

Saltfork Craftsmen

Artist-Blacksmith Association

August 2020



Textured Pot Rack and Texturing Tools
By Gerald Franklin
(Page 20)

The 2020 Annual SCABA Conference is CANCELED.
(Details on Page 7)

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Editor's Notes:

Just last month in this same space, I had just announced that the board of directors had recently met and decided to continue moving forward with the 2020 Conference. At that time, a lot of COVID-19 restrictions were loosening and it looked like the trend would probably continue.

I don't think any of us were expecting that COVID would cease to be a concern but we thought there was a good chance of making the Conference happen. We were concerned and closely watching a number of issues that might undermine our plans. We even had several contingency plans worked out for some of those. But shortly after making that announcement, it became clear that the 2020 Conference was just not to be. Hopefully, we will be back on track in 2021.

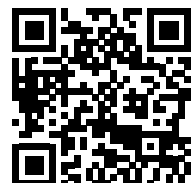
We still don't have the normal level of regional meetings so the newsletter is noticeably light. I would like to thank all of the other affiliates who share content as it is even more critical now than ever. And I especially want to thank our members who are continuing to send in projects or gallery photos. Without that content, we wouldn't have much of a newsletter. This month, Gerald Franklin sends information on a nice project and some texture tooling you can make yourself to get some really interesting results!

-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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President's Notes:

Hello everyone. I hope everyone is doing well. I don't have to tell you how hot it has gotten. It seems to really hurt me when it gets so hot since I have gotten older.

We as the board of SCABA have decided to cancel the conference in 2020. It has been a hard decision to make and we regret having to make it very much. But we want everyone to be safe and looking ahead we don't know what the future holds at this time. I don't think anyone does. You watch the news and get different stories everyday.

We look forward to having a very good conference in 2021 if everything gets back to "normal."



Everett hosted a great meeting last month at Elk City Museum. I don't know if it was because it has been so long since we had a meeting or what, but I had a very good time.

The trade item was an Egg spoon which no one knew what that was until it was looked up. Everett brought his outdoor cooker set and most of us cooked eggs in the trade item spoons. He had tortillas warmed up and they were very good. I don't think anyone had a hard time with staying apart for safety. We played like a bunch of youth around the fire while some did forging. It is very fun when someone thinks outside of the box for the meeting trade items.

You can never have enough tools.

Thanks, - Mandell

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.

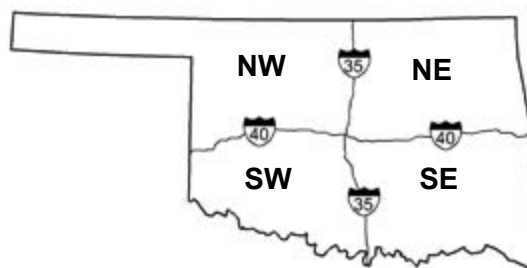
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

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.

****Oklahoma State Fair Canceled****

Many Saltfork members usually volunteer annually to demo at the Oklahoma State Fair. Michele Blasius coordinates the time slots for the volunteers each year. She wanted to let everyone know that the fair board has recently canceled the fair for 2020. And thanks to everyone who usually volunteers. Michele said she will try again next year. - Editor

Coronavirus Safety Concerns/Event Cancellations:

With recent developments concerning COVID19, a large number of blacksmithing related events have been canceled for safety reasons. It will be more important than ever to stay posted with websites, social media, etc. and to double check before assuming events will be held.

-Russell Bartling, Editor

Membership Dues:

Thanks to Eric Jergensen, starting with April, **your membership expiration date is now printed on the back of the newsletter.** Memberships are no longer limited to the March to March duration but are a full year from the date of registration or renewal. So, the back of the newsletter will now be a quick reference to check your renewal date. - Editor

2020 Workshop Schedule

Currently no workshops are scheduled.

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.**

Where is YOUR Part of the Saltfork Gate Project?



This is a community project that is open to all Saltfork members. The project is a four-foot-high by sixteen-foot-long gate to be displayed outside at the Route 66 Blacksmith Shop Museum at Elk City.

Secure your place in Saltfork History FOREVER!*

**(This statement has not been verified by God, Mother Nature, Father Time, Current Scientific Understanding of Metal Oxidation, or the Elk City Museum Management. But probably for a long, long time at least. - Editor)*

Participating members will be given a steel ring that can be filled with any (family appropriate) forged work that will fit in the ring and be permanently attached to it.

Mandell Greteman is coordinating the project and will provide the standardized rings. All of the rings will be provided to ensure they are a standardized size. Once the projects are returned, Mandell will weld them into the gate to be displayed at the museum.

You can submit multiple entries if you would like. If the gate fills up and we have extra entries, we can do additional gates.

Your Facebook post will most likely be forgotten in two days but daily visitors from around the world will see your gate project for years at the Elk City Museum. Don't forget your touchmark!

Contact Mandell if you have any additional questions or to find out where to obtain one of the project rings: **Mandell Greteman 580-515-1292.**

**** CANCELLATION NOTICE ****

The 2020 Annual SCABA Conference is Canceled

After much deliberation and attention to current events, the Saltfork Craftsmen Board of Directors has reluctantly concluded that we must cancel the Annual SCABA Conference for 2020.

Our primary focus is on the safety of the participants, demonstrators and volunteers that make the conference happen. We also want to present the same family friendly educational and entertaining blacksmithing experience and hospitality that Saltfork has become known for providing over the years.

Due to recent re-escalation of COVID-19 related cases and the resulting restrictions and safety guidelines, it has become apparent that we will not be able to present the conference to reasonably meet those minimum standards. It now appears that the safety guidelines and restrictions will remain in place through the remainder of the year. That includes international and state travel restrictions which impact our planned demonstrators. It also includes social distancing and meal prep/delivery guidelines that are impractical to implement for the planned blacksmithing demonstrations and venues available.

Unfortunately, it takes lead time to plan and implement a conference of this magnitude and we have reached the point where confirmations must be complete, or we have to cancel the process. And the current environment has proven that many confirmations either cannot be made reliably or cannot be made at all.

Rest assured, the Board does not make this decision lightly. And, assuming the COVID-19 situation will be under control by then, the Board is committed to continue bringing the same high level educational event back in 2021. The best is yet to come.

- Editor

2020 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 4th (Open)	Jan 11th (Byron Doner)	Jan 18th (Open)	Jan 25th (Rory Kirk)
Feb 1st (Open)	Feb 8th (Byron Doner)	Feb 15th (Open)	Feb 22nd (Monte Smith)
Mar 7th (Open)	Mar 14th (Open)	Mar 21st (Bruce Willenberg) CANCELLED	Mar 28th (Mandell Greteman) CANCELLED
Apr 4th (Open)	Apr 11th (Open)	Apr 18th (SCABA Picnic) CANCELED	Apr 25th (Don Garner) CANCELED
May 2nd (Open)	May 9th (Open)	May 16th (Ricky Vardell) CANCELED	May 23rd (Terry Kauk-CANCELED)
			May 23rd (SW-JJ McGill Boy Scouts-CANCELED)
Jun 6th (Open)	Jun 13th (Open)	Jun 20th (Jim Obenshain -CANCELED)	Jun 27th (Everett Timmons)
Jul 4th (Open)	Jul 11th (Open)	Jul 18th (Open)	Jul 25th (Mandell Greteman)
Aug 1st (Open)	Aug 8th (Open)	Aug 15th (Open)	Aug 22nd (Open)
Sep 5th (Open)	Sep 12th (Open)	Sep 19th (Ricky Vardell - JJ McGill - Sulphur Tractor Show) **CANCELED**	Sep 26th (Ron Lehen- Bauer as Host - Don Gar- ner as Contact Person)
Oct 3rd (Open)	Oct 10th (Conference Setup Work Day)	Oct 17th (Conference Weekend)	Oct 24th (Rory Kirk)
Nov 7th (Open)	Nov 14th (Bill Phillips)	Nov 21st (Open)	Nov 28th (Bob Kennemer)
Dec 5th (Open)	Dec 12th (Open)	Dec 19th (Open)	Dec 26th (Open)

2020 Fifth Saturdays:

February 29th (Tong Making Class in Elk City - See Workshop Schedule)

May 30 (Open)

August 29th (Open)

October 31st (Open)

August 2020

NE Regional Meeting August 1st : Open.

SE Regional Meeting August 8th: Open.

SW Regional Meeting August 15th: Open.

NW Regional Meeting August 22nd: Open.

September 2020

NE Regional Meeting September 5th: Open.

SE Regional Meeting September 12th: Open.

SW Regional Meeting September 19th: **CANCELED.**

NW Regional Meeting September 26th: Will be hosted by Ron Lehenbaur (Don Garner as contact) at the Fairview Tractor Show. Directions: 1 ½ miles east of Fairview on Hwy 58. Watch for signs on the north side of the road.

The trade item is actually two items. The first is a blacksmiths double caliper with loop for hanging (Originally the trade item for last April's meeting which was canceled.) The second trade item (new for this meeting) is an adjustable trammel.

Forging will be set up outside under the shade trees with a six foot distance roped off between forges and spectators. Please bring your portable forge kit. We will attempt to comply with state and federal COVID safety guidelines as much as possible.

Lunch will be provided but please bring a side dish or dessert to help out. Contact: Don Garner 580-302-1845 if you have questions.

***This meeting and the tractor show are planned to take place at this time. But planning ahead is difficult and uncertain with COVID issues changing daily. If you plan to attend, keep an eye on the next newsletter, e-mail announcements, and the Saltfork social media posts for any updates. ** - Editor*

Around the State...

NW Region June Meeting: (Following Page)

NE Region July Meeting: No Meeting was held.

SE Region July Meeting: No Meeting was held.

SW Region July Meeting: No Meeting was held.

Around the State...

NW Region June Meeting:

On June 27, 2020 Everett Timmons hosted the Northwest Region monthly meeting at the Elk City Route 66 Museum.



It was nice to see the familiar faces after our absence of meetings. In total seventeen smiths showed up with ten trade items turned in. The group had a few guests come and go along with some visitors to the museum.

The group had too much fun playing with the trade item for the month, so not a lot of forging got done in the morning. The trade item was an egg spoon which is used to cook an egg on an open fire.



It was decided that all trade items had to be quality checked by the maker cooking an egg in their spoon, that is when things got fun.

A swing grate fire pit was on hand to provide the fire. It was amazing to watch smiths who turn out works of art and tools with fire, hammers, tongs and dies with exact designs, try to balance the spoon with one hand and crack an egg with the other! Some egg went into the fire I am sad to say. In the end several breakfast burritos and a couple of omelets disappeared to never be seen again.

Mandell Greteman brought his Dutch oven rig and provided a cherry cobbler as his side dish for lunch which was very well received.













If you haven't got to get into some of that Dutch oven cherry cobbler, you have missed some good food!! Maybe once a year we need to park the forges and have a Dutch oven class!



After lunch some work got done with many of us getting pointers from the experienced smiths on how to refine our work and skills.

As hard as it is for many to believe you cannot learn all there is to blacksmith work watching You-tube. You still have to swallow some pride and sit at the feet of the masters and learn the trade, even if they are younger than you. You can not replace the time with your fellow smiths in learning the craft which was very evident in the conversation and fellowship in the forge.

It was a very good meeting to start out on after being closed up so long.

-Everett Timmons

Photography by Laquita Greteman



Member Gallery

Dragon Heads By Bruce Willenburg

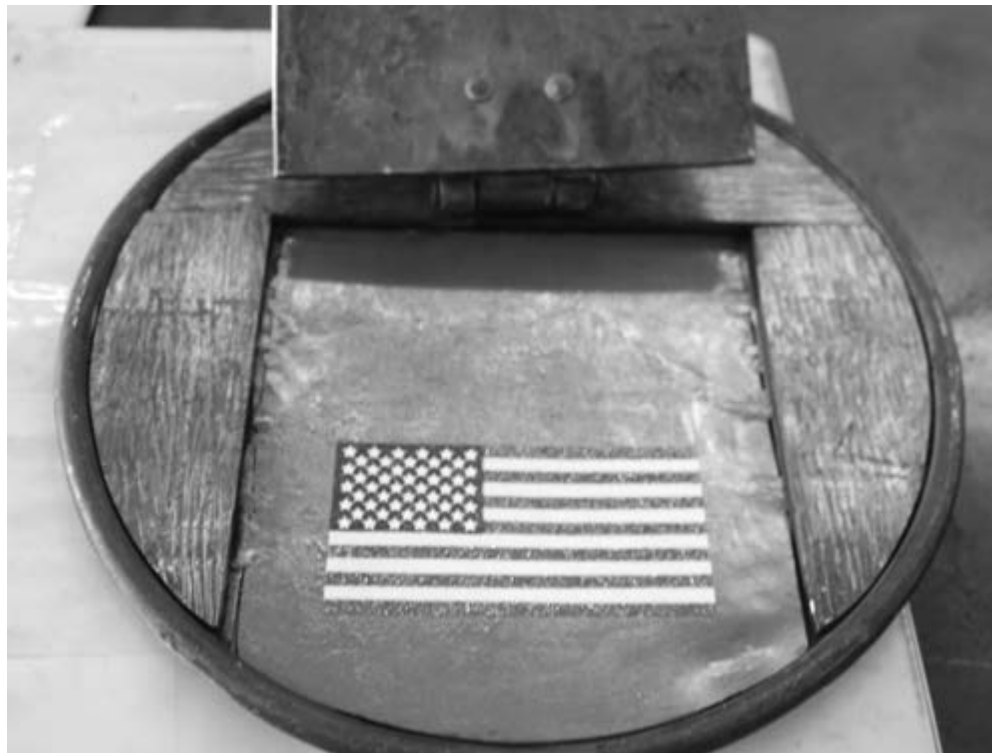
Bruce sent photos of his first ever dragon heads based on the how-to article by Rory Kirk in the July 2020 newsletter. He said these were just practice and that he probably never would have started without the guidance from Rory's article. Bruce said he is working on the next pair! Bruce wanted to say thanks for the information and inspiration to try something completely new. Looks great Bruce! And thanks for the kind words! - Editor



Member Gallery (Continued)

Saltfork Gate Project By Bruce Willenburg

The latest Saltfork Gate Ring Project is by Bruce. It has a surprise inside! - Editor



Textured Pot Rack

By Gerald Franklin



Photo 1: The Finished Pot Rack

I finished a pot rack recently (Photo 1) and wanted to share some of the “specs.”

The texture die (the part on the left side of Photo 2) was used to texture all of the $\frac{3}{16}$ ” x $1\frac{1}{2}$ ” material. Texturing was done hot with the power hammer.



Photo 2: The Texture Die
(Left Side Was Used for Pot Rack)

The head of a $\frac{1}{4}$ ” X $1\frac{1}{2}$ ” lag bolt was de-plated and distressed with a ball punch and center punch. (Photo 3.)

Double and single hooks (Photo 4) were forged from $\frac{1}{4}$ ” square stock and textured with the same die in Photo 2.



Photo 3: Distressed Lag Bolt



Photo 4: Double and Single Hooks

The rack curves out from the wall by about 3” or so. The wide rail and the narrow rail were curved at a 36” radius.

The narrow (top) rail provides a bumper for the hooks to hold them on the rack in case the cook bumps one of them while getting a pot/pan off.

The hooks at each end of the rack are single hooks since a double hook won’t clear the wall behind the rack (Photos 5 and 6.)



Photo 5: Pot Rack End Detail



Photo 7: Pot Rack Wall Bracket Detail



Photo 6: Pot Rack Center Detail

The wall brackets have a slight offset and are riveted to the main bar.

More on the texture tool:

The texture tool that I used is mounted on a Kick Ass 75 hammer, but a treadle hammer, sledge hammer, or about any sort of hammer would work.

It mounts on the bottom die and is bolted on with the 5/8" – 11 bolt at the lower left. (Photo 8.)

I make the little tool spuds up in a batch of several so that when I get ready for a new tool, I don't have

to try to remember how to make the spud. By the way, I keep a dedicated ratchet with deep well 5/8" socket hanging on the tool rack beside the KA75. It saves scurrying around trying to find the right wrench when other things are happening.

The tool itself is just a piece of scrap mild (I think) steel with 6011 rod run across it. I let the rod sort of undercut the bead which makes it look like it was gouged ahead of time. This undercut was not planned, it just happened that way since I was making sure I got penetration with the bead.



Photo 8: Texture Tool on the KA-75

After the bead was cooled and wire wheeled, I took the height down a bit with a 60 grit flap disc so it wouldn't be so severe. I suppose that an undressed bead would work but the texture would be really deep.

The 6011 or equivalent mild steel rod will hold up fine since all work is done hot. This particular die is at least 12 years old since that's how old the KA75 is. I have no idea how many feet of material this die has textured.

Note: I made a similar texture tool for Friedrich's crosses from an old ball peen hammer. The peen was reshaped into a really sharp cross peen for the wood grain effect and the face was treated with stick weld bead for the "distressing" side. It works very well.

The "wood grain" texture beside the weld bead side is done hot, of course, with a simple hot cut chisel. It textures well for many applications and has held up well over the years. The grooves need to be brushed out between passes since they tend to fill up with scale.

If you remember the little table that I brought to one of the conferences (Photos 9 and 10), it was wood grained with a tool made from this die. I wanted the wood grain for the table to be a little "softer" than this die provides so I made a paddle type tool from this die into a piece of 4140 and welded a handle onto it (Photo 11.) This second generation paddle/die was then used to texture the "wood" for the table top, hot, on the KA75. Again, I don't know how many feet of material this paddle tool has textured, and being made from 4140, it's really durable.



Photo 9: Simulated Wood Grain Table

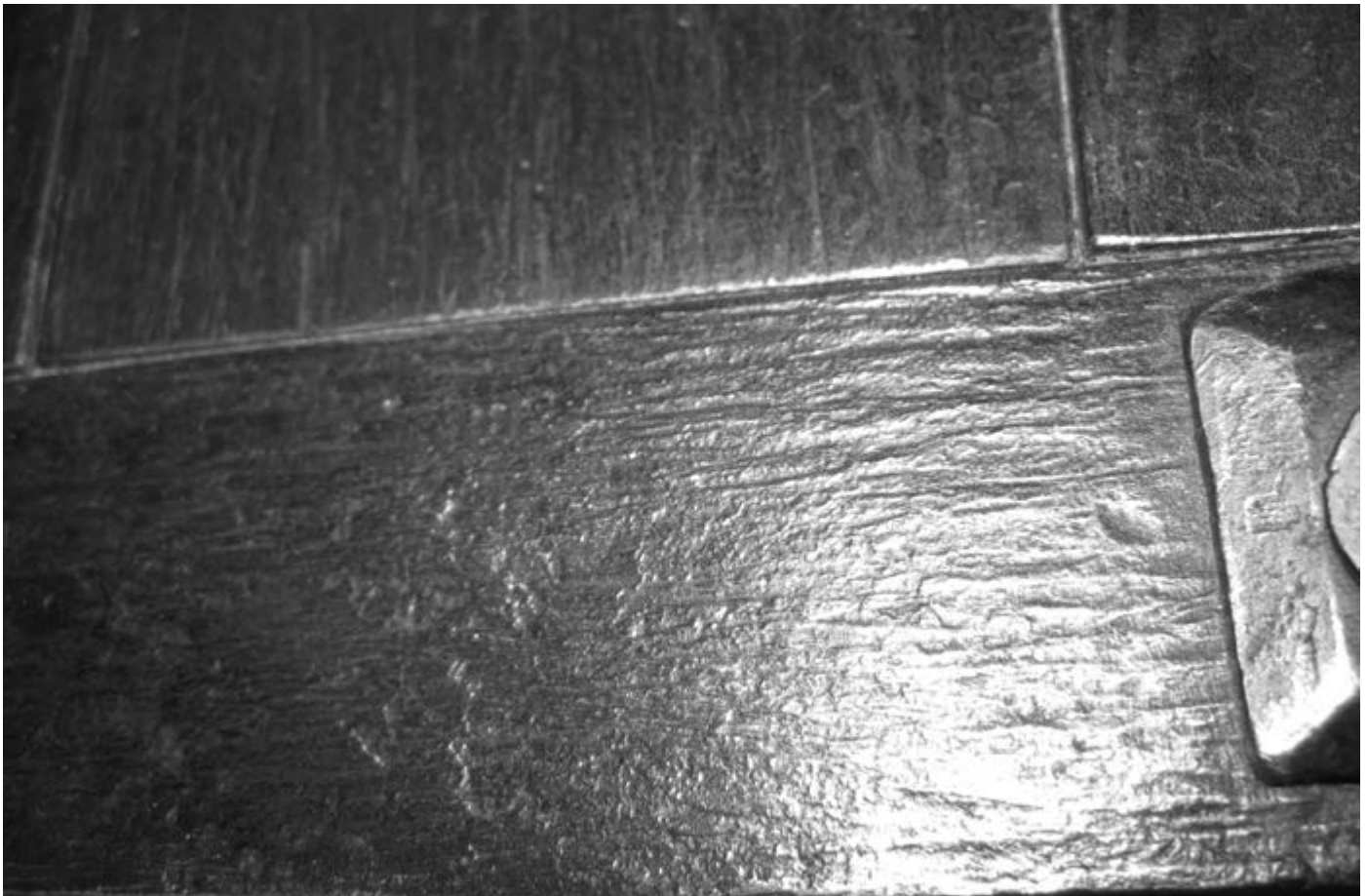


Photo 10: Detail of the Simulated Wood Grain



Photo 11: Hand Held Paddle Die Created from Power Hammer Die in Photo 2

- Gerald Franklin

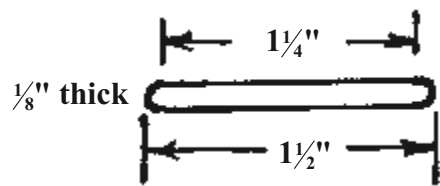
This and the following article are a review of the fundamental procedure of slot punching and drifting for a square/rectangular pass through blocking. This will be a useful skill if you want to try one of the projects that will be in the September newsletter. Stay tuned... - Editor

Slot Punch

story & illustrations by California Blacksmith staff

Awhile back Mark Aspery of Springville, California, dropped off a punch and a sample 1" round hole in a piece of 1¼" x ½". He prefers punching because the sides of the opening are left clean. With a splitting chisel, a ragged flap is often left. It must be removed if the hole is to be left open. The flap, which cools fast, may distort the hole when drifted. However, almost no material is lost.

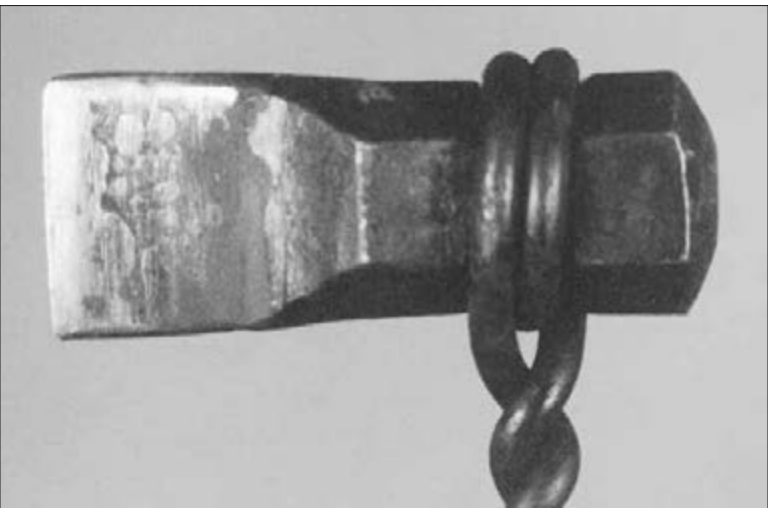
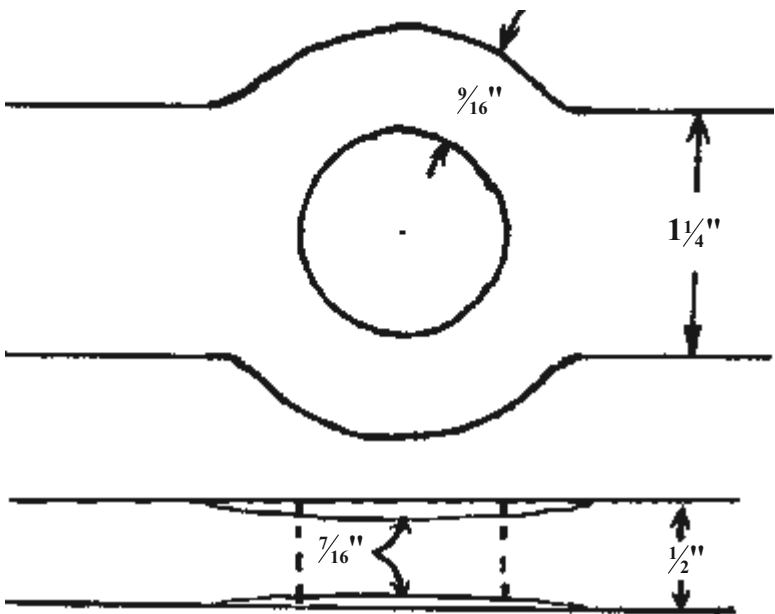
When making a punch, the perimeter of the punch should be a little less than that of the desired hole. The thickness should be ⅛". As you can see from *Picture 5*, the amount of material lost is the area of the punch and a little over ⅓₂" thick. For the 1" round hole, the business end of the punch is:



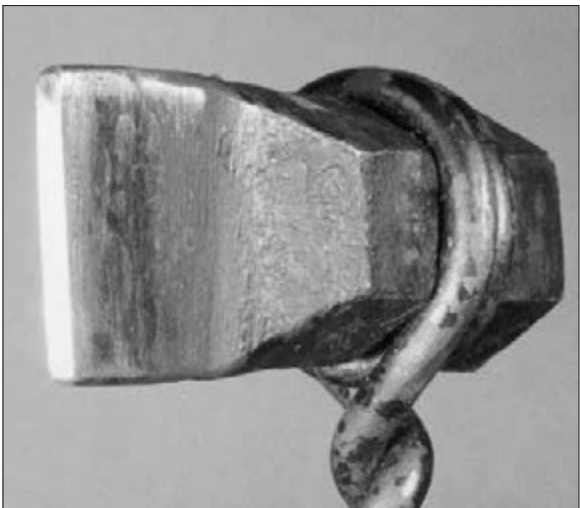
It might even be ⅛" or ¼" shorter.

Mark's comments on the finished hole:

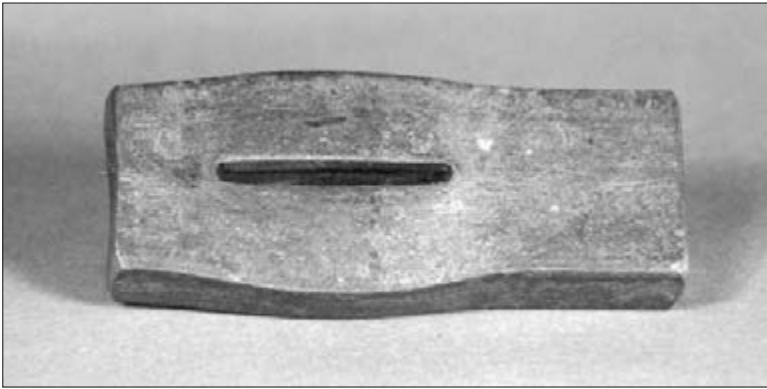
- 1. With the 1¼"-wide bar and the ⅛" thick punch, each side was ⅙" wide. Good.
- 2. The maximum thickness of the sides lost is ⅙₁₆", which could have been prevented by upsetting prior to punching.



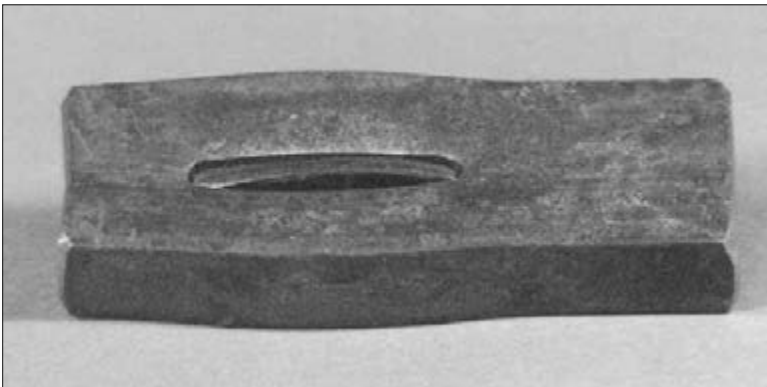
1. Mark's punch.



2. Working end of the punch, ⅛" thick and flat.



3. At a yellow heat, the punch is hammered in. Be sure to cool the punch every two or three blows. Hammering stops when the sound changes. (The thin metal next to the anvil is cold.) Displaced material is pushed sideways – causing the frog's eyes. Mark quickly turned the piece over, placed the punch over the dark area and hammered down to shear and move the waste.



5. The waste is a little over $\frac{1}{32}$ " thick.



6. Notice the cleanly sheared wall.



4. For show and tell, Mark didn't knock out the waste.



7. The drifted 1" hole. ♣

Square & Rectangular Blockings

by Mark Aspery, Springville, California

Blockings are used when you want a square or rectangular bar to pass through another bar. Both styles of blockings are formed by upsetting the slot-punched hole and then drifting it to a new size and shape.

First the math. There is a math formula that will get you in the ballpark with regard to the size of the slot punch needed for the final drifted hole. Starting with the square blocking, let's work through the math that will help us calculate the dimension of the slot punch needed.

You know the size of the square bar that you want to pass through the blocking. Let's say it is $\frac{3}{4}$ " square. Take a circle that has the same diameter as one side of the square. That will give you a $\frac{3}{4}$ " diameter circle. Now work out the circumference of that $\frac{3}{4}$ " diameter circle.

$$C = \pi \times d$$

Where **C** is the circumference, π is approximately equal to 3 and **d** is equal to the diameter of the circle, which in this case is $\frac{3}{4}$ ".

$$C = \pi \times d = 3 \times \frac{3}{4} = \frac{9}{4} = 2\frac{1}{4} \text{ inches}$$

From here you have to work backwards from the final tool. You know from earlier projects that slotting punches about $\frac{1}{8}$ " thick work well in that they stand up to the rigors of use and yet are small enough not to drag the eye. With the upset eye, the circumference of the slotting punch is equal to the circumscribed circle, in this case $2\frac{1}{4}$ ".

We know that the slotting punch has two half-round ends that when added together must make a circle, and we know the diameter because the tool is $\frac{1}{8}$ " thick. Therefore you have a $\frac{1}{8}$ " diameter circle.

When you take the circumference of this smaller circle away from the circumference of the larger circle ($2\frac{1}{4}$ "), that will leave you with the combined length of both sides of the tool.

So, first the circumference of the small circle:

$$C = \pi \times d = 3 \times \frac{1}{8} = \frac{3}{8} \text{ inch}$$

Subtract the $\frac{3}{8}$ " from the $2\frac{1}{4}$ " and that will leave the combined lengths of the two sides. From there you have to divide the result in half to give the length of one side.

$$2\frac{1}{4} - \frac{3}{8} = 1\frac{7}{8} \text{ inch}$$

Divide the result by 2 to get the length of each side.

$$1\frac{7}{8} \div 2 = \frac{15}{8} \times \frac{1}{2} = \frac{15}{16} \text{ inch}$$

So now let's add all that together to get the total length of the tool. You know already that it is $\frac{1}{8}$ " thick. You have two half-circles each of $\frac{1}{8}$ " diameter and $\frac{1}{16}$ " radius, and the length of one side is $\frac{15}{16}$ ". The length of the punch will be the sum of the radius of the first and second half-circles and the length of one side.

$$\frac{1}{16} + \frac{15}{16} + \frac{1}{16} = 1\frac{1}{16} \text{ inches}$$

So the slotting punch will be $\frac{1}{8}$ " thick by $1\frac{1}{16}$ " long. As this slot will be upset, it does not matter that the length of the punch exceeds the width of the drift as in non-upset slotted holes.

OK, we are ready to go to work. Make a slotting punch to the above dimensions.

Use a piece of material $1\frac{1}{4}$ " x $1\frac{1}{4}$ " and a convenient length for upsetting on the floor anvil. First you need to conduct a test to determine how much the bar will stretch, shrink or if it will remain unchanged. You should be able to give it a rough guess. You know that the slot will be $1\frac{1}{16}$ " long and that it will eventually be a $\frac{3}{4}$ " square. That means the ends of the slot have to come in $\frac{5}{16}$ ". So the overall bar length should shrink by at least that much. Make two punch marks in the center of the bar, one at the 4" mark (one side of the slot) and one at the 1" mark (a datum).

Using a pair of dividers, set the legs at the distance between the two marks. I know that it should be 3", but the dividers will be a more accurate way of determining the change in measurement. You can offer this pair of dividers up to the 1" mark and the edge of the hole after you have completed your test to find out how much they did move. You will be conducting this test by taking measurements from one side only as the stock will be quenched from one side only. In other circumstances, you would take a measurement from both sides of a forging to get an average.

As you are working on what is, in effect, the end of the bar, I am presuming that you will place the other end on a work stand that is on your side of the anvil.

Take a light welding heat at the 3" to 4" mark and slot punch the hole. The side of the slot punch nearest you should rest on the center punch mark made at 4". That means that the slot is between the 4" mark and the end of the bar.

Take a heat around the slot and quench out the end of the bar to within $\frac{1}{16}$ " from the start of the slot. Why $\frac{1}{16}$ "? You will be upsetting the material around the slot and eventually turning the slot into a circle. The sides of the slot need to be able to move. They need at least their

own width to do that. As the bar is $1\frac{1}{4}$ " wide, and you have taken $\frac{1}{8}$ " out for the slot, that should leave you with $\frac{5}{16}$ " on each side. Try to keep the heat to just around the slot. Don't get it too hot further up the bar or it will upset at the same time as the slot. If you are working in a gas forge, you will have to quench both above and below the slot (to within $\frac{5}{16}$ " or so) before upsetting the slot.

If this is a production job, I would use a rose bud on an oxy/fuel system and get the heat that way.

If, per chance, the slot is off to one side or the other, mark the thin side on the edge of the bar away from the hole. You will be referring to this mark later.

Turn the bar 180° after each time that you throw it into the floor anvil. That will help keep the upset even. Upset the hole until it becomes round. Take care as you approach the round stage, for the hole will tend to collapse rather than upset. One side will look significantly better than the other due to the slot punching process. Using a round drift, reshape the hole to a perfect round. Don't try to stretch it too much.

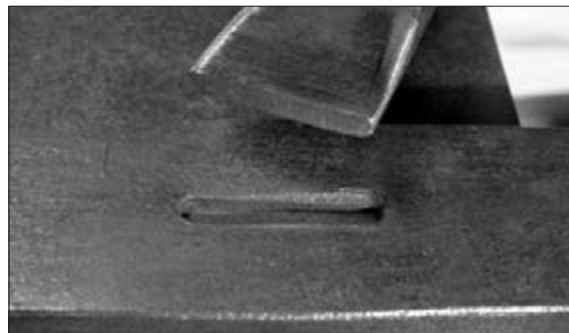
At this stage the bar may not be straight and level. If you leave the bar in that condition and you apply the square drift, to which side of the bar will you align the side of the drift? Lock the bar in the vise, and using a straight edge, align the bar on either side of the hole.

Now you are ready to apply the square drift. If your slot was off to one side, the thick side of the hole wants to go down in the coals. By leaving the thin side up and uncovered by coals there will be a difference in heat to the two sides. If you work quickly with the drift, the thicker, hotter side will now stretch in keeping with the thin cooler side. Maybe, if you are quick enough, you will now thin the thick side and bring the hole back to the center.

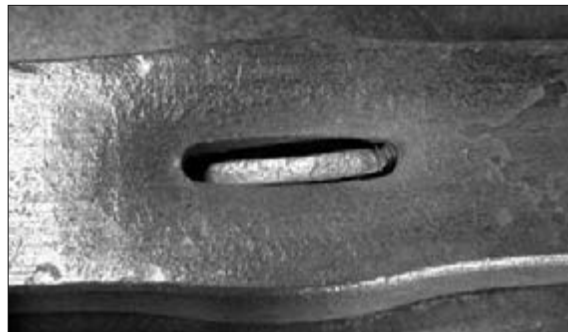
If you are working in a gas forge, you will have to quench the thin side to achieve the same effect. The disadvantage of quenching is that the cold side now acts as a heat sink and sucks heat away from the rest of the eye. That will cut down your forging time on the anvil per heat.

Drive in the drift from both sides. I like to have flat sides to the blockings. In order to get the flat sides, I need to forge them in. I don't want to stretch the eye, so I forge them in lightly (so as not to penetrate the whole of the bar), and I start to flatten the sides quite early in the drifting process, certainly before I have driven the drift fully through the hole.

Using your dividers, check to see what happened to the length of the stock between your center-punch marks. Knowing this alteration in length, you can apply it to the layout as you mark each hole.



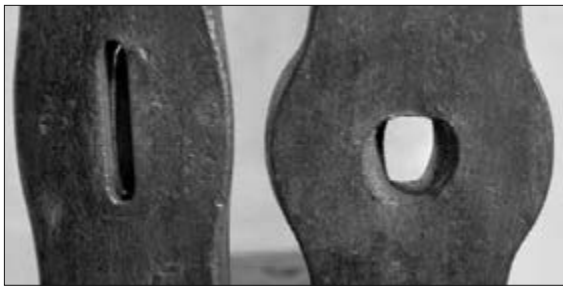
The slot after a few blows and the business end of the slot punch.



Result of the slotting process. The slug is left in for demonstration and should be removed by the smith.



The result of the first upsetting. The original slot on left is shown for comparison.



The result of the second upsetting. Note the shape of the hole in the back differs from the front.



Correcting any deviations with the stock held in the vise. Sometimes two hammers are required.



Check for alignment of the sides on either side of the hole. A piece of scrap plate was used.



Starting to drift. Note that the sides of the drift are parallel to the sides of the bar.



Starting to dress the sides of the blocking. Use light blows so as not to stretch the hole.



Return to drifting the hole. Remember to work from both sides of the material.



Refine the edges still further.



The square blocking complete with a taper to the end of the bar and a tenon drawn.



The blocking fitted to a hinge style. ♣

22 California Blacksmith

This article is reprinted courtesy of the California Blacksmith Association newsletter Jul/Aug 2003.

Editor's Note: This article was written by IBA member Ray Phelps and was published by the Rural Smiths of Mid-America newsletter in 1994. It has since been reprinted by the Alabama Forge Council and by the Philip Simmons Artist Blacksmith Guild before coming to us.

Ray's Coat Hook

The coat hook shown here is one made by Ray Phelps at his forge as a demonstration piece for our R & M A meeting of Jan. 1994. The basic design for the hook is one shown in "The Hammer's Blow," p. 8; Fall, 1993.

Ray made modifications in the original plans that most of us felt were improvements.

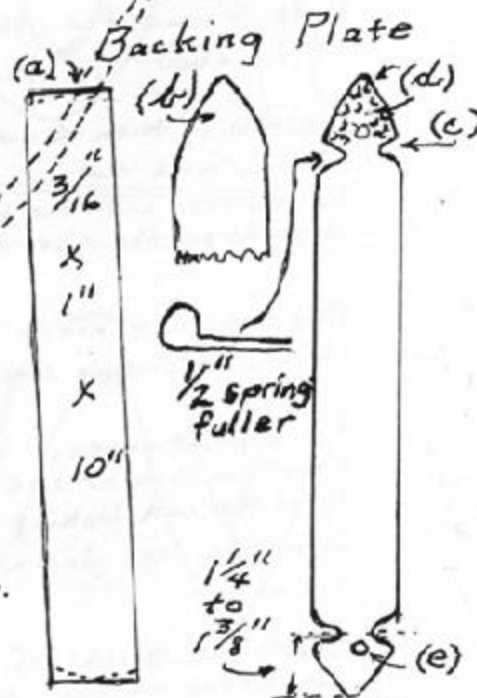
1. (a) He began by rounding the ends of the backing plate with a file (a) to prevent cold chutes.

(b) The ends were then shaped for arrowhead finials.

(c) Notches were made as shown at (c) about $1\frac{1}{8}$ " to $1\frac{3}{8}$ " from the ends.

(d) The edges of the arrowhead were chamfered with a hammer and rounded up toward the centerline. Hammer marks were left in to simulate the shipping marks seen in a real arrowhead.

(e) Holes were drilled in the arrowheads ($\frac{1}{4}$ " (as shown at (e)) for wall mounting.



Demo by Ray P.
Write-up by Jim Mc.

Coat Hook (cont.)

2. ^(a+b) To make the hooks, Ray used the flat stock shown, first drilling holes at (a) and (b) 3" and 4" from their respective ends. Holes were $\frac{3}{32}$ ".

(c) He then split each end up to the holes.

(d) All the arms were spread and each was upset on the end.

(e) Each end was notched about $\frac{3}{8}$ " in from the end (but moderately).

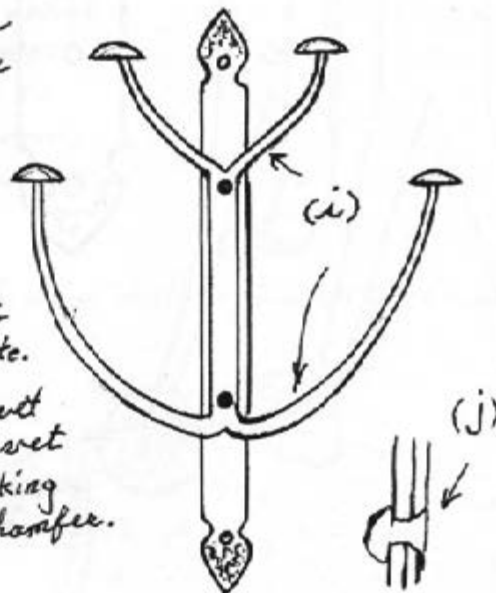
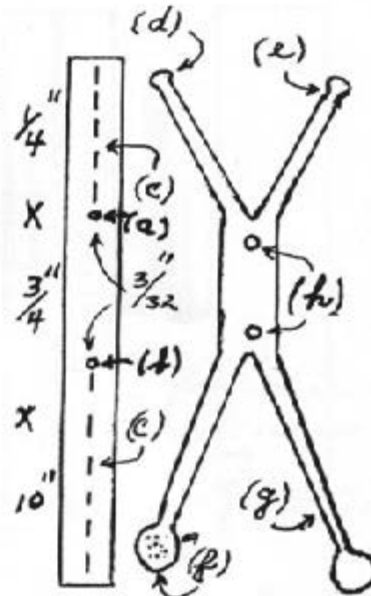
(f) Ray forged a $\frac{3}{4}$ " to 1" penny-foot on each end, cupping each one according to its final position. (See below before cupping.)

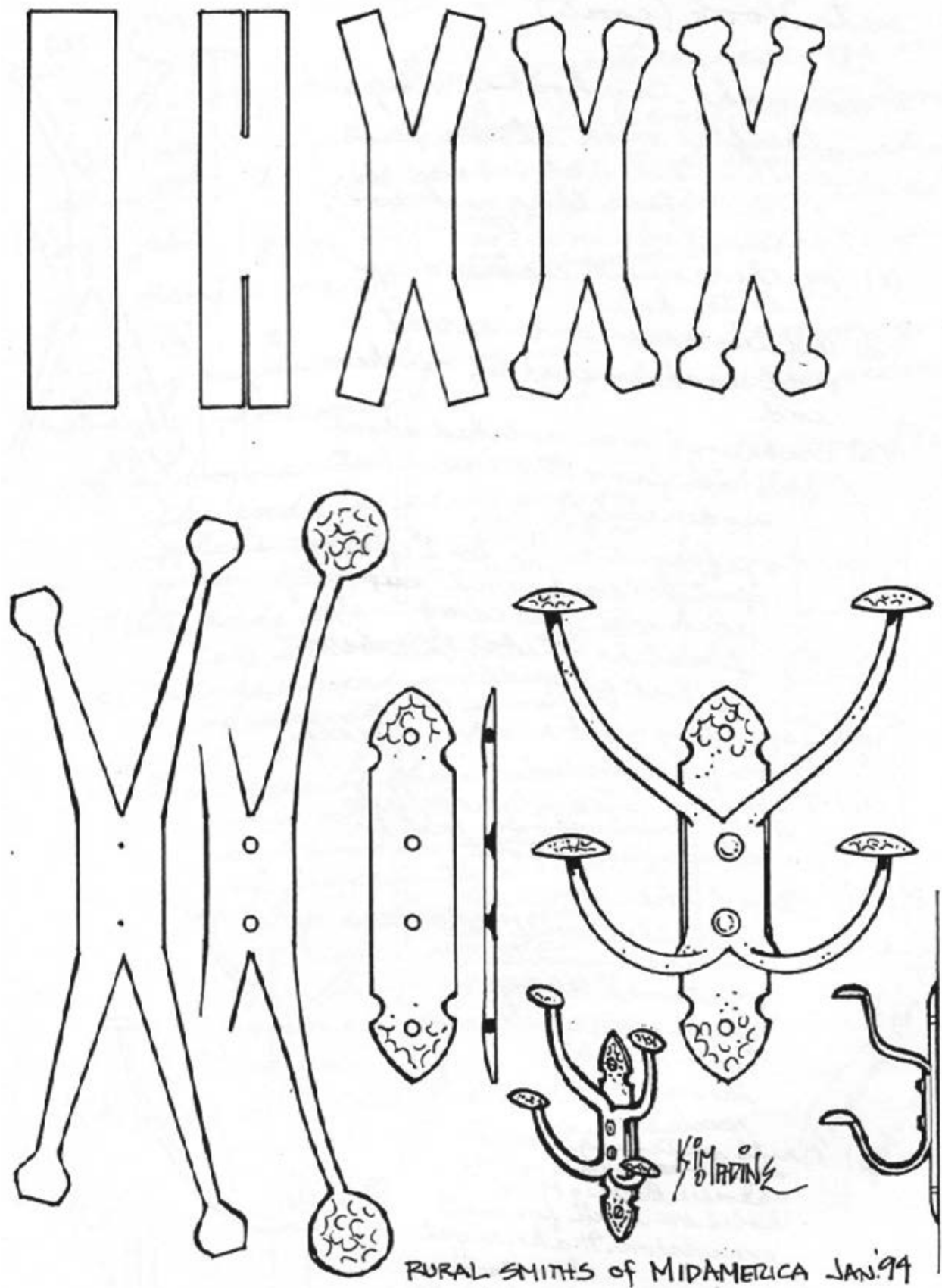
(g) Tapering and rounding each arm came next.

(h) Mounting holes were drilled. This step could be last to reduce distortion.

(i) Bend the arms so that they will be an appropriate distance away from any wall you might mount your rack on.

(j) Drill matching mounting holes in Backing Plate. Chamfer Backing Plate holes on back for rivet expansion. Make rivet $\frac{3}{16}$ " longer than Backing Plate thickness for $\frac{1}{3}$ " chamfer.





This article is reprinted courtesy of the Indiana Blacksmithing Association newsletter The Forge Fire - June 2020.

2020 SCABA T-Shirts

For a LIMITED time, new 2020 SCABA T-Shirts are available. These were planned to be the Conference T-Shirts (an annual tradition) but since the conference is canceled, the design has been modified to acknowledge the reason for the cancellation. (And it infers how most people feel about COVID-19!)



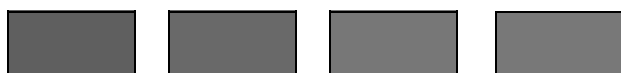
Gildan Adult Heavy Cotton™ 5.3 oz. Pocket T-Shirt

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Available Colors: View the Newsletter Online to See the Sample Colors Available



Graphite Heather

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Red

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Safety Green

Sapphire

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Remember When Choosing Your Colors: The Printing is Black and White so Lighter Colors Will Have the Best Visibility.



Example: Sapphire



Example: Graphite Heather

T-Shirt Order Form

First Name _____ Last Name _____

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Phone (Best Number to Contact) (_____) _____

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Size	Color	Quantity	Price Each	Sub-Total

Shipping: \$2:50 for first shirt plus \$0.25 for each additional shirt:

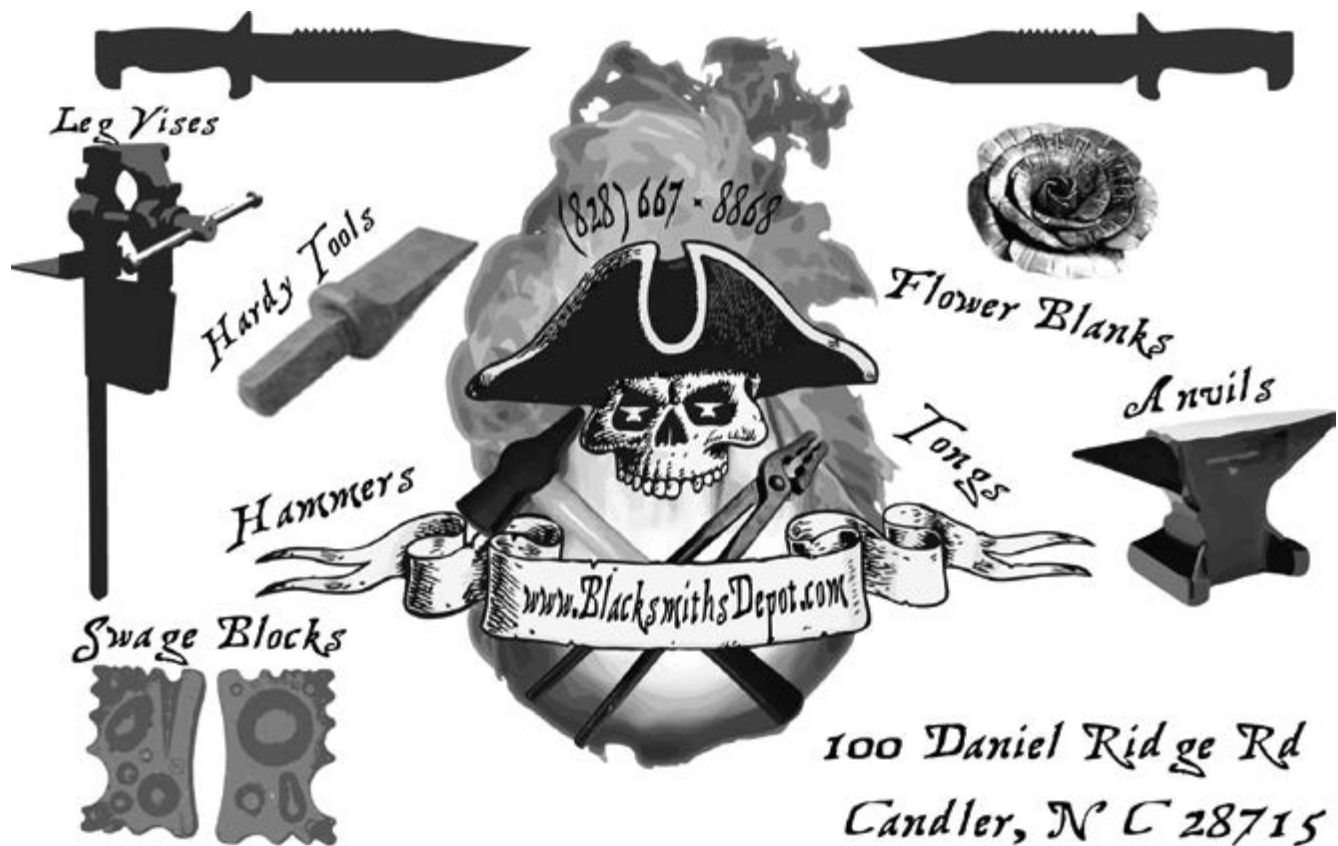
T-Shirt Price:	
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4X to 6X:	\$20 Each

Total:

Mail this form with payment to:

*Teresa Gabrish
322 Washington
Blanchard, OK 73010*

SCABA Shop and Swap



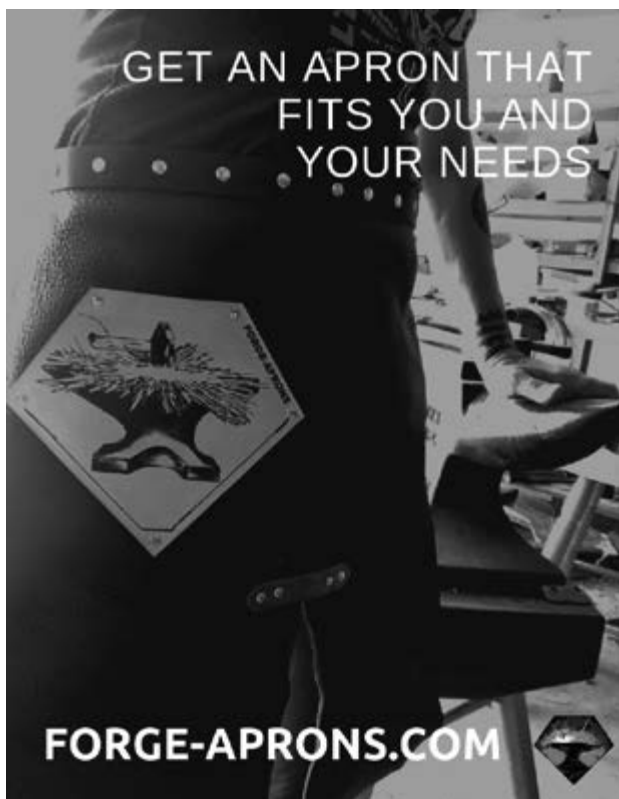
For Sale: 15 Lb Tire Hammers:

\$1,200 for everything from the base plate up. Two rounding dies included as standard. Has 1/2 HP 115V Motor. Contact: David Barfield - 580-595-1476



SCABA Shop and Swap

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SCABA Shop and Swap



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Thank you to our Conference Vendors who graciously donated items for the Conference Auctions!

Their contributions helped to support SCABA. Please consider patronizing these vendors to return the favor!



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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.

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. Inventory is always changing. Contact: Craig Guy (SCABA Member), Piedmont, OK
Cell Phone: 405-630-7769 (Call or Text)

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

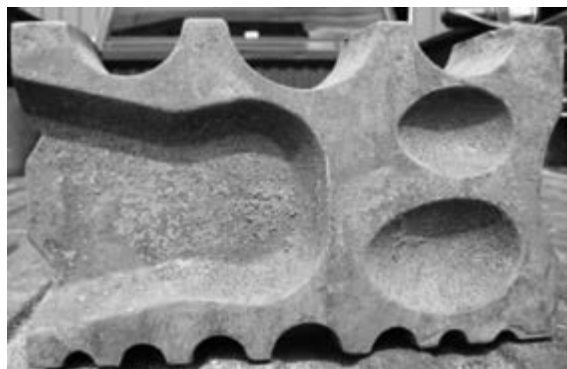
Librarian: Don Garner 580-302-1845 (Cell)
Call or Text. If you get voice mail, please leave a message.

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 Shop 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



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:

****NOTICE****

Charlie McGee is no longer hosting the coal pile in the NE region. If you would be interested in hosting a location in NE, let one of the SCABA Board members know.

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

SCABA T-Shirts!

2018 Saltfork Collector T-shirts are available with the 2018 Conference Logo. \$20.00 (plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.



Legacy SCABA T-shirts and long sleeve denim shirts are also available on clearance while supplies last. T-Shirts are \$5.00 and Denim Shirts are \$10.00. (Plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.

If you would like to purchase shirts, contact Josh Perkins (918) 269-3523.



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 Shop and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have.



SCABA Membership Application

For Annual Membership

(Please Print Clearly!)

Date _____

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Renewal _____

First Name _____ Last Name _____

Married? _____ Yes _____ No _____ Spouse's Name _____

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City _____ State _____ Zip _____

Phone (Best Number to Contact) (_____) _____

e-mail _____

ABANA Member? _____ Yes _____ No _____

I have enclosed \$30.00 for dues for one year membership from the date of acceptance.

Signed: _____

Return to: Saltfork Craftsmen, 6520 Alameda, Norman, OK 73026

Note: Registration online by Paypal OR credit card is available from the website.

www.saltforkcraftsmen.org

You do NOT need a Paypal account to use your credit card and registration/renewal is immediate.



Saltfork Regional Meeting Hosting Form

Region: _____ NE _____ SE _____ SW _____ NW

Date: Month _____ Day _____ Year _____

Name: _____

Meeting Address: _____

Host Phone (Best Number to Contact) (_____) _____

Host e-mail _____

Trade Item: _____

Lunch Provided: _____ Yes _____ No _____

Please provide detailed directions and/or a map to meeting location if possible. Meetings are scheduled on a first come basis.

Return to: Saltfork Craftsmen Regional Meeting Coordinator, Russell Bartling

70 N 160th W Ave

Sand Springs, OK 74063

You can also send the information in an e-mail or text or fill out the online form available on the website in the top banner of the Calendar Tab: www.saltforkcraftsmen.org/Calendar.shtm

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