

Saltfork Craftsmen Artist-Blacksmith Association

April 2021



Photo by the California Blacksmith Association

The SCABA Annual Picnic is This Month!
It's time to practice for the forge contest!

(See Pages 5 and 7 for More Details on the Contest)

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Artist-Blacksmith Association
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Editor's Notes:

Saltfork Craftsmen 2021 Director Elections:

The terms for three SCABA Directors are up this year. Byron Doner, Mandell Greteman and Don Garner are all up for re-election. Don Garner does not plan to run for re-election. To date, only one nominee has been received (Brad Nance) and agreed to run as Don's replacement and will be put on the ballot.

We will hold elections for these positions at the Annual Picnic in April.

The ballot is on page 11.

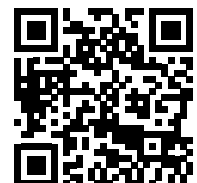
Please vote!!

-Russell Bartling, Editor

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

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Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org



President's Notes:

Hello everyone.

I hope everyone is doing well. We finally had a meeting at our shop in Foss last month. We didn't have a big turnout but we had a good time. I forged about all morning and part of the afternoon. As usual, we had a good meal. It has been so long since we had a meeting that we just about forgot to take any photos.

We still plan on having the annual picnic and the conference. We will have had a board meeting by the time you read this and that meeting will be to focus on moving the picnic and the conference forward.



We will be having hot dogs at the picnic with chili and other "fixin's." They will be Bar-S hot dogs, imagine that! They were donated by Bar-S.

I hope everyone can enter the forging contest at the picnic. There will be a place for beginners and novices so don't be shy. If anyone needs help, there will be someone there to lend a hand or provide some guidance.

We will be having an online auction to help the club. We still need donations to sell. The date for the auction is not set yet until we get enough items accumulated. Events like this help to have a good club. Thanks to everyone for their input and contributions. It really helps.

Keep your hammer handles tight.

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.

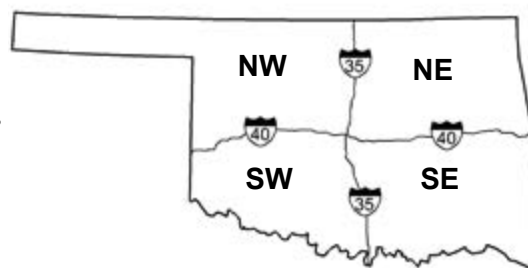
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

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

Getting Ready for the SCABA Picnic Forging Contest?

The Mark Aspery demo (in the March 2021 newsletter) is provided by the California Blacksmith Association and provides a lot of tips for forging a good scroll in general. Keep in mind that in the contest the snub end scroll will be done on the 1/2" square stock while the penny scroll will be done with the 1/4"x3/4" stock. So, this one is not a perfect representation of either scroll that you will do in the contest.

You can also get some additional info from "Wrought Ironwork - A Manual of Instruction for Craftsmen" published by the Rural Development Commission, Salisbury. This book is available at no cost for downloading but is copyrighted so I can't reproduce it here. You will like this book if you haven't already downloaded a copy. This is one link, or you can search for the title:

<http://www.mooseforge.com/library/Wrought%20Ironwork.pdf>



Good Luck in the Contest!!

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 (Doug Hyde)
Mar 6th (Open)	Mar 13th (Open)	Mar 20th (Open)	Mar 27th (Mandell Greteman)
Apr 3rd (Don Garner)	Apr 10th (Diana Simon)	Apr 17th (Open)	Apr 24th (SCABA Picnic!)
May 1st (Open)	May 8th (Open)	May 15th (Open)	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)
Oct 2nd (Open)	Oct 9th (Conference Setup)	Oct 16th (Conference Weekend)	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)

NW Region February Meeting: (See page 10.)

NE Region March Meeting: No Meeting was held.

SE Region March Meeting: No Meeting was held.

SW Region March Meeting: No Meeting was held.

April 2021

NE Regional Meeting April 3rd: Will be hosted by Don Garner at the Route 66 Museum Blacksmith Shop in Elk City. (Note: NW region using alternate date to adjust for picnic on April 24th.)

Trade item is anything you want to make to donate for the upcoming **online SCABA auction**. (See Page 9.)

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.

SE Regional Meeting April 10th: Will be hosted by Diana Simon and the Cherokee Strip Historical Society at the new Blacksmith Museum and Shop. 2617 W. Fir Ave, Perry, OK 73077. The shop is located approximately 1/4 mile east of Exit 186 from I-35 on north side of the road (Hwy 64 or Fir St.) (Note: NE region using alternate date to adjust for NW meeting on April 3rd.)

The trade item is anything you want to make. The meeting is planned to start at 9:00 AM. Lunch will be provided. Please bring a side dish or dessert to help out.

Contact Diana Simon at 580-572-8290 or dsimon@gmail.com if you have questions.

SW Regional Meeting April 17th: Open.

NW Regional Meeting April 24th: SCABA Annual Picnic!

at the Murray County Tractor Show grounds just north of Sulphur OK. Seven miles north of Sulphur on Hwy 177, 3/4 mile east on Tractor Road (Same location as the annual Conference the last few years.)

Rory Kirk is the **Forging Contest** Director this year. The challenge will be **free forged penny scrolls and snub end scrolls** (no jigs can be used.) Ten inch lengths of 1/2" bar will be provided for snub end scrolls and ten inch lengths of 1/4"x3/4" stock will be provided for the penny scrolls. Scrolls must be forged on both ends of each piece and both types of scroll must be completed. The judges will determine the winners based on the best individual scroll end on each piece. There may be a time limit but this is not intended to be a race. Form and finish are the primary focus of this competition.

The contest will have two levels - Beginner and Advanced. This contest is open to everyone so don't be shy! There may be a demo prior to the contest but this is to be determined. You may want to practice on your own before coming to the picnic. Any final rules or requirements on how the contest will be controlled will be confirmed the day of the contest so details are subject to change. See Page 13 for some tips on forging these scrolls.

This is a family friendly event and there is plenty of room to social distance at your own discretion. Please bring your own lawn chairs for convenience. Tickets will be for sale at the picnic to win the 2020 Conference Toolbox since the 2020 Conference was canceled (See the toolbox photos on page 8.) Please bring side dishes and desserts to go with hot dogs.

May 2021

NE Regional Meeting May 1st: Open.

SE Regional Meeting May 8th: Open.

SW Regional Meeting May 15th: Open.

NW Regional Meeting May 22nd: Open.

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!



2020 SCABA COVID CONFERENCE

We did not have a cash flow in 2020 like we usually do after a conference due to Covid cancellations. We are planning to have an auction online to increase our cash flow. 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.

If you could get your donations to me, or any board member, we will compile them. This should be fun! Text or email me with any questions!

Carol Doner, 405-760-8388, caroldoner7@gmail.com

Carol Doner,
State SCABA Secretary

2021 Donations received so far for the online auction:

Terry Jenkins	Blacksmithed Heart with Roses
EWS	Welding Helmet
Gerald Franklin	3 Blacksmith Books
Mike Taylor	3 Bottle Openers worth \$40 Each
Dale Dixon	8 Foot Ornamental Windmill (In Box) Made In USA
Mandell Greteman	3 Lb Diagonal Pein Hammer
Gerald Franklin	Cannady Otto Hand Crank Blower with Stand
Gerald Franklin	Champion 200 Hand Crank Blower (no stand)



Around the State...

NW Region February Meeting: Was hosted by Doug Hyde at the Gretemans' shop in Foss, OK. From LaQuitta: "Today we had the Saltfork Craftsmen meeting at our home. It was so good to see everyone. We even had a few more show up later in the day. The trade item was a Friedrich's cross. There were four turned in. Outstanding job guys!"



Saltfork Craftsmen Artist Blacksmith Association

Board of Directors Election 2021

There are **three** director terms expiring this year. Byron Doner, Don Garner and Mandell Greteman. Don Garner is not running for re-election. One nomination to replace Don's position was received.

The following list includes the nominations for election to the three positions. You may choose from three candidates on the list or write in another candidate who is a member in good standing. Please vote for a total of **three** positions. Only one ballot per household.

VOTE FOR THREE:

- ☐ Byron Doner, Norman, OK
- ☐ Mandell Greteman, Foss, OK
- ☐ Brad Nance, Sallisaw, OK
- ☐ (Other): _____

Please hand deliver your completed ballot to any of the Board members or submit in person at the 2021 SCABA Picnic. Final deadline for hand delivery is April 24th at the SCABA Annual Picnic. Additional ballots will be available at the picnic.

You can also mail in your ballot if desired. Please fold and tape this form closed (postage stamp is required) or place in an envelope and mail the completed ballot to the newsletter editor:

Saltfork Craftsmen 2021 Ballot
C/O Rory Kirk, Director
501 S 3rd Street
Cheyenne, OK 73628

Deadline for **receipt** of your ballot by mail is **Saturday, April 17th**.

All ballots will remain sealed until opened by the Board members in attendance at the Picnic.

PLEASE VOTE!!!



Saltfork Craftsmen 2021 Ballot
C/O Rory Kirk, Director
501 S 3rd Street
Cheyenne, OK 73628



29th Annual Ozark Conference

April 29th - May 2nd , 2021
Missouri State Fairgrounds
Sedalia, MO

pre-registration must be postmarked by April 1st



29th Annual Ozark Conference April 29th - May 2nd , 2021

We will meet again at the Missouri State Fairgrounds (MSF) in Sedalia, MO. Located just 19 miles South of I-70 on US-65 at the junction of US-65 & US-50.

Don't forget our traditional fund raisers: Benefit Auction, Raffle, and BAM Boutique—as these are BAM's major source of income for the year. Items deemed to be valued at more than \$25 should be donated to the Auction.

Please be courteous to our instructors and fellow attendees by keeping your personal conversations outside the demo areas and remain seated so that others are able to see.

Due to safety concerns, safety glasses are required at all events. Please keep a safe distance from forges and demonstrators unless invited to move closer.

Thank You.
Conference Committee

Questions?

Contact:

Mike Gorzel
(636) 336-6347

mo.blacksmith.conference@gmail.com

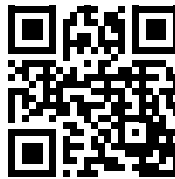
VENDORS AND TAILGATERS

Sites are still free to registered participants in designated areas. Vendor spaces will be assigned and tables will be available from the Fairgrounds at \$8 / table. To make arrangements please contact:

Karen Bouckaert
1-636-673-1996

For full BAM conference flyer visit the BAM website:

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



Demonstrators will be Roy Adams (Christ Centered Ironworks)
and
Allen Newberry J.S. (ABS Journeyman Smith and Forged in Fire Champion)

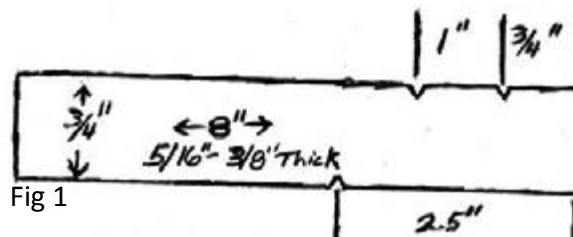
Tongs Demonstration

Written by Mike McLaughlin

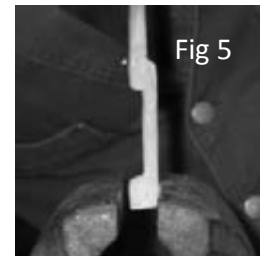
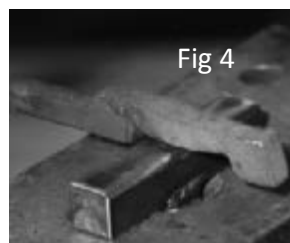
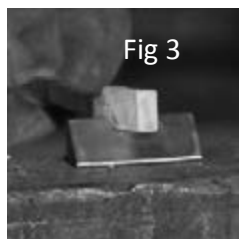
Photos: Bruce Herzog, Bob Stormer, John Sherwood, And Mike M.

These are the steps I used to create 2 different sets of tongs. The first set is a design borrowed from a Youtube video by Toby Hickman. The second pair I was just winging it. I usually make these on a little giant. I did draw out the reigns on the little giant before the demo. I have a supply of 3/4" sucker rod that I use. I forge it to a rectangle about 5/16" x 3/4" and cut it off at 8" long. This size of material has worked ok for tongs that hold up to 3/4" material. The material I used for the demo was 3/8" x 3/4" mild steel 8" long.

Mark bar with cold chisel. (fig 1) 3/4" mark is the jaw area. 1" is between the jaw and boss. 2.5" is other side of boss where reigns will begin. This will net reigns 12" long. Make indent deep enough to index to your butcher or anvil devil. Make sure it is perpendicular to bar length. Use a file to straighten out crooked marks.



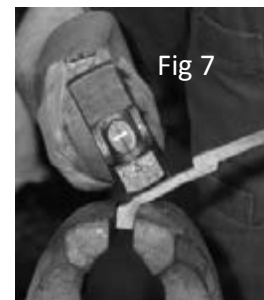
Butcher a little shy of halfway in. (fig 2 and 3) Use a radiused tool for final blows to make sure you don't have too sharp a corner. Make sure the angle of your butcher is going the correct direction.



I draw out the reigns first, so I don't have to use tongs for the rest of it.

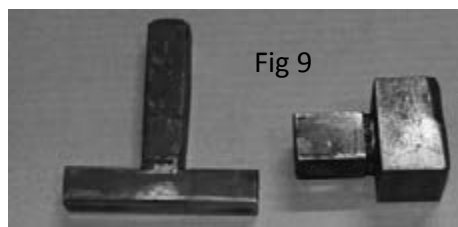
Forge out area that will be the curved part of the jaws. (fig 4 and 5) Using either the nearside and far side edges of the anvil with half faced blows. Or use a little tool like the 3/4" hardy tool I made. I also have a 2" x 2" block that fits in the hardy to help form this area. (fig 9) You are looking for half the thickness of the original bar. It should be about 2" between the boss and jaw area. Make both halves the same length.

Heat boss area clamp in post vise and bend and hammer back almost 90 degrees. (fig 6) Heat jaw area and bend back at least 45 degrees. (fig 7) Use an area of the vise that has radiuses or use radiused jaw liners. Do them the same.



Heat and bend area between the boss and jaw over the horn or use bending fork. The flat part of the jaw should line up with an imaginary center line drawn by the reigns and the center of where the rivet will be.

(fig 8)



Clamp in jaw cutting fixture in post vise. (fig 10) Mark a center line on jaws with hot cut chisel. (fig 11) Heat and cut from one side keeping on center line. Load tongs the other direction to meet in the middle. You will probably have to do this in multiple heats. I had been chiseling from the same side and I would run off center. Plus my chisel isn't ground exactly the same on both sides so I rotate it every few hits. For holding material up to $\frac{1}{2}$ " you only need to go about $\frac{1}{4}$ " deep. Use anvil devil or edge of anvil to form jaws to a 90 degree angle. (fig 12)

Hot punch or drill hole for rivet. I use $\frac{5}{16}$ " X 1". If you punch do it with the tongs facing the same direction. The sides that are on the anvil will be the sides that will touch when assembled. Keep area flat and file if necessary. I set the rivet cold. You will have to tighten it up after you adjust the jaws and reigns.

Heat up the entire jaw and boss area. Clamp flat area of jaw in vise with chiseled area up. (fig 13) Using a hammer and a little bending knock boss area over to line up center of jaws to the center of the boss. Do the same for both sides. Heat up jaws again then take a piece of the material you wish to hold and place in jaws of tongs. Squeeze in vise to make the jaws conform to the shape. (fig 14) If you have enough heat you can spread and adjust reigns to the spread you want to hold them comfortably. You may have to do this multiple times to get everything lined up. I then heat up the boss area on the reign side. Grip the reigns as close to the boss as possible in the corner of the vise jaws and bend past center, (fig 15) then move it up about $\frac{3}{4}$ " to 1" and bend back to center the reigns. (fig 16) Do both sides the same. This may take a few heats. I do all of these adjustments by eye. Building some tooling for the offsets would probably make it easier. But after you make a couple pair it gets easier.



Fig 10

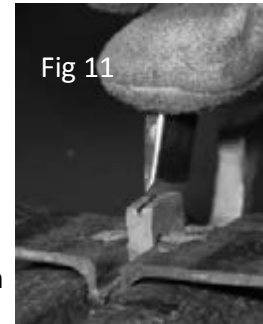


Fig 11

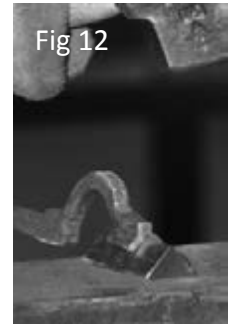


Fig 12



Fig 13



Fig 14



Fig 15



Fig 16



The second set of tongs I use to hold chisels, punches, and my touchmark. I did not have very many pictures of the steps, but hopefully you can get it by my description. It uses the same $\frac{3}{4}$ " x $\frac{3}{8}$ " X 8" long piece of mild steel. I mark it with a chisel at the 1.5" mark on one side and 2-1/4" on the other. (fig 1) This gives you the $\frac{3}{4}$ " for the boss area.

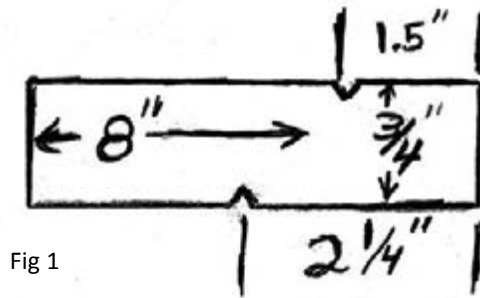


Fig 1

Butcher a little shy of halfway in. Use a radiused tool for final blows to make sure you don't have too sharp a corner. Make sure the angle of your butcher is going the correct direction.

I draw out the reigns first, so I don't have to use tongs for the rest of it.

Heat jaw end. Clamp in vise close to the 1.5" butcher. Twist it 90 degrees not too fast but not too slow. Twist the other one the same direction. Forge out the jaw out about $\frac{3}{8}$ " to $\frac{1}{2}$ " longer keeping the $\frac{3}{4}$ " width the same. Make both sides match in length.

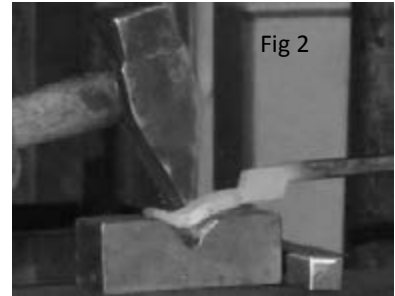


Fig 2

I used a small v-block and a hammer with a thin peen to curve the jaws. (fig 2) If you have a treadle hammer or a striker, you could lay a piece of round over it and drive it in also. You could use a piece of square and drive it on the diamond to get square jaws. Do both and get as close to the same shape as possible.

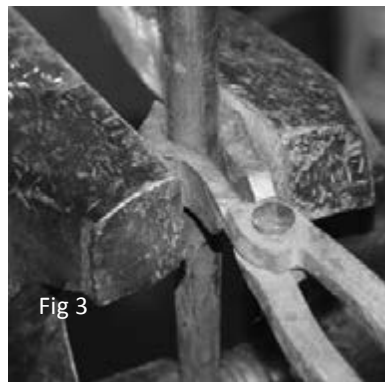


Fig 3

Punch or drill holes for the rivet. Put halves together and rivet.

Heat the boss area clamp on material then clamp in vise to adjust the reigns. (Fig 3) I put more offset in these than I do in the others.

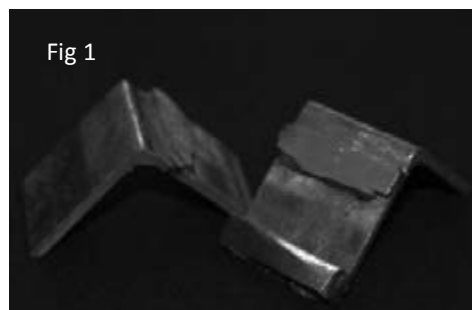
Then heat up the end of one reign. Pick an edge of the anvil that has about a $\frac{1}{4}$ " radius. Hold reign at a 45-degree angle to the face and put in dents in the outside edge of reign spaced about $\frac{1}{2}$ " apart. 7 or 8 notches will be enough (about 3"). Bend over the horn to a nice curve. Heat the other reign and make a loop. The center of it should be approximately at the center of the radius on the other reign.

Use 6 to 8" of $\frac{1}{4}$ " round to make a loop like a chain link. The material I used for this one was an inch short. Put through loop on reign. Clamp material in jaws and squeeze together and see if the link will lock in. You will have to make the link a little bigger or smaller to get it to lock firmly. But that is part of the fun of it.

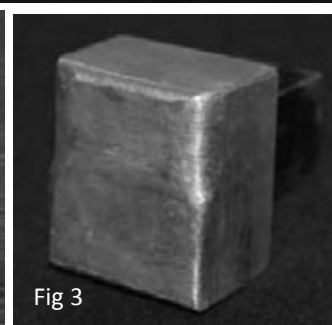
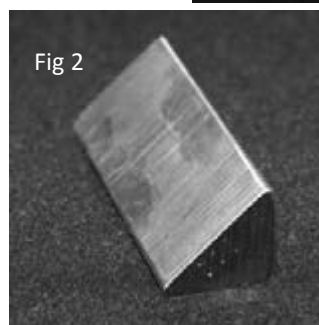


Tooling Notes

Jaw cutting fixture (fig 1). 2 pieces of 2" angle iron 1.5" long. I tacked welded 5/16" square 1/4" from the angle to both sides clamped together. Then I cut through the 5/16" to separate them. I welded across the bottom all the way. I used a belt sander to grind the thickness down to hold the tongs. I added another piece of 5/16" to the edge opposite the angle so it would pinch them. You may have to grind that a bit to fit also.

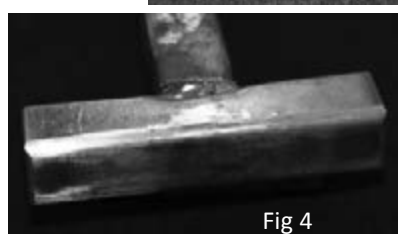


The Anvil Devil (fig 2) is a piece of 1" square tool steel sawn on the diamond. This steel was shank tooling to hold carbide inserts for lathe tooling. It is probably 41xx or 43xx. It is tough but not hard. I ground a 3/32" radius on one side and 1/8" on the other. It is also ground to about an 86 degree angle. It keeps it from flopping over on the anvil when using it.



The block (fig 3) is just a 2" x 2" block of mild steel welded to a shank to fit my anvil. I ground a couple different radiuses on it.

The other block (fig 4) is 3/4" square lathe tool shank welded to a hardy shank. It has 3/16" radiuses on it.



The V-block (fig 5) is 1.5" square with a hole drilled in it and cut at a 90 degree angle. I have a couple different sizes of these.

There is many different ways of making tongs. Some are easier and some are more difficult. I kind of like these at the moment.

Random Pictures



The Swing Hook Project: Enhancing Basic Skills

Len Ledet

Several years ago Mo Hamburger received a commission to construct several “swinging hooks”. It was a good project that encompassed the applying of many of the basic skills of blacksmithing. This included joinery skills thru the construction of tenons, heading of tenons, and collars as well as heating, drawing out, bending, upsetting, and piercing . With Mo’s blessing I decided to re-create the project. It was a fun project and great to practice and enhance basic skills.



Hook Components:

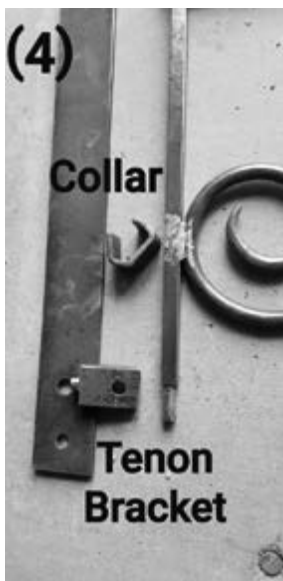
Scroll: 1/2" round 14 inches long; Tenon Bracket: 1/2" x 1 1/4" x cut length 2"; Hook: 1/2" x 1/2" x 17" long; Swing Bar: 1/2" x 1/2" x 15"; Mounting Bar: 2" x 3/16" x 22" long; Collar Material: 3/16" x 1"



Swing bar with a "Slit and Drift" hole and tenon. See Mark Aspery "Mastering The Fundamentals Of Traditional Joinery". Excellent book.



Tenon bracket, Cut both ends 2 inches long.



Tenon bracket and collars ready for assembly

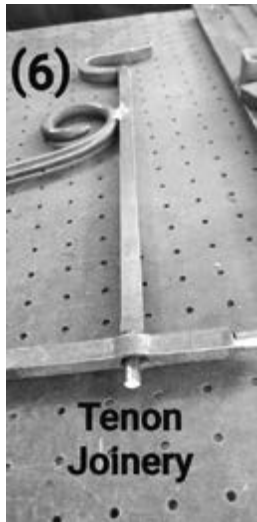


Tenon bracket ready for welding



Tenon in countersunk hole.

The Swing Hook Project: Enhancing Basic Skills (continued)



Tenon Joinery



Ready to head the tenon



Heating and forging the tenon head



The complete joint



Collars forged and ready to be applied



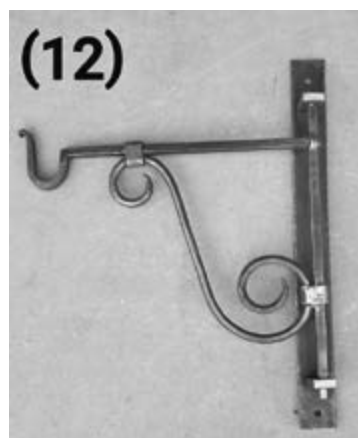
Collar applied



Slip the swinging assembly into the top tenon bracket.



Slip the swinging assembly into the bottom tenon bracket and weld that bracket to the mounting bar.



Finished

March 2021

California Blacksmith *Online*

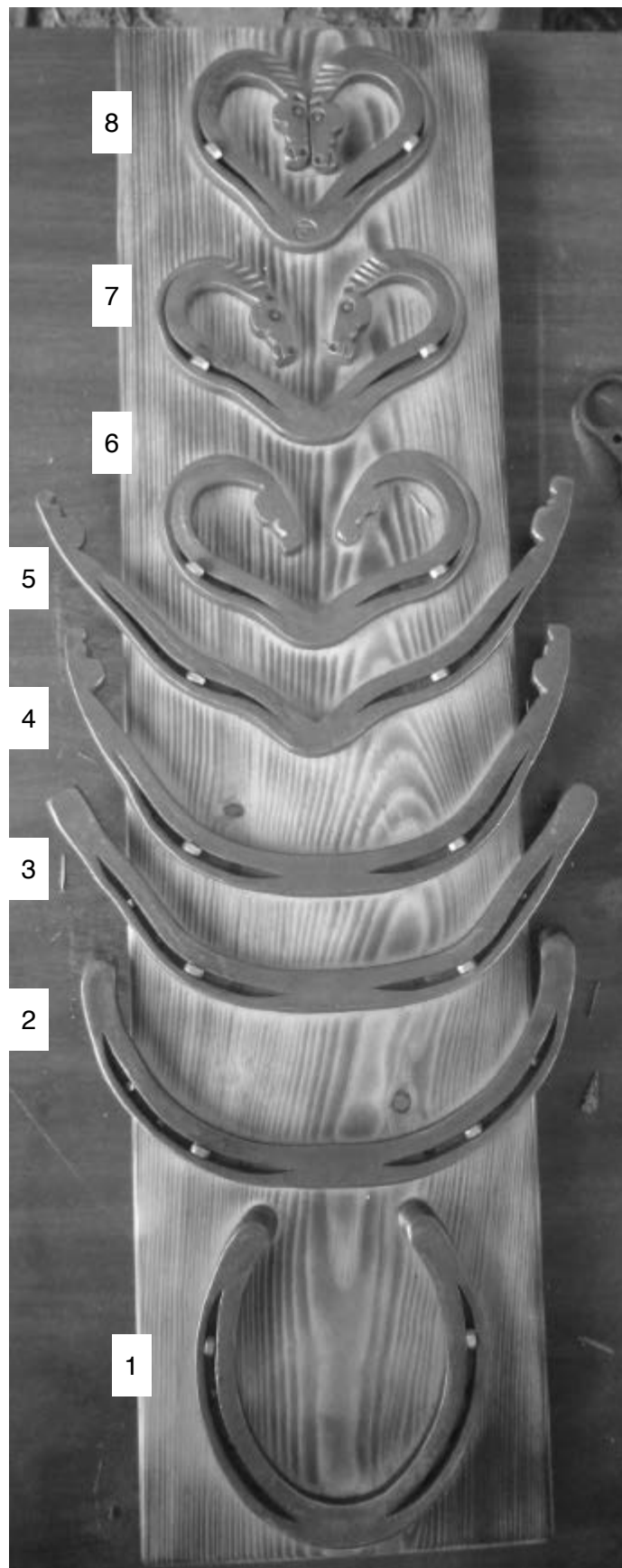
Horseshoe to Heart An Exquisite Storyboard from Steve Taylor

Shown at Oktoberfest 2016

1. Your basic horseshoe.
2. Bend outwards, being careful to avoid collapsing the center groove.
3. Straighten the ends.
4. Create the neck-to-head transition (step): half-on/half-off blows over a sharp corner of the anvil, or use a side set to make the step.

Draw the lower face out. Use a small fuller to make the two indents to define the snout.

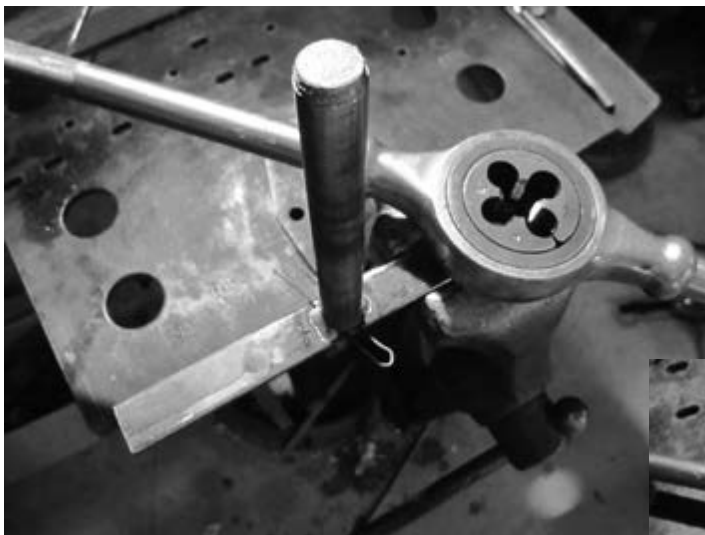
5. Locate the center of the horseshoe, then over a vee-block or double bar bottom tool, use a fuller to make the center indent.
6. Bend the heads around, keeping both curves even and matching.
7. Punch in the eyes, nostril, mouth, and mane. This will probably take several heats.
8. Bring the heads together and even. Tweak and necessary.
9. Clean and enjoy!



SHOP TIP - Threading

By Jim Carothers

I recently had to thread some 3/4" bar. It was not worth the trip to town to the local machine shop I usually get help from, so I decided to try it myself here in the home shop. What I found was that I did not have a vise, including my pipe vise, that would hold the 3/4" round bar against the torque required for threading. After a few minutes, it occurred to me to tack weld a torque arm, scrap flat bar, onto the bottom of the round. The torque arm reacts against the sides of the vise; problem solved. Since I only had two pieces to thread, this saved me a lot of time and some money as well.



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
- Safety 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



Graphite Heather



Heliconia



Irish Green



Orange



Red



Royal



Safety Green



Sapphire



Sport Grey



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 _____

Address _____

City _____ State _____ Zip _____

Phone (Best Number to Contact) (_____) _____

e-mail _____

Size	Color	Quantity	Price Each	Sub-Total

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

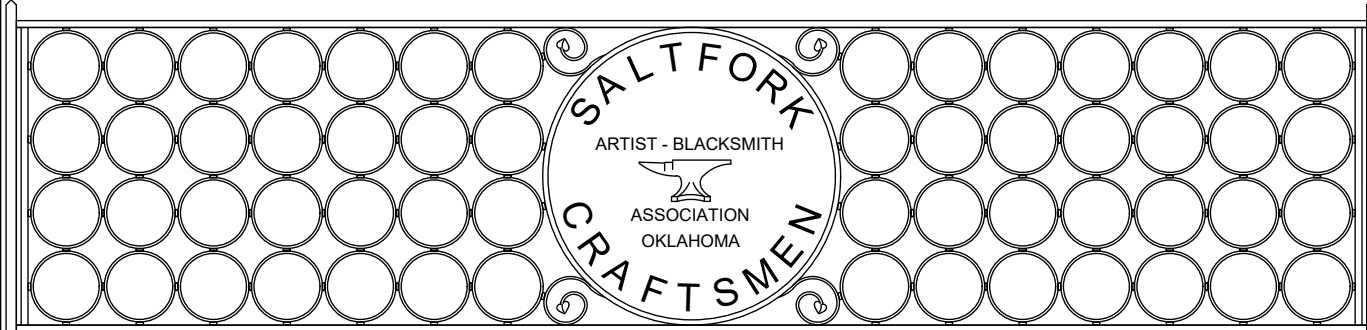
T-Shirt Price:	
Small to 3X:	\$15 Each
4X to 6X:	\$20 Each

Total:

Mail this form with payment to:

*Teresa Gabrish
322 Washington
Blanchard, OK 73010*

The Saltfork Gate Project Still Needs More Rings!



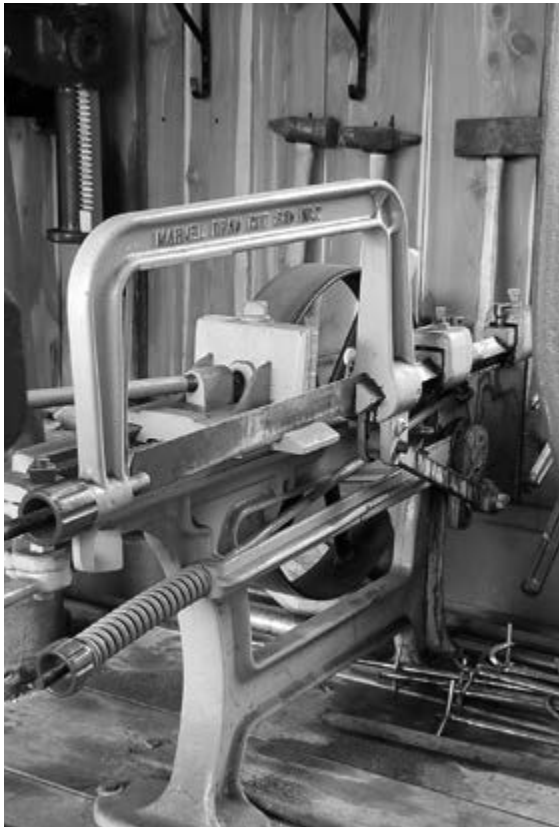
This is a community project that is open to all Saltfork members regardless of skill level or experience. There is still room for more rings. You can see more details about the project in any of the past newsletters from August 2019 through January 2021.

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.**

SCABA Shop and Swap

Wanted to Buy:

I am Saltfork member James Bohrer and I am looking for a powered hacksaw or drawsaw and also line shaft stuff for my forge. The attached photos are the kind of saw I am looking for. Thank you. **Contact James Bohrer at 405-566-8550.**



SCABA Shop and Swap



Your one-stop-shop for
Quick and Rapid Tongs,
blacksmithing tooling,
accessories, apparel, and
the MZ75 Power Hammer.

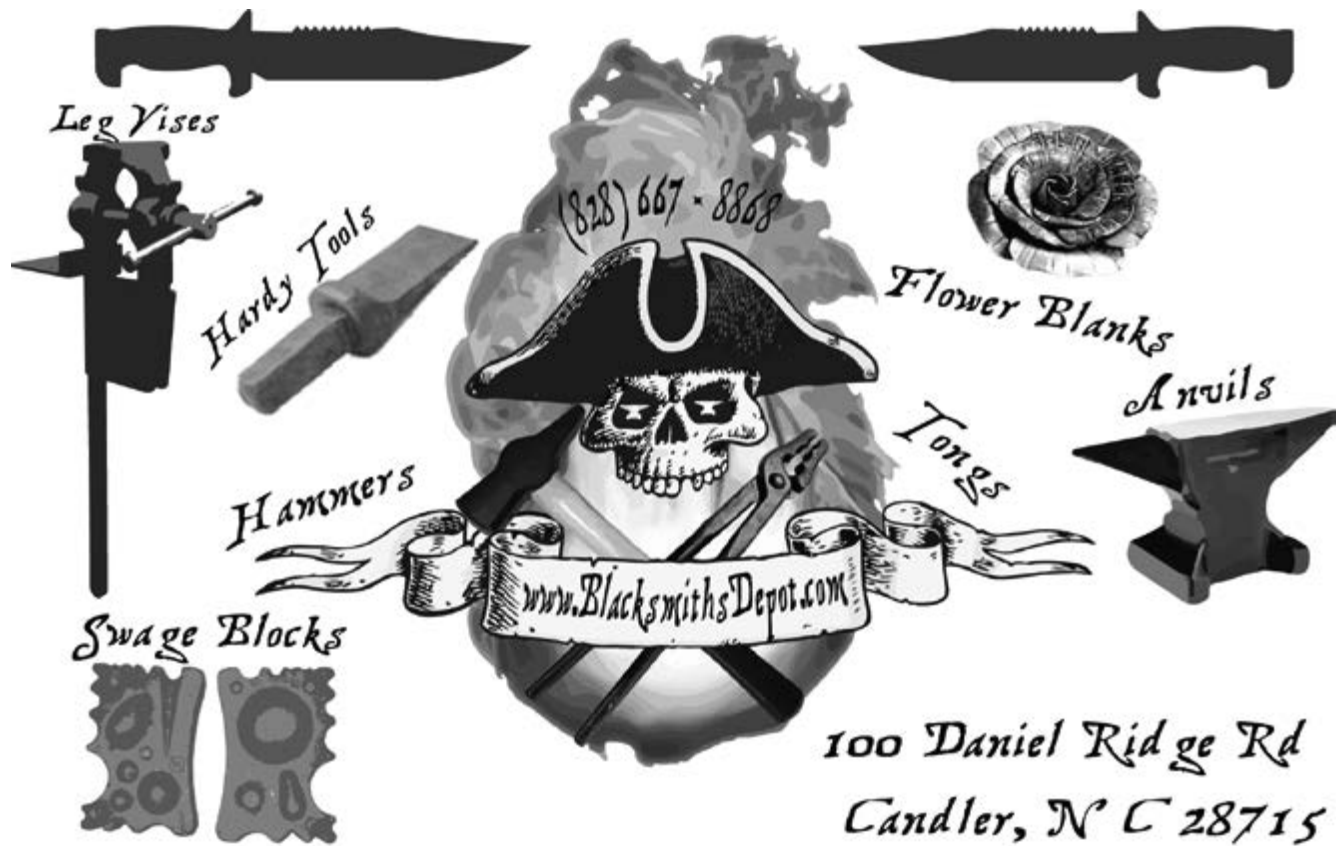


WWW.KENSIRON.COM

Ken's Custom Iron

37634 County Road 9, Avon, MN 56310 | 320.746.8161 | mail@kensiron.com

SCABA Shop and Swap



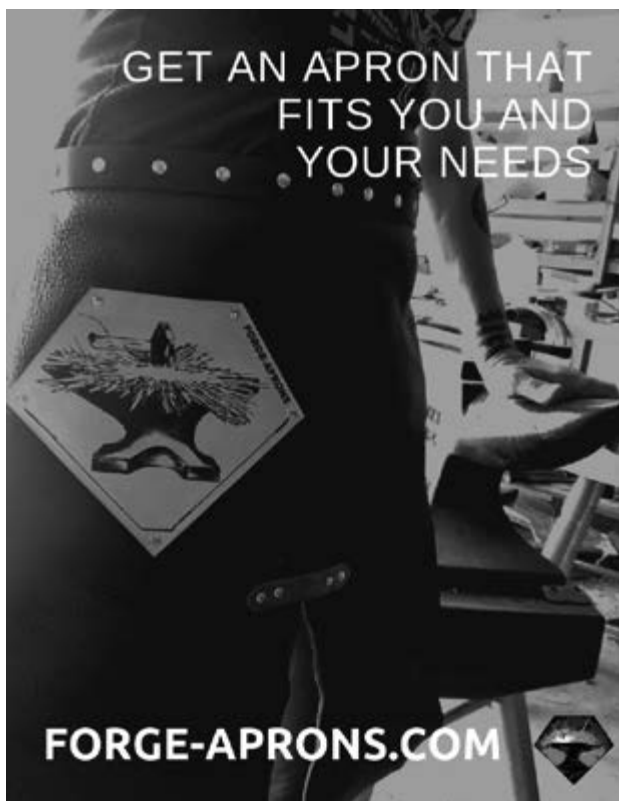
For Sale: 15 Lb Tire Hammers:

\$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

GET AN APRON THAT
FITS YOU AND
YOUR NEEDS



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SCABA Shop and Swap



Call to Order Toll Free 24/7 - 866-627-6922

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!



Reeder Products Inc.

3201 Skylane Drive, Suite 114
Carrollton, Texas 75006 United States
(469) 257-1000

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

**** (NOTICE: Price Change) ****

\$250.00 plus shipping.
(Same price to members and non-members.)



SCABA Floor Cones



\$275.00 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:

**** (NOTICE: Price Change) ****

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces. The coal is \$300.00/ton or .15 /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 (\$.15 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. \$5.00 (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?

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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. 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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