Saltfork Craftsmen
Artist-Blacksmith Association
December 2020

Fantasy Dragon Fireplace Set by Rory Kirk

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Artist-Blacksmith Association
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Editor's Notes:

You may have noticed an abundance of dragon heads in the newsletter lately. Rory's great "how to" article in the July 2020 newsletter spurred a lot of people to try it out.

A common comment seems to be something like: "I always wanted to try one of these and I am pretty happy with my first one!"

As an editor, it is great to see when information we provide helps others produce actual projects.

If you feel like sharing your favorite project in the same way, please consider submitting an article on how you do it. I know a lot of people don't like writing articles and it can be hard to keep notes, capture photos and forge by yourself. But there are ways to make it easier. Please contact me if you have such a project and would like to get it in print. I can help!

-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.

Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org

President's Notes:

Hello everyone. Another month has rolled around. I hope you didn't get the ice storm. For those of us who did, who knows how long it will take to clean it up. I guess we will have plenty of firewood to get rid of.

I hope everyone is getting to forge all they want. When I used to demo more often, I always had someone telling me that their grandpa, or uncle, or someone in their family was a blacksmith. I told Ron that when I first met him one time, he just shrugged his shoulders and kept working. We used to go to Elk City to the blacksmith shop and forge about every Sunday. One Sunday an older woman came walking in and started to cry. We asked if there was something wrong. She said that was the first time she had smelled coal smoke since her grandfather had passed away. She used to help him in his shop when she was younger and it brought back a lot of great memories. She stayed and watched and talked to us for hours. The smell of coal might be hard to find in a few years. A lot of mines have closed and it is getting harder to find coal.

I hope everyone has safe and happy holidays.

And I hope you get your holiday gifts made.

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.

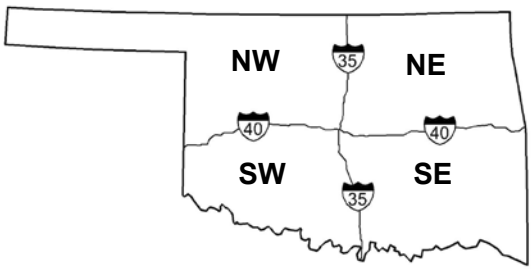
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

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

SCABA Regions



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

Safety

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

2020 SCABA COVID CONFERENCE

We do not have a cash flow like we usually do after a conference. I would like to propose that we have a silent auction and/or a live auction online to increase our cash flow. The board members have voted affirmative to have one. Therefore, we are asking for donations to auction off. Ordinarily we would have asked for donations for our conference. If you could let me or a board member know what you would be willing to donate, as soon as we have enough donations, we will organize the auction(s). Thank you for caring about our organization.

Carol Doner,
State SCABA Secretary

2020-2021 Workshop Schedule

Currently no workshops are scheduled.

The Board of Directors and the Workshop Coordinator are always looking for feedback from members on what workshops you would like to see from fundamentals to advanced. Please let them know! If there is group interest in a specific workshop topic, they will work hard to try to make it happen.

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.

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

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-CANCELED)
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 LehenBauer as Host - Don Garner as Contact Person)
Oct 3rd (Open)	Oct 10th (Open)	Oct 17th (Diana Simon-CANCELED)	Oct 24th (Rory Kirk-CANCELED)
Nov 7th (Open)	Nov 14th (Bill Phillips-CANCELED)	Nov 21st (Open)	Nov 28th (Bob Kennemer-CANCELED)
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)

December 2020
NE Regional Meeting December 5th: Open.
SE Regional Meeting December 12th: Open.
SW Regional Meeting December 19th: Open.
NW Regional Meeting December 26th: Open.

January 2021
NE Regional Meeting January 2nd: Open.
SE Regional Meeting January 9th: Open.
SW Regional Meeting January 16th: Open.
NW Regional Meeting January 23rd: Open.

The 2021 Meeting Schedule is on the next page.

Around the State...

NW Region October Meeting: No meeting was held.
NE Region October Meeting: No Meeting was held.
SE Region October Meeting: No Meeting was held.
SW Region October Meeting: No Meeting was held.

2021 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 2nd (Open)	Jan 9th (Open)	Jan 16th (Open)	Jan 23rd (Open)
Feb 6th (Open)	Feb 13th (Open)	Feb 20th (Open)	Feb 27th (Open)
Mar 6th (Open)	Mar 13th (Open)	Mar 20th (Open)	Mar 27th (Open)
Apr 3rd (Open)	Apr 10th (Open)	Apr 17th (SCABA Picnic-Tentative)	Apr 24th (Open)
May 1st (Open)	May 8th (Open)	May 15th (Ricky Vardell-Tentative)	May 22nd (Open)
Jun 5th (Open)	Jun 12th (Open)	Jun 19th (Open)	Jun 26th (Open)
Jul 3rd (Open)	Jul 10th (Open)	Jul 17th (Open)	Jul 24th (Open)
Aug 7th (Open)	Aug 14th (Open)	Aug 21st (Open)	Aug 28th (Open)
Sep 4th (Open)	Sep 11th (Open)	Sep 18th (Open)	Sep 25th (Ron LehenBauer as Host - Don Garner as Contact Person-Tentative)
Oct 2nd (Open)	Oct 9th (Conference Setup Tentative)	Oct 16th (Conference Weekend Tentative)	Oct 23rd (Open)
Nov 6th (Open)	Nov 13th (Open)	Nov 20th (Open)	Nov 27th (Open)
Dec 4th (Open)	Dec 11th (Open)	Dec 18th (Open)	Dec 25th (Christmas Day)

2021 Fifth Saturdays:

January 30th (Open)
May 29 (Open)
July 31st (Open)
October 30th (Open)

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**.

2020 Conference Toolbox

Since the 2020 Conference was canceled, Bill Corey modified the graphics on the toolbox. The current plan is to offer tickets for a drawing at the spring picnic. Stay tuned for details!

Beginner Blacksmith Class - November 14th:

We had a breezy morning but the fair weather held and, after a brief word on safety, we were off to a good start.

The event was held in Muldrow City Park, and drew onlookers, passers-by, and even a reporter from the Fort Smith Times Record.

(Click image for link to the article - Editor)


A1
NEWS
READER SUBMITTED PHOTO
Turning up the heat
CORONAVIRUS PANDEMIC
'Breakthrough finding' reveals why certain COVID-19 patients die
LOTTERY
Times Record Community Christmas Card on hold for 2020
Arkansas man arrested in death of girlfriend's father
WE NEED YOUR HELP!
LET'S SHOW LOVE TO ALL AREA CHILDREN IN FOSTER CARE THIS CHRISTMAS!

The students worked their way steadily through an "S" hook, and a leaf key chain fob, learning the basics of tapering, drawing, setting a shoulder, and material isolation, before a delicious mid-day meal.

Lunch was a fine affair of chili, brown beans, cornbread, and all the fixings.

Afternoon brought us to the hot cut chisel where we learned about symmetry, heat treating, and tempering. Everyone involved had a great day, and students got to go home with some very nice tools and trinkets to show for all their hard work.

Unfortunately, no group photo was taken.

A big Thank You to all the students who came out. Thank You as well to my fellow Blacksmiths, Tracy Cowart, Chuck Waite, and Ragnar! - Brad Nance

Upper Right: Julie Noakes

Right: Sondra Hawk and her son.

Continued...


BULLDOG CAR WASH
ZOMAX


MCALESTER

Upper Left and Left: Brothers in Law, Patrick and Cody (Sorry, no last names)

Top: Gerald Stroup and his son.

Member Gallery

Trumpet Vine and Hummingbird By Gerald Brostek

Recently created from mild steel and installed in one of the window openings of my gazebo. Measures 40” X 60”, dark gold/bronze coloring. - Gerald Brostek

(See the Original Gazebo Photos in the October 2020 Newsletter. - Editor)

Member Gallery (Continued)

Dragon Fireplace Set by Rory Kirk

This fantasy fireplace set was made by Rory Kirk for a local client. It stands 44" high. She was reportedly very happy with her purchase! - Editor

Member Gallery (Continued)

The tools used for creasing the dragon's wings.

Member Gallery (Continued)

Dragon Head Door Knocker by Rory Kirk

(Refer back to the July 2020 newsletter for step by step instructions on how Rory makes the dragon heads. - Editor)

Member Gallery (Continued)

First Ever Dragon Heads...

These dragon heads were first ever attempts by Rory Kirk fans following his directions as published in the July 2020 newsletter.

The dragon head on the right is by **Noah Richer** (he is 15 years old.)

The dragon head on the bottom right is by **Mike Taylor**. Mike changed the pupil by using an elliptical punch. His plan is to mount the head on a porch stair railing with the head on one end and a tail at the other.

The dragon head on the bottom is by **Mario Castonguay** who says he always wanted to forge one.

Member Gallery (Continued)

The Latest Saltfork Gate Project by Gerald Brostek

As the Burn Turns By Bob Pickens

Bob Pickens has come up with improvements for the burner of your gas forge. There are several details that can upgrade the burner design made from pipe fittings. One of the concerns is the threads on the pipe connections cause turbulence in the air flow. The threads in the large end of the reducer could be ground out to improve air flow. This can be overlooked but, thread removal can improve the burner's efficiency. Bob decided to forge the parts so when they were welded together, there would be a smooth transition between the fittings. To forge the inlet fitting, he heated and upset 1 1/4" sch 40 pipe. This thickened the wall, so when it was swaged to size it did not split. Not upsetting the pipe resulted in the pipe splitting at the seam every time, so upsetting the pipe is an important step. Bob used a die set and a 40 ton hydraulic press he has in his shop. This procedure is quite involved and may not be possible to address in your own shop.

Top: Sch. 40 pipe on left, upset, forged truncated reducer on right. Below: Die set used with a 40 ton hydraulic press.

What *you* can do to improve your burner:
He also made a adjusting disc for the air inlet reducer which can be easily made. Air adjustment seems to be a reoccurring problem and annoyance for the user. Adjusting the three screws on the air adjustment disc is time consuming. Additional issues that can occur when adjusting the three screws are that you may be moving the orifice and also getting it out of center. Bob developed an easy solution that can adapt to your existing burner. This idea is something you can do in your shop with common materials you probably have on hand.

How to: (Two Choices!)
Choice A
1. Replace the 3 adjustment screws with 3/4" longer screws to make room for the adjusting disc.
2. The adjusting disc needs to be made of 1 7/8" round 1/4" thick with 1/8" pipe thread in the center.
3. Install underneath the existing air adjustment plate, below the nut, this will allow for easy air adjustment. Just spin "open" for more air or less air! Easy!!!

Choice B
1. Remove the existing air adjustment plate.
2. Make and install new adjusting disc. (See above)
3. Make a support bridge. The bridge is made from 1/8" plate, 6" long. The legs should be about 1 7/8" long with the center drilled to 11/32nd and tapped for 1/8" pipe and attach. There are two suggested methods of attachment.
   (a) You can weld onto the reducer; however, grind two flat spots to insure a secure weld.
   (b) Attach by drilling and screwing on the bridge to the sides.

Left: *Pipe thread with adjusting disc. The threaded pipe can be purchased at a hardware store in the lamp parts department.*

Center: *Common pipe fitting reducer. Usually the three screws on top plate must be adjusted to change air flow. With the addition of the adjusting disc, air flow is easily regulated.*

Right: *Support bridge can be connected to pipe fitting reducer or custom forged reducer to accommodate the air flow adjusting disc.*

This article is reprinted courtesy of the Pittsburgh Area Artist-Blacksmiths Association newsletter November 2020.

Remembering Jim Dyer
By JJ McGill

James Ray Dyer
1937-2020
Gentleman Jim Dyer

Born May 22, 1937 and passed away November 3, 2020 at the wonderful age of 83. He was born to Ray O. Dyer and Mildred E. Wimberly, in Ardmore Oklahoma. He graduated from Springer High School, and then went on to Oklahoma State University in Stillwater, Oklahoma. He received a Bachelor's Degree in Agriculture Journalism and a Master's Degree in Journalism.

After Graduation he went to work for the Progressive Farmer Magazine. As his father had done while working at the magazine, he enlisted in the United States Army on June 8, 1961 and achieved the rank of 1st Lieutenant. He was stationed at the U.S. Army Personnel Center. He also served in the U.S. Army CORPS and was honorably discharged on May 29, 1963. He continued working for the magazine until May of 1973 when his father passed away. At the time of his passing, Jim had been the Managing Editor of the magazine for most of his employment with them. He had made three moves with them to different states. They were in Alabama at this time. He came back home to take care of the family farm and his Mother. His Father was the first Ag agent for Carter and Marshall County's, then was asked to become the first Ag Agent for the World Famous, Ag Research Station "The Samuel L Roberts Nobel foundation in Ardmore Oklahoma." After retirement, he went to work for one of the largest Cattle/Farms in Southern Oklahoma. "The Legendary 301 Brady Ranch of Springer Oklahoma"

Jim, went to see where his dad had been working and collect his father's last check. Then, after what turned into an all day tour of the ranch and after that, seeing what his father had been doing and his love for agriculture. He asked Mr. Brady if he had found a new Manager yet. Mr. Brady replied "No sir. And if you're half the man your father was I would be very happy for you to pick up the reins and continue running this Ranch as he did." And, of course, Jim proudly did. He worked managing the ranch until the death of the daughter and the ranch was broken up and sold to the highest bidder in the spring of 1994.
After finding himself retired after the auction he set out starting a very large personal collection of farm equipment of the past. He helped set up and form The Greater Southwest Museum in Ardmore, Oklahoma. Where after over 40 years of service there is a section entitled "The Tool of Our Land Exhibit." This section was dedicated with a 30 x 20 Mural of Jim riding his 1936 B John Deere, on his 80th Birthday. It houses the Prize collection of all of Jim's travels and finds.

Jim Joined the Murray County Antique Tractor & Implement Association in 1990 as a Charter member and Served as PR Coordinator until 2017. He was a Member of the Saltfork Craftsman Association since 1992.

Jim attended the First Presbyterian Church of Ardmore his entire life.

He volunteered two days a week and dedicated his services to two museums, The Greater Southwest Historical Museum and The Military Memorial Museum. He served in all capacities, and was Chairman of both boards at the time of his passing.

His favorite hobbies were Blacksmithing and his collection of antique farm machinery. His love for blacksmithing was shared with his church youth group and area Scouting groups that he did demos and teaching for special yearly events.

He spent countless hours behind the lenses of cameras taking pictures of the tractor club, blacksmithing, and church events. The tractor club has a photo library of over 120 albums. He loved to photo restorations and the steps of blacksmithing projects.

If you ever had a chance to meet and visit with Jim you would leave with a new friend and have a great respect for the Man and understand why the ladies called him Gentleman Jim and the men called him Mr. Dyer.

Mr. Dyer will be missed in many ways and will always be remembered from the friendships he made to the lifelong tribute and the mural of him at the Greater Southwest Museum Tools of Our Land exhibit.

New Hammer Making Video From Chris Crawford Knives

If you are a knife maker, you probably already know about Chris Crawford Knives and the great knife making videos he produces. The list of videos produced to date is long and they cover a wide range of topics with many well known makers. But Chris also produces videos that primarily focus on blacksmithing topics beyond just knife making.

This is an unsolicited review of his recent release, "**Hammer Making with Derek Melton**." The video is over 2 hours long and shows Derek forging a Brian Brazeal style rounding hammer in his own shop. Learning the techniques used to make this style of hammer will allow you to make just about any other style of hammer as well.

Derek Melton is a part-time blacksmith & bladesmith who is currently located in Clinton, Mississippi. He's been working with wood and metal for most of his life, and he's been making knives and other items from metal since 1999. Having a love for the forged blade and a keen eye for detail, Derek took his skills to television in 2018 and appeared on an episode of the hit History Channel show "Forged in Fire". He competed for and won the title of "Forged in Fire Champion" on episode 21 of Season 5.

Derek is on the board of the Mississippi Forge Council (MFC) and can often be found demonstrating blacksmithing in the MFC's McIntosh Blacksmith shop on the grounds of the Mississippi Agricultural Museum in Jackson, Mississippi. Derek's current maker's mark is simply his name. "Melton", with an elongated and stylized "t" which represents his faith in Christ.

In this video, Derek demonstrates how he makes a rounding hammer in the popular Brian Brazeal style. While Derek uses some pretty heavy equipment throughout the video, he also explains how one can carry out these same processes using hand tools.

This video contains the following chapters:

* Introduction
* Shaping the Billet
* Punching and Drifting the Eye
* Troughing and Cheeking
* Cleaning and Heat Treating
* The Handle - Part 1
* Detailing the Head
* The Handle - Part 2
* Finishing the Hammer
* Closing Remarks

Total Run Time: 2 hours 5 minutes.

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www.ChrisCrawfordKnives.com

Hammer Making with Derek Melton

Chris Crawford Knives Presents

Hammer Making
with
Derek Melton

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The video is professionally done with clear views of each process and crisp audio. Derek does a great job explaining each step of the process from material selection to final finish.

Derek uses his self contained power hammer, hydraulic press, and treadle hammer while forging but he also explains how the same operations can be done by hand or with a striker. He uses a small, single burner, shop built propane forge for all of the forging. The video shows each of the drifts, dies and support fixtures used to make the hammer. Almost all of these tools were shop made by Derek and are fairly easy to reproduce by anyone who has the most basic metal working tools and skills.

Derek demonstrates forging a blank to the correct starting dimensions for a given hammer weight, punching then drifting the eye, drawing out cheeks and fullering behind the faces. At every step he explains the thinking behind what he is trying to accomplish and when/how to correct deviations as they occur. Once forging the head is complete, Derek shows how to make and fit a handle from scratch and how to finish both the head and the handle.

Seasoned beginner to intermediate smiths who follow Derek's formula should have no problem producing a quality hammer. If you have made hammers before, a lot of this will be familiar. But there are a number of good tips and tooling ideas that still make this an interesting video even for more advanced smiths. And, overall, it is a very well done demo. *-Editor*

Visit Chris Crawford Knives to see his entire list of titles:

https://chriscrawfordknives.com/dvds/

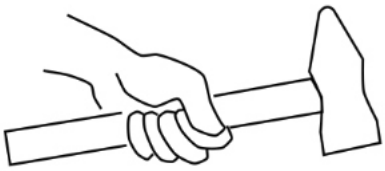
By the way, it pays to be past customer as Chris offers periodic sales and first release discounts to existing customers!

Get a Grip

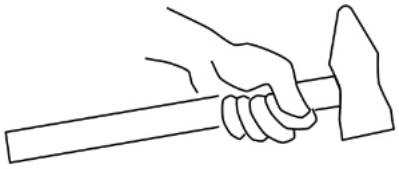
Mike Chisham, Petaluma

How you grip a handle when forging is almost more important than the handle itself.

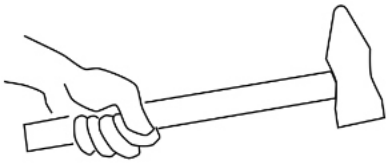
If the handle is of the proper length, when a smith grips/holds a handle in the middle of the handle, the smith has average power and an average amount of control during the hammer stroke. As the grip is moved more toward the head of the hammer the smith gains much more control of the hammer. But at the same time, there is a loss of power. As the grip is moved more towards the end of the handle the smith gains more power but loose's some control. This concept issues in the reality that a smith really never holds or grips a hammer in the same place throughout the entire forging process. With every hammer blow, the grip is constantly moved up or down the length of the handle to either gain more control and loose power or increase power and loose some control. The grip on a hammer handle is never static.



Average Control/ Average Power



More Control/ Less Power



Less Control/ More Power

The handle of a hammer is important though. If the handle is too thick or too thin, it requires the smith to increase the amount of strength it takes to grip the handle to keep it from rotating within their grip while forging. Improper grip will significantly increase the amount of hammer blows it takes to produce the desired outcome, not counting the fatigue it will take to accomplish it. A trick to find out if you are properly gripping is to wrap your hammer handle with newspaper. The paper should never tear throughout the entire forging process. If it does, your handle is improper for your hand size or because of inexperience you are gripping way too hard.

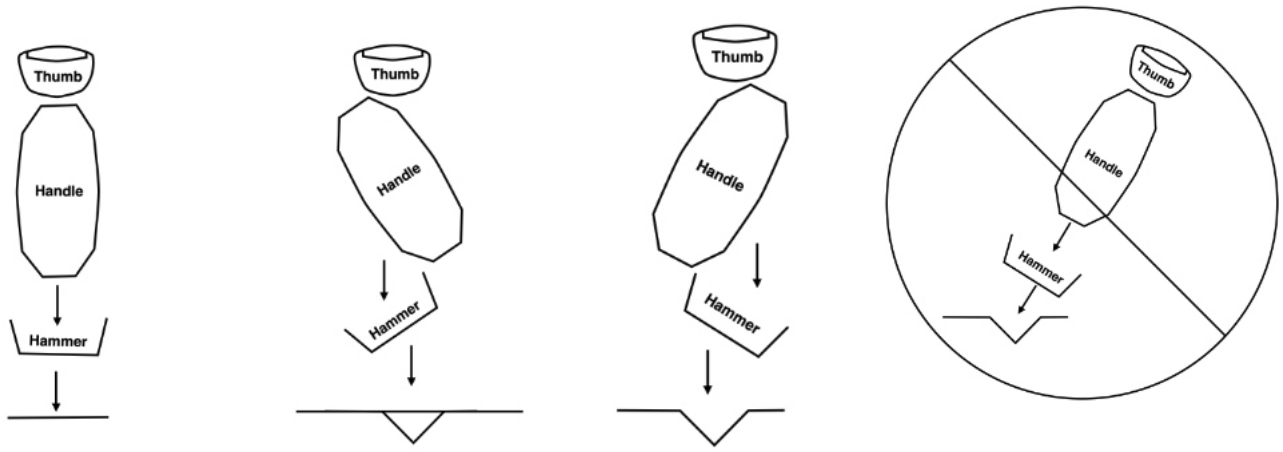
So, how should you grip a hammer handle? The first thing to consider is finger position. The concept of Tenouchi must be issued in here now. Tenouchi is the principle behind how to properly hold a Samurai sword. Like a hammer, the sword, from a stationary position, is raised upward toward your head. The tendency is for the sword to continue moving upward because of momentum. As the sword is being raised, only the ring finger and little finger (aka: bottom fingers) should be gripping the handle. The index finger and middle finger (aka: top fingers) should be totally relaxed. They are only helping to guide the sword on the upward phase of the stroke to avoid wobble. To stop the sword or hammer, all one has to do is to increase their grip on the bottom fingers and do nothing with the top fingers. Once the sword has stopped, the top fingers now come into play. They still do not grip the handle. The bottom two tighten their grip while the top fingers simply guide the sword/hammer to the intended target during the downward phase.

Top Fingers Relaxed

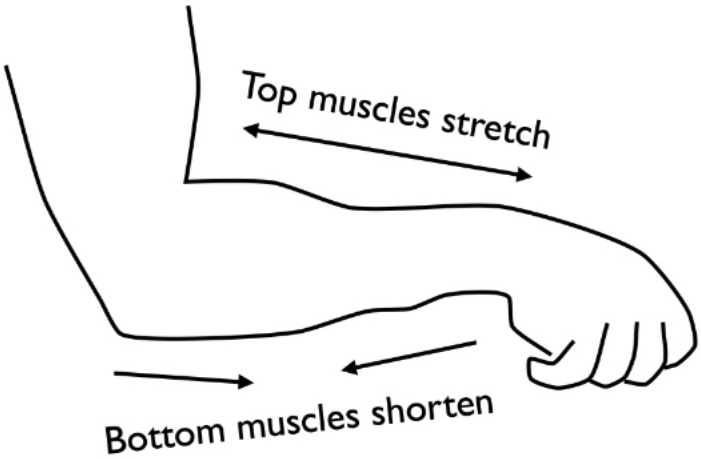
Bottom Fingers Grip

Grip

What's the thumb doing? With a power hammer, the power comes from the top down. The top guides on a power hammer guide the falling weight of the heavy top die towards the bottom die. All it does is guide. It does not supply any power or force to the downward stoke itself. The thumb does the same. It remains on top of the handle and guides the hammer head toward the hot metal. If the thumb is doing it's guiding job, it is not putting much pressure on the hammer handle. Just as the sword/hammer is about to make contact with an object, the bottom fingers are quickly tightened to produce a downward snap moments before contact is made. The thumb is rotated either left or right to help obtain the correct angle placement of the blow. The top fingers are used to avoid sideways deviation and help maintain grip placement on the handle. The bottom fingers do all the work.



So why is this grip so important? The hypothenar muscles located on the bottom of the forearm are very large and powerful muscles. The hypothenar muscles control only the bottom two fingers. The top two fingers and the thumb are controlled by thenar muscles on the top of the forearm which connect to muscles in the shoulder and neck area. When playing sports that require extensive use of the wrist, you are taught to keep your wrist straight, tight and avoid flexing it. Bowling, golf, tennis, fencing, etc. The same is even more true in forging. As the hammer is guided toward the anvil on the downward stroke, the top fingers should not be clenched in a tight grip. If they are, this means that the thenar muscles on the top of the forearm are tight. If your anvil is too low or you are tall, you will have to drop your wrist in order for your hammer to make proper contact with the hot metal. This means that the already tight thenar muscles on top of your forearm have to stretch even more than they already are, to achieve the desired hammer mark. It's like over stretching an already taut cable. This constant stretching will eventually break down the integrity of the thenar muscles. It will eventually pull on the neck muscles and soon the muscles of your back as well. Ever wonder why your back is tight and aches after long periods of improper forging?

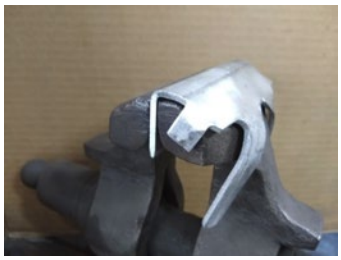


Grip

Gripping with only the bottom fingers is a different story. If the wrist is dropped downward, the already tight hypothenar muscles on the bottom of the forearm, do not get overstretched. In fact, they shorten in length. This allows them to be tightened to produce even tighter grip with little or no extra effort or work. To raise the hammer, the top finger muscles should slacken their grip as the bottom two fingers kick into gear. As the hammer rebounds upward after the downward hammer blow, and the top fingers are held tight, the thenar muscles are stretched to their max. If the top fingers are kept in tight contact with the handle after being over stretched and are never relaxed, you are straining and over working them. Doing this consistently the muscle tissues will break down and you will be sore! You will be on your way to Carpal Tunnel problems. This constant abuse because of improper forging techniques, we refer to as Blacksmith's Elbow (unless you do play tennis).

When the hammer is in the downward phase, all the muscles in the arm and hand are each doing their job and are working together to accomplish the desired hammer stroke and hammer mark. During the upward phase, everything should be relaxed. Even the grip of the bottom fingers is relaxed until your arm reaches the top of the upward phase. This allows the muscles to relax enough so that there is no cramping due to a build up of Lactic acid. Your grip should be so relaxed that someone could walk up behind you and pull the hammer out of your hand just before it reaches the top of the hammer stroke and the bottom fingers begin to do their job again. So, get a good grip on things. Wax on Wax off.....Relax up Power down.

This article is reprinted with permission from the California Blacksmith Association Online newsletter Sep-Oct 2020.

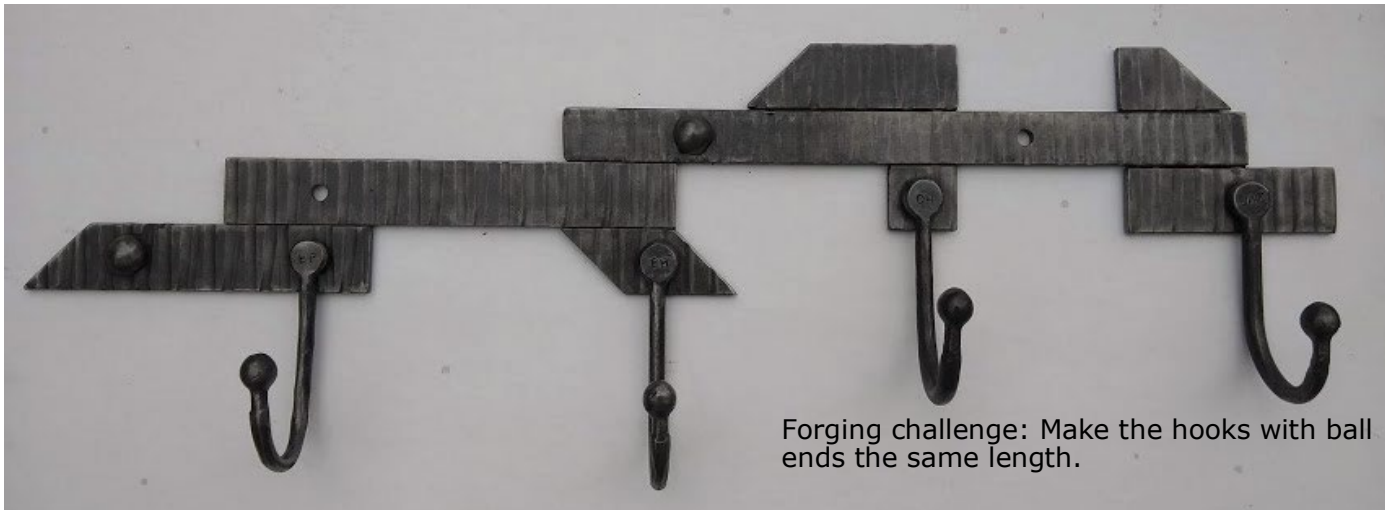


Vise Jaw Liners

Cut out pattern and trace on aluminum or copper plate, make two, a right and left. Fit on your vise to protect work from marring when work needs protection. These liners fit a 4" vise, adjust to fit your vise size.
Design by Country Fab!

This pattern is reprinted courtesy of the Pittsburgh Area Artist-Blacksmiths Association newsletter November 2020.

Time to Hang It Up! By John Steel and Chris Holt



Forging challenge: Make the hooks with ball ends the same length.

When a good friend retires from a lifelong stressful job, it is a special occasion. By now, they have accumulated all the "stuff" they need and are on their way to a free and easy lifestyle. It is now "time to hang it up", but also get ready to enjoy more interesting activities. They may just want to grab their hat and go! Make it easy for them with this contemporary city scape, custom coat rack; it is the perfect gift to commemorate the retirement day!

At Steel Welding, we have lots of pieces/parts left over from previous projects. They are just too good to recycle. Check through some of your cutoffs you may have in your shop for similar material. Textured bar works well for this project. This pattern was done on a power hammer using two lengths welded together (back to back) and run cold through drawing dies. You might have hammered material or textured material using a hand hammer, or severely rusted and pitted metal, all will work just fine.

Materials:
Pieces/parts of flat metal bar with texture
Rivets
Round stock for four hooks, we used Allan Kress' 3/4" closed ball dies
Lag screws with decorative heads (we attached rivet heads to lag screws, and ground two slight flat sides for mounting)

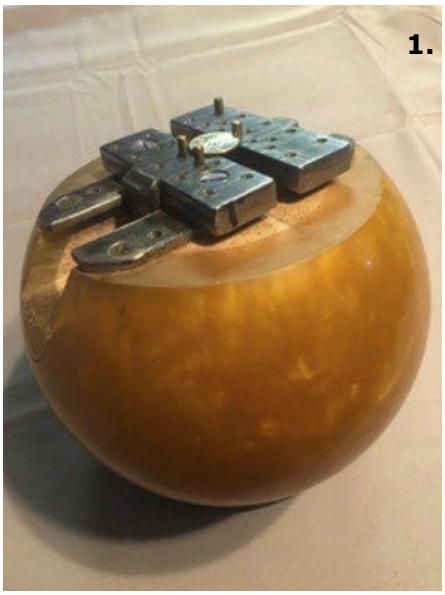
How To:
1. Gather your pieces/parts of like material and decide on approximate length of finished coat rack.
2. Mark off 16" Center so you know where you need to place your lag screws for mounting on wall.
3. Layout– Move your parts around, try different combinations until one seems reasonable. Try different lengths next to one another. This hat rack has four hooks, 7" apart on two levels.
4. Add your touchmark, date and year on your work, this makes it much easier than doing it later! Since four people gave this gift, initials were placed on the flattened disc on each hook.
5. When you have achieved a pleasing design, trace around the parts and figure out where hooks will be placed and avoid the mounting lag screw sites, this is important. Walk away, go cut the grass, shovel snow, have lunch, stack firewood for about 45 minutes. Return to shop and revise your design. Do you still like it, is there something that looks "wrong", is something too close together? Adjust.
6. Drill or punch holes in pieces that will hold the lag screws. Drill or punch holes for rivets. Make sure all sections are straight and true. Replace parts on drawing as you work on each piece or you will forget where it goes!
7. Weld together on back.
8. Forge out hooks, makes sure they are of some substance. This coat rack design is a strong statement, you want hooks to look substantial.
9. Attach hooks, apply finish and clear coat.
10. This gift will be used rain, snow or shine….a memorable gift!

This article is reprinted courtesy of the Pittsburgh Area Artist-Blacksmiths Association newsletter November 2020.

A Desired Bowling Split By Phil Travis

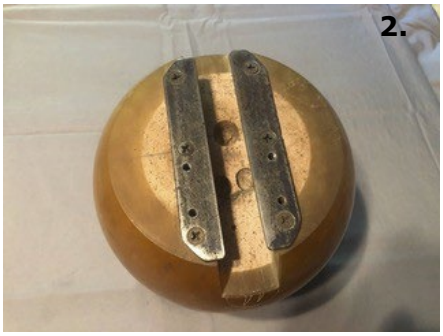
A few years ago I had decided to try my hand at repousse' and also dabble in hammer and chisel engraving. To do this, I needed to hold my work-piece firmly and at a convenient angle. Below is what I came up with.

I used a bowling ball as a rotating and tiltable base. The first ball I cut a small flat on one side with a regular carpenter's handsaw. This left a flat area about 6 1/2" on the top. I went to the table saw and cut a dado (rectangular slot) centered on the flat. This was wide and deep enough to accommodate the screw mechanism I wanted to mount on top. (Photo 3, photo is shown with mechanism upside down before installation).


1.

The vise slide portion was made with a few pieces of 1/4" X 1" flat mild steel stock. This allowed about 1/4" to overhang the slot in the ball and was the length of the flat (about 6").

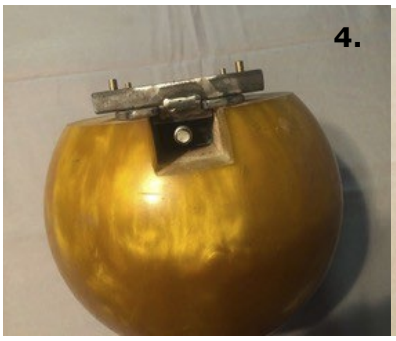
The two pieces that form the jaws of the vise are 1/2" X 1 1/4" X 4" and are drilled with multiple holes to accept pins to hold the work by its edges. The one jaw is drilled and countersunk to fasten solidly to the slide portion of the vise. This is done in a couple locations to adjust for needed size on the side bars. The second jaw is the movable jaw. This is accomplished by welding an angle iron piece with spacer to the underside. The spacer, with clearance, allows it to slide but, not lift or twist out of position. This angle iron is drilled and tapped for a screw thread (I used 1/2"). The fixed jaw has a small "tongue" welded to the outside edge and is drilled at the same location to align with the tapped hole. This hole is drilled as a clearance hole to allow the bolt to freely turn.


2.

The carriage bolt I chose was a 4" (6" would give a little more travel) because they generally are threaded to the underside of the head. The carriage bolt also has a domed head with a square section below. I ground off the edges of the round head to match the square section below. I sawed a screwdriver slot across the end and use it to tighten and loosen the vise jaws. To hold this bolt in place, I simply threaded two nuts on either side of the "tongue" and tack welded the nuts to the bolt.


3.

1. Bowling ball with vise holder in place holding a quarter. 2. Dado cut and vise slide in position. 3. Vise assemblage pictured upside down. 4. Assemblage from side showing dado cut and carriage bolt. 5. Side view with working piece in place. 6. Bowling ball vise in place, top view.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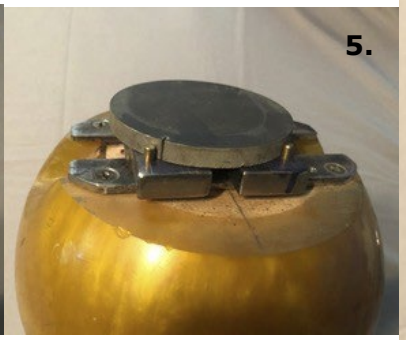
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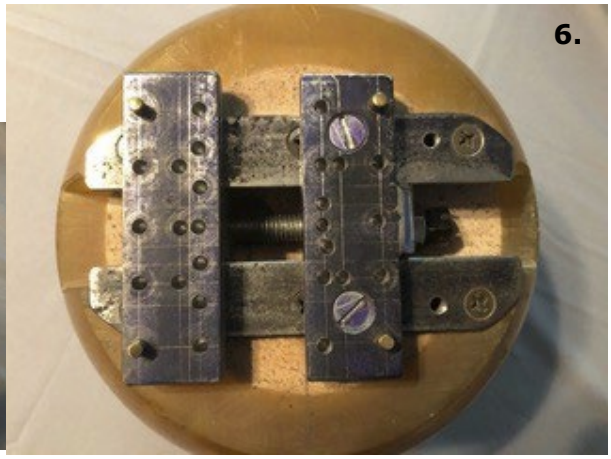
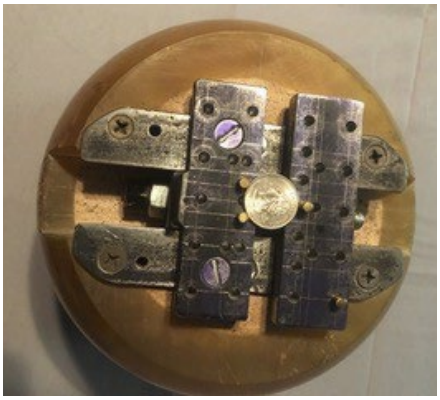

6.

A few notes on assembly:

- Be sure that mounting holes are well countersunk.
- The slide plates most be PARALLEL and overhang the slot in the ball.
- Slides are screwed down solidly. Remember: This is absorbing your hammer blows.
- Drill lots of pin holes for versatility in mounting work pieces.



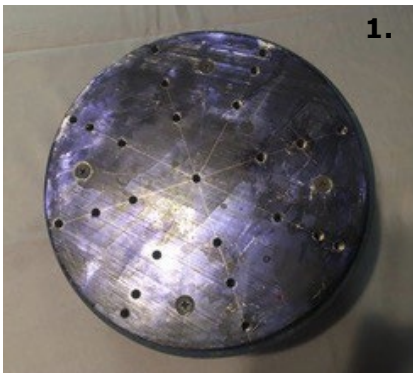
I used 1/4' X 20 size bolts to secure the fixed jaw in position. I also made matching holes in the slide plates to secure it in other places to extend the clamping range of the vise.

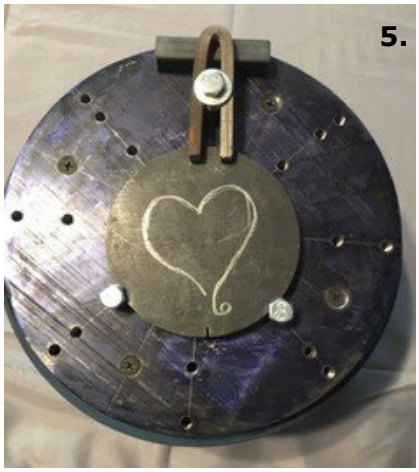
In use, I place the ball in a donut ring. Mine happens to be an old 8" OD (approx. 4 1/2" ID) lawnmower hard rubber tire. I found one with a plastic hub so it was easy to bust it out. This also is used in the following project.

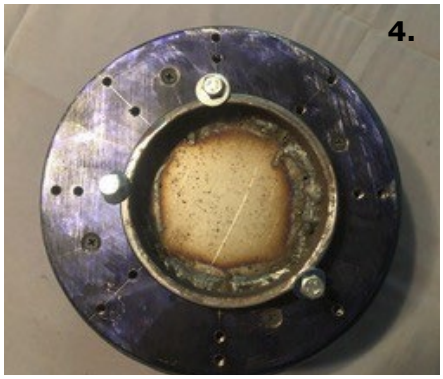
It's a Spare! By Phil Travis

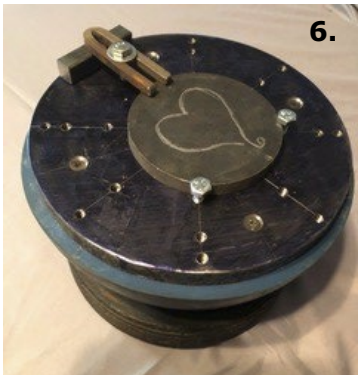
The second holding device I created was also based on a bowling ball. I cut it in half and attached an 8" X 1/2" steel disc to the top. On this disc I laid out a pattern of holes which was drilled and tapped for 1/4 X 20 bolts. The disc is secured to the ball with long drywall screws drilled through in counter-sunk holes. All the drilled and tapped holes were drilled through into the ball to allow clearance for the clamp bolts, this avoids the possibility of lifting the plate off the ball if too long. Make a ring with a bottom to fill with pitch so your work can fit on top for engraving or repousse work. The hemi-sphere of the ball is approximately 8 1/2", so a larger steel disc could be used and may have some advantage to do so. I simply used what I had at the time. This allows the pitch dish to be bolted or clamped down to its surface.

1. Top View, 2. Side view set on lawnmower tire. 3. Side view with ring to be filled with pitch. 4. Top view with ring to be filled with pitch. 5. Work secured in place and plate ready for engraving. 6. Side view









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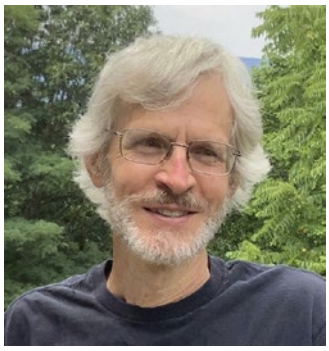
Side Draft Forge Flue By Glenn Horr 10-2020



My flue of thirty years continued to rust out, it was apparent that it needed to be replaced. That original flue was made of steel and based on the interior dimensions of a masonry flue from a plan in an *Anvil's Ring*. In researching flue designs to compliment the side blast forge that I was building, I came across a plan for a side draft flue on the AnvilFire website. The base is smaller than my old one and the front of the opening is angled. Like the forge I built, I used stainless steel I had salvaged for its construction.

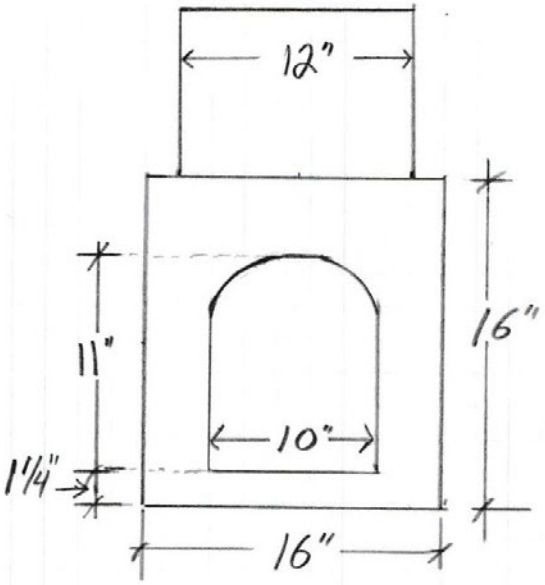
I particularly like the geometric transition piece between the square box and the round flue, which I believe allows for better air flow. This transition could be constructed from a mechanical drawing but, I created a full size pattern using a jig/roll method (see diagram) learned at one of Francis Whitaker's workshops.

I have been using my new forge and flue for three months now and they have been working out well. I have found that it helps to start the draft by placing a lit ball of paper in the flue opening when starting the fire. The benefits of using stainless are, it will last a long time and my TIG welding skills have greatly improved!

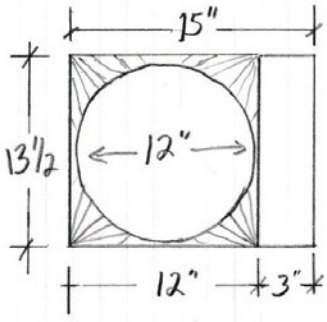
Details:

As most may know, it is best to back up stainless when welding, I used aluminum or copper plate, angle shapes for the corners clamped in place, and weld in short welds. Stainless likes to warp something bad. Most seams are butt, some lap.

The 13.5" width is so I could fit 3 thin fire brick in the bottom of flue.

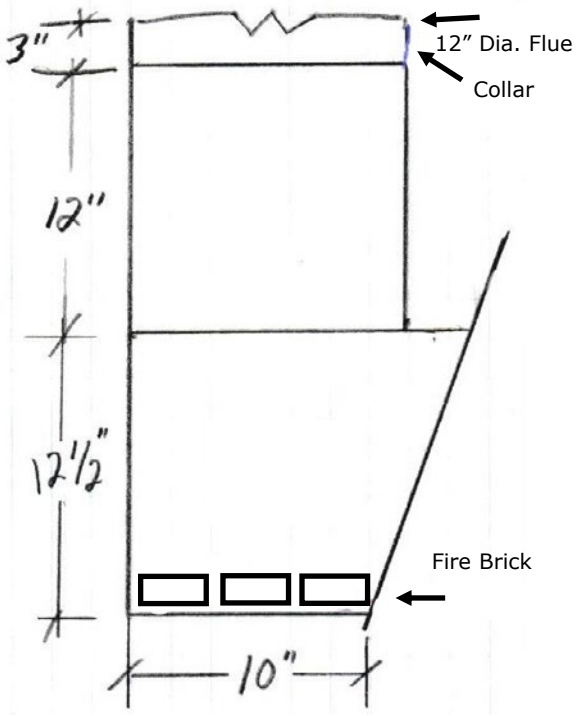


Front View



Top View

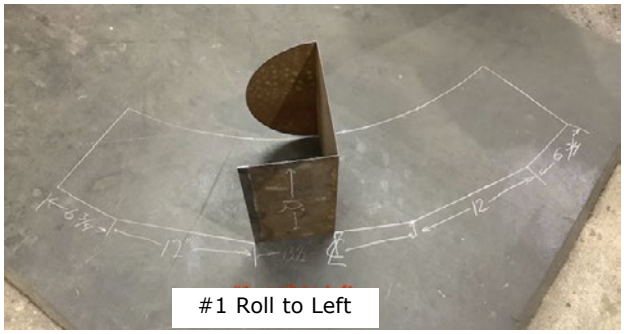
Side View



How to use the transition jig:

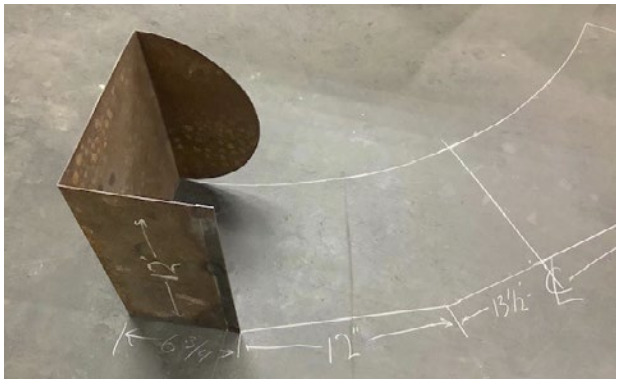
To make the transition jig, you roll it as you mark a line starting from the center line going left and right. I so happen to make mine as a one piece. But, you should make 2 halves and weld together. (See photos of layout.)
Then, bend it up. I used a bar clamped to the table, a press brake would nice for this if you have one. The bottom part could be made from a sheet, bent up for the 2 sides and bottom, then the back and the sloped front welded on.

To learn more about Glenn: glennsforge.com or contact him glennsforge@me.com or 304-258-4058

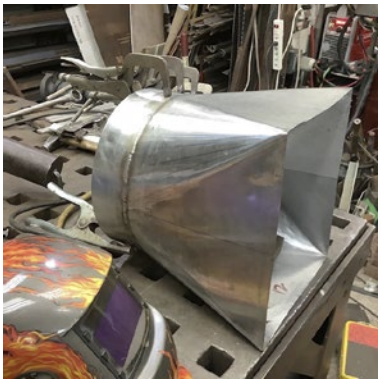


#1 Roll to Left

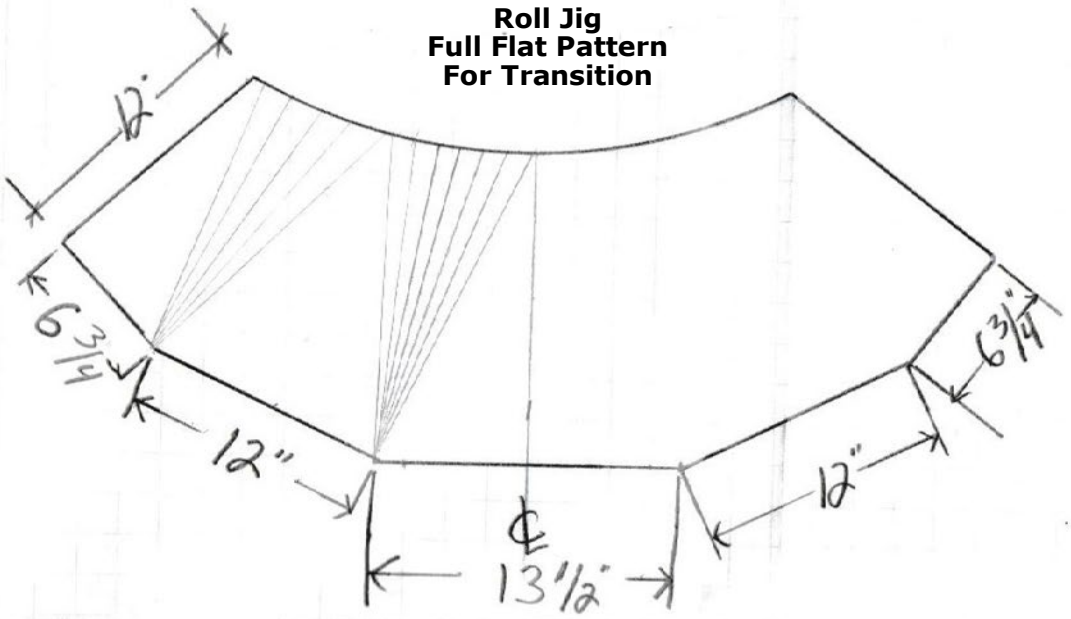
#2 Roll to Left

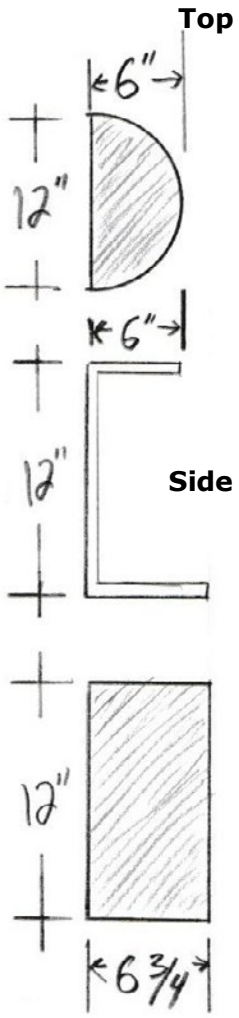


#3 Roll to Left



Roll Jig
Full Flat Pattern
For Transition





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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!)

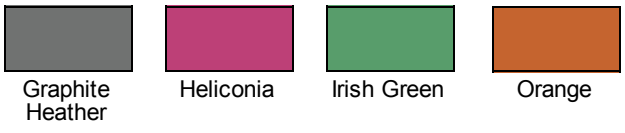
Gildan Adult Heavy Cotton™ 5.3 oz. Pocket T-Shirt

	S	M	L	XL	2XL	3XL
BODY LENGTH	28	29	30	31	32	33
BODY WIDTH	18	20	22	24	26	28
SLEEVE LENGTH	15.625	17	18.5	20	21.5	22.875

Fabric

- 5.3 oz., 100% cotton
- Saftey Pink, Safety Green, Neon Green, Graphite Heather and
- Heather Radiant Orchid are 50/50 Cotton/Polyester

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



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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Size	Color	Quantity	Price Each	Sub-Total

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

Total:

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Mail this form with payment to:
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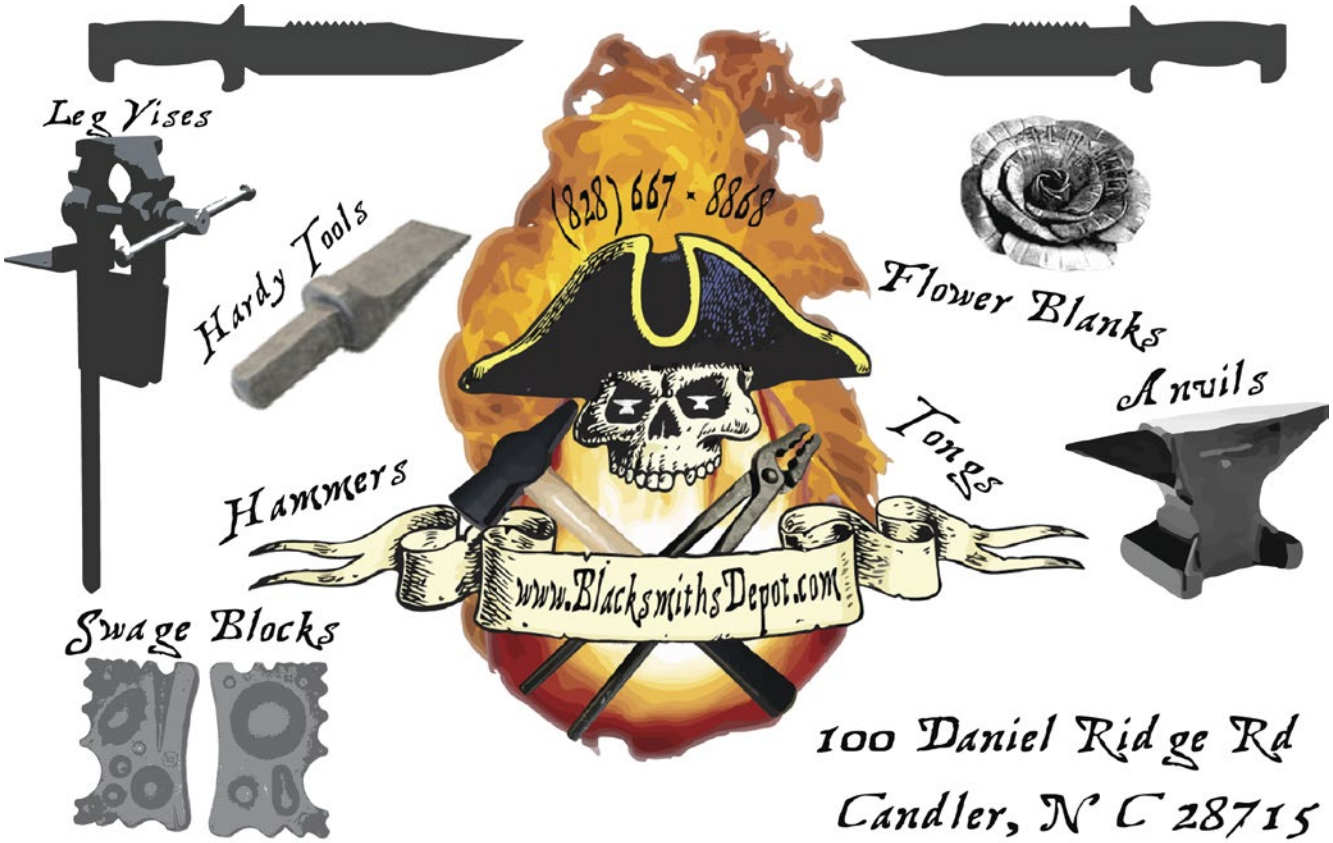
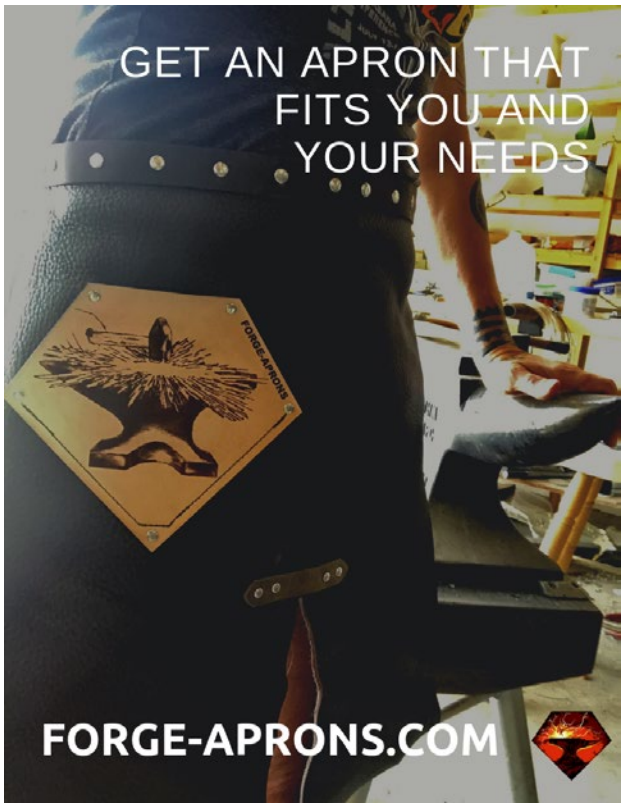


For Sale: 15 Lb Tire Hammers:

$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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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

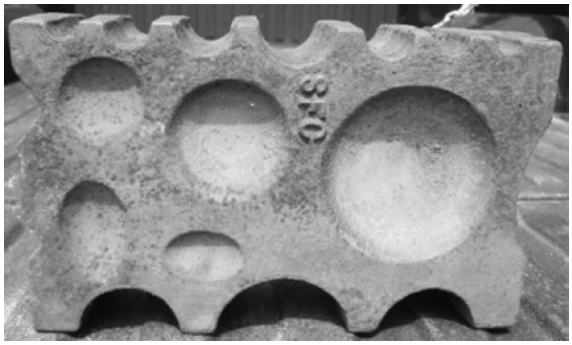
Librarian: Don Garner 580-302-1845 (Cell)
Call or Text. If you get voice mail, please leave a message.

Have an Item for Sale? Item Wanted?

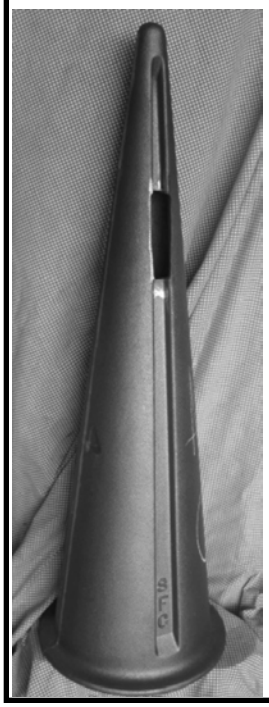
If you have any items that are appropriate for Blacksmiths that you would like to list in the Shop and Swap section (or items you are looking for), please send me your description, contact info, and any photos that you have.

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 _____

New Member _____
Renewal _____

First Name _____ Last Name _____

Married? _____Yes _____ No Spouse's Name _____

Address _____

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. Meetngs are schduled 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

Saltfork Craftsmen Artist Blacksmith Assoc. Inc.
6520 Alameda
Norman, OK. 73026

Non Profit Organization
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Permit #2177

Address Service Requested

SALTFORK CRAFTSMEN