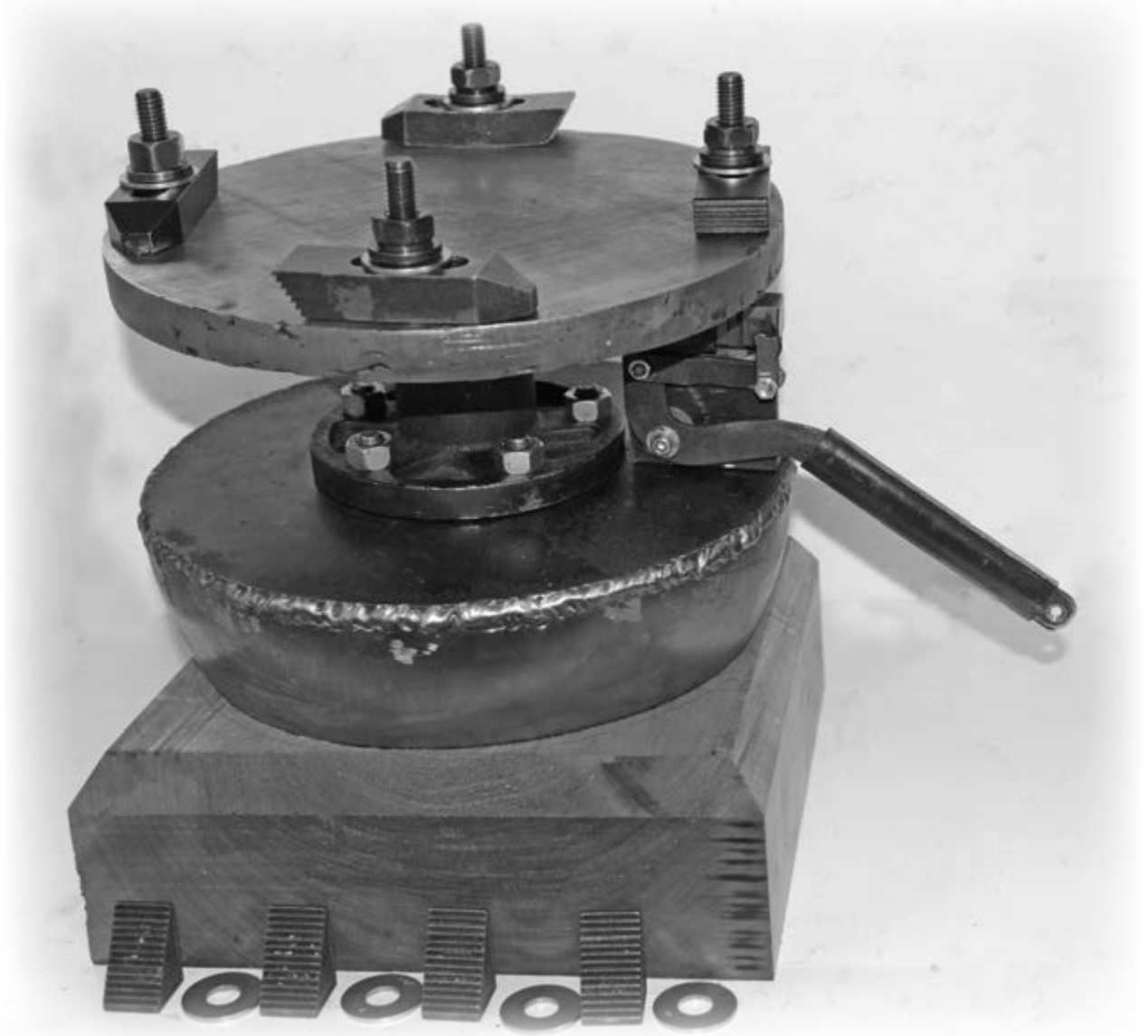


# Saltfork Craftsmen Artist-Blacksmith Association

August 2021



**Build a Variable Axis Rotating Table**  
By H. Kent Hepworth - Powell, Tennessee  
(Page 23)

**Saltfork Craftsmen  
Artist-Blacksmith Association  
Officers and Directors**

**President/West Workshop Coordinator:**

Mandell Greteman 580-515-1292  
409 East Broadway  
Foss, Okla. 73647 mandell01@windstream.net

**Vice-President/Conference Chair:**

JJ McGill 580-369-1042  
5399 Pete Nelson Rd.  
Davis, OK 73030 jjmcgill88@yahoo.com

**Director:**

Byron Doner 405-650-7520  
6520 Alameda  
Norman OK 73026 byrondoner@esok.us

**Director:**

Rory Kirk 580-497-6426  
501 S 3rd Street  
Cheyenne, OK 73628 ershkirk@gmail.com

**Director/East Workshop Coordinator:**

Brad Nance 918-774-4291  
106570 S. 4690 Rd  
Sallisaw, OK 74955 bradley.nance@cnet.com

**Director:**

Eric Jergensen 405-414-8848  
625 NW 18th  
Oklahoma City, OK 73103 gericjergensen@gmail.com

**Director:**

Russell Bartling 918-633-0234  
70 N 160th W. Ave  
Sand Springs, Ok 74063 rbartling@ionet.net

**Assignments:**

**Secretary:**

Carol Doner 405-760-8388  
6520 Alameda  
Norman, OK 73026 caroldoner7@gmail.com

**Treasurer:**

Teresa Gabrish 405-824-9681  
322 Washington Ave  
Blanchard, Ok 73010 tgabrish@gmail.com

**Editor/Regional Meeting Coordinator:**

Russell Bartling 918-633-0234  
70 N 160th W. Ave  
Sand Springs, Ok 74063 rbartling@ionet.net

**Webmaster:**

Dodie O'Bryan  
Pawnee, Ok scout@skally.net

**Librarian:**

Don Garner 580-302-1845  
23713 E 860 Rd  
Thomas, OK 73669  
Call or Text. If you get voice mail, please leave a message.

**Editor's Notes:**

**What About the Conference??**

Usually, by the August newsletter (this one), we have detailed information on the current year's conference, registration form, etc.

Well, we have had some very last minute changes including recent travel restrictions in the Netherlands which will keep Joey Van der Steeg from being able to attend. We knew it could be a possibility and had a plan "B" in place. But that plan too may be unraveling. As we move down the alphabet to through the back up plans, some details remain to be determined. We will keep you posted and provide updates as soon as they are available. Look for supplemental communications including the website, Facebook, and postal mail to get the most timely information as it becomes available. -Russell Bartling, Editor

**\*\* SCABA Board of Directors  
Meeting \*\***

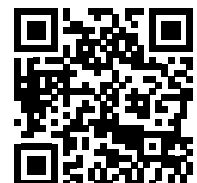
There is a Board of Directors meeting scheduled for **2:00 PM Sunday, August 8th, 2021** at Byron Doner's shop in Norman.

Board meetings are open to any member to attend. This is the best place to offer any comments, ideas or criticisms you have on how your club operates. Feel free to attend. If you plan to attend and have an issue that needs addressed, please send your topic(s) to the Secretary, Carol Doner, to get on the agenda prior to the meeting date. - 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.

Material from this newsletter may be freely copied without permission for non-profit purposes. Please credit the author and this publication.

**Visit our Saltfork Craftsmen Website:**  
[www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org)



## President's Notes:

Well as summer rolls along it is warming up nicely if you like it hot. I personally do not! We are getting ready to have a beginner's class at the Elk City museum shop. We have had twenty two students sign up so we are going to split into two different classes. The weather up until recently has been a little cooler than it could have been but, wouldn't you know it, the weather man says the first 100 degree day is going to be the first day of our class.

We are working on this year's conference and it is my understanding that Joey Van Der Steeg will not be able to travel to the United States due to reinstated travel restrictions in the Netherlands. We are working on plan "B" now and watching the situation closely.

We are looking for volunteers to work at the Oklahoma State Fair. Contact Richard Blasius or his wife, Michel, if you would like to demo at the fair. (*See more info on page 10 - Editor*)

The coal that I bought (that I mentioned in last month's newsletter) seems to burn plenty hot but it also seems to make a lot more clinker than the coal we've had in the past.

A lot has been slow over the last year but I have given a few private lessons in the past few weeks. There seems to be some new interest in blacksmithing and iron work. I think that is a positive sign.

Stay cool and hydrated!

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.

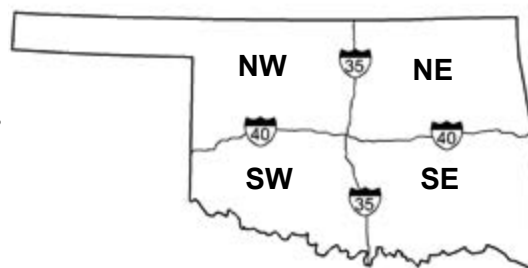
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

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.

## We have two workshop coordinators:

**Western Areas:** Mandell Greteman is the SCABA Workshop Coordinator.  
Contact Mandell at 580-515-1292.

**Eastern Areas:** Brad Nance is the SCABA Workshop Coordinator.  
Contact Brad at 918-774-4291.

## 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.**

## 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**

# 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 (Rory Kirk)
Jun 5th (Open)	Jun 12th (Open)	Jun 19th (Open)	Jun 26th (Everett Timmons)
Jul 3rd (Matthew (Ragnar) Crowson)	Jul 10th (Open)	Jul 17th (Open)	Jul 24th (Open)
Aug 7th (Diana Simon)	Aug 14th (Open)	Aug 21st (Open)	Aug 28th (Open)
Sep 4th (Tracy Cowart)	Sep 11th (Open)	Sep 18th (JJ McGill)	Sep 25th (Ron LehenBauer as Host - Don Garner as Contact Person)
Oct 2nd (Open)	Oct 9th (Conference Setup )	Oct 16th (Conference Weekend)	Oct 23rd (Rory Kirk)
Nov 6th (Diana Simon)	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 (Boy Scout Meeting at Murray County Antique Tractor Show Grounds.)

July 31st (Beginner Blacksmith Workshop - Elk City)

October 30th (Open)

# August 2021

**NE Regional Meeting August 7th:** 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.)

The trade item is a Friedrich's Cross. The meeting is planned to start at 9:00 AM. Lunch will not be provided this time but there will be a food wagon on premises and fast food restaurants are close by. We are going to have a family fun day at the same time so we should have a great crowd! We will have coffee and I am sure someone will bring donuts for in the morning.

Contact Diana Simon at 580-572-8290 or [dsimon@gmail.com](mailto:dsimon@gmail.com) if you have questions.

SE Regional Meeting August 14th: Open.

SW Regional Meeting August 21st: Open.

NW Regional Meeting August 28th: Open.

# September 2021

**NE Regional Meeting Sept 4th:** Will be hosted by Tracy Cowart at Dan Cowart's shop at 10380 N 4010 Road, Wann, OK 74083. (See map on next page.)

Trade item is something used at the grille: Steak turner, fork, brush, spatula, spoon, corn cobb holder, etc.

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

Contact Tracy Cowart at 918-630-7025 or [gtcowart@gmail.com](mailto:gtcowart@gmail.com) if you have questions.

SE Regional Meeting Sept 11th: Open.

**SW Regional Meeting Sept 18th:** Will be hosted by Ricky Vardell and J.J. McGill in conjunction with the Murray County Antique Tractor & Implement Association Show.

The trade item is two coal forge fire tending tools. Make any two of a coal poker, scraper, or shovel. (Or you can make all three if you want!)

Lunch will be on your own. Directions are 7 miles north of Sulphur on Hwy 177 then east ¾ mile on Tractor Road. If you need more information, contact Ricky Vardell at 580-512-8006 or JJ McGill at 580-369-1042.

**NW Regional Meeting Sept 25th:** Will be hosted by Ron Lehenbaur (Don Garner as contact) at the Fairview Tractor Show. Directions: 1 ½ miles east of Fairview on Hwy 58. Watch for signs on the north side of the road.

The trade item is a two sets of cabinet door pulls (Total of FOUR pulls.) Start with 5" long x 1/2" wide x 1/8" to 3/16" thick stock. Both sets do not have to match.

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.





# 2020 SCABA COVID CONFERENCE: Watch for the Auctions on E-bay!

Thank you to everyone who donated items for an online auction to help make up for the canceled conference in 2020!

We received a number of great items and Eric Jergensen has started listing the items on E-bay on behalf of Saltfork. The items are not all being listed concurrently but are, instead, being spread out to help build positive seller feedback and to have more time to build awareness of the listings.

To date, the decorative heart/flowers by Terry Jenkins, the diagonal pein hammer by Mandell Greteman, and the helmet from EWS have been sold. There are more great items coming up!

If you are interested in bidding, check E-bay for the seller "saltfork0." Go to the advanced search option and enter saltfork0 in the seller ID field. (That is saltfork with a zero at the end.) Members can watch their e-mails for an announcement with links from Saltfork when the listings go live. You can save the seller on E-bay to receive notifications of new listings. If you are new to E-bay, creating an account and bidding is easy and you can get notifications as the auction progresses.

Here is a link to the Saltfork listings (current at the time this newsletter is being produced. Hopefully, this link will remain valid as listings change) :

[https://www.ebay.com/sch/saltfork0/m.html?item=373631337087&hash=item-56fe29c27f%3Ag%3AzBgAAOSwUWpg2oUw&rt=nc&\\_trksid=p2047675.l2562](https://www.ebay.com/sch/saltfork0/m.html?item=373631337087&hash=item-56fe29c27f%3Ag%3AzBgAAOSwUWpg2oUw&rt=nc&_trksid=p2047675.l2562)



***Thank you to everyone who donated  
items and thank you to the bidders!***



# Oklahoma State Fair is Back!

Hello Saltfork Club members! It is time to dust of your equipment and get back in the swing of things. The Oklahoma State Fair is set to take place this year after a year off from Covid.

Mark your calendars for the upcoming demonstration days:

**Thursday, September 15 through Sunday, September 25, 2021**

Like most things, the State Fair Budget was cut. But they secured the Frontier Experience and our demonstrators! Let me know sooner, rather than later, if you are interested in volunteering for this event. You will receive free admission and premier parking for the days you demonstrate.

This is a great opportunity to draw members into our club while brushing up on our skills. We are seeking those who would like to help promote and talk about the club by demonstrating to fairgoers. In years past we have also had a complimentary hotel for those traveling a greater distance from out of town. Consideration is given on a first requested and distance traveled consideration.

If you would like more information about this fun event, please contact Richard Blasius 405-881-0804 or his wife Michele 405-550-9850.

## SALTFORK CRAFTSMEN 2021 STATE FAIR CALENDAR

### SEPTEMBER

SUNDAY	MONDAY	TUESDAY	WEDNESDAY	THURSDAY	FRIDAY	SATURDAY
				<b>FIRST DAY 16</b> *	<b>17</b> Anthony Griggs (Cheryl Griggs) *	<b>18</b> *
<b>19</b> *	<b>20</b> Anthony Griggs (Cheryl Griggs) *	<b>21</b> *	<b>22</b> Anthony Griggs (Cheryl Griggs) *	<b>23</b> *	<b>24</b> *	<b>25</b> *
<b>LAST DAY 26</b> *						

**Scheduling:**

Richard Blasius 405-881-0804

Michele Blasius 405-550-9850

## Demo Opportunity:

From: "Kitty Williams" <[okierennie1@yahoo.com](mailto:okierennie1@yahoo.com)>

To: [mandell01@windstream.net](mailto:mandell01@windstream.net)

Sent: Wednesday, July 21, 2021 5:49:41 AM

Subject: Inaugural Celtic Festival

Greetings,

I am writing on behalf of the committee of the **Inaugural Grove Celtic Festival** to see if any of your fine demonstrators/artisans would be interested in and available for **Saturday, Sept 25th, 2021**. The Festival will be held at **St. Andrews Episcopal Church in Grove, Ok.** The festival has a Facebook page where more information can be found as well as being able to send messages to the committee directly.

Thanks ever so much!

Kitty Williams  
Vinita, Ok, USA

Creator, President, & CEO of Williams Entertainment,  
a 501 (c) 3 Company, Home of:

"The Ladies of the Salty Kiss," "Native Souls," Grand Lake  
Renaissance Festival & Shark Bay Pirate Festival

<https://www.WilliamsEntertainment.org/>

<https://www.facebook.com/GrandLakeRenaissanceFestival>

*NOTE: I tried to find a link for the Inaugural Grove Celtic Festival Facebook page but, at the time of printing, it did not appear to be active yet. - Editor*

# Little Giant Power Hammer Rebuilding Class October 15-17 Nebraska City, NE

Attached (*see next page*) is information for the last Little Giant power hammer rebuilding class that will be taught by Sid Suedmeier, former owner of the Little Giant company. The business has been bought by longtime friends David Sloan and Doug Klaus, and they intend to carry on the rebuilding class.

Thank you so much for your support through the years in promoting the rebuilding class. We hope it will help keep the machines and blacksmithing alive for generations to come.

- Doug Klaus



**LEARN HOW TO MAKE YOUR  
LITTLE GIANT POWER HAMMER  
WORK HARDER THAN EVER!**

In 1991, Sid Suedmeier, having recently acquired the dusty remains of the Little Giant business, hosted his first Little Giant Hammer rebuilding class.

The class and Sid were taught by our good friend Fred Caylor of Zionsville, Indiana, at that time one of few authorities on these antique machines. As Fred grew older, Sid took over teaching the class, and has taught at best count 27 classes.

Sid sold Little Giant, the parts and repair business, to his long time machinist in 2013, and just this year the business made a move to our good and capable friends, David Sloan and Doug Klaus.

This 2 1/2 day class is a hands-on format. You will help transform a 25 LB Little Giant hammer from sloppy to sharp. This is the last class that Sid Suedmeier, intends to teach. He will be handing the reins over to David Sloan, who has attended at least 15 classes and has assisted Sid through the years.

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

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

No experience is required to attend this class. Past students have ranged from age 15 to 90, and from all walks of life. Anyone who wants to learn will benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop.

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

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

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

**School Dates  
October 15-17  
2021 REGISTRATION**

Name: \_\_\_\_\_

Business name: \_\_\_\_\_

Address: \_\_\_\_\_

Telephone: \_\_\_\_\_

Email address: \_\_\_\_\_

**Since we no longer operate a business,  
payment needs to be by check or money  
order. Checks should be made out to  
Sid Suedmeier.**

**POWER HAMMER INFO**

Brand: \_\_\_\_\_

Size: \_\_\_\_\_

Serial Number: \_\_\_\_\_

*Please call or email if you have any questions, or  
prefer to register by phone. You can reach us at  
402.873.6605 or Sidsshop@windstream.net.*

*Sid's shop is located at 420 4<sup>th</sup> Corso, Nebraska  
City, NE 68410.*

## Around the State...

**NW Region June Meeting:** On June 26, 2021 the Northwest Region of Saltfork Craftsmen had their monthly meeting at the Route 66 Museum in Elk City. Seventeen members and guests turned up, along with several tourists coming through the museum. It was good to see people starting to move around and get back to traveling after the shut downs.

Some of the guys worked on and visited about their certification projects. Hopefully they can lead others of us down the road to better work. A demonstration was done for a family on nail making and the kids decided that would be a long process to make enough nails for a house so they would go to the hardware store. The lady explained to the kids that it was not an option at that time. It is a real pleasure to see people interested in the craft and explaining the daily function the forge and anvil had.

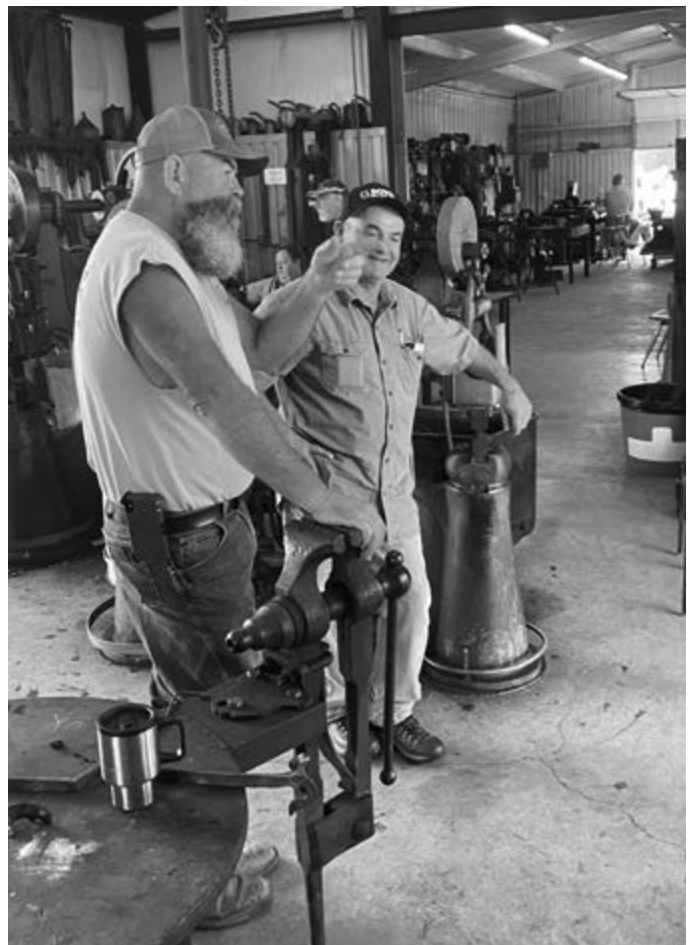
We had eight trade items, which was a livestock bell, turned in. Most all of these were very nicely made, while mine needed some TLC. I think it would go good on a buffalo heading south for the winter. With the bells setting out, several of the people passing through could not resist ringing all of them, and were comparing the different tones of each bell. By the end of the day a cell phone ring could not register with you.

The dinner went off great. We had Thanksgiving in June. Doug Hyde, "Doc" attended bringing a smoked ham, while I brought my cooking rig and made a Dutch Oven turkey. Once the lid came off the pot it was decided that I could stay even with an ugly bell. There were plenty of side dishes and desserts so nobody went without.

At the end, it was more like Christmas in June, all the bells clanging and ringing as the shop closed and the smiths loaded up their pretty bells, and one ugly one, heading off to home waiting on the next meeting.

- Everett Timmons

















*This bell was made by Donita Smith. This one was not one of the trade items. Nice work!*  
-Editor

---

## Around the State (Continued)...

**NE Region July Meeting:** Was held by Matthew (Ragnar) Crowson. No meeting photos or write up are available.

**SE Region July Meeting:** No meeting was held.

**SW Region July Meeting:** No meeting was held.

## Around the State (Continued)...

### Dust Bowl Days Celebration (Sayre, OK):

The local Saltfork Craftsmen members from western Oklahoma were invited to demo at Sayre Oklahoma during their Dust Bowl Days Celebration Saturday, July 10th. Mandell Greteman, Monte Smith and Rory Kirk volunteered for the task. LaQuitta Greteman and Donita Smith helped out with showing off some of our displayed items and answering questions about our organization. I think we had a nice turnout. We made several keychains and other small items. There were lots of nice people to visit with and all-in-all it was a really nice day. - Rory Kirk.







# Member Gallery

## Baby Spurs By Rory Kirk

Rory Kirk has a brand new grandson. Don't let the hidden smile in the photo fool you, he is proud of the latest addition to the family! Rory made his first ever pair of spurs, baby sized, to honor the occasion. The dimes on the strap buttons have the birth dates of both parents and the rowels have the baby's birth date. I don't think you could ask for a better first set of spurs. Nice Job Rory! - Editor



# Create A Variable Axis Rotating Table (VART)

H. Kent Hepworth - Powell, Tennessee

## (Part One)

Peter Renzetti published an article on “**Building the V.A.R.T. (Variable Axis Rotating Table)**” which is in the Fall 1996, Artisan Blacksmith Association of North America (ABANA) Anvil’s Ring pp 41 & 42. At the Alabama Forge Council (AFC) 2009 September Conference, Ernie Dorrill used a version of Renzetti’s VART in the Repoussé and Chasing Session of his demonstration. Ernie’s use of the VART in chasing a complex element convinced me that the VART is an ergonomically useful tool by reducing physical strain and fatigue in repoussé, chasing, piercing and engraving processes. My purpose in revisiting the VART is to bring attention to this useful blacksmithing tool and for those interested in building their own VART identify sources for components and suggest variations to Renzetti’s original design. Blacksmiths by their very nature are creative and imaginative (i.e. think “out-of-the-box” types) in the fabrication, modification and variation in tool construction. This VART project is no exception and I look forward to discovering their innovations and improvements.

Perusal of the bill of materials and Figure 1, demonstrates the center of gravity (CG) of this VART is located well above the hemisphere’s top plate. This causes the VART to be “top heavy” at any position unless it is used solely in the absolutely vertical position and this limits the tool’s function. To overcome the CG obstacle Renzetti suggests using ballast in the hemispherical base cavity to lower the VART’s CG to a reasonable level. This suggested fix solves the CG problem; however, it adds considerable weight to this already heavy tool. Most blacksmiths desire their tools to be somewhat mobile for taking to demonstrations, workshops etc... As configured the VART is cumbersome to transport; hence, this version as designed is composed of four (4) sub-assemblies: 1) **Hemispherical Base**; 2) **Hub/Spindle & Table Platform**; 3) **Table Lock Mechanism**; and 4) **Ball Joint Stand**. Disassembly to its sub-assembly level is accomplished by removing five (5) nuts and two (2) bolts. Each of the individual sub-assemblies weight and size is reasonable to transport and reassembly does not require realignment or fit concerns.

A VART implies its user is readily able to rotate and arrange its table in almost any desired position to allow performance of desired tasks. A necessary condition is the table will maintain its position until it is repositioned by its user. To accomplish this feat Renzetti’s version of the VART uses a foot operated band brake system; while, Dorrill’s variation does not include a table restraining system other than its internal bearing friction (observing Dorrill performing chasing work on his VART during his AFC demonstration indicated this mode of operation is satisfactory for his applications). This version of the VART incorporates a simple, quick and easy to use, lever operated system to either lock or allow rotary table motion. Its operating basis for locking the table is a straight tooth spur gear attached to the rotating table with a lever controlled sliding bar to engage the gear’s teeth. Simplicity is the virtue of this system; however, it has a minor limitation. This limitation is based on the number of teeth,  $N$ , on the spur gear. Angular rotational discrimination,  $\Delta$ , from one locked position to the next is determined by:  $\Delta = 360^\circ / N$ ; so, for 22 gear teeth this translates to a  $\Delta \sim 16^\circ$ . For the blacksmithing applications of chasing, repoussé, piercing and engraving this

discrimination is adequate. If your application requires a tighter angular discrimination it is suggested you choose a gear with the number of teeth to achieve your goal. A simplifying option is to omit the lock mechanism altogether, thus use bearing friction to control table movement (this option allows replacing the spur gear with a steel plate). Table rotation control is simply accomplished by adjusting the bearing's pre-load using the castle nut fastener in the hub/spindle. Within the Hub/Spindle & Table Platform sub-assembly there is a Carter Key "keeper" inserted through the Castle Nut and threaded spindle (see Figure 6) to control its taper roller bearing pre-load. If the castle nut is loosened one, two or more notches the hub will rotate more freely; likewise, tightened one, two or several notches will constrain rotation freedom substantially. In fact, an "over tightened" castle nut will effectively lock together the Hemispherical Base and Hub/Spindle & Table Platform sub-assemblies resulting in manual rotation of the table causing rotation solely between the Hemispherical Base and its Ball Joint Stand. If you elect the option to use bearing pre-load friction to control table motion and later determine a locking device would prove beneficial. Including a spur gear in the initial build, this option can be retrofit by constructing and installing the Table Lock Mechanism sub-assembly.

### **VART Fabrication Materials**

The following are lists of components and their sources used in the fabrication of the VART 12" Table system illustrated in Figure 1. Size variation and substitution of materials for components can be made if care is exercised to insure fit and function are not impaired.

#### **Hemispherical Base and Hub/Spindle & Table Platform Component and Materials:**

*Note: Allow generous curf cut allowance.*

- A) Table Platform; 7/8" thick steel plate, ~12" diameter [Obtained- local salvage yard (Alternative: 3/4" to 1" thick steel plate)]
- B) Hemisphere's Top Plate; 1/2" thick steel plate, ~12" diameter [Obtained- local salvage yard (Alternative: 7/16" to 1/2" thick steel plate)]
- C) Spur Gear; ~3" diameter, ~1 1/2" thick, 22 straight teeth [salvaged from heavy equipment repair; Obtained- local Department of Transportation equipment repair facility (Alternative: see introduction for discrimination limitation criteria)]
- D) Hemisphere's Hub/Spindle Cup; 3" standard wall steel pipe (3 1/2" OD) ~3 1/2" length [Obtained- local salvage yard]
- E) Hub/Spindle Cup Cover; 1/4" thick steel plate, ~3 1/2" diameter [Obtained- local salvage yard]
- F) Hemisphere Shell; 12" steel, 1/8" wall thickness (7 1/4 lb.) [Off-shelf available: Lawler Foundry Corporation; 4908 Powell Avenue; Birmingham, Alabama 35232; 800-624-9512; Internet: [www.lawlerfoundry.com](http://www.lawlerfoundry.com); Product ID: WB-4190-HS (Alternative: as suggested by Renzetti - surplus compressed gas cylinder top "round" section)]
- G) Hub/Spindle Assembly; 1,500 pound trailer axle, 5-Lug [Off-shelf available: Northern Tool and Equipment; 2800 Southcross Drive West; Burnsville, Minnesota 55306; 800-221-0516; Internet: [www.northerntool.com](http://www.northerntool.com); Model # 80116, Product ID: 128007(Alternative: salvage Hub/Spindle assembly)]
- H) Ballast Bung; 3/4" NPT pipe plug [Alternative: 55 gallon drum vent cap]
- I) Lug Studs and Nuts; Quantity 5 [Note: Normally supplied with Hub/Spindle assembly]
- J) Table Platform Clamp Studs; Quantity 4; 1/2"x13 tpi all-thread rod; [Obtained- local supplier; each stud cut to desired length]



- K) Table Platform Clamp Stud Nuts; Quantity 4; 1/2"x13 tpi rotating flange nuts [Off-shelf available: McMaster-Carr; 9630 Norwalk Blvd.; Santa Fe Springs, California 90670; 562-463-4277; Internet: [www.mcmaster.com](http://www.mcmaster.com); Product ID 90477A033]
- L) Table Platform Plane Clamp- Quantity 4; 1/2" stud size; 4" long; 1 1/4" wide; 3/4" height; 1 5/16" Slot Length [Off-shelf available: McMaster-Carr; Product ID 84945A35 {Alternative: Step Clamp (same specifications); Product ID 4999A32}]



**Figure 1**  
**VART 12" Table Platform and Ball Joint Stand**

**Table Lock Assembly Component and Materials** (obtain all from local suppliers):

- a) Mounting Bracket; 2 1/2" x 2 1/2" x 1/4" angle iron (~2 3/4" length)
- b) Lock Bar Guide; 1" 12 gauge (0.109" wall) square tube (~2 1/2" length)
- c) Lock Bar; 3/4" square bar (~3 1/2" length)
- d) Lock Bar Extension; 3/8" square bar (~1" length)
- e) Lock Lever; 3/4" x 3/16" flat bar (~10" length)
- f) Transfer Link (Rotary to Linear); 1/2" x 1/8" flat bar (~2 3/4" length)

### Lock Mounting Hardware:

- g)  $\frac{3}{8}$ "x24 tpi x  $\frac{3}{4}$ " bolt, lock washer (Quantity 2)
- h)  $\frac{1}{4}$ "x20 tpi x 1" bolt, 2 flat washers, lock washer, nut (Quantity 1)
- i) #10x32 tpi x  $\frac{3}{4}$ " flat head screw, flat washer, lock washer, nut (Quantity 1)
- j) #10x32 tpi x  $\frac{1}{2}$ " flat head screw, flat washer, lock washer, nut (Quantity 1)

VART Fabrication is divided into three (3) major sub-assemblies:

1) **Hemispherical Base**; 2) **Hub/Spindle & Table Platform**; and 3) **Table Lock**

**Mechanism.** Recall, reasonable substitutions of "scrap materials" can be made; but, insure fit and function of the components are not impacted.

### 1) Fabrication of Hemispherical Base Sub-Assembly:

The following steps (or reasonable facsimiles) are used to construct the Hemispherical Base using an off-the-shelf hemispherical shell.

- 1) As supplied there is a small drilled hole located in the bottom of the Hemispherical Shell (Item F). Weld this hole to seal shell then grind inside and outside weldment excess to maintain a hemispherical shape.
- 2) Scribe a 12" diameter circle on the  $\frac{1}{2}$ " Top Plate (item B) and center punch the center. Using a plasma or "oxy/fuel" cutting torch cut the 12" circular disk. Using the center punch mark as its center, scribe a  $3\frac{1}{2}$ " diameter circle for the Hub/Spindle Cup (Item D) then cut and remove the  $3\frac{1}{2}$ " disk (Figure 2). Note: clearance should allow the Hub/Spindle Cup to slide into this space (if necessary grind the cutout to allow sufficient clearance). Grind a welding chamfer on both sides of the Top Plate's  $3\frac{1}{2}$ " diameter cutout.



**Figure 2**  
**Hemisphere's  $\frac{1}{2}$ " Top Plate Top and Hub/Spindle Cup**

- 3) Select an "exterior face" for the  $\frac{1}{2}$ " Top Plate. Grind plate's side to an  $11\frac{7}{8}$ " diameter circle with an inward  $10^\circ$  taper ("interior face"  $\sim 11\frac{9}{16}$ " diameter). Taper is to allow the

Top Plate and the Hemispherical Shell to overlap  $\sim 1/4"$ ; thereby, providing mating surfaces for a fillet weld (Figure 10). DO NOT WELD shell to plate (see: Suggestion following Step 1.7).

- 4) Remove the pressed in five (5) wheel Lug Studs (Item I) from the 5-Lug Hub/Spindle Assembly (Item G) [avoid stud damage by installing Lug Nuts (Item I) flush to top thread then pop loose the lug with a decisive hammer blow]. Retain these five lugs; they will be permanently installed on the Top Plate (step 1.7).
- 5) Center then clamp securely the 5-Lug Hub/Spindle assembly (spindle flange side up) on the Top Plate (Figure 3). Install a  $9/16"$  drill (diameter of removed stud's splines) in a drill press and use the 5-Lug Hub/Spindle assembly as a drill jig. a) drill two (2) holes through the clamped plate/hub; b) install two (2) lug studs through the plate/hub and using lug nuts tighten the studs securely (seating the stud's splines into the Top Plate's drilled holes); c) remove clamp(s) and drill the remaining three (3)  $9/16"$  holes into the plate/hub. Remove the two (2) installed studs and hub. Note: lug nuts typically are designed to fit into a wheel's  $82^\circ$  counter bore holes. Suggestion: on the spindle flange side of the hub counter bore each of the five (5) lug holes with an  $82^\circ$  counter bore (insures plate/hub alignment remains consistent every time these components are disassembled and reinstalled).



**Figure 3**  
**Hub/Spindle Assembly (Flange “Side-Up”) Clamped to Hemisphere’s Top Plate**

- 6) Ballast needs to be added into the hemisphere’s cavity region to lower the VART’s CG. Hence, add an access port to the hemisphere’s cavity. A candidate location for this port is on the hemisphere’s Top Plate. To load a ballast of “heavy pellets” into this cavity a port with a diameter of approximately one inch is adequate. It is suggested this access port be a  $3/4"$  NPT pipe plug located as shown on Figure 4. Since this port is used to add ballast and

not to seal against liquid or gas leaks a 15/16" drill is adequate; drill then tap with a 3/4"x14 tpi NPT tap. Note: if available a vent cap from a 55 gal drum (Figure 4) can be used in place of a 3/4" NPT pipe plug (Item H).



**Figure 4**  
**Hemisphere's 1/2" Top Plate with Lug Studs and 3/4" NTP Access**

- 7) Cut the Hub/Spindle Cup (Item D) to the length of 3 1/4" and its Hub/Spindle Cup Cover (Item E) to a 3 1/2" diameter. On a welding table lay the Top Plate "exterior face" down then center the Hub/Spindle Cup in place and tack weld. Locate the Hub/Spindle Cup Cover on the Hub/Spindle Cup and weld. Install all five (5) lug studs using lug nuts to firmly seat all the studs in the Top Plate then weld studs and spindle cup securely (Figure 10). Turn assembly over and finish weld the Hub/Spindle Cup to the Top Plate. Note: to allow the 5-Lug Hub/Spindle assembly to seat flush maintain the weld within its chamfer, Step 1.2 (if necessary grind the weld flush with the Top Plate's "exterior face," Figure 11).

Suggestion: If a lock assembly is to be constructed and installed delay welding the Top Plate to the Hemisphere Shell. Rational, it is easier to hold the top plate rigid and flat when drilling and tapping the "off-center" lock assemblies mounting holes (Figure 11), then to attempt this drilling procedure on an assembled hemisphere top surface (I did not wait and to complete this otherwise "simple" task I had to conjure-up additional jigs and fixtures!).

*To be Continued Next Issue in Part 2...*

## Go for a Dip in the Tank! By Tom Rohosky

Most of you are probably aware that soaking an object in white vinegar is a great way to easily remove forging scale and rust. The vinegar will dissolve most of the scale or rust and significantly reduce the amount of time and effort needed to clean up your surface. I've been using this method for years on both forging and restoration projects.

It's pretty easy to do with smaller parts, but it becomes more of a challenge for larger items. What you need is a non-metallic container that's big enough to submerge the entire part all at once. Submerging the whole item is important. If you try to soak it in sections, you'll get visible lines because the vinegar also etches the metal a bit. A simple plastic bucket works well for small objects, but you'll need a better solution for larger items.

I made the fixture shown below to help me with this problem. The construction is very simple. It has a plywood base and a few two-by-four sections to make up the walls. The two-by-four walls are simply screwed to the base, so they can be moved to create a "well" of any size and shape needed. I also drilled a hole in one corner of the well for a drain.

Once I have a well sized for my project and screwed to the base, I line it with plastic sheeting. I use the cheapest plastic available. It doesn't need any significant strength, and it doesn't need to last more than a day or so. When I'm done with the soak, I put a bucket under the drain and poke a hole in the plastic to drain out the vinegar. (The vinegar can be reused several times.)

There are other approaches I could have used, but this fixture gives me the flexibility to soak a wide variety of item sizes and shapes while not using any more vinegar than I need and the cost was very reasonable. I only had to buy the plastic sheet, and I purchased a 10' X 25' roll for around \$10.00. This will last me a long time.

I've used this method a number of times--for big parts and small--and it has worked well for me. Give it a try.

*Note: You can purchase 5% acetic distilled white vinegar at Rural King for less than \$2.00 per gallon and can be used multiple times. When vinegar is "used" use it as weed control.*

*Left: Items fit in adjustable small well Center: Well lined with plastic Right: Same container extended for longer item.*



This article is reprinted courtesy of the Pittsburgh Area Artist-Blacksmiths Association newsletter August 2021 - Editor



## ABANA'S Education Committee Announces the National Curriculum

From ABANA: We have some exciting news from the Education Committee; ABANA has fully adopted the National Curriculum (NC), based on the curriculum of the CBA (California Blacksmith Association).

As our core mission is to perpetuate the noble art of blacksmithing, we recognize it's incumbent as a national blacksmithing organization, to share a successful and practical working curriculum with members, affiliates, and the blacksmithing world at large.

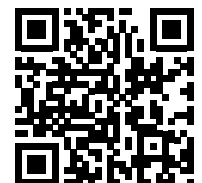
What is the National Curriculum? The NC is a departure point for those that seek a structured program of study that can be used at schools, conferences, meetings, and individual shops through one on one, small groups and self-guided study.

We present the curriculum as one way to learn blacksmithing, but certainly not the only way. From this set of goals, lessons, and benchmarks, smiths at any skill level can pick this up and continue their education. The curriculum provides the framework for the student to progress through increasingly challenging projects that focus on the skills expected of a journeyman smith, culminating with the Level III Grille. - ABANA Education Committee.



*If you are interested in finding out more about the curriculum, information on all three levels is available on ABANA's website:*

*<https://abana.org/abana-curriculum/>*



*Mark Aspery has shared a series of articles from the CBA related to the Level III Grille Project and its associated tooling. I will include this series in upcoming newsletters for those who are interested. This is essentially the same information that ABANA is adopting and additional information and resources can be found on their website. - Editor*

# THE CALIFORNIA BLACKSMITH ASSOCIATION LEVEL III GRILLE (PART 2)



# CBA Level III Curriculum

## The grille project- article #2

Mark Aspery

One of the first things that you should notice from the drawing is that the corners are greater than  $>90^\circ$ . Opening a  $90^\circ$  corner will result in a crack being formed at the inside bend of the corner. The cracking is as a result of a 'stress riser' or concentration of the stresses at the corner caused by the bending action.

What you need from the drawing is a position at which to place the two corners along a length of bar? When forming the corners, you need to leave sufficient material to generate a tapered scroll from the upset corner to the scarf for the weld to the leaf and scroll assembly that you've already made.

You allotted  $1\frac{1}{2}$ -inches, per side, for the weld, but you have since drawn that material out somewhat, lengthening the bar as you worked.

It is the length of the actual bar now, post welding, that is required as you calculate the material required to complete the scroll to the square corner.

Draw a line from the inside to the outside of the upset corners, and then use your dividers to 'step out' the distance from the middle of the upset corner nearest the scroll to the point where the leaf and scroll start to branch. *Note that this is beyond the point where the scarf is placed on the leaf/scroll assembly.* Set your dividers to a  $\frac{1}{2}$ -inch gap to keep the math straightforward. Record this measurement, as you'll need it later on.

Convert your 'steps' to an inch measurement by dividing by 2. Now take your already forged leaf and scroll assembly and measure down from the branch of the leaf and scroll to the step of the scarf.

Subtract that last measurement from the overall length of the scroll taken earlier and you have the length of taper required from the upset corner to the scarf with which you will make the weld to the leaf and scroll.

Knowing the length of the scroll taper alone is not sufficient to go to work. The taper needs to be converted to original flat bar stock material in order to position the two upset corners.

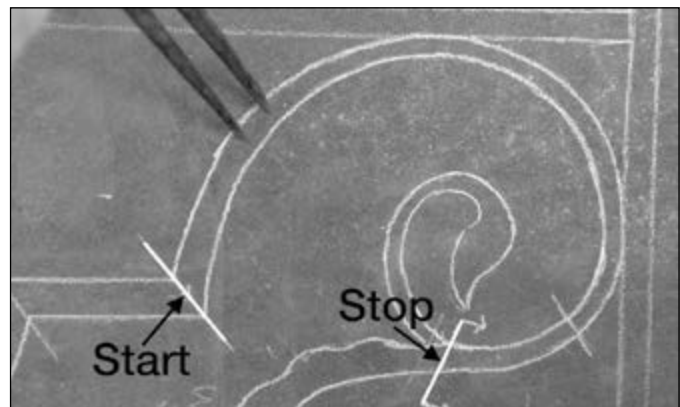
Making the corners now, before the weld to the leaf, is the easiest method of working.

If the scroll tapered in both directions (width and thickness) we would need to find its volume and contrast it to a length of the rectangular bar needed to make the upset corners.

In this case, the width of the stock does not vary from the upset corners to the base of the leaf—it is a consistent  $\frac{3}{4}$ -inch wide, only the sides change dimension.

With the width remaining constant, it means that instead of having to create a volume comparison, we can do an area comparison of the side of the scroll to the side of the bar.

There are any number of ways to find the area of the tapered side of the scroll. Perhaps the easiest method is to average out the height or thickness of the scroll taper and divide that answer by two, and then multiply it by the length of the taper needed. Remember that we only need enough material to reach the scarf of the leaf/scroll assembly and no more.



*Step out the scroll from the corner to the branching leaf*



*Measure the leaf/scroll assembly and subtract that measurement from the scroll length (above). I'd skip any odd  $\frac{1}{16}$ "*



The point at which the two bars will be welded looks to be about  $\frac{5}{16}$ -inch thick on my drawing. I know the drawing calls for  $\frac{1}{2}$ -inch thick bar at the upset corners. According to my measurements and my previous forging of the scroll/leaf assembly, I need a taper about  $9\frac{3}{4}$ -inches long—from mid corner to step of the scarf.

I'm going to add the  $\frac{5}{16}$ " thickness to the  $\frac{1}{2}$ " thickness measurement and divide the answer by 2 to get the average thickness of the tapering bar. By doing so, I can then treat the taper as a rectangular bar. I'm going to multiply the answer by  $9\frac{3}{4}$ " and that will give me the area of the taper—corner to weld point.

To find the area of a rectangle, multiply the length by the height.

I'm going to call all the height (thickness) measurements on the tapering scroll as Height-1 or H1. There are two height measurements on the tapering scroll— $\frac{1}{2}$ " at one end and  $\frac{5}{16}$ " on the other. The length of the bar I shall refer to as Length 1 or L1 for the scroll. My formula is going to look like this:

$$\frac{(H1a + H1b) \times L1}{2} = \text{Area of the tapered scroll}$$

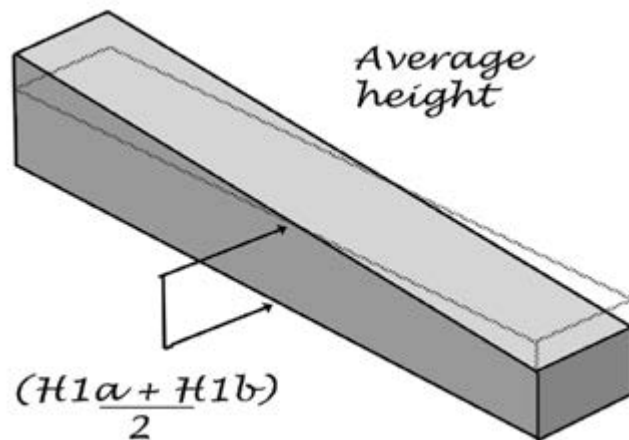
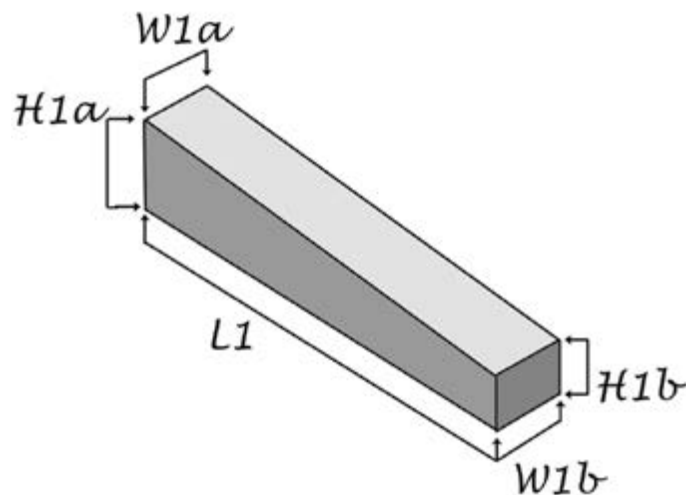
I'm going to call the height measurements on the un-forged rectangular flat bar as Height-2 or H<sub>2</sub>.

The flat, rectangular bar is a constant  $\frac{1}{2}$ " thick. What is unknown at present is the length of the flat bar required to make the taper. I'm going to refer to this unknown as Length 2 or L<sub>2</sub> for the un-forged flat stock.

I know the area of my tapering scroll. What I need to do now is compare that to the un-forged flat bar to determine the unknown length of bar required to make the tapered scroll. I need to find a point where both figures are the same. My formula will look like this:

$$\text{Area of tapered scroll} = \text{area of un-forged flat bar}$$

To isolate the unknown portion (length) of the un-forged flat bar, I have to divide that side of the equation by H<sub>2</sub>. BUT whatever I do to one side of the equation, I have to do to the other side—thus both sides get divided by H<sub>2</sub>.



You will notice that the denominator used in the previous area calculation is now below the fraction or division bar - which, I believe, is fair game in math.

$$\frac{\text{Area of tapered scroll}}{H_2} = \frac{H_2 \times L_2}{H_2}$$

We can put both of those formulas together to simplify the math. The formula would look like this:

$$\frac{(H1a + H1b) \times L1}{2 \times H2} = L2$$

Let's plug in some numbers and get a definitive length of bar required.

$$\frac{(.5" \times .3125") \times 9.75"}{2 \times .5"} = 7.92"$$

I'd call it  $7\frac{7}{8}$ -inch as you have material stored in the scarfs to help out.

## The square corners; what's happening?

I like to work with measurements taken along the center-line of a bar. When a bar bends, the inside dimension is compressed and that the outside dimension is stretched. Generally, the center-line measurement remains a constant. The same is true of upset corner bends.

With an upset, square, corner bend, the outside dimension on EITHER side of the corner will be stretched by half the thickness of the parent bar. The total growth to the outside of the bar being the parent bar thickness.

The inside dimension will also change (decrease) by half the thickness of the bar on EITHER side of the corner. Again the total change will be the thickness of the parent bar.

When forging an upset corner, then the compressed material from the inside of the bend is moved out to the outside corner of the bend and knocked it around a bit until it forms a square corner.

Before you get started with a bar of metal, let's make a 90° bend using some computer generated drawings.

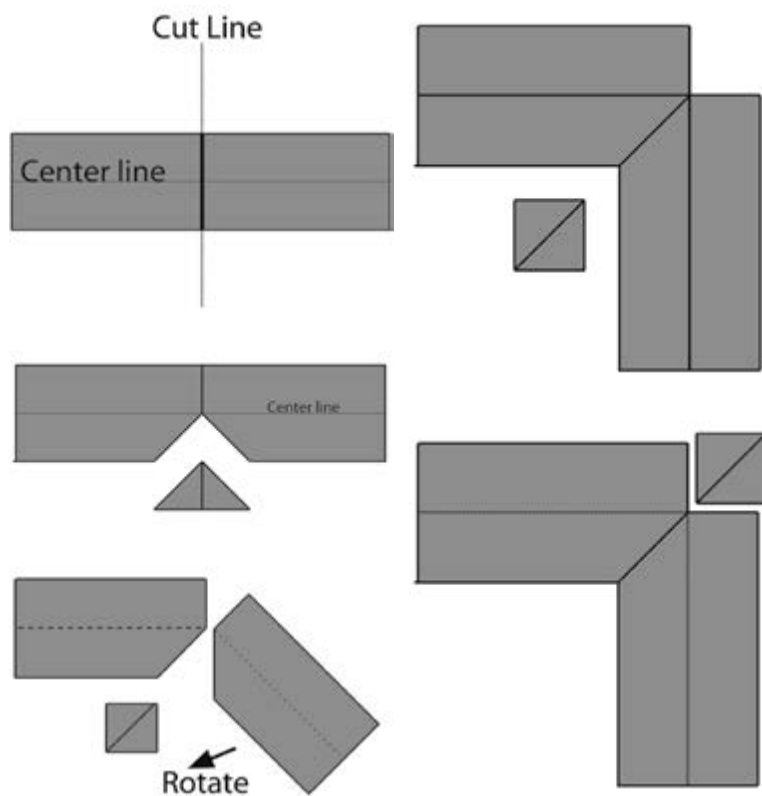
Make cuts in the drawing where a metal bar would bend as it helps demonstrate what will happen to the bar of steel during an upset square corner process.

In order to get a 90° bend, I will have to remove some material from what will be the inside of the bend. This will be the first cut in the drawing, cutting it in half—allowing it to pivot and act like a bar of steel.

The second cut is to remove the two corners that will stop the drawing from being bent at 90° along the center line. This is the excess material that would be compressed if we were to do this while bending a hot bar of steel. *These two cut out corners, when added together, will form a square.*

The drawing is rotated about its center line, the square gap that is formed at the outside of the bend represents the stretched and thinned material if we were to do this hot on a bar of steel.

The material removed earlier is now placed in the gap left after bending. This represents upsetting a hot bar of steel and moving the compressed material from the inside of the corner to the outside of the corner by judicious hammering.



We should now be able to see that the smaller square section of stock formed by the two small triangles is half the thickness of the original drawing. If the drawing was 2 inches thick, then each small triangle will measure 1 inch high, 1 inch at the base and whatever across the hypotenuse.

Looking at the drawings, you will note that the inside edge was shortened, and the outside edge was increased, by half the thickness of the material. This piece of trivia can help us when we are trying to follow the grille drawing. ☺

*This article is reprinted with permission from the California Blacksmith Association - Submitted by Mark Aspery.*

# ABANA Affiliate Newsletter - July 2021

Artist-Blacksmith's Association of North America  
47 Walnut Street, Suite 200  
Johnstown, PA 15901-1521

## \*\*\*CALL FOR AFFILIATES\*\*\*

Any ABANA Affiliate groups that have teaching trailers/facilities available for unrolling the NC (National Curriculum) please respond to Affiliate Chairman, Chris Rowan ([ironcloverforge@gmail.com](mailto:ironcloverforge@gmail.com)) or the Education Committee ([nc@abana.org](mailto:nc@abana.org))

## ABANA is creating a touchmark registry:

ABANA is creating a comprehensive registry of touchmarks. To submit your touchmark, please check the ABANA webpage and follow the instructions. <https://abana.org/touchmark-registry/>

## Iron to Art Festival Tickets are on Sale, Register Early, Save Over 30%:

The dates are set, October 14 through October 16, 2021. ABANA will host the Iron to Art Festival at our new headquarters in Johnstown, Pennsylvania. Tickets are on sale now. [event.abana.org](http://event.abana.org)

## Early Registration Discounts Available!

- Member registration: \$125.00 before August 31st. After 8/30 (late registration) \$165.00
- Member Spouse registration: \$50.00 before August 31st. After 8/30 (late registration) \$75.00
- Non-Member registration: \$185.00 before August 31st. After 8/30 (late registration) \$245.00
- Non-Member Spouse registration: \$70.00 before August 31st. After 8/30 (late registration) \$90.00

**ABANA would like to interest you in being a Craft Vendor at Iron to Art Festival:** This is our inaugural event in Johnstown, PA and ABANA wants you!!!!!! We are expecting 500 + visitors to the conference with 5000 visitors to Johnstown itself over this new 3 DAY EVENT and ABANA wants YOU to get in on the action. Rent a 12x12 vendor booth for the low cost of \$250 (for all 3 days), comes with electricity and if you're performing live demonstrations for your craft you will receive an ADDITIONAL ½ space for free to showcase your skills. There will be visitors and exhibitors from far and wide, what a perfect venue to showcase your crafts and passions. See [ABANA.org](http://ABANA.org), Iron to Art, then click on the vendor icon and we will SEE YOU THERE!!

## Discount Providers:

There are several vendors that value us as customers and offer discounts to ABANA Members. The ABANA website has a list of those vendors that we can support while saving a few dollars. There is a new offer, a grinder discount, for ABANA members from Beaumont Metals. See the ABANA site for more details. Please visit [www.abana.org](http://www.abana.org) to find discounts under the market-place / vendor page.

## Share Your Stuff!

Remember ABANA is always willing to share affiliate activities, projects and photos. Send any information to [exedir@abana.org](mailto:exedir@abana.org)

# ABANA Affiliate Newsletter (Continued...)

## Call for Entries - ABANA Home Office Sign:

The ABANA Home Office in Johnstown, Pennsylvania is looking for members to design signage for the new Home Office location. The chosen blacksmith will have the honor of creating the sign for ABANA's first Home Office at the historic train station and will be paid to forge and fabricate the sign or sign(s). Included in the entry should be the cost or quote for creating each sign including labor and materials.

This call for entries is for ABANA affiliates and members to propose designs and quotes for two types of signs:

-A flat building-mounted 3' X 5' foot vertical sign (side of building)

-and a hanging sign that will jut out from the building with a forged bracket (see image) 4' X 6'

The signs need to include the ABANA logo (trademarked) and the street address: 47 Walnut Street, in the design. The location where each sign will be installed is pictured. Submit your design entry/ quote.

**Entries must be submitted via web link, postmarked or email by August 31st , 2021**

Submit your interest by completing the web form.

For details or questions, contact:

Janie Grela, ABANA, Executive Director:

PO Box 426, Johnstown, PA 15907 814 254-4817 OR emailed to: [exedir@abana.org](mailto:exedir@abana.org)

## New ABANA Membership:

A Reminder about ABANA Membership Options and Pricing

ABANA membership options and pricing changed as of April 15, 2021.

ABANA now offers two membership options: ABANA Digital or ABANA Print.

CLICK HERE to download the new half page membership form.

Each option offers the same membership benefits. The only difference is in the delivery method of ABANA's premier publications, the Anvil's Ring and the Hammer's Blow:

- **ABANA Digital** membership is available world-wide for \$55/year. (This is your only choice if you live outside of North America.) ABANA will send publications digitally to the member's e-mail address on file; no print copies will be mailed.

- **ABANA Print** membership is a \$65/year option for those whose mailing address is in North America (Canada-USA-Mexico); publications will be delivered to the Canada-USA-Mexico mailing address on file by the USPS.

The office has received a few checks in the mail using old forms which feature pricing and options no longer available. For example, the two-year membership option is no longer available. We regret any confusion this has caused to our valued members!

Moving forward, every effort will be made to contact those who mail in checks using old forms, and we'll inquire as to how you'd like proceed and/or to which membership option your payment should be directed.

# ABANA Affiliate Newsletter (Continued...)

Please be assured that existing memberships will be honored until they expire, at which point ABANA's current membership pricing options will be available.

Thank you for being a valued ABANA member, and please don't hesitate to reach out to us with any questions.

Membership benefits include:

Publications: Four quarterly issues of the Anvil's Ring

Four quarterly issues of the Hammer's Blow Members-only access:

- to recent 5 years of digital publications
- to educational videos and materials
- to ABANA membership directory

Eligibility for education grants and scholarships

Option to join ABANA's 'Find a Blacksmith' module, searchable by the general public

Discounts: Conference registration, vendor booths, ABANA Store Voting rights, such as annual election of Board members to forge the future of blacksmithing

Participation in ABANA Board committees

Your Anvil's Ring and Hammer's Blow publications delivery is either by mail or by e-mail...

Sincerely,

Jerry Boyd  
ABANA Affiliates Committee  
Shop Helper  
325-207-8253

## ADDRESS

ABANA Home Office  
PO Box 462, Johnstown PA 15907

## GET IN TOUCH

Phone: (814) 254-4817  
Email: [exedir@abana.org](mailto:exedir@abana.org)

# SCABA Shop and Swap

## 2021 Conference T-Shirt

T-Shirts must be pre-ordered. Please place your order by September 24<sup>th</sup> if you want your shirt at conference.



Back of T-Shirt



Pocket

There are two shirts to choose from this year.

The first is a 50/50 poly cotton blend. This shirt comes in tall sizes.

Port & Company<sup>®</sup> Tall Core Blend Tee. PC55T

Sizes range from Large Tall to 4X Large Tall.

COLOR INFORMATION										
Aquatic Blue PMS 2389C	Ash PMS COOL GRAY 3C	Athletic Heather PMS COOL GRAY 7C	Athletic Maroon PMS 209C	Carolina Blue PMS 7682C	Charcoal PMS COOL GRAY 11C	Dark Green PMS 560C	Dark Heather Grey PMS 7540C	Desert Sand PMS 2224C	Jet Black PMS NTR BLACK C	Kelly PMS 340C
Light Blue PMS 278C	Lime PMS 367C	Medium Grey PMS 2337C	Navy PMS 2180C	Orange PMS 177C	Purple PMS 7672C	Red PMS 200C	Royal PMS 2111C	Safety Green PMS 379C	Safety Orange PMS 021 C	Sapphire PMS 2185C
		<i>View the form in the online newsletter or Saltfork website to see the color selection</i>								
White	Yellow PMS 127C									

The second shirt is a tri-blend poly/cotton/rayon shirt. This is a much softer shirt.

**BELLA+CANVAS**  
LOS ANGELES

**3413C primeplus**

**Bella + Canvas Unisex Triblend T-Shirt**

*Small to 3X: \$15 Each*

*4X to 6X: \$20 Each*

*5X and 6X are special order and may be a different shirt. Contact Teresa for shirt details:*

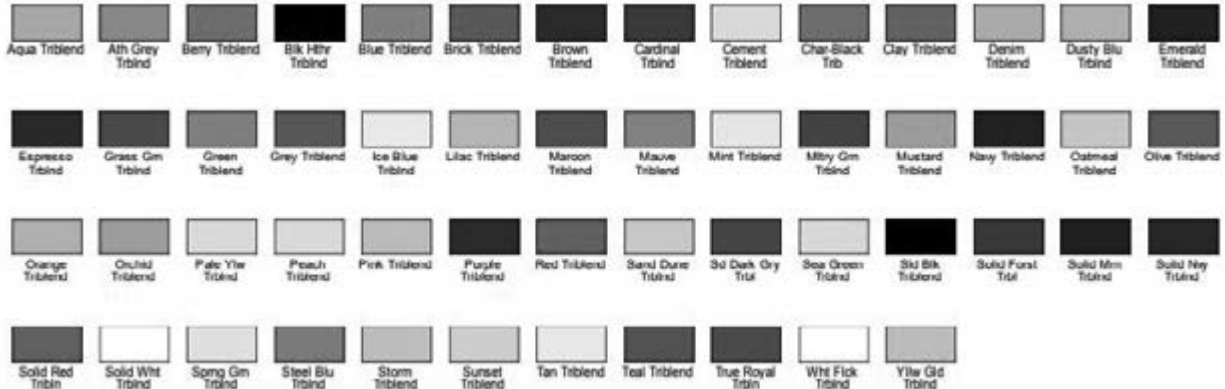
*[tgabrish@gmail.com](mailto:tgabrish@gmail.com)*

*405-824-9681*

**Sizes range from an XS to a 4XL**

*View the form in the online newsletter or Saltfork website to see the color selection*

**53 Available Colors**



**Name:** \_\_\_\_\_ **Phone:** \_\_\_\_\_

T-Shirt Style (Port or Bella)	Size	Color	Price	Number	Total

**Make Checks Payable to Saltfork Cratsmen Artist Blacksmith Association**

**Mail to Teresa Gabrish, 23290 NE Wolf Road, Fletcher OK 73541**

***Shirts will be available to pick up at the Conference. For shirts ordered after the September 24<sup>th</sup> deadline or to have shirts mailed to you, contact Teresa to arrange shipping.***

# SCABA Shop and Swap

## For Sale:

### 50 Lb Little Giant Power Hammer - Asking \$4,800

In good shape. Owned by me since 1961 or 1962. Has been on loan for several years with limited use and kept well oiled. Currently has a 3 phase motor installed. Located in Wagoner, OK. **Contact William Burling at 918-485-1508.**



## For Sale:

### Water Jet Services - Saltfork Discount

Taswallson Manufacturing is offering waterjet services at discounted rates for Saltfork members. I am currently operating nights and weekends.

Contact: **Ragnar at [rtaswallson@yahoo.com](mailto:rtaswallson@yahoo.com) or 918-855-8250.**



# SCABA Shop and Swap



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

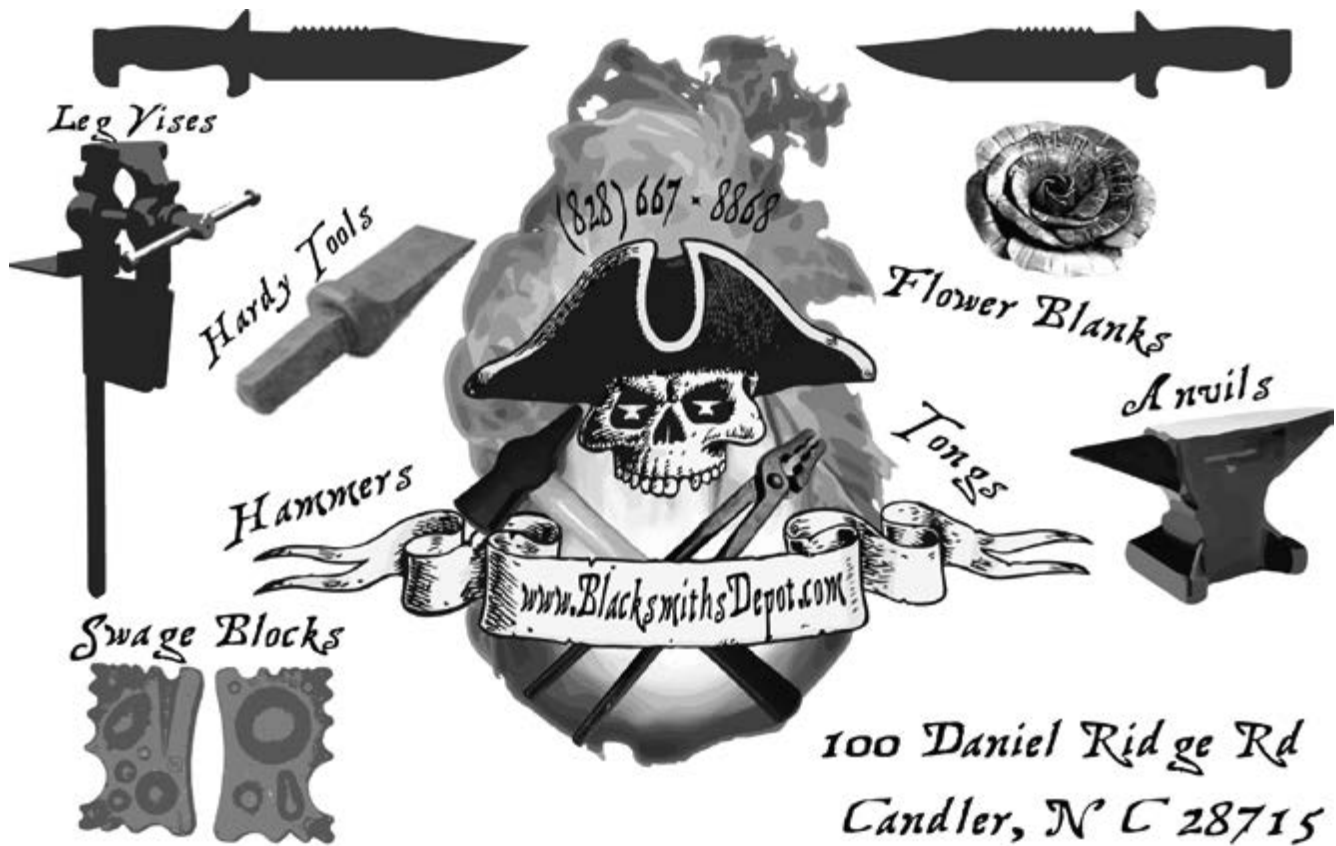


[WWW.KENSIRON.COM](http://WWW.KENSIRON.COM)

Ken's Custom Iron

37634 County Road 9, Avon, MN 56310 | 320.746.8161 | [mail@kensiron.com](mailto:mail@kensiron.com)

# SCABA Shop and Swap



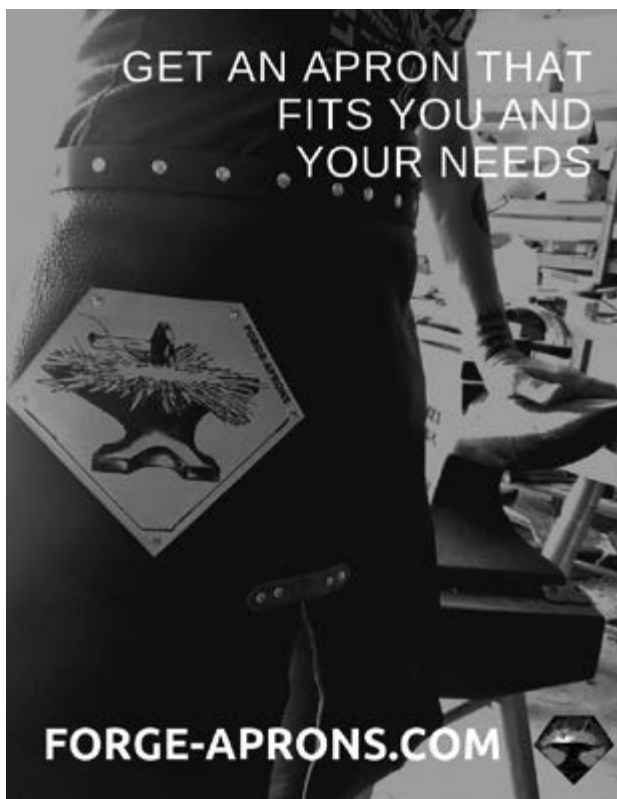
## For Sale: 15 Lb Tire Hammers:

\$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



**FORGE-APRONS.COM**

## KAYNE & Son -- Blacksmiths Depot

Custom Hardware, Inc.

100 Daniel Ridge Rd.  
828-667-8868

Candler, N.C. 28715  
fax 828-665-8303

Steve Kayne

- Tools for the Metalworker
- Hammers & Tongs
- Spring Swages & Texture tools
- Anvils, Vices, Slakes and Hardy tools
- Books & Videos
- Specialty Fasteners
- Blacksmithing
- Custom Hinges and Handles
- Thumb latch sets & Lock sets
- Exterior/Interior Hardware
- Builders/Architectural Hardware

BlacksmithsDepot.com - CustomForgedHardware.com



**Ken's Custom Iron, LLC**

37634 County Road 9  
Avon, MN 56310  
(320) 746-8161  
mail@kensiron.com

## Blacksmith Supply

Modern Tool For the Modern Blacksmith  
www.blacksmithsupply.com

**John Elliott**

jelliott@blacksmithsupply.com  
804-530-0290

P.O. Box  
Chester, VA 23831



**Blacksmithsupply**  
.com

## Raker Knives & Steel

**Ray Kirk ABS-MS**



www.rakerknives.com  
gadugiblade@yahoo.com

**918-207-8076**  
Tahlequah, Ok

**T STAR LEATHER**



Brett Smith  
310 B. Fry Terrace  
Claremore, OK 74017  
410-251-4463  
tstarleather@gmail.com  
www.TStarLeather.com

**Fine Hand Crafted Leather Work**  
Craftsmanship, Detail, Creativity, Excellence



"T Star Smith"  
SASS #72768



# 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?

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 \_\_\_\_\_

Newsletter Preference:

☐ No Print Copy

☐ E-mail Alerts for New Newsletters

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](http://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](http://www.saltforkcraftsmen.org/Calendar.shtm)

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

Non Profit Organization  
U S Postage Paid  
Oklahoma City, Ok  
Permit #2177

Address Service Requested

