settings. The fix is: with the gas off at the regulator or the tank, open the knobs on the torch a couple of turns and slightly tighten the lock nuts. A very slight turn on the lock nut tightens the valve knob so it won't easily move when bumped.

Continued on next page

Gas welding

- When welding flat bars side by side, leave enough of a gap so that you can get good penetration between the bars: the width of the filler rod for bars less than 1/4". For bars 1/4" and over grind a bevel on the edges to be welded. Technically the included angle should be 60°. Tack weld in the middle to avoid pulling the bars out of parallel.
- Weld direction (when gas welding with a filler rod) is to push the flame/puddle.
- Start the weld from the right side (for a right hander) by forming a puddle—push the rod into the puddle and work to the left. Pushing the rod into the puddle is like "feeding the baby." Don't push the rod into the puddle too far (you'll gag the baby) and don't hold the rod above the puddle (the baby will scream) and the filler rod will drip.



- When welding outside corners don't over-lap the pieces—place them corner to corner and weld in the gap to get good penetration.

- When doing a T weld, aka fillet weld, set up a fixture or two to make the weld easy.

Jig 1

Jig 2

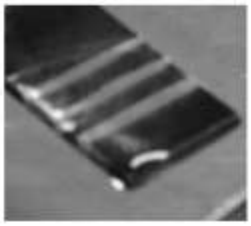
This fixture (right) is for finishing one side of the weld. It is easier to weld in a trough.

Jig 1 and 2 are for tack welding the ends. Use what you have available.

Continued on next page

- When welding outside corners (i.e., a cap on a square tube) instead of cutting the cap the exact size of the tube, cut the cap slightly smaller.
- Weld in the corner to get good penetration.
- File or grind the weld round for a nicely finished weld.

- When welding tube to a plate, tack weld the corners first. If the tube's walls are 1/4" or thicker, bevel the end and weld in the gap.
- Why waste rod? When a gas welding filler rod gets short—Stick it to the weld and weld a new rod to the short rod. Burn the original rod loose.
- Hide welds whenever you can. One way is to use plug welds—grind flat and heat with a torch to create some scale blend.
- When a weld is stopped, restart the weld in the crater that is left, but stay in the crater half as long as you would normally to prevent a knob.
- With all gasses in any kind of welding don't over pressurize. If anything, slightly under pressurize.
- When using a shield gas for mig or tig, back off the recommended pressure until porosity shows up in your weld, then increase the pressure slightly and use that as your setting.
- Same thing when brazing. Use less pressure on oxygen and acetylene—creates a softer flame that works better. If you're impatient, the higher pressures do work.
- Brazing works well as a substitute for inlaying brass. Fill a grooved pattern using a silica-brass rod, sand the piece, bring the tempering color up to purple.



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Randy Calhoon on Plasma Cutters

Pros

- They can run on different voltages.
- Portability.
- Work well to cut 4' x 8' sheet metal down to a manageable size.
- The best way to cut expanded steel.

Cons

- One dimensional.
- Can't heat with it.
- Can't weld with it.
- Slow pay-back on the money you pay for it because it is not used very often.

Tips

- The newer plasma cutters have built-in compressors assumably with a built in air dryer.
- On older cutters use two air dryers: One on the output of the compressor and one on the air intake of the plasma cutter and use as little air pressure as possible. Less air means less moisture cuts down on dross (rag on the cut) and prolongs the life of consumables because less condensate = less water degradation.
- Practice cutting at different speeds until you find the speed where no dross is left on the cut.
- If dross is present use a ball-peen hammer to lightly tap the dross off. Tap dead on the edge, not at 90° to the edge.

Welding and layout tables

- A good welding fixture is a piece of angle iron with the inside corner ground square and the outside corner ground flat - to allow a place for the lower jaw of a clamp or vise-grips to seat. Weld the angle to the edge of your welding table.
- Cut C clamps in half and weld top to a plate. Clamp or weld the plate to the welding table.

Continued on next page

- Put laser grid lines on the layout or welding table off-set at 5" - 10" - 15" - 20" - 25" etc. for stair layout.
- A dead on lazer groove perpendicular for center line layout.
- Drill pritchel hole and hardy on one end of your table so you can use anvil tools on your table.
- An old school layout table is made of small I beams with spaces between the beams for clamping.
- Instead of a 4' x 8' x 1" thick layout table, use several 2' x 4' x 1" thick tables on wheels that you can move together in any configuration—long and thin or long and wide.

Shop tips by Albin Drzewianowski of the *Mid Atlantic Smith's Association's Fall 2017 newsletter*

Files: Here is a handy way to clean a hand file. If the normal file card can't get out those two to three stubborn bits of steel stuck in the teeth of your file, take a large bullet casing (brass) and flat-ten the end so that you have two very sharp points (see photograph). Look for the largest shell casing that you can find. The one in the picture is 4" long. A large casing allows you to have a really firm grip on the tool and makes it easy to manipulate. This tool will allow you to pick out those really stubborn bits of steel in your file. The brass allows you to exert pressure without damaging the teeth of the file.

File Cleaning Tool Photo by Albin Drzewianowski

Wire Brushing: This is a double "Shop Tip." At the 2016 Principio Iron Furnace Hammer-In, featured demonstrator Derek Kemper would soak his wire brush in water before he wire brushed the scale off of his work. I have taken to doing this on the final wire brushing when I am trying to get fire scale off my work. The water seems to make the fire scale "pop" off. I use a stainless steel wire brush. This has two advantages: being stainless steel, the bristles do not rust from repeatedly going into the water. Also, I have heard from a number of different sources that stainless steel wire brushes, both handled and the ones that go on bench grinders do a better job because they are a harder steel and they last longer. They are more expensive, but I think they are worth it.

This five page article is re-printed courtesy of the Rocky Mountain Smiths, Forge Facts Newsletter, Fall 2017

Learn how to make your Little Giant power hammer work harder than ever!

You are invited to join us for our annual Little Giant Rebuilding Seminar. It will be held Friday March 16 through Saturday March 17, 2018.

First taught by our good friend Fred Caylor of Zionsville, Indiana, we carry on his tradition of teaching how to make Little Giants run well and hit hard.

This 2 day class is a hands-on format. You will help transform a 25 LB Little Giant from running but sloppy condition into a well tuned, quiet, hard working machine. Sid Suedmeier, former owner of Little Giant, will share all his knowledge and experience gained from Fred and 26 years of repairing and rebuilding Little Giants.

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

The class is held in our shop in historical Nebraska City, Nebraska. Our city has a nice selection of cafes, outlets, antique and gift shops, orchards, wineries and museums.

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

No experience is required to attend this class. Our past classes have been attended by folks from every walk of life, from students to retirees ...anyone who wants to learn can benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop.

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

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

When we receive your registration, we will send you a city map, along with travel and hotel information.

Airports are located in Omaha (45 miles north), Lincoln (50 miles west) and Kansas City (125 miles south).

2018 REGISTRATION

Name:_____ **Business name:**_____
Address:_____
Telephone:_____ **Email address:**_____

PAYMENT

Check enclosed

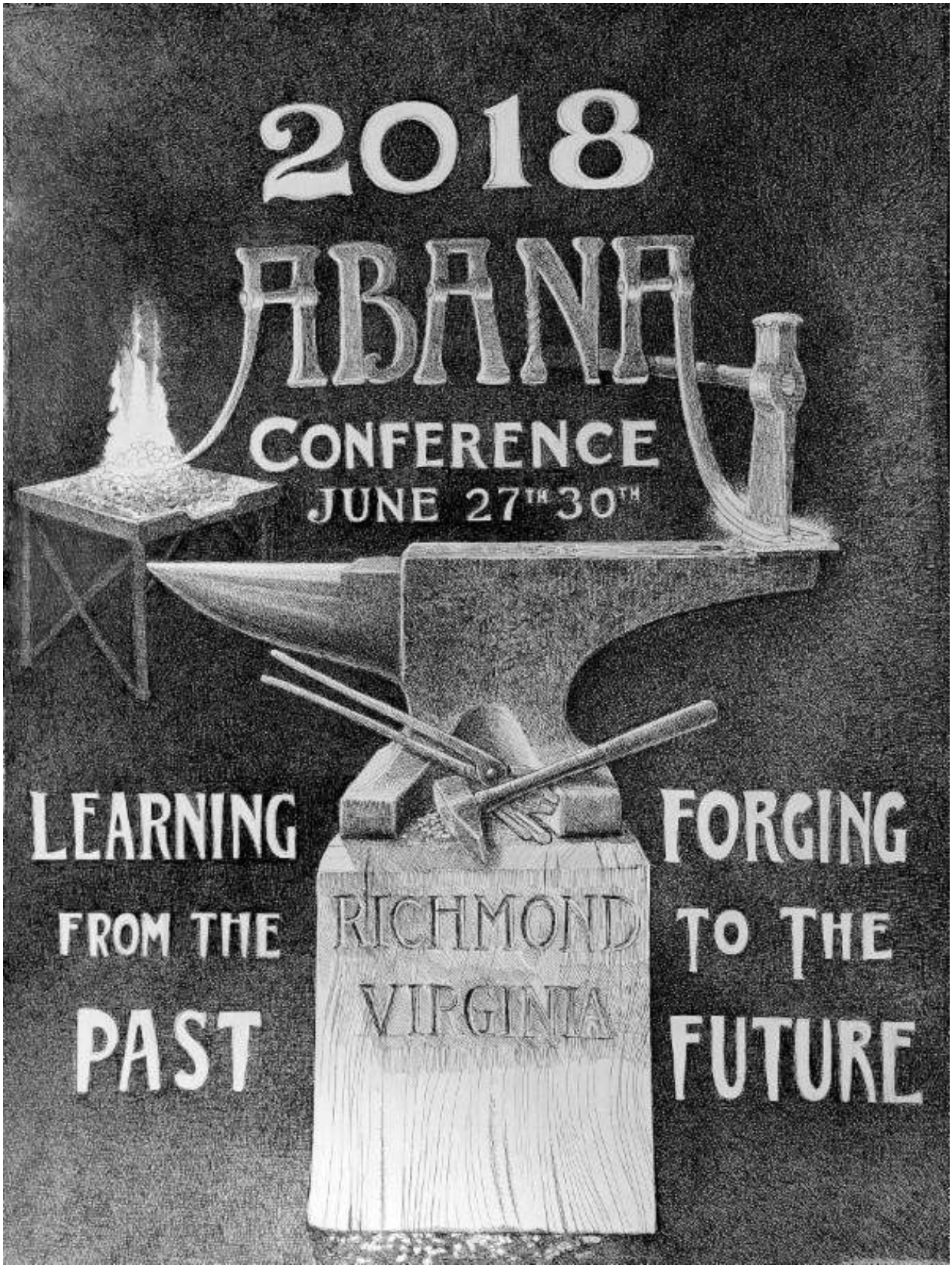
Cash in person

(Sorry, we no longer accept credit cards, although credit cards can be used to purchase parts through the Little Giant business owned by Roger Rice, also in Nebraska City)

POWER HAMMER INFO

Brand:_____Size:_____Serial Number:_____

Please call or email if you have any questions, or prefer to register by phone. You can reach us at 402/873-6605 or sidsshop@windstream.net



Registration for the 2018 Conference is now open
make your reservations as space is limited
Various Accommodations ie hotels and Camping check
ABANA.org for information.

SCABA Shop and Swap

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)








Post Vice,

Forge Blowers and

Lever-Type Forge

Call for Pricing…

SCABA Shop and Swap

Bill Davis Forge Welded Tomahawk DVD

This DVD is now available to members for a minimal cost (cost of DVD's is minimal to cover reproduction and shipping if applicable.) Contact the SCABA Librarian, Doug Redden, if you would like to get a copy of this DVD.

Doug Redden 918-230-2960 or doug.redden2@att.net.

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.

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

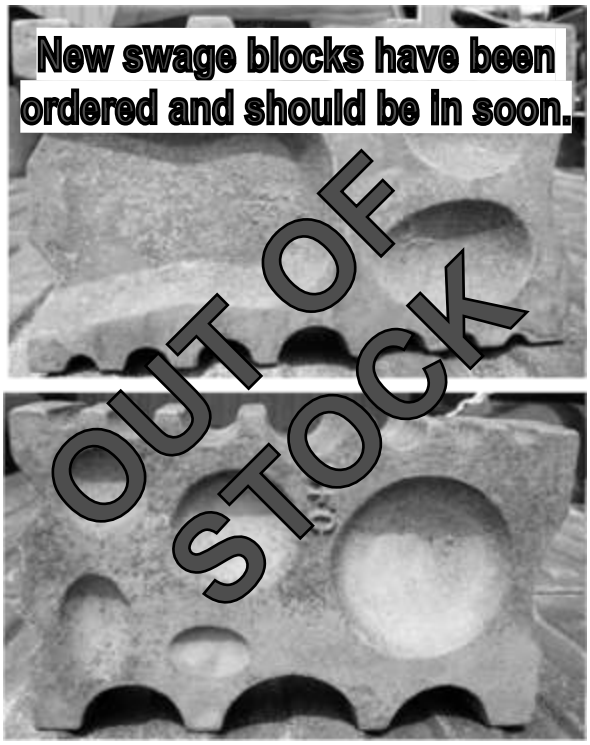
SCABA Library DVD's Available:

This is a partial list of the DVD titles available to members from the SCABA Library. Contact the Librarian (Don Garner) 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

SCABA Swage Blocks

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

SCABA Floor Cones

$200.00 plus shipping.

(Same price to members and non-members.)

For more information, contact Bill Kendall, Byron Doner (Contact info inside front cover) or

Nolan Walker at Nature Farms Farrier Supply in Norman, OK.

405-307-8031 or 800-460-6759.

SCABA Shop and Swap

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 580-302-1845 (Cell Phone) 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 Mike-Marideth@sbcglobal.net

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 18 to March 31, 20 19

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 19

Note: Dues will increase in March 2018 to $30/Yr!

Signed: _____

Return to: Saltfork Craftsmen, P.O. Box 18389, Oklahoma City, Ok. 73154

Saltfork Craftsman Regional Meeting Hosting Form

Region_____NE _____SE_____SW_____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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