

Saltfork Craftsmen

Artist-Blacksmith Association

May 2018



Brad Nance

Novice Class
Contest Winner



Travis Gabbard

Master Class
Contest Winner

***Congratulations to the 2018 SCABA Annual Picnic
Contest Winners!***

***The contest was a timed competition to produce five S-
Hooks which were judged on consistency and finish.
Thanks to Bill Phillips for making the trophies.***

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Editors notes...

Thanks to everyone who voted in the recent Board of Directors elections. There was relatively good voter participation (voter participation is historically pretty low as a percentage of the total number of members) and ballots were counted at the 2018 SCABA Annual Picnic. These are the results:

Russell Bartling - 53 Votes

Ricky Vardell - 47 Votes

JJ McGill - 45 Votes

Eric Jergensen - 23 Votes

The first three names are voted in as directors with Russell and JJ continuing and Ricky being a new director.

Long time director Bill Kendall who's term is actually up next year, is getting off the Board creating an immediate opening. The Board is appointing Eric Jergensen (the only other nominee) to fill that void. So in effect, we have all of the nominees on this year's ballot becoming Board members. So if you read anything I wrote in previous newsletters, the "your vote matters" theme may seem to be at odds with these results. BUT rest assured that this scenario is not the norm and next year I will reiterate that your vote does matter in the 2019 elections. The directors take their responsibilities very seriously and you, as members selecting a representative Board, have the right to pick Directors that you feel will best take the organization in the directions you would like to see.

The election of the new directors will be formally accepted at the next Board of Directors meeting and the contact information/Officer positions will be updated in the next newsletter once that meeting takes place.

Congratulations and welcome to the new Directors. And thank you in advance for volunteering your time and effort.

And thanks to Bill Kendall. I don't know how long Bill has been a director but I think he has shipped so many Saltfork Swage Blocks that he is on a first name basis with all the shipping options in the Tulsa area. (You know they had to love seeing him walk through the door with another 70 pound block, or blocks, to set on the counter.) As with many others, Bill has dedicated a good portion of his personal time to serve the club in a purely volunteer basis. That kind of commitment surely deserves a big "Thank You!"

- 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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www.saltforkcraftsmen.org



President's Notes:

A big Thank You to everyone who helped with the basic class we had on 3-31-18! I believe all the students learned a lot, and there seemed to be plenty of people helping teach. There were some distractions, but all in all, I believe everyone had a good time.

Even though it was a cold and windy day, there was a great turnout for the picnic. Not sure how many "S" hooks were made, but I'd say at least 50 were entered in the competition! There was plenty to eat too. Too many desserts to be able to try them all! Thank You to everyone that helped make the picnic a fun day for all!

I'm sure you have all heard "do as I say, not as I do!" Well, here it comes again. If you've watched me hammer, you probably noticed how I hold the hammer with a death grip and basically hammer like a small child. This not only moves very little metal, it's also a great way to get tennis elbow! Also all the shock travels up the arm which makes my neck sore and kind of locked up. Of course putting my thumb on top of the hammer not only multiplies this problem, it also kills the rebound of the hammer.

I had always thought that the tennis elbow was caused from the shock of hammering. But when Gerald Franklin explained to me that he had started having problems with his tong holding hand, I learned that it's more the tight gripping that gives the problem. His doctor told him to put a fairly strong rubber band around the tips of his fingers and thumb, and then try to spread them out. This kind of negates, or cancels out all the strain that happens when gripping hard and too long, by working the muscles in the opposite direction. If I remember right, you're supposed to push fingers and thumb out, then hold it a few seconds before relaxing. Followed by several repetitions.

So how are you supposed to hold and swing a hammer? I found a U-tube video by Josh Greenwood called Basic Hammering that explains it fairly well. In it he talks, and shows how he holds the hammer loosely between his thumb, and index finger. When he picks it up, he raises the hammer up close to his head letting the hammer kind of pivot back, then when he swings it back down, he lets it pivot back forward. And for more speed and power, he closes his other fingers at, or almost at the end of the swing. This causes a snapping motion that really speeds up the blow.

I've heard guys say that the index finger and thumb are for guiding, and the other fingers are the power fingers. This is a lot like a baseball pitcher snapping his wrist just before turning the ball loose. When you hold the hammer with this loose grip, it doesn't transfer the shock to your hand and arm. Mark Aspery uses this same technique. These are his words; "I think of my hammer swing as like cracking a whip or a badly executed fly rod cast. Very loose in the wrist!" He also explains that a rectangular shaped handle makes it a lot easier to use this technique than the more oval, or round handle, which is the way most are manufactured.

I seem to almost keep the handle parallel with the anvil face with my "death grip" which pretty much locks my wrist. As I jerk the hammer up, then quickly change directions to a downward swing, there isn't much velocity left by the time the hammer hits the metal. This also wears my arm (and the rest of me) out very quickly. I have found that it is very hard to make myself use this loose grip method. It feels awkward to me, and I get impatient. Then I seem to revert back to my death grip, and try to go faster, like I think I'm making up time. It's a hard habit to break.

So for your own good, do like I say, and not like I do!



Happy hammering! -Byron

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.

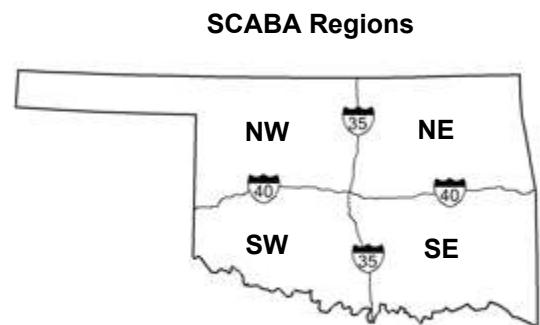
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the 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 of I40 and west of I35.)

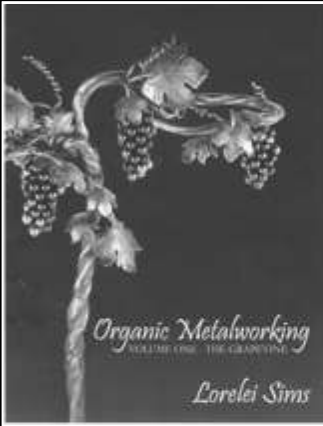
All meetings are encouraged. These boundary definitions and regional meeting dates are a suggested framework to facilitate orderly meeting scheduling, planning and promotion with a minimum of overlaps and a maximum exposure to the greatest number of members. Not all meetings fit precisely within a rigid 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.

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.



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 2016 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 a second shipment of this book and many have already sold. The price of the book through SCABA is the same as the price directly from Lorelei and proceeds from sales benefit SCABA. **Contact Josh Perkins (918) 269-3523** if you would like to purchase a copy. - Editor

Saltfork Has a New T-Shirt Manager!

Josh Perkins is now the manager of the Saltfork T-shirts, Denim Shirts, Licence Plates, etc. Thank you Josh for taking over this responsibility! If you would like any of these items, please contact Josh at (918) 269-3523 or hithforge@gmail.com

Knives, Blades and Swords, Oh My!

You may notice the occasional article in this newsletter that is either directly related to or on the fringes of being a "knife maker" article. You may be wondering if the SCABA newsletter is going to focus more on watered down blade making at the expense of forging/blacksmithing. The short answer is no. There are organizations specifically for that serious blade making group. Saltfork will never be the premier blade making group as our interest is primarily blacksmith/artist related.

The long answer is that blade making overlaps the forging and metal working that is of interest to our group. And within our group are blacksmiths who have an interest in blade making or just using the similar techniques to make better chisels, punches, hot cuts, etc. And with the increasing knife craze fallout from the TV reality show "Forged in Fire," there are many new people looking to get started in basic blacksmithing with the intent to make blades. I have personally seen some young stock removal guys come as guests to one of our regional meetings and see forging up close. I believe their comment was "I didn't even know you could do that!"

We should attempt to bridge the gap between pure blacksmithing and pure blade making where it makes sense to do so. And the sharing of articles among ABANA affiliates is likely to turn up more blade related topics due to the current trends. If you are not a blade maker, please keep in mind that most of the apparently blade related information that will appear here usually has applications beyond just blades. Please let me know what you think! I am always interested in your feedback and suggestions. - Editor

2018 REGIONAL MEETING SCHEDULE

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

2018 Fifth Saturdays:

March 31st (Beginner Blacksmithing Workshop - Norman, OK - See Workshop Schedule)

March 31st (Beginner Blacksmithing Workshop - Tulsa, OK - See Workshop Schedule)

June 30th (Tool Making Workshop at Mandell Greteman's Shop in Foss. See Workshop Schedule)

September 29th (Open)

December 29th (Open)

May 2018

NE Regional Meeting May 5th : The Saltfork Craftsmen Northeast meeting for May 5 will be held at Dan Cowart's Shop at 10380 N. 4010 Rd. Wann, OK 74083. The E-mail address is ddcowart@gmail.com and the cell phone number is 918-440-0653. I will cook a couple of port butts and have some sides. Please fill free to bring other sides and desert. The trade item will be a letter opener. If you know someone that doesn't have e-mail you might tell them about the meeting.

SE Regional Meeting May 12th : Open.

SW Regional Meeting May 19th : Will be hosted by JJ McGill a the Murray County antique tractor show grounds location. This meeting will host Boy Scouts from Tulsa plus Leaders and Parents. Any smiths that would like to help out educating and working with the young Scouts are greatly appreciated.

The trade item is a Dutch Oven Lid Lifter. Lunch will be provided but please bring a side dish or dessert to help out. Directions: 7 miles north of Sulphur on Hwy 177 then east $\frac{3}{4}$ mile on Tractor Road. Contact JJ McGill at 580-369-1042 if you have questions.

NW Regional Meeting May 26th : Will be hosted by Don Garner at his shop at 23713 E. 860 Rd. In Thomas, OK. Directions: Go one mile west, then one mile north of Thomas.

The trade item is a Colonial Thumb Latch. Lunch will be provided but please bring a side dish or desert to help out. Contact: Don Garner 580-302-1845.

June 2018

NE Regional Meeting June 2nd : Will be hosted by Josh Perkins at 9620 N 427, Chelsea, OK 74016 (see Map on next page.)

The trade item is a rolled rose. Lunch is provided but please bring a side dish or desert to help out. Contact Josh Perkins at 918-269-3523 or hithforge@gmail.com

SE Regional Meeting June 9th : Will be hosted by Ronnie Smith at the Camp Hope Kids Ranch, 400 N. "A" St., McAlester, OK 74501.

Directions: From the Indian Nation Turnpike go East on Hwy 270 to first stop light which is "A" street. Turn left onto "A" street and go 1 block to stop sign. Go through the stop sign and the location will be on the right.

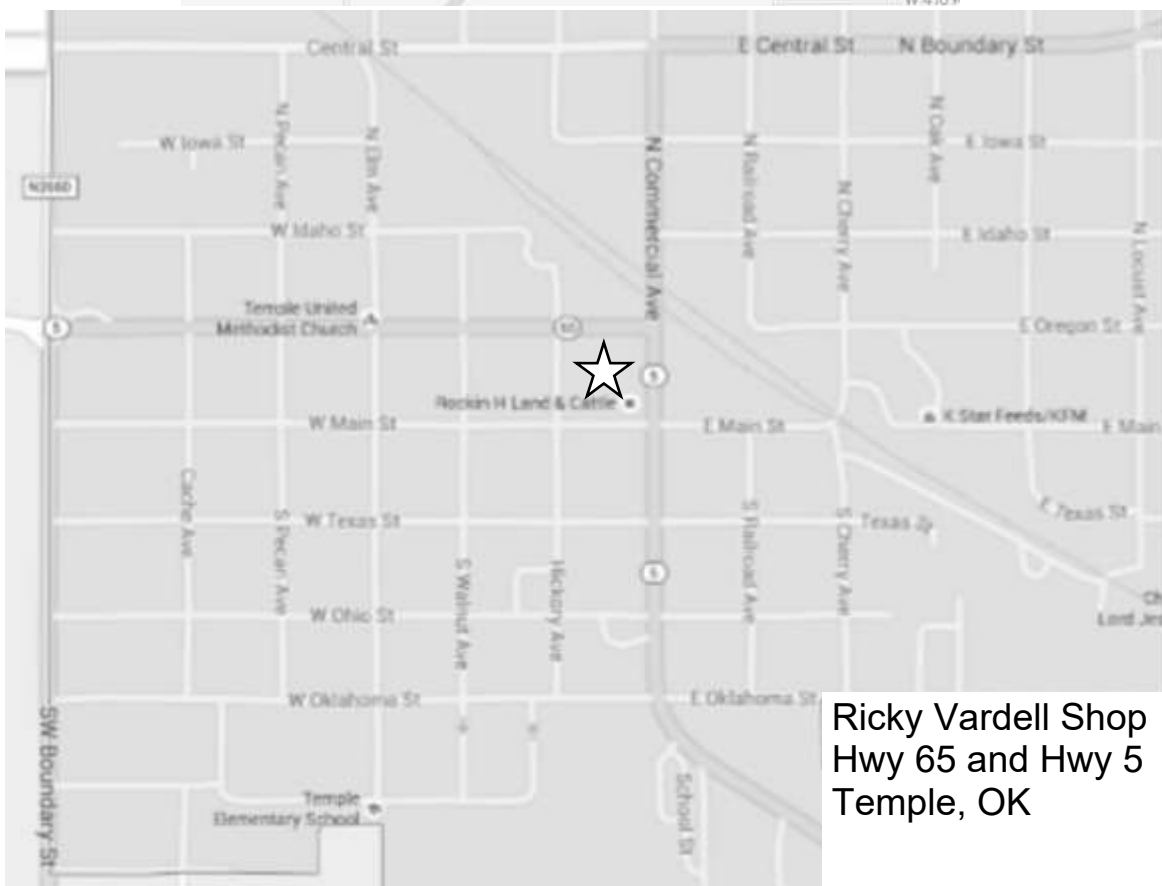
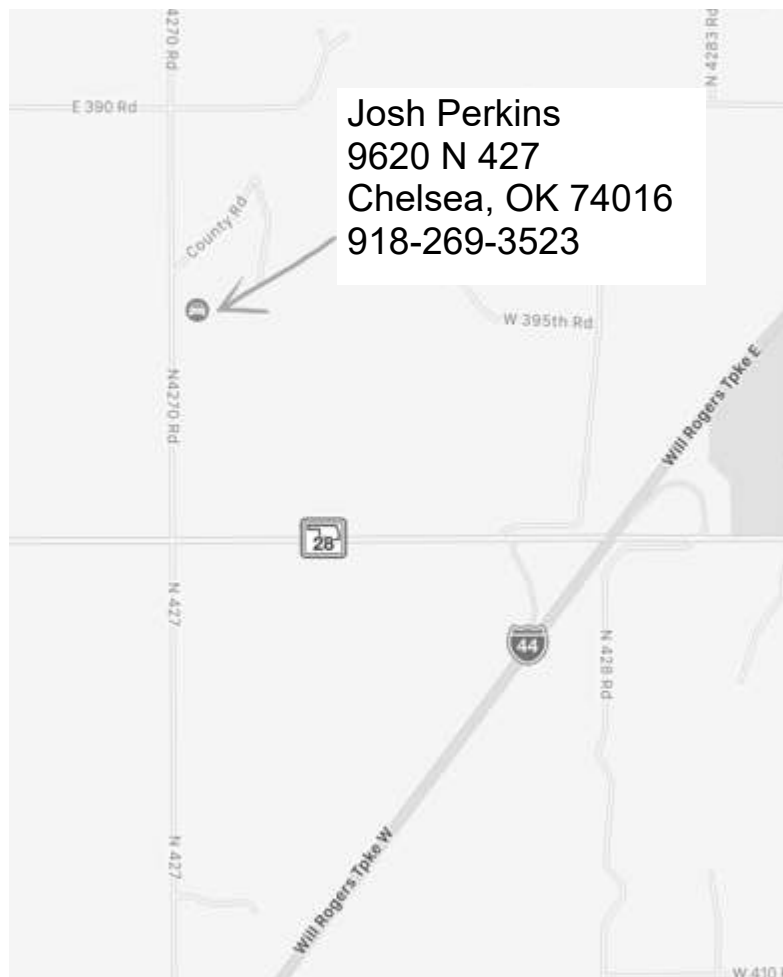
The trade item is any kind of flower. Lunch will be provided but please bring a side dish or dessert to help out. Contact Ronnie Smith at 918-916-3426 or camphope321@yahoo.com.

SW Regional Meeting June 16th : Will be hosted by Ricky Vardell at his shop in Temple, OK. The shop is located in the block southwest of the intersection of Hwy 65 and Hwy 5 (N Commercial Ave) in Temple. (See Map on next page.)

The trade item is a traditional blacksmithing door knocker. Lunch will be provided but bring a side dish or desert to help out. Contact: Ricky Vardell 580-512-8006. Rickyv.vardell@gmail.com

NW Regional Meeting June 23rd : Will be hosted by Terry Kauk at his home/shop in Leedey, OK at 8411 N 2080 Rd. About 2 miles south of Leedey, go east at the intersection of Hwy 34 and Hwy 47. Go 2 miles east from the intersection, then 2 miles south, then 2 miles east, then approximately 1 $\frac{1}{8}$ miles south. Look for a two story brick house with tan shop north of the house.

Trade item is a C-Clamp. Lunch is provided but please bring a side dish or dessert to help out. Contact Terry Kauk at 580-821-0139 if you have questions.



2018 Workshop Schedule

June 30th Tool Making Workshop:

Mandell Greteman will be hosting a tool making workshop at this shop in Foss, OK Saturday June 30th (last weekend in June.) This will be an informal workshop and is free to attend. Lunch will be provided but donations will be accepted for the food.

Bing your own material and bring your own idea for a tool that you want to make.

Mandell and other instructors will be on hand to help you get the tool made, offer assistance, tips, etc. Forges and anvils currently on hand at Mandell's shop will be available for sharing unless you want to bring your own setup.

Prior to the start of the class, Mandell is planning to demo tong making and hardening & tempering. (Possibly subject to change based on who attends and what they want to make, etc.) The workshop is planned to start around 8:30 AM.

This will be a good opportunity to take advantage of some of the experienced talent we have in Saltfork and get some one-on-one assistance with your project.

Remember to bring your own material for the project and have a clear idea of what you want to make!

If you have any questions about the workshop or want to discuss what materials would be appropriate for your project, please call Mandell at the number below.

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.**

Around the State...

NW Region March Meeting: The NW Region March Meeting was hosted by Mandell Greteman at his shop in Foss, OK.







We had a good turnout with 27 people attending. The trade item was three sizes of drifts and there were eleven sets made. We had a lot of work in workshop all day and plenty to eat with lots of desert. Thanks to everyone who brought food.

I would like to thank everyone who attended and helped make this meeting a success.

-Mandell and LaQuitta

(Photos by LaQuitta Greteman and Rory Kirk)

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

SE Region April Meeting: The SE Region meeting was also the date for the 2018 SCABA Annual Picnic which was hosted by Bill Phillips. About 65 to 70 people attended.



The contest was forging five S-Hooks in 30 minutes with the finished hooks being judged on consistency between each hook, overall finish and aesthetics, etc. In the event of a tie, extra points were given for embellishments like a twist and there was a penalty for going over the time limit.

There were two categories - "Master" and "Novice." The Master class had two competitors - Tracy Cowart and Travis Gabbard. Travis was the winner. The Novice class had six competitors - Brad Nance, Andy Merts, Jerney Perkins, Aaron Merts, Josh Perkins, and Jason Odell. Brad Nance was the winner.



Congratulations to the winners and all of the competitors. This was not an easy competition to judge and all of the hooks looked good. As many of you know, it is often no easy task to forge in a competitive setting (or even with one single par of



eyes watching you!) so kudos to all of those who took on the challenge!



Gerald Brostek brought some really nice knives and one of his stunning multi-colored pattern welded axes for display. Ed McCormick brought a fascinating new artistic lamp he created with some unique colorations and textures on the base (there were some hidden features that the picture doesn't capture and some of the base is concealed by the shade.)





I had to leave early and can't give any details but some leftover demonstrator made items from the 2017 SCABA Conference were auctioned off at the end of the picnic.

Overall it was a good turnout for a fairly cold day. Thanks to Phillips' for hosting this year's event!

- Editor

From the Hosts:

I just want thank all of you for coming to this year's picnic. I am sorry I didn't get a chance to





meet all of the new members that showed up. I hope all had a good time. And a special Thank you to LaQuitta and Mandell for coming down the day before and helping with setting up and staying for clean up for the picnic.

And thank you to all those who helped with getting table chairs from church and setting them up and then taking down and getting them back to the church. And Thank You to all of those who helped setting up and serving food and emptying trash. It was a team effort.

Thanks to all who braved the cold to come!

- Bill & Angie Phillips

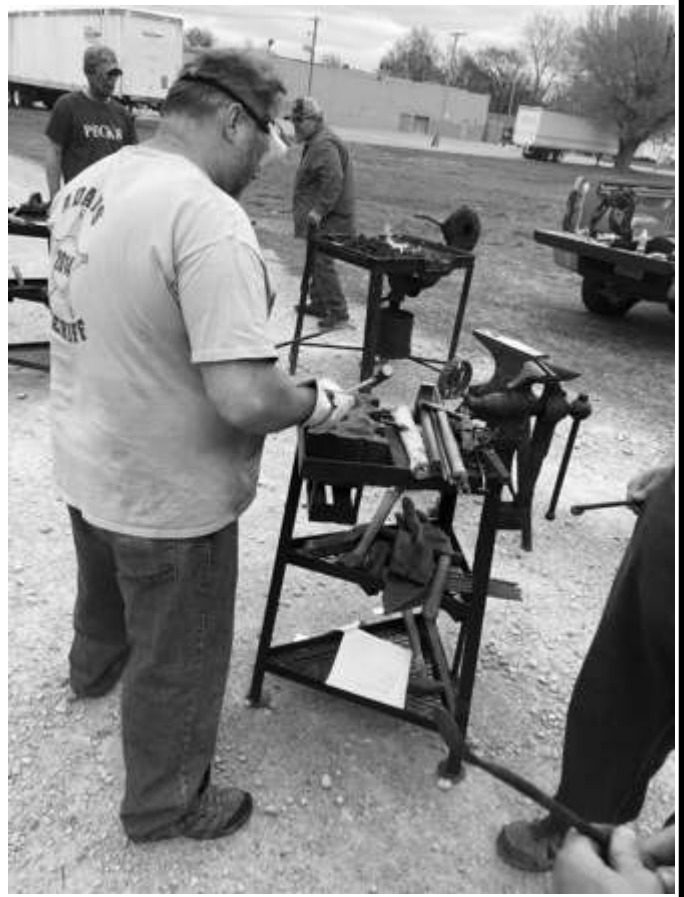
(Photos by the LaQuitta Greteman, Rory Kirk and Editor)

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

Beginner Blacksmith Class - NE Region:

A beginner blacksmith class was held March 31st at Bill Kendall's shop in Tulsa. The instructors were Tracy Cowart, Chuck Waite, Josh Perkins and Brad Nance. Ten students learned to make S-Hooks, flux spoons, chisels, and leaves.





Beginner Blacksmith Class - SE Region:

A beginner blacksmith class was held March 31st at Byron Doner's shop in Norman. There were several instructors and assistants including Byron Doner, Mandell Greteman, Gerald Franklin, JJ McGill, Bruce Willenberg, Anthony Griggs, Terry Jenkins, and Ron Lehenbaur. There were ten students that made a variety of projects.











Billy Goat Foundation Demo:

Some of the NW blacksmiths provided a demo at the Thunder Roadhouse Run Cafe in Oklahoma City April 7th and 8th. The Billy Goat foundation was raising money for families with children who have neuroblastoma cancer. Demonstrators were Samuel Titone, Erin Helvey, and Rory Kirk. It was a cold start in the morning but by evening spectators were showing up making it a good day.

- Rory Kirk







Alicia Lusk demoing at Easter on the Prairie, 03-31 2018 Yukon OK

Member Gallery

I got this commission skillet rack job last month.

The main frame is made from 3/16" x 1 1/2", and it has 10 hooks from 5/16" round. The corners have 1/2" square bars that are flattened to 1/4" x 1/2" on the end that is riveted between the corners of the main frame pieces, and 3/8" tenons on the end that goes through the ceiling.

I welded 3/8" all thread to the end of the tenons to mount the rack to the ceiling, and the square washers are 1/4" x 2 1/2" x 2 1/2" and hammer textured like the rest of the rack. I used two, 1" x 4" boards running across the trusses to catch two bolts each to ensure solid mounting.

The finish is Johnson's paste wax that I applied hot, and then went over with the acetylene torch running only acetylene (which really blackens the

wax), and then rubbed with a clean rag while it was still hot.

It was really a simple project. I did need a second set of hands to hold pieces while I set the 4 rivets that hold the rack together at the corners, but if I would have had two blacksmith's helper stands and a hardy block, I wouldn't have needed help then.

I also needed help doing the install. I needed one person in the attic installing bolts, and one in the room with the rack holding it up to the ceiling. The piece needed to hang close to the ceiling to allow head room as the home only had 8 foot ceilings.

I am also showing a sheet that I give customers when they want large commission pieces if it will help other club members with pricing.

I hope this information is useful to some club members. Sincerely, Travis Gabbard



Member Gallery



Commission Piece Pricing Sheet

Design Fee = \$50

Manufacturing = \$???

Finish = \$???

Installation = \$35/hour plus materials

As I sit with you, as a potential client, to discuss your desired piece of ironwork, there are many topics that we will discuss. Such as, design, varying textures that may be applied, varying finishes that may be applied, budget, and time frame. I require a Design Fee at the time of our design consultation, at the end of which the design is yours in the event that you wish to explore other manufacturing routes. If we agree on a design that I can provide, and pleases you, I require a 50% deposit of the estimated manufacture, and finishing (if the finish is one that I can do in house), cost of the piece before I will begin forging the piece. After manufacture, I will either finish the piece, or take it to be finished by the desired professional, at which time I will require the balance of manufacture and finishing costs. After this point you can either have me do installation (if required) or install the piece yourself. Thank you for considering Great Horned Forge as the Blacksmith shop you have chosen to forge your desires. Sincerely, Travis Gabbard



Abrasives for Belt Grinders

By Billy Helton

Abrasive belts for belt grinders have a vast amount of choices for different applications. Let's go through a quick rundown on some of the differences and definitions to put a lot of information in one spot to help you chose.

We are going to start with the backing material that the abrasive grit is affixed to and some of the different applications for each:

J Weight- This is a flexible backing and typically I use these for handle contouring and some metal shaping. Mostly I use aluminum oxide belts in this weight. It is very handy to clean plunge lines on a knife grind by hanging the belt over the flat platen or hollow grinding wheel about 1/8 of an inch and break it over to soften the line and make smooth transition radiuses.

X Weight- This is a medium flexible weight and typically I don't use this weight very often. Most jobs call for either flexible or rigid weights.

Y Weights- This is a very stiff backing that has little to no flex to it. Generally this weight is used for heavy stock removal. With these Y weight belts being stiff they help define grind lines and plunge lines.

Next up is the abrasive grit that is applied to the backing that we just discussed. This is one of the most important parts to get a handle on. Using the right abrasive for the right material saves money and time and results in less frustration:

Aluminum Oxide (A/O)- This is a general purpose Abrasive that has a very reasonable price range and also has a huge selection of grits, lengths and backings. A/O works best on woods and soft metals, but although it can be used on metal it really reduces the life span on the belts to do so. I typically use these in the J Weight backing for the flexibility in sculpting my wood and bone knife handles.

Silicon Carbide- This form of abrasive grit has very sharp edges that break off revealing fresh cutting surfaces as you grind, but one drawback is that it doesn't like heavy pressure. It tends to wear quickly because of the constant fracturing of the grit. Typically this abrasive is applied to J Weight and X Weight backings.

Ceramic- Ceramic belts are very durable and typically come in Y Weight backings. This type of belt works best on hardened material for jobs like rough grinding, profiling, and general heavy stock removal. These belts tend to be 2 to 3 times the cost of A/O belts. Typically these belts come in grits from 24-120 grits but because of the grain structure they don't go above 120 very often.

Zirconia Oxide- Zirconia abrasive is the middle of the road abrasive between aluminum oxide and ceramic. It takes medium to heavy applied pressure well and cools very nicely reducing heat buildup in the belt. It has a middle of the road price range. I have found that this abrasive grit doesn't like mill scale or heat scale. It tends to gum up while grinding so it is a better choice to grind on clean metal.

Structured Abrasive- I use these a lot on my finish blade grinds but don't know of a good way to describe these so I am going to use 3M's description: "Consists of a series of unique 3D structures that contain multiple layers of abrasive distributed evenly across the belt's material. While in use they wear away to continually expose fresh minerals to the surface". I use these on a lot of my blades before I start the hand sanding process. These are referred to as gator belts sometimes.

Conditioning belts- These belts are great for a brushed finish. They come in course, medium, fine and very fine ratings. When I sand a blade that it is a general purpose blade that doesn't get a hand sanded finish, I use these for the final machine brushed finish.



Coatings- There are a variety of coatings that are applied to these belts sometimes. These are cooling agents that help in the belt cooling. Keeping belts from overheating will prolong their useful life. When belts build up too much heat from grinding and friction from the flat platen the glue can start releasing the abrasive that was applied to the backing. When you see different colors on belts, those are often the cooling agents and the manufacturer will usually describe that in their product description.

Scalloped Belts- these are very handy belts that typically come in a/o or silicon carbide. I use mostly 1" wide belts. The edges don't have a straight edge but are very wavy which keeps the edge of your belt from digging into your wood, bone or others soft materials. I prefer them in a J Weight also for superb flexibility.



Directional Belts- A majority of the belts on the market are directional belts and will have arrows on the inside to indicate the direction. This has to do with the direction the abrasive was applied on some belts and others are referring to the direction to run because of the seam in the belt.



The knife maker's belt choice, which typically is the 2" x 72" belt grinder, has a huge selection available for all of these belts we discussed. As for suppliers, there are a bunch out there and I would encourage you to compare prices as there can be a big difference between suppliers for the same product.

One of the big things to consider is shelf life of the belts you buy. Most suppliers only warrant their belts for three months. This may be more important to some than others because they will only last a certain amount of time depending on actual use but when stored in improper conditions they do deteriorate. I recommend to not store them in areas that are subject to high heat like a closed up shop in the heat of summer or in very humid areas. With that said, I do keep mine in my shop where those conditions do fluctuate and very rarely do I have any seams come apart.

Belt Grinder Safety - Remember to Use a Respirator

As a full time Knife maker grinding daily, safety is a real concern as particles can be very hazardous to your lungs. Even when only grinding occasionally, you should be concerned about safety and follow appropriate procedures to protect yourself for your unique situation, methods and materials.

Today's resins that are used to stabilize woods, micarta, G-10 and most bone material are very toxic and should be given extra caution. I use three different types of filter systems. There are numerous systems on the market and you will be able to find the one that fits you best. Here are the three that I use:

- 1) Respirators that cover the mouth and nose tend to be good respirators for knife makers. They have a fine micron filter and replaceable air filter cartridges for long life of the main mask. These typically run from \$20-\$75 depending on brands.



- 2) Another choice that I use a lot is the R-Z full face covering neoprene masks that are Velcro attached and are a lot less bulky in size for prolonged use. R-Z mask company has several models and sizes that range from \$25-\$40 (www.rzmask.com). This mask is easy for quick use also and has mid range protection.

(Continued on next page...)

Billy Helton, owner of Helton Custom Knives, is a full time blade maker and blacksmith from Claremore, OK. Billy was featured on one of the early episodes of Forged in Fire.

You can visit his website at: <http://heltoncustomknives.com/>

- Editor





- 3) One of my favorites is the Resp-o-rator. It allows me protection from harmful particles but gives me the flexibility of quick removal for small or very quick needs in grinding projects. This mouth piece is very similar to a scuba divers mouth piece and works quite well. You can find these on Amazon or www.duxterity.com. Price is around \$20.



I hope you find this information helpful in sorting out and using the many choices in abrasives available for your 2x72 belt grinder.

- **Billy Helton**

Being a Classy Craftsman *Take Pride in Your Work as a Blacksmith*

It was about 2001 the first time I encountered a blacksmith. My parents and I were attending the Edinburg Ole' Time Festival where I witnessed the late Bill Moss demonstrating behind the anvil. My interest was instantly peaked. I had been taught as a youngster the art of Swedish wood carving by my father, but the idea of working spoons out of metal instead of wood inspired me. It was a feeling that I could not overcome. It wasn't long after that I heard about the apprenticeship program at the Museum of American Frontier Culture. Being homeschooled at the time, I convinced my mother to drive me to the museum (an hour away) two to three times a month so that I could train as a blacksmith. After an application to the museum, an essay on why I wanted the job, and a lengthy interview, I was admitted to apprentice under Russ Stallings. The year was 2002.

My first several times at the museum were not exactly what I had expected. My first assignment by Russ was to spend days in the museum library studying the numerous publications on Blacksmithing, reporting back to Russ at the end of the day on what I had learned. Later we took a road trip to Williamsburg and other places where I met gentlemen such as Peter Ross, Ken Schwarz, Chris Furr, and Lee Sauder. At the time I did not know the significance of this. I learned later that Russ was instilling in me a respect for the masters that had gone before me. Once I finally got to work with Russ out in the shop I was tasked with what many of you may consider crazy. On the shop floor was an enormous pile of scrap steel which had accumulated; cast away pieces of years gone by. My job was to take each piece and forge them out into quarter inch square bars. Later these bars would be forge welded end to end, and subsequently they would be used to make nails for the daily demonstrations. It took me the rest of that first year to master the hammer control to accomplish this. The skills I learned from it were vital. After completing several lengths of bar, forge welding, and learning how to make nails, I was charged with forging a spoon. At last I could make what I had first sought out to! What I didn't expect though was all of the filing. You see, Russ took great pride in his work. At least half of that pride was put into the finishing process, or so it seemed. I spent hours at the vice, filing all of the rough edges off of that first spoon. I learned that until it is finished, it isn't finished.

I don't remember the exact date that I first joined up with the Shenandoah Valley Blacksmith Guild. It was sometime around 2003 I think. I remember it was right after the guild moved to their new location at the buggy shop. Finding the guild was like going to heaven for me at the same time. Surrounding yourself with mentors who all know more than you do is the best and quickest way to learn your craft. As a teenager in the guild I progressed quickly with my skills. I earned some recognition in the local paper and lots of people started asking me to make things for them. Briefly I worked my way through a bladesmithing phase. I enjoyed going to numerous events. I especially enjoyed the few that the Museum used to host. It wasn't long though before life, marriage, children, etc. began to take over my heart. None of those were bad things. But I grew stagnant as a blacksmith, infrequently attended guild meetings, and became a general disappointment to myself and sometimes to others.

One of the mentors that I can remember disappointing is our very own Dale Morse. Sometime around 2014 I brought a project to the guild meeting to show. I received general praise by all but one person, Dale. After the meeting Dale privately approached me and said something like, "Drew, your design was good, but why did you half-ass your finish? You've been around a while; I know you can do better than that. Next time do your best." For the past several years this has stuck in my brain almost weekly. Dale may not remember this conversation, but I took it to heart. What was my piece lacking? It was lacking my pride. I did not put all of my pride into it.

I just want to quickly break down what I believe every piece that we forge should have. Many of these things were missing from that piece that I received valuable criticism for. This list is not complete, but are things that took me a while to learn, and am still.

1. Texturing: The texture of the piece should always be considered before construction. Part of this is choosing the proper size stock for your project. Is the bar too thick? Would a narrower stock look better? How will it be textured? Will the piece be polished smooth?
2. Design: Before beginning your project you really should spend time with a paper and pencil, or a piece of chalk, and draw out how your project will look. It is much easier to make adjustments with chalk than it is after you start forging. Ask yourself, is this design elegant? Does it have good flow? Where are my connections? How will I assemble it?
3. Assembly: How will your piece be assembled? Will it be welded? Will you forge weld it or use an electric or torch weld? If you use an electric weld, will you be able to conceal the weld with a collar or by other means? Will you use rivets? What sized rivets are needed? Do you have a rivet head tool? Will this piece look better if I add another material such as wood, leather, or brass?
4. Finish: Will the piece be wire brushed, sanded, filed, or etched? Will it be painted or clear coated?

At the risk of sounding pretentious I want to express my concern that if we don't treat blacksmithing with respect, it will quickly become a brutish act instead of the art form that it is. I want to be a Classy Craftsman, not a brutish blacksmith; remembering those that have gone before me, taking pride in my work, and staying classy.

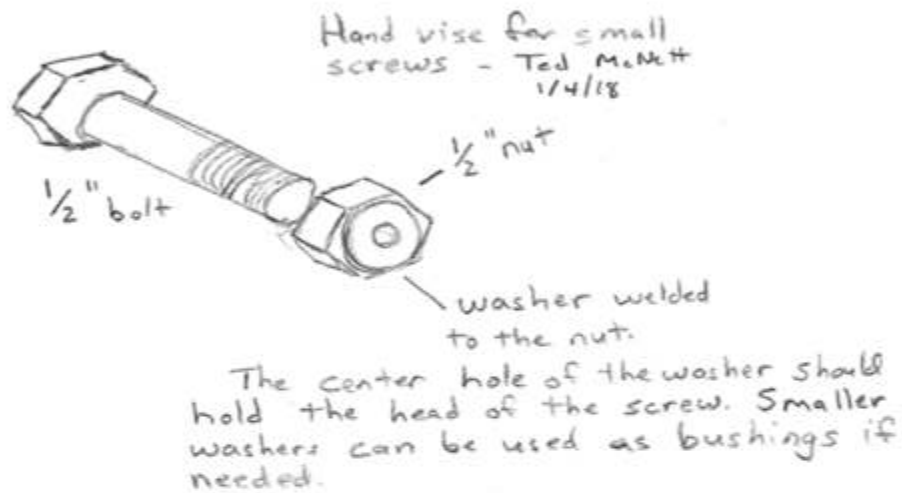
Regards,
Drew Alexander
January 2018

General Notes - Continued

Shop tip from Ted McNett, BGCM

Hand vise for small screws

Drawing by Ted McNett, Sample and Pictures by Ray Plank



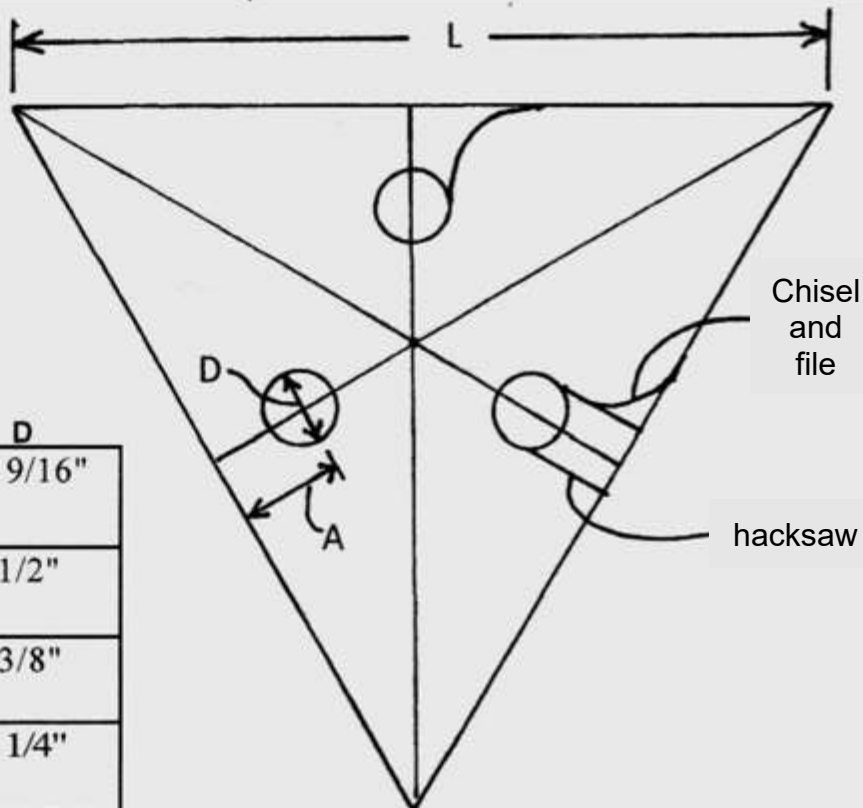
This article is re-printed courtesy of the Shenandoah Valley Blacksmith Guild, Now and Then Newsletter, April 2018

Trillium

by Steve Anderson,
a MABA member.

STOCK-12 gauge sheet steel.

For a cluster of three, cut one of each size. Other groupings as well as individual flowers can also be made.



	L	A	D
LARGE LEAF	5 3/4"	7/8"	9/16"
MEDIUM LEAF	4 5/8"	3/4"	1/2"
SMALL LEAF	3 1/2"	1/2"	3/8"
FLOWER	3"	3/8"	1/4"

1. Use a narrow fuller to form the center vein in each leaf. Then while hot, use a cross pein to create vein lines. Keep leaves symmetrical and lines radiating from the same point:



2. Cup centers (a forged ring works well), then curl leaves down over the horn while only curling the tips of the flowers slightly outward:



3. Forge a mounting frame from 5/16" round stock. Bend to a "V", forge weld and forge down to 5/16", then bend 1/2" up at 90 degrees and drive down to form a round disc 5/16" thick:



Arrange large leaf (with flower), medium, and small leaves to your liking, placing them close enough to hide the frame. Bend frame to line up with arrangement and cut off ends 1/4" beyond center of flower.



Bend ends up 1/2" then forge down to form 5/16" discs.

5. Drill discs for 3/16" rivet and countersink the back side. Drill center of leaves and flower (do not drill before forging). Make a 1/4" tall

spacer to slide over the rivet between the flower and large leaf to raise the flower up.

6. Before riveting, wire wheel all parts, use a brass brush to highlight the flower, and apply the first coat of clear coat.

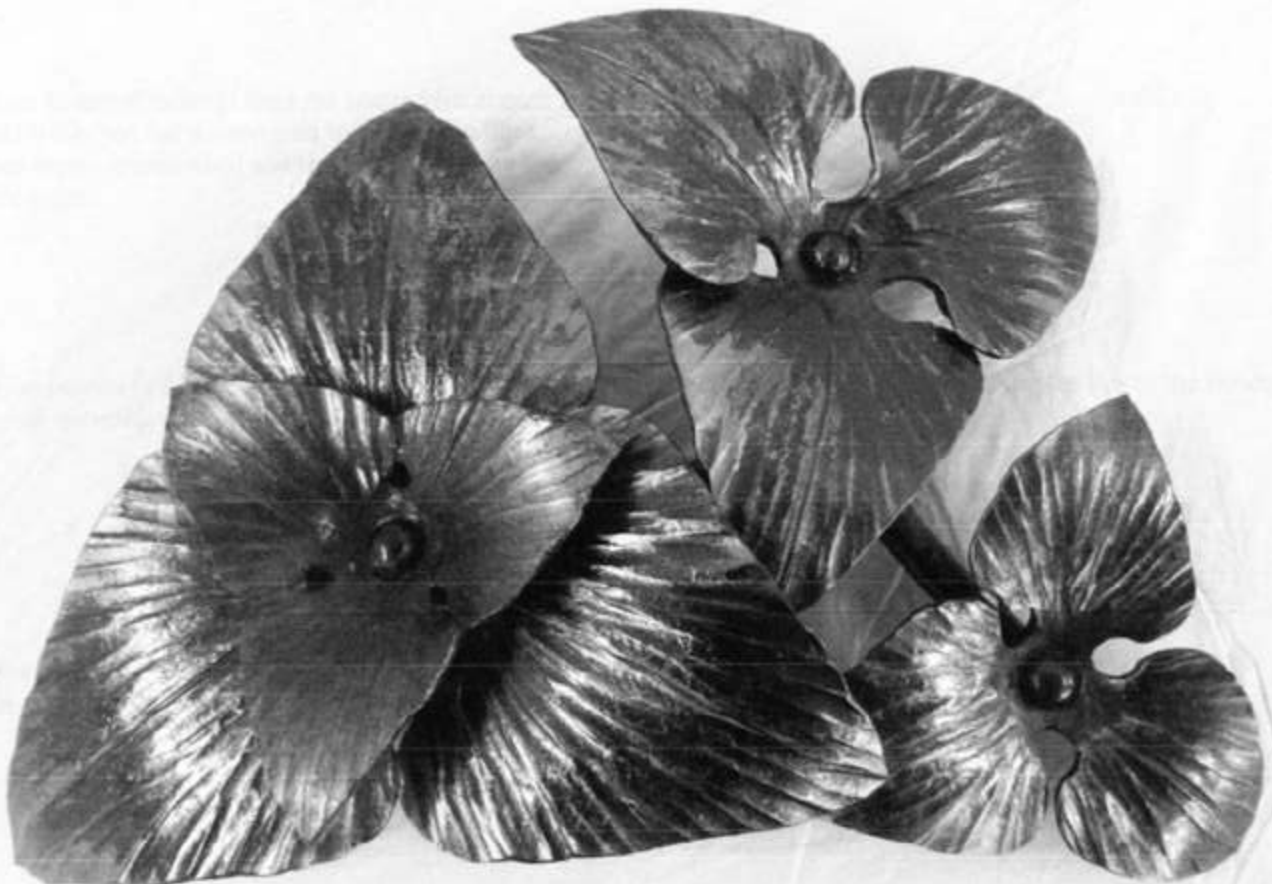
7. Rivet the two leaves and the leaf with flower using a narrow rivet set that will not damage the leaves. Arrange to hide the mounting frame and to line up the flower so the petals fall between the leaves before riveting solidly.

8. Apply final coat of clear coat and 3 coats of wax.

Trilliums
photographed at
Fernwood
Botanical Gardens-MI



Reprinted from The Upsetter Michigan Artist Blacksmith's Association May-June 2014



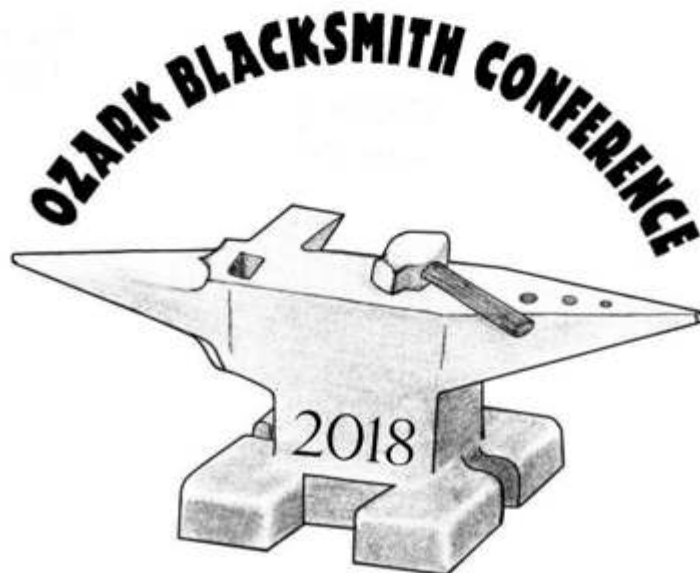


27th Annual Ozark Conference

May 3rd - May 6th , 2018

Missouri State Fairgrounds
Sedalia, MO

pre-registration must be postmarked by April 1st



Demonstrators will be Pep Gomez , Fred Crist , and Mark J. Hopper

**For conference details and registration information, visit the
Blacksmiths Association of Missouri Website:**

<http://www.bamsite.org/>



STEAM AND GAS ENGINE SHOW

PLEASE NOTICE

Fri-Sun, May 4-6, 2018

THIS

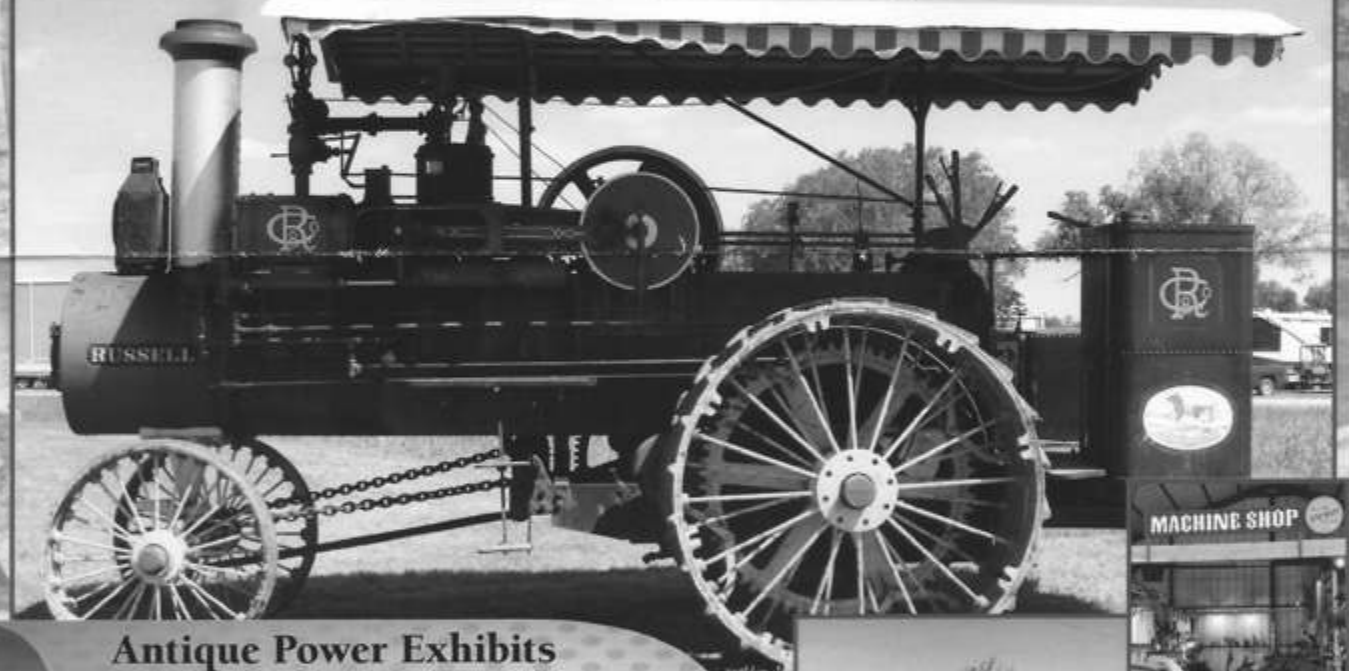


Gates Open ● 8:00 am

Steam Park Grounds Historic Pawnee, OK



Oklahoma Steam Threshing & Gas Engine Association



Antique Power Exhibits

• Fun Family Events •

\$10/Day-\$15/Multi-Day Pass

• 12 & Under Free •

FRIDAY IS SCHOOL DAY

(Free Admission to School groups accompanied by teacher)

SAW MILL - MACHINE SHOP

WHEAT THRESHING

CORN GRINDING - SHINGLE MILL

OklahomaThreshers.org • 918.762.2108



SOUTHWESTERN IRONWORKS

TAILGATE SWAP MEET

MAY 19, 2018

8:00 AM to _____?

**302 W. College
Guthrie, OK**

**All Hobby Machinists,
Blacksmiths & Woodworkers,
Bring your unwanted tools and
equipment to
Buy-Sell-Trade**

Contact Information:

David King (405) 348-0476

Cell: (405) 426-0476

Bob Paddack (405) 642-5243

MISSISSIPPI FORGE COUNCIL

Memorial Weekend Conference

May 26 & 27

Featuring Bob Patrick

Mississippi Agricultural Museum

1150 Lakeland Dr

Jackson, MS 39216

601-432-4500

Learn to make a hammer with Lyle Wynn

See attached registration form to reserve your spot.

Mississippi Forge Council Memorial Weekend Conference

May 26 and 27, 2018 Saturday and Sunday
Location: The Agricultural Museum
1150 Lakeland Dr. Jackson, MS 39216

FEATURED DEMONSTRATOR

BOB PATRICK: TRADITIONAL FORGING REGISTRATION FORM

Please Print Legibly

Name: _____

Phone _____

Address _____

Email _____

Registration \$60.00 X _____

Lunch \$10.00 X _____

T-Shirt \$20 X _____ size _____

Stainless Tumbler \$20 X _____

Hammer Class \$100.00

Thursday, May 24 _____

(Choose date)

Friday, May 25 _____

TOTAL \$ _____

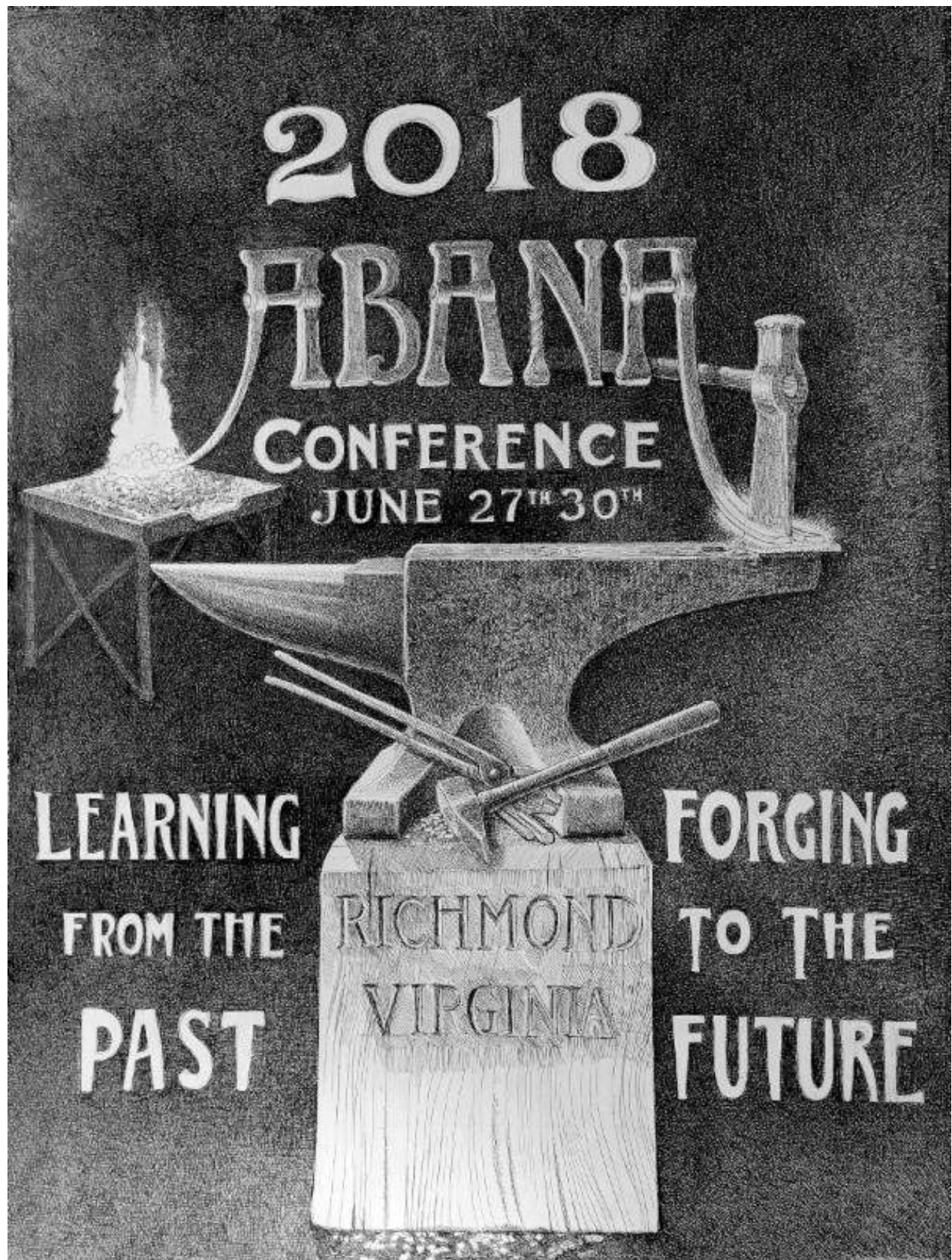
**Mississippi Forge Council
P.O. Box 320744
Flowood, MS 39232**

More information call 601-540-6030

Make a hammer with Lyle Wynn Thursday or Friday \$100

Contact: toolstomaketools@gmail.com

To reserve your spot



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, Don Garner, if you would like to get a copy of this DVD.

Don Garner: 580-302-1845

(Call or Text. If you get voice mail, Please leave a message.)



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

Librarian: Don Garner 580-302-1845 (Cell)

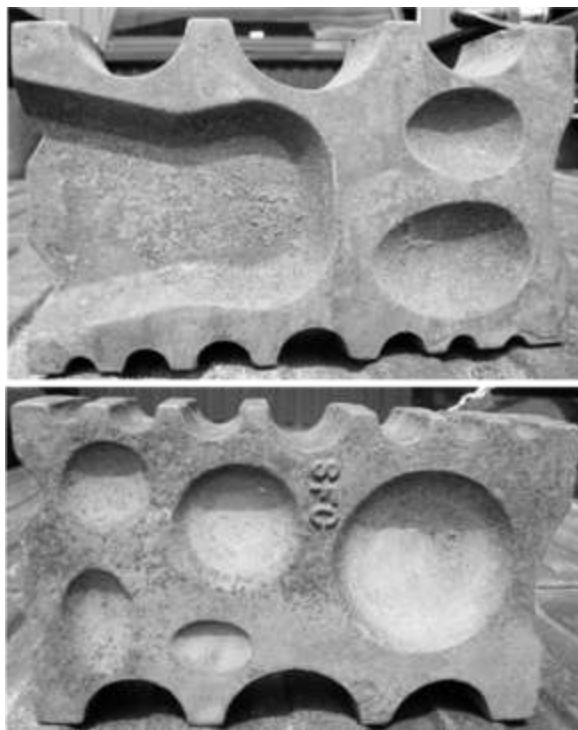
Call or Text. If you get voice mail, please leave a message.

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 Swage Blocks

\$200.00 plus shipping.
(Same price to members and non-members.)



SCABA Floor Cones

\$200.00 plus shipping.

(Same price to members and non-members.)

To order swage blocks or cones, contact our distributor:

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 Josh Perkins 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.

SCABA T-Shirts

SCABA T-shirts and long sleeve denim shirts: 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 Josh Perkins (918) 269-3523.



SCABA Membership Application

January 1, 2018 to March 31, 2019

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 \$30.00 for dues for the period ending March 31, 2019

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

Non Profit Organization
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Permit #2177

Address Service Requested

