

Saltfork Craftsmen Artist-Blacksmith Association

March 2021



Dragon Candle Holder by Rory Kirk

Rory won the weekly contest for the week of February 21st
in the "Weekly Blacksmith Challenges" Facebook Group

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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.

If you would like to run or nominate someone else to be on the Board of Directors, please do so as soon as possible. We will hold elections for these positions at the Annual Picnic in April.

******Please send any nominations for other candidates to either the Secretary, any current Board member or the newsletter editor by March 20th to be on the printed ballot. ******

-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 and they didn't have too many problems with the cold. I went to my shop to do some smithing and it took two days to thaw out my quench tank.

I made a hammer to give to the club to auction off in the online auction that Carol is working on. We could still use other donations if you want to participate. *(Details on page 9 - Editor)*

We are really lucky to have the members we have to help the club keep working. It takes a group effort to keep a club going.

I hope we get back on track having meetings and getting together and that we can stay safe doing so. Some members have started signing up for meetings again. And some meeting venues are starting to open up.

We plan on having our Annual Picnic and Annual Conference this year. We really look forward to seeing everyone. I hope everyone can attend and have a good time. We are going to have a board meeting in March to continue working on plans for this year. It won't be easy to plan everything but we are hopeful that we will not have as many roadblocks this year.

Using a set hammer helps in close work.

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.

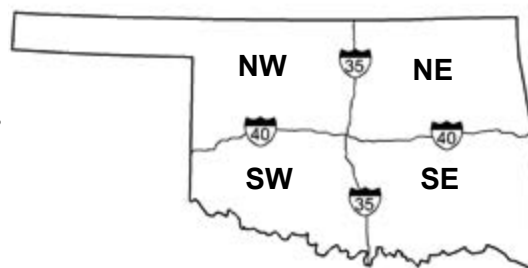
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

REGISTRATION WILL OPEN SOON - SAVE THE DATE!

CBA SPRING CONFERENCE 2021



CANCELED

April 16 - 18, 2021
FRI-SAT-SUN

great educational program of essential skills for all levels

- ★ Hands-on Education!
- ★ Forging Games & Competitions!
- ★ Auctions!
- ★ Midnight Madness Forging!
- ★ Vendor and Tailgate Sales
- ★ On-site Camping & Food!
- ★ Nearby Lodging Discounts!
- ★ Iron-in-the-Hat!
- ★ Art Gallery

Vista Forge at the Antique Gas & Steam Engine Museum
2040 N Santa Fe Ave. Vista, California 92083 (760) 941-1791 www.agsem.com
For questions or to volunteer to help, email: agsemblacksmiths@gmail.com

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 (Bob Kennemer)	Apr 10th (Open)	Apr 17th (Open)	Apr 24th (SCABA Picnic!)
May 1st (Open)	May 8th (Open)	May 15th (Ricky Vardell-Tentative)	May 22nd (Open)
Jun 5th (Open)	Jun 12th (Open)	Jun 19th (Open)	Jun 26th (Open)
Jul 3rd (Open)	Jul 10th (Open)	Jul 17th (Open)	Jul 24th (Open)
Aug 7th (Open)	Aug 14th (Open)	Aug 21st (Open)	Aug 28th (Open)
Sep 4th (Open)	Sep 11th (Open)	Sep 18th (Open)	Sep 25th (Ron LehenBauer as Host - Don Garner as Contact Person)
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)

Around the State...

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

March 2021

NE Regional Meeting March 6th: Open.

SE Regional Meeting March 13th: Open.

SW Regional Meeting March 20th: Open.

NW Regional Meeting March 27th: Will be held by Mandell Greteman at his shop in Foss, OK.

The trade item is a 3/8" and a 1/2" round drift.

Lunch will be provided but please bring a side dish or dessert to help out. Contact Mandell at 580-515-1292 if you have questions.

April 2021

NE Regional Meeting April 3rd: Will be hosted by Bob Kennemer at the Route 66 Museum Blacksmith Shop in Elk City (Pending release to use the facility by the museum administration.) If the museum shop is still restricted due to Covid concerns, the alternate location will be Mandell Greteman's shop in Foss. Trade item is to be determined. Lunch will be provided but please bring a side dish or desert to help out. Contact Bob Kennemer at 580-799-1878 if you have questions.

SE Regional Meeting April 10th: Open.

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 deserts to go with hot dogs.

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. I would like to propose that we have a silent auction and/or a live auction online to increase our cash flow. The board members have voted affirmative to have one. Therefore, we are asking for donations to auction off. Ordinarily we would have asked for donations for our conference. If you could let me or a board member know what you would be willing to donate, as soon as we have enough donations, we will organize the auction(s). Thank you for caring about our organization.

I received a beautiful blacksmith heart with roses from Terry Jenkins and an awesome welding helmet from EWS for the auction. Gerald Franklin has donated 3 books. Mandell Greteman is donating a hand forged diagonal cross pein hammer. We have heard from a few others. 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!

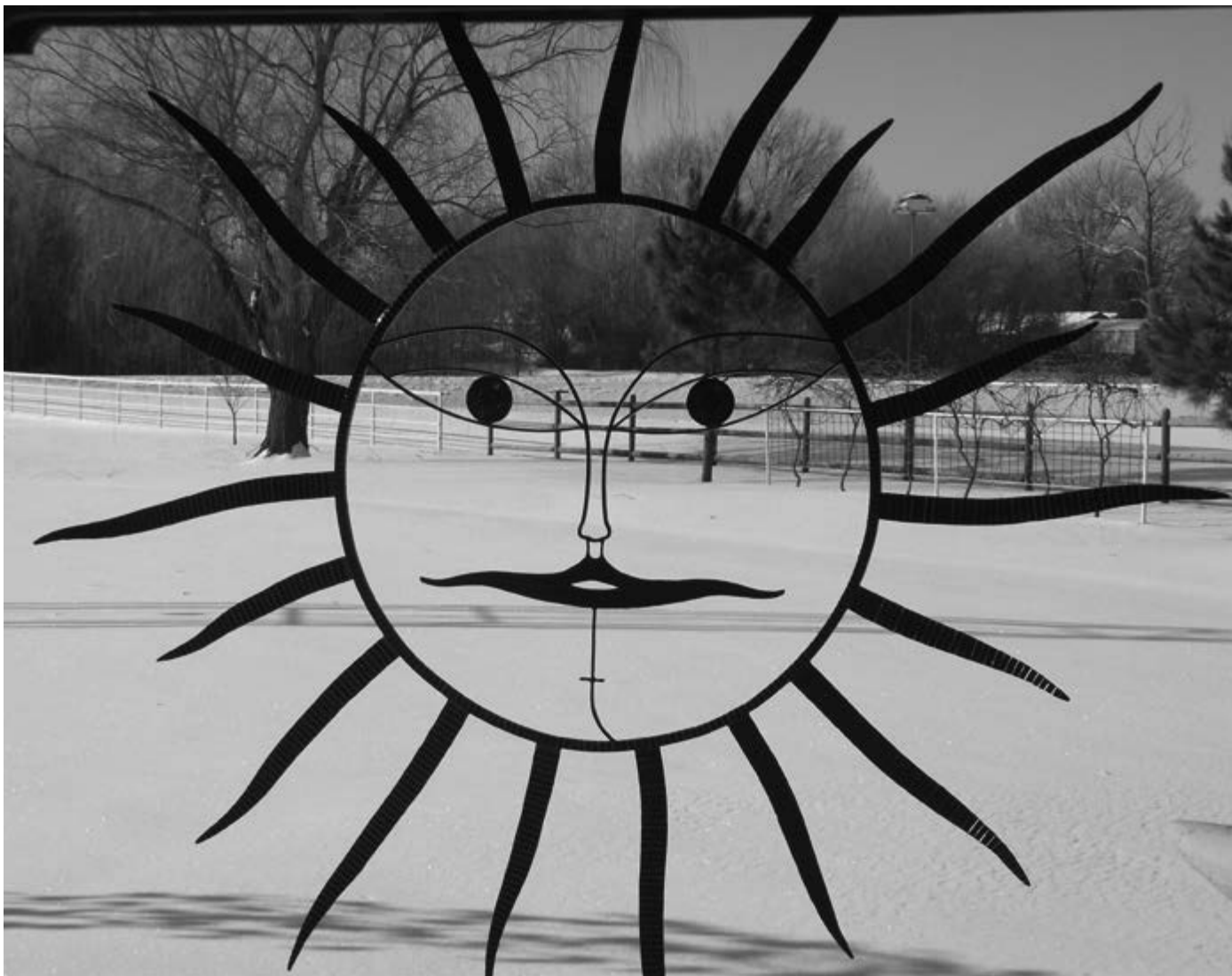
Carol Doner, 405-760-8388, caroldoner7@gmail.com

Carol Doner,
State SCABA Secretary



Member Gallery

“Good Morning Sunshine” By Gerald Brostek



Member Gallery (Continued)

“Flowers and Butterflies” By Gerald Brostek

Forged from mild steel, 40”x20” painted and clear coated.



2021 New Announcements:

(Repeated from February Newsletter in Case You Missed it!)

Recent Board of Directors Meeting: The board was finally able to meet on January 24th to discuss a number of items. This is a summary to bring you up to date:

- **Interim Director Change:** Saltfork Director Ricky Vardell has asked to resign from the board due to a current overload of work and personal time commitments. Ricky's term would not be up until next year so the board appointed Rory Kirk who agreed to serve the remainder of the term when the normal bi-annual election process will be due for Eric, J.J., Rory and Russell. Thank you for your past efforts Ricky and welcome Rory!
- **2021 Director Elections:** Byron Doner, Don Garner, and Mandell Greteman are up for re-election this year. Don is not running for another term so we will only have two incumbents this year. As always, **we are asking for nominations** if you would like to volunteer to be a director or if you know someone who has agreed to do so. Directors must be members in good standing but these positions are open to anyone who might be interested in helping direct the club activities. Please consider filling one of these positions if you are interested. We always need new people and ideas to keep the club vibrant. Brad Nance from Muldrow has expressed an interest in running but no other nominations are on the table at this point.

And if you have read this far, the board has agreed to a special 2021 Covid stimulus which doubles the salary for new directors. That's right DOUBLE! Of course the base salary is zero so, sorry that the math sometimes kills our dreams.
- **SCABA Annual Picnic:** We are moving forward with plans for the annual picnic. The date is set for April 24th at the Murray County Tractor Show grounds north of Sulphur (Same location as the last few conferences.) The contest is being directed by Rory Kirk and will be a free forged penny end scroll (no jigs can be used.) Look for details in the next newsletter.
- **SCABA Annual Conference:** The Conference dates were finalized (October 16th-17th) and we will move forward with planning a conference in 2021. There are many details that are not yet confirmed and we will probably have to remain flexible until closer to the conference date than we would like given the uncertainties that Covid has thrust on us all.
- **Club Coal Price Increase:** We have had to increase the price of club coal from \$0.07/Lb to \$0.15/Lb. The board never likes to increase prices and this one is a bit overdue. But the costs for the club to obtain coal have increased to the point that it was necessary.
- **Swage Block and Cone Price Increase:** Just like coal, the costs to the club for being able to provide swage blocks and cones has dictated a price increase. Swage Blocks will now be \$250.00 each plus shipping and Cones will be \$275.00 each plus shipping.
- **Next Board Meeting:** The next board of directors meeting is scheduled for March 21st. The meetings are open to all members. If you have good ideas, or want to bring up a club related matter, or just want to hang out and stare at the board members then feel free to attend. If you plan on coming to discuss something specific, please let the secretary know prior to the meeting to get on the agenda.

The Solid Snub-End Scroll

by the CBA Staff

Want to push around some steel? Making the square blob for the snub requires that you push/pull the steel with your hammer in any way that works. You'll enjoy the plasticity of the steel! Material may be square or rectangular. The size of the snub is determined by the material overhanging the anvil in the first step. The material shown was $\frac{1}{2}$ " square with a 1" overhang.

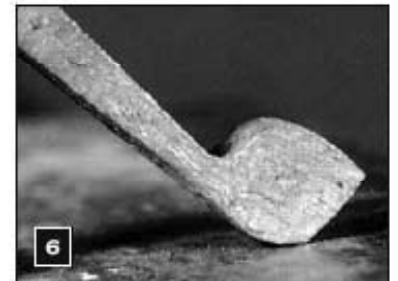
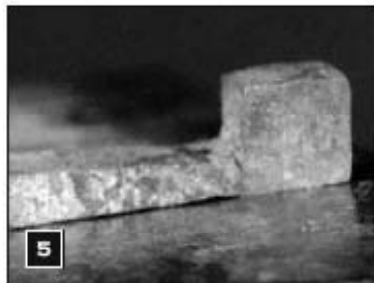
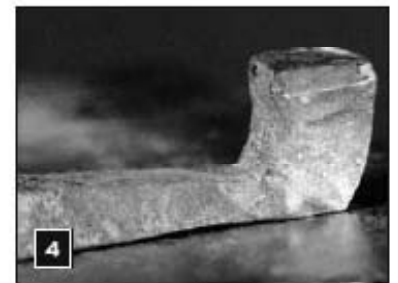
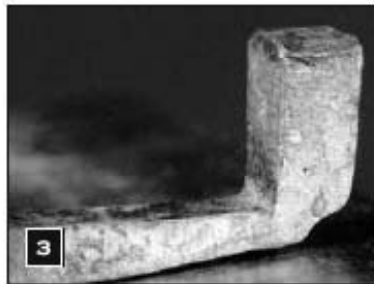
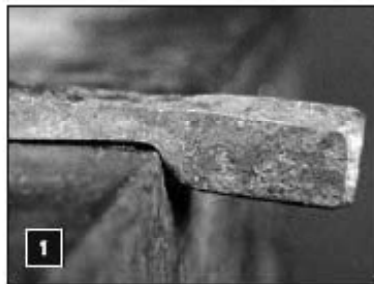
CoSIRA's *Wrought Ironwork* states, "The amount of material projecting over the edge should be equal to the thickness of the bar."

Step 1. With your predetermined overhang, hammer half over the anvil to start the scroll. Forge the spread back to the material width. The thin section should be about half to a third the bar thickness. **If thin section cools to a dark red, stop working.** A crack will develop and you will have to start over. See "Two Things to Avoid" on the next page.

Step 2. Turn over the work and bend the snub down, but less than 90°.

Steps 3 & 4. Turn the snub up and hammer down at more than 90° to start a square (*as viewed from the side*). (Feel the plasticity of the steel?)

Step 5. Hammer, wipe, do whatever you need to do to square the snub. **Check the square. Use a square. Measure the sides.** Getting it square makes it easier to round it later.

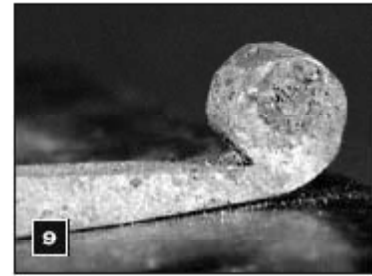
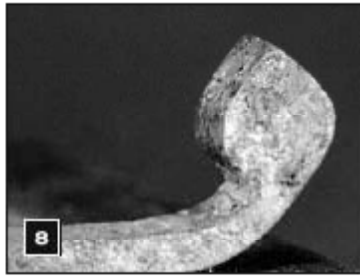


California Blacksmith

Steps 6 & 7. Forge in the two corners to get a leaf-like blob.

Steps 8 & 9. Turn the snub up a bit. Round the last corner. Start your scroll with your hammer as shown in the final result (see first picture). Bring the snub around into a nice curve. Mark Aspery sees an American Eagle's beak as the scroll opens. (Look at the negative space, not the steel.)

If you are only making one or two scrolls you may want to finish the scroll with your hammer. For several scrolls you will certainly want to make a scroll iron. When using a scroll iron, CoSIRA states, "On no account must the snub be allowed to do any of the holding or it will be distorted; this is very difficult to rectify." ♣



Two things to avoid



Remember the thin metal next to the snub must be hot enough (red) so that it will not crack while you are working. If it cracks, start over.

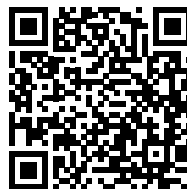


If you get carried away with the hammer on the last corner, the end of the eagle's beak will be gone. Start over.

This Mark Aspery demo 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!!

Articulating Compass

By Steve Alford of Athens Forge

Bob Taylor had a compass like this on a visit to Athens Forge where he showed off some raised copper vessels. He used the compass to draw guidelines around the vessels and then followed the lines with the hammer while rotating the vessel on a stake.

I went home and made my own version. Then I posted it on Facebook and got several requests for more information. Here it is.

The pictures show all the parts assembled and the drawing gives dimensions for each part. I don't think any of the dimensions are all that critical; I got them by just eye-balling Bob's compass to start with! I used 1/8 x 1/2 inch hot rolled flat bar because I had some on hand. I cut the pieces to length, then stacked them up and drilled tap-size holes all at once. Then I tapped the holes that needed tapping and drilled out the clearance holes. I chose the clearance hole size for a close fit.

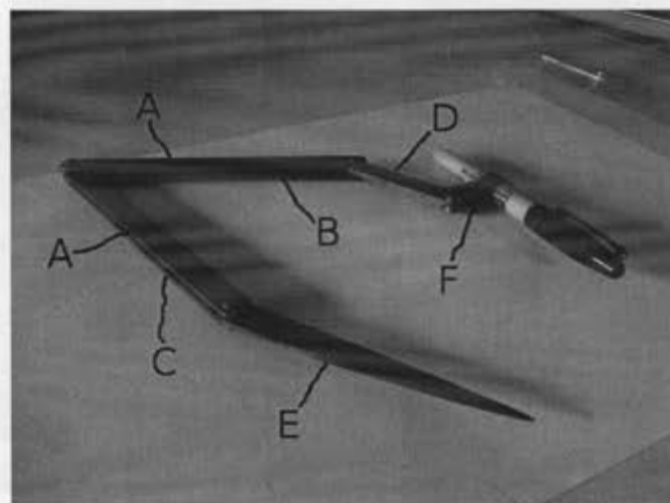
The screws are 8-32x1/2 socket button heads, again because I had some. 10-32 might be even better. I like that these screw heads use hex drivers to tighten. They clamp down securely so the compass setting doesn't change. I imagine Phillips or slotted screw heads would get buggered up quickly.

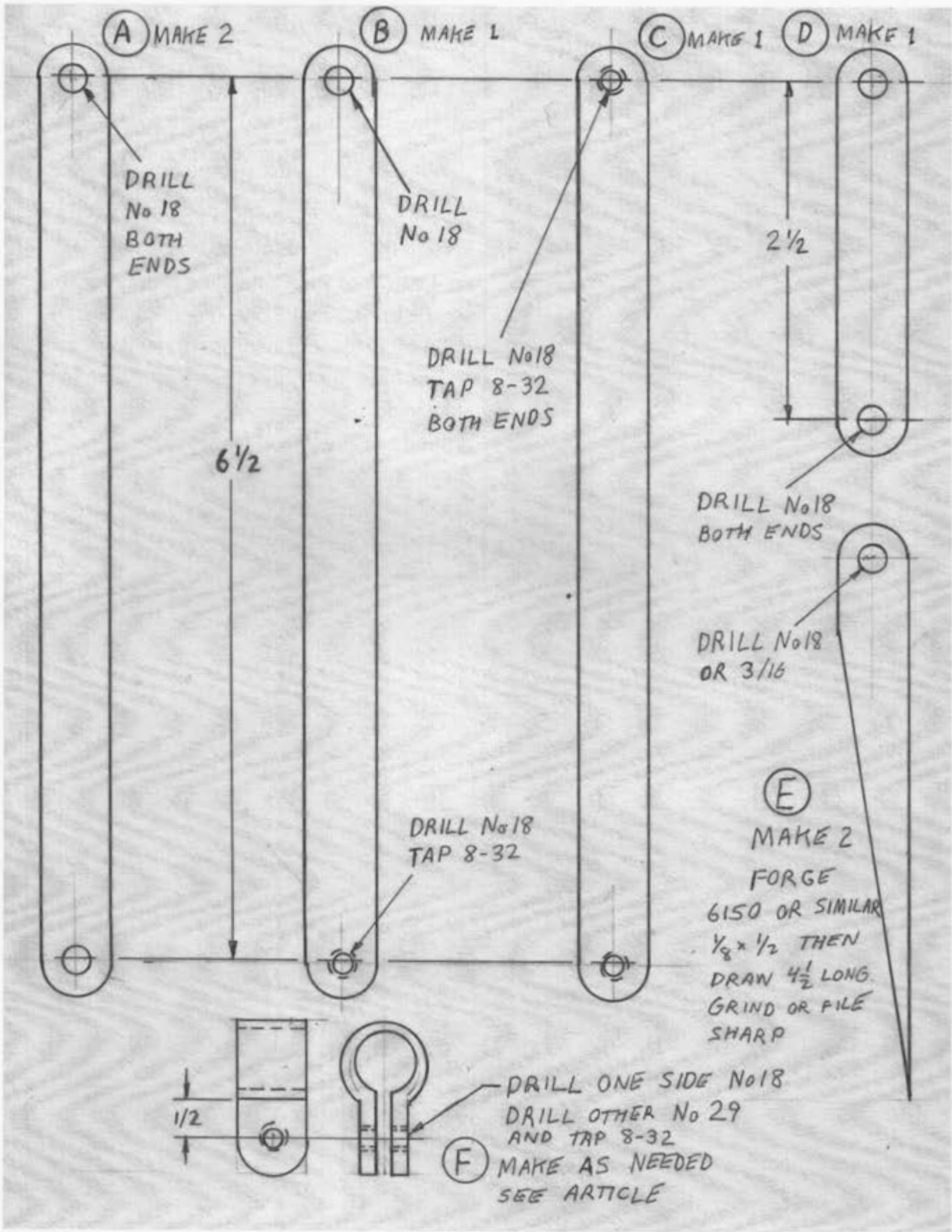
Text continues on page 20



Above: Bob Taylor using his compass to lay out guidelines on a raised copper vessel.

Below: My compass with extra divider point and pencil holder, and a view showing how the pieces go together.





I made the pencil and Sharpie holders by heating and wrapping the end of a bar of 1/8 x 1/2 flat around a round bar, getting the eye all nice and symmetric, then cutting the piece off the parent bar and drilling and tapping as shown. For the Sharpie I wrapped around 3/8 round, then drilled out to 7/16. For the pencil I wrapped around 1/4 round, then drilled out to 9/32.

I forged the points from a piece of 6150 that started out about 5/16 x 9/16, so I had to point it and also forged down close to 1/8 x 1/2. I took it

to final dimensions and sharpness on the grinder. Any other hardenable steel would work fine for the points. I find that 6150 air hardens in such thin cross sections and didn't bother to temper it.

I cleaned up all the mill scale and rounded the ends at the grinder. You could also file the ends and draw file to a shiny finish. Or you might decide not to make it shiny. I polished with maroon Scotch-Brite and then finished with Birchwood-Casey PermaBlue.

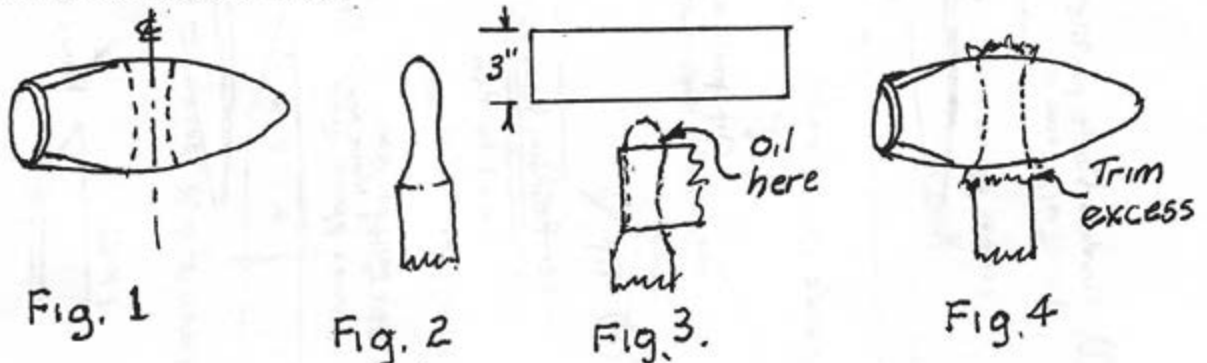
This article is reprinted with permission courtesy of the Alabama Forge Council "Bituminous Bits" newsletter March-April 2021. - Editor

SHOP HINT FROM AUSTRALIA by Reed Oswalt--Kodiak, Alaska

While on a recent trip to Australia, I met Paul Mitchell of Pinehurst Forge, RSD 134 Parattah, Tasmania, Australia 7120.

He told me that an old Australian smith showed him a method of mounting hammer heads that eliminates shock, reduces fatigue, saves handles and never fly off. Here's how.

First, the eye is centered with taper from outside to middle, Figure 1. Then shape the mounting portion of the handle similar to the eye but of course slightly smaller, Figure 2. Rasp, file and sanding does this nicely.



Then using about a 3-inch wide strip of inner tube, wrap this tightly around the handle mounting with two loops. [Note: Extra hands may be needed here], Figure 3.

Now, when pulled tightly, put a little oil in the eye and on the handle point. Next, place the hammer head on the anvil-over the handle hole-insert the handle and hit it hard until fully home. Then trim the rubber excess, Figure 4. If done properly, no wedge is required and you have a perfect handle.

The significant benefits of this type handle mount can readily be demonstrated by comparing it with a similar hammer conventionally mounted. The difference is clearly apparent when working on the anvil. Try it! You'll like it!

APPALACHIAN AREA CHAPTER NEWSLETTER
MAY, 1996

This article is reprinted with permission courtesy of the Prairie Blacksmith Association Newsletter Jan-Feb 2021. Originally from the Appalachian Area Chapter Newsletter May 1996. (This is one I have never seen before. Might be worth an experiment.)- Editor

March-April 2021

Bituminous Bits

Copper Raising Bench

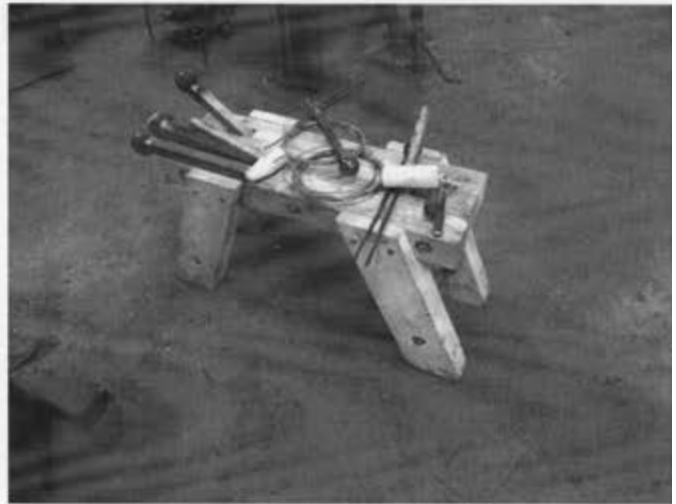
I saw this bench at Travis' shop and figured it must be for doing something with stakes. While I was looking it over, "Copper Bob" Taylor came by and filled in some more info.

He built the bench from construction lumber and threaded rod. The top is made from 4x4s, with slots cut in before assembly so that the finish bench has square holes to hold the shanks of Japanese style stakes. The idea is to sit on the bench and hammer toward yourself while rotating the copper sheet on the stake. There's also a round hole in the other end of the bench, also for holding stakes. Bob said the Japanese would drive wood wedges in around the stake to keep it from shifting while they worked.

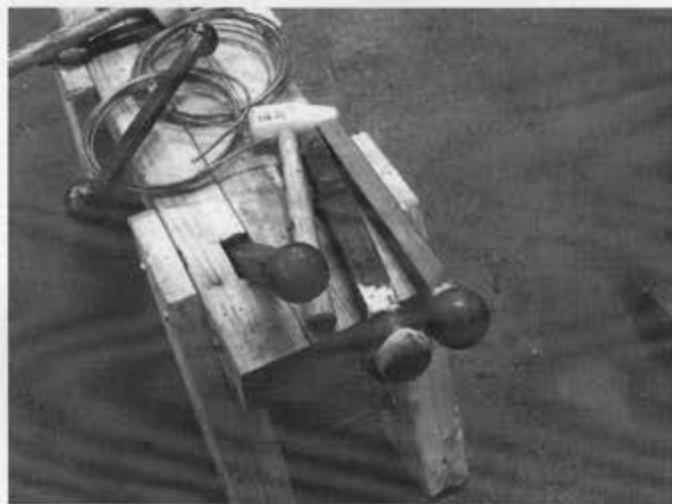
The Japanese style stakes have square shanks and a single end, different from the T-shaped Western style with tapered shanks to fit stake pockets, or the double-ended stakes that some of us make to hold in a vise. The Western technique is to hold the stake in a vise or use a stakeholder with tapered sockets, and then to stand facing the stake while hammering away from oneself.



Bob using a T-stake held in a vise



The raising bench at Travis' shop



Square shank stakes



A couple of T-shaped stakes

February 2021

Pittsburgh Area Artist – Blacksmiths Association

How to Become Enlightened! By John Steel and Chris Holt

When you are approached to make a special item for an organization or individual, there are a number of questions that need to be answered. It is always a compliment to be asked to make a one-of-a-kind item, but is it something that can be made, do you need outside help, or is it something you have all the skills for but, just executed in a different order?

The Unitarian Universalist Church of North Hills (UUCNH) approached Steel Welding with a request to make a chalice for their church services. There were several "must haves". There needed to be two rings that interlock, and a chalice or vessel to hold a lighted candle to signify their time of worship. We met with the donor and fortunately she was very decisive and was able to express her wishes clearly. It is important for you to gather some background information, if possible. We researched this religion to have a better understanding of what was important to the congregation. We found that this religion is open to individuality and nature is a guiding factor in their principals. With this information a general sketch almost to size was drawn prior to a face to face discussion with the Donor and Reverend. This gave the project a base point to make decisions as the design evolved. When we were first contacted, we did make a site visit to get an idea of exactly where this creation would be placed. It is important to actually "see" the site of the project. Sometimes the site can be misleading in photographs. We had questions prepared prior to the meeting regarding, size, material, details that could be included and price points for the three variations we proposed. With these questions answered the process of design fell into place.

We started with the vessel, it was the focal point and the most challenging part of the sculpture. At first, we thought we would sink the vessel by hammering metal into a carved wooden depression. By brainstorming and thinking of an alternative plan and also a more productive outcome, we cut a piece 6" pipe to a shape that would form to the boat-like vessel. We first made a paper template to size, folded it into place to make sure the dimensions were correct and transferred it to the pipe. It looked weird and rough but, as accomplished blacksmith, Chris Winterstein said at a demo. "You got to work through the ugly parts!" We are reminded of this statement many times when doubt and frustration avails itself. The pipe was placed in a vise, heated with a torch and slowly manipulated with a wooden hammer to a rough shape, the seam was gas welded and finish forging took place. The rest of the project was pretty straight forward, adding weld beads to simulate bark of a tree, a biomorphic shaped aged base to represent the soil and details added to the forest floor: snail, frog and oak leaf with acorns. The finish of choice was done with heat and a brass brush. Sometimes the most unlikely materials and solutions can be transformed to a beautiful object with perseverance and a new "enlightenment"!



Overall design was approximately 22" tall and wide. Vessel was 2 1/4" deep.



Left: Working sketch of project.

Right: 6" pipe, pipe cut from template, shaping pipe, pipe upside down with sides coming together.



Riveting Work with Mica by Bill Robertson

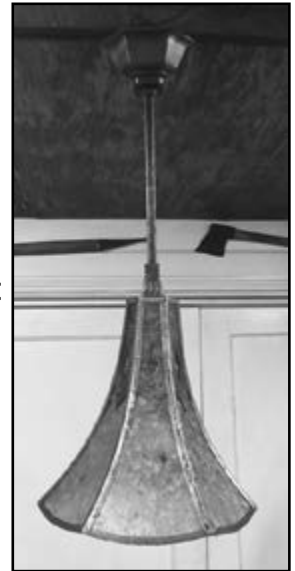
Editor's Note: You can see this lighting fixture on the PAABA web site. Bill was commissioned to make this lovely classic chandelier for a client.

This lamp was constructed using mica, 16 gauge sheet steel, and blind rivets.

Mica is a silicate mineral (rock) that has many uses, one of which is a replacement for glass. It comes in many colors, amber being the one most common for giving off the soft yellow glow you see in most church lighting. The mineral easily flakes into extremely thin elastic flakes that are pressed into sheets in various thicknesses for use in lighting. The Ashville Mica Company in Ashville NC (www.ashvillemica.com) is a good resource. I would recommend ordering their sample packet that comes with all the colors and thicknesses they sell before making your first order.

Working with mica. The thinner sheets cut easily with kitchen scissors or a razor blade. When drilling, I would recommend you have it backed on wood to avoid splintering. Because it is pressed together in a resin it becomes flexible when warmed on low heat in the oven, about 200°. It is quite heat resistant and is used as an insulator in heat shields, so there is no worry designing a project with a light bulb that comes into close contact with it.

Forging angle iron. The lamp ribs were made by cutting ½ inch wide strips from a sheet of 16 gauge mild steel using a power, hand metal shear. Prices for these shears run \$50 and up. Small bench table shears start at \$1,000. To form the angle, I made a jig by welding two pieces of angle iron to a plate for a bottom fuller and a modified ball peen hammer forged into a chisel peen. (See photo below) The hammer has become one of my favorite tools for chasing deep lines. Under the treadle hammer, the duo easily bends the 20 gauge to 45 degrees but, does not develop a sharp crease. You risk cutting through it with multiple passes trying to create a sharp crease with this tooling alone. To develop the crease you will need to planish it from both sides against a sharp edge with glancing blows. To ensure each lamp rib was uniform, I made a jig by welding a length of square stock on the diamond to a piece of angle iron to the length and curvature of the rib. I marked one end with whiteout on each rib so I would not to confuse which end was up when assembling it. Both ends were similar.



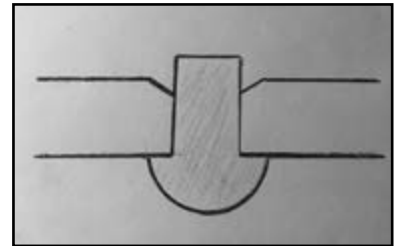
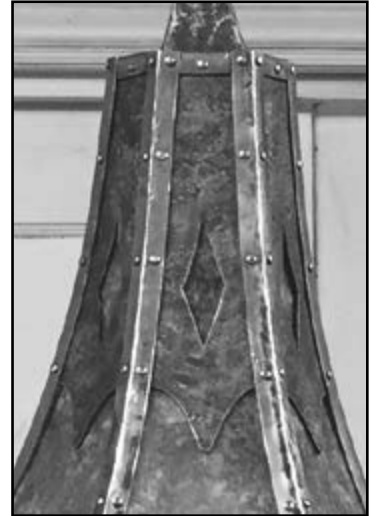
Left: Jig for making angle iron under treadle hammer with customized chisel peen for this step. Middle: Developing sharp crease carefully against sharp edge using glancing blows. Right: Curved square stock to shape ribs.



Blind rivets are used to hide a rivet, or when there is inadequate hammer access to peen the rivet over. A blind rivet is created by filing a radius on the rivet hole or by slightly countersinking a radius with a larger size bit. The rivet is cut so that it only slightly protrudes with just enough mass so that when hammered from the opposite side (or laying on a flat surface hammered from the opposite end of the rivet) the metal swells into the radius created. It becomes blind (hidden) when the surface is filed or sanded flush. Although there is only a tiny bit of metal swelling into the radius, it locks the rivet in quite strongly.

Blind rivets (92) were used in this project because it was impossible to get a hammer in to peen the rivets in the neck of the shade. The neck of the shade was slipped over an "L" shaped hardy and peened from the dome side. The rivets that were assembled by hammer were peened using a small cross peen hammer with all the rivets extending only 1/16 of an inch. If they are too long, you will risk bending the rivet in the mica layer. The rivets were made from Home Depot Linoleum nails (zinc #16 x 11/16), pushed through and nipped. All of the rivets in the lamp were backed by tiny washers that were made from drilling a series of holes (the diameter of the nails) in strips of 22-gauge sheet steel then cutting them out with tin snips

Texturing and Finish. The ribs were forged cold and heated just hot enough to melt a 50/50 (by melted weight then cooled to a cake paste) beeswax/ linseed oil mix. Keeping the heat under 600 degrees keeps the metal silver, a finish I wanted to contrast with the metal partial panels between the ribs. The metal panels were cut out on a band-saw, the curves refined on a bench grinder stone. The diamond shapes were cut out with a jeweler's saw. To **texture**, the panels were heated to a bright orange over a torch (this can also be done in the forge) watching for the black scale bubbles to form, (they mostly form on the top surface). Once the bubbles form, you hammer them in hard enough that the scale imprints but not so hard you displace the metal. This is repeated several times wire brushing in between. The panels were then soaked in a 50-50 muriatic acid / water solution for 20 minutes, (soaking overnight in vinegar works just as well). When taken out, I like to rinse in water then rub some baking soda on them to neutralize it. The texture when sanded (220 grit), turns a once shiny new metal into what looks like a 300 year old antique. For a darker finish and to bring out the texture, reheat to at least 600 degrees to turn the metal a darker grey. Lightly sand to bring out the highlights and melt the wax mix on. An option is to reheat, turn gray, cool, spray black high heat paint on and quickly wipe off, let dry overnight, lightly sand, reheat to melt the wax on. The paint although wiped off tones down the shine and leaves the depressions darker which helps bring out the hammer marks or the texture used. Sometimes the hot wax will darken the work too much and you will need to lightly sand some more after its applied and still hot, then apply more wax before it cools to much.



Specialize a Hammer!

1. A good use of "upcycling" a hammer you already own.
2. Good for incising, texturing and more!

After forging, I re-heat hammers above magnetic (orange) and temper in oil. Never work them hot below that temperature (red) or you will create stress fractures. It's important to note that this procedure is not recommended for newer hammers made in China. The metallurgy is inconsistent and they can shatter. I always look for hammers with older handles that are skinny in the neck.

Tip From: John Steel



If the "5 Second Rule" regarding eating pistachios in the shop applies to you, make sure there are no wire wheel remnants remaining on the pistachio after hitting the floor. They can stick into your inner lip and hurt...quite a bit!

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
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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:

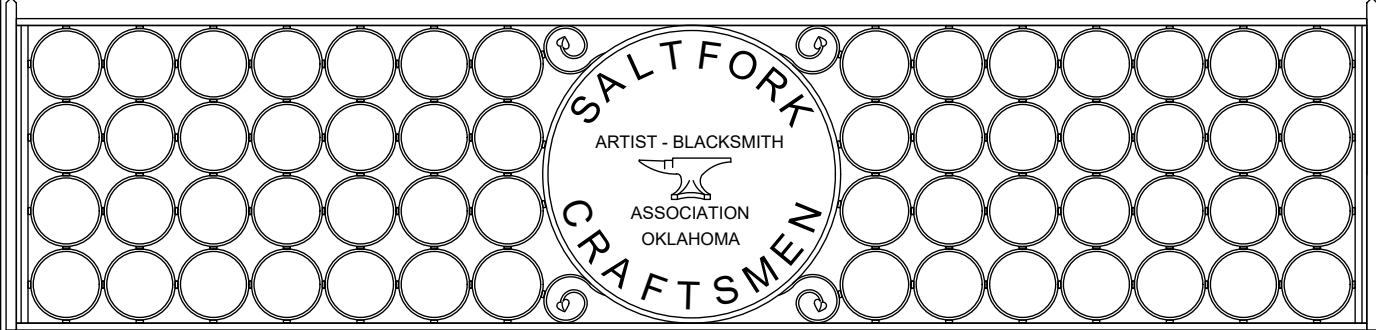
T-Shirt Price:	
Small to 3X:	\$15 Each
4X to 6X:	\$20 Each

Total:

Mail this form with payment to:

*Teresa Gabrish
322 Washington
Blanchard, OK 73010*

The Saltfork Gate Project Still Needs More Rings!



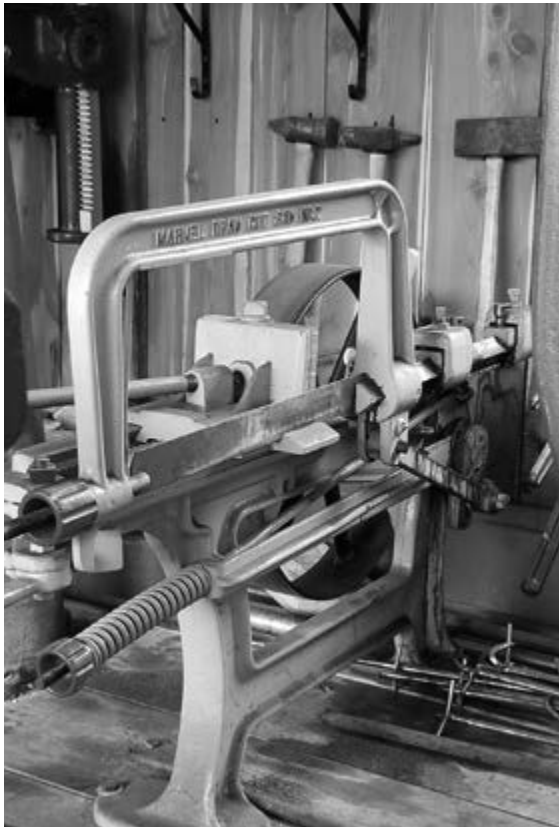
This is a community project that is open to all Saltfork members regardless of skill level or experience. There is still room for more rings. You can see more details about the project in any of the past newsletters from August 2019 through January 2021.

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.

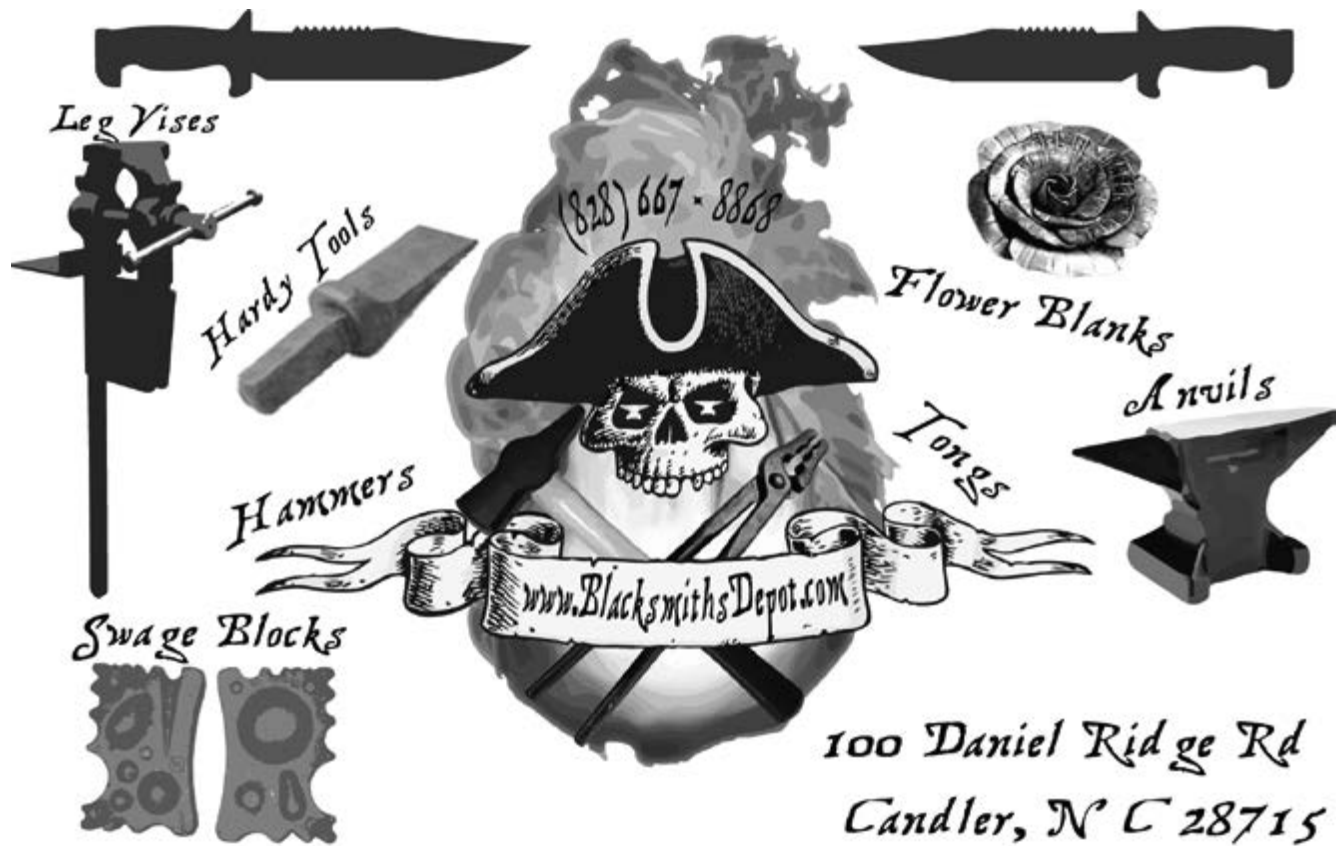


WWW.KENSIRON.COM

Ken's Custom Iron

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SCABA Shop and Swap



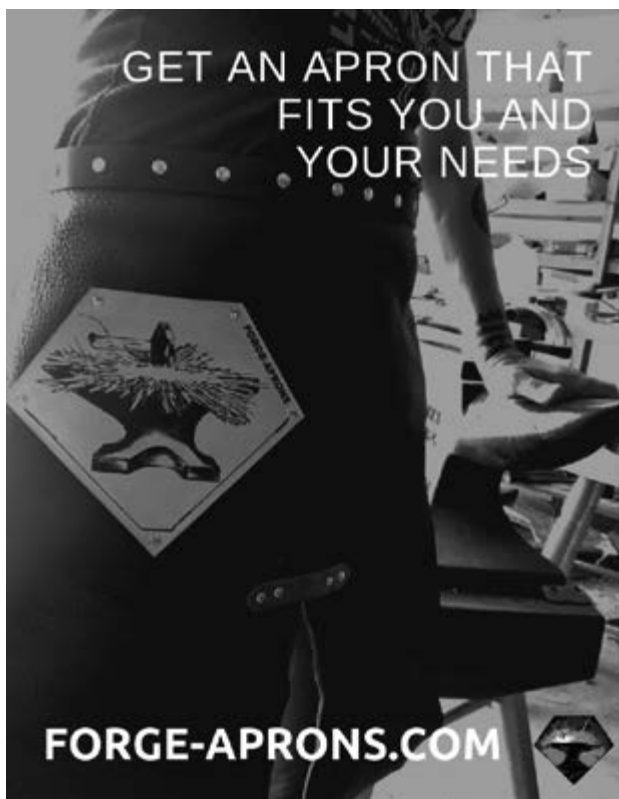
For Sale: 15 Lb Tire Hammers:

\$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



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

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



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.



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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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