

# Saltfork Craftsmen Artist-Blacksmith Association

May 2021



## **Catching the Bug (not *that* bug, the Blacksmith Bug!)**

**Everrett Timmons forging a camp tripod at the Route 66 Blacksmith Museum in Elk City. His assistant was a visitor from Maine passing through the museum who's whole family was fascinated and ended up staying for the meeting. The family now plans to join their local blacksmith club when they get home.**

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## Editor's Notes:

Once this newsletter has been distributed, the 2021 SCABA picnic will be over and the 2021 director elections will be done.

Look for a summary review of the Picnic and election results in the June newsletter.

Now finalizing details for the 2021 Saltfork Conference will be front and center. It will be here before you know it!

*-Russell Bartling, Editor*

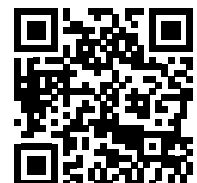
### **\*\* SCABA Board of Directors Meeting \*\***

There is a Board of Directors meeting scheduled for **2:00 PM Sunday, May 16th, 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.

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



# President's Notes:

Hello everyone.

Well I think Mother Nature has finally let go of winter so maybe it will warm up in the shop. And before you know it, it will be very hot.

By the time you read this, we will have had our picnic and I hope everything goes well.

We are focusing our work now on having a good conference this year. If anyone would like to build a toolbox for this year's conference, please let a board member know. The conference will be here before you know it.

The North Texas Blacksmith Association is looking for volunteers to donate their time for the ABANA conference next year. They said that for every day you work, you get a free day to attend.

Back to our Saltfork conference, if you would like to help with it, please let us know. We always need good help. If we are to keep the club strong, we need to get more people, especially younger people, to help put on the conference. Some of us are getting old.

I hope everyone is doing well and staying in good health.

Don't drop you big anvil on your foot when you are moving it.

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.

**\*\*\*\*NEW\*\*\*\***

## **Beginner Blacksmith Workshop - Saturday, July 31st:**

There will be a Beginner Blacksmith Workshop July 31st at the Route 66 Museum Blacksmith Shop in Elk City, OK.

The class size will be limited to 10 people so if you are interested secure your place in the class as soon as possible.

Contact Mandell Greteman at 580-515-1292 to register for the class or if you have any questions.

**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**

# 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)	<b>Feb 27th</b> (Doug Hyde)
Mar 6th (Open)	Mar 13th (Open)	Mar 20th (Open)	<b>Mar 27th</b> (Mandell Greteman)
<b>Apr 3rd</b> (Don Garner)	<b>Apr 10th</b> (Diana Simon)	Apr 17th (Open)	<b>Apr 24th</b> (SCABA Picnic!)
May 1st (Open)	May 8th (Open)	May 15th (Open)	<b>May 22nd</b> (Rory Kirk)
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)	<b>Sep 18th</b> (JJ McGill)	<b>Sep 25th</b> (Ron LehenBauer as Host - Don Garner as Contact Person)
Oct 2nd (Open)	<b>Oct 9th</b> (Conference Setup )	<b>Oct 16th</b> (Conference Weekend)	<b>Oct 23rd</b> (Rory Kirk)
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 (Boy Scout Meeting at Murray County Antique Tractor Show Grounds. See next page.)**

**July 31st (Beginner Blacksmith Workshop - Elk City)**

October 30th (Open)

## May 2021

NE Regional Meeting May 1st: Open.

SE Regional Meeting May 8th: Open.

SW Regional Meeting May 15th: Open.

**NW Regional Meeting May 22nd:** Will be hosted by Rory Kirk at the Route 66 Museum Blacksmith Shop in Elk City.

Trade item is a forged key chain "thing" - character, bird, animal or bug. (The photo is for reference. It doesn't have to be a dog.)

Lunch will be provided but please bring a side dish or dessert to help out. Contact Rory Kirk at 580-497-6426 if you have questions.



## May 2021 (Extra Fifth Saturday Meeting)

**Fifth Saturday May 29th:** Will be hosted by JJ McGill at the Murray County antique tractor show grounds location. This meeting will host Boy Scouts from Tulsa plus Leaders and Parents. Any smiths who would like to help out educating and working with the young Scouts are greatly appreciated.

The trade item and Scout Challenge is a camp cookware set.

Lunch will be provided but please bring a side dish or desert to help out.

Directions: 7 miles north of Sulphur on Hwy 177 then east  $\frac{3}{4}$  mile on Tractor Road. Contact JJ McGill at 580-369-1042 if you have questions.

## June 2021

NE Regional Meeting June 5th: Open.

SE Regional Meeting June 12th: Open.

SW Regional Meeting June 19th: Open.

NW Regional Meeting June 26th: Open.



# 2020 SCABA COVID CONFERENCE

We did not have a cash flow in 2020 like we usually do after a conference due to Covid cancellations. We are planning to have an auction online to increase our cash flow. Therefore, we are asking for donations to auction off. Ordinarily we would have asked for donations for our conference. If you could let me or a board member know what you would be willing to donate, as soon as we have enough donations, we will organize the auction(s). Thank you for caring about our organization.

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

**Carol Doner, 405-760-8388, [caroldoner7@gmail.com](mailto:caroldoner7@gmail.com)**

Carol Doner,  
State SCABA Secretary

## 2021 Donations received so far for the online auction:

Terry Jenkins	Blacksmithed Heart with Roses
EWS	Welding Helmet
Gerald Franklin	3 Blacksmith Books
Mike Taylor	3 Bottle Openers worth \$40 Each
Dale Dixon	8 Foot Ornamental Windmill (In Box) Made In USA
Mandell Greteman	3 Lb Diagonal Pein Hammer
Gerald Franklin	Cannady Otto Hand Crank Blower with Stand
Gerald Franklin	Champion 200 Hand Crank Blower (no stand)
Gerald Franklin	Decorative Punch Set with Holding Tongs
Mandell Greteman	Pair of Mini-Tongs
Anthony Griggs	Three Pairs of Tongs



## 2020 SCABA COVID CONFERENCE (continued...)



Decorative Punch Set by Gerald Franklin - Hot cut is S7. The other punches are 1045 water hardened and tempered at 425 degrees for 2 hours.



Mini-Tongs by Mandell Greteman



Tongs by Anthony Griggs



## Around the State...

**NW Region March Meeting:** Was hosted by Mandell and LaQuitta Greteman at Mandell's shop in Foss, OK. From LaQuitta: "We had a good group today for our meeting. I believe everyone had a nice time. We had seven sets of trade items (the trade item was 3/8" and 1/2" round drifts) but I didn't get a photo of all of them. Thanks everyone for coming and for bringing sides. It was nice to see everyone!"















Saltfork Craftsmen Artist-Blacksmith Association



## Around the State...

**NE Region April Meeting:** The NW Region April 24th meeting was held early on April 3rd in the time slot of the NE region since the date was open and April 24th was scheduled for the SCABA Picnic.

The meeting was hosted by Don Garner at the Route 66 Museum Blacksmith Shop in Elk City. It was a small turnout but a powerful day. A family from Maine visiting the museum stopped by the forge and ended up staying for most of the meeting.

Bob Kennemer gave the young man of the family a handful of iron. Then the young man helped Everett Timmons with a camp tripod project by helping to hold the stock while Everett forged.

The father ended up giving a generous donation to Saltfork so the blacksmiths gave the camp tripod to the family before they left. It seems that the family was bitten pretty hard by the blacksmith bug and plan to look up their local group when they get back home.

Some of the gate project rings were hung on a temporary gate panel display in the shop. A few rings are finished but haven't been delivered to Mandell. There is still a lot of room to fill in the actual gate before these rings can be permanently assembled into the final display gate.







Tiny Tongs: Monte Smith's on the left and Mandell Greteman's on the right















## Around the State...

**SE Region April Meeting:** The NE Region April 3rd meeting was held on April 10th in the time slot of the SE region since the date was previously scheduled for the NW region and it allowed more time to advertise the meeting. The meeting was hosted by Diana Simon at the Cherokee Strip Historical Society Blacksmith Museum and Shop in Perry, OK. From Diana:

On April 10th the Cherokee Strip Museum hosted the NE Region Saltfork Craftsmen Assoc. It was a beautiful day! Tom Nelson, Bryon Doner and Dale Dixon came out and showed around 40 people how it is done. I believe we picked up 3 new members and everyone seemed to really enjoy the day! Sloppy Joe's and chips were served for lunch by yours truly! We had visitors from Douglas, Norman, Mustang, Stillwater, Perry, Cushing, Chandler, Garber, Edmond, Oklahoma City and even a gentleman from Louisiana! All in all it was a great day!

Thank you to all who came out!

Diana Simon  
Cherokee Strip Museum  
2617 W. Fir Ave.  
Perry, OK 73077  
580-336-2405

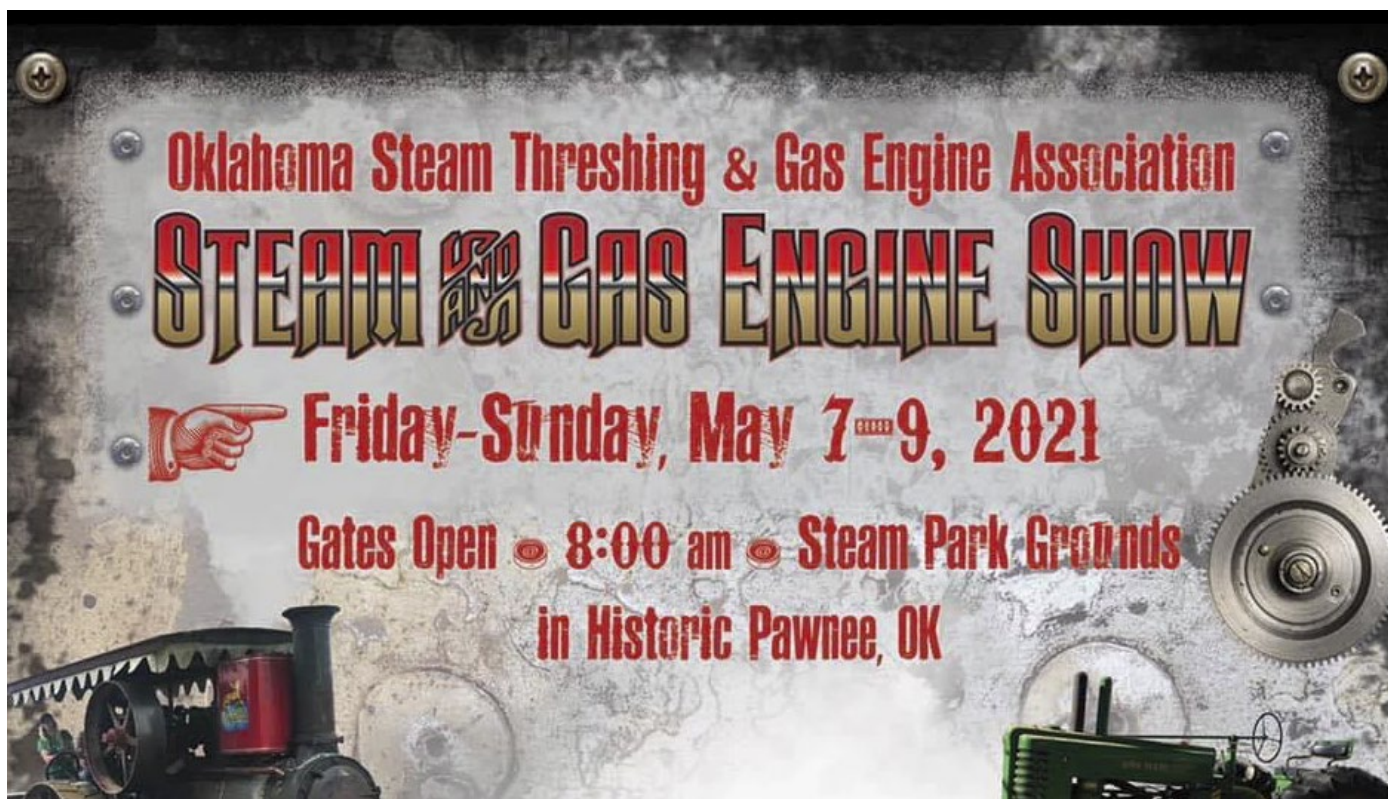




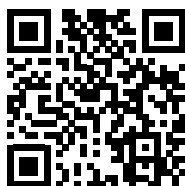
## Around the State...

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





<http://www.oklahomathreshers.org/info>



## 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.**

## Easy V-Bit Bolt Jaw Tongs – Bill Corey

Good tongs are an extension of your hands, allowing you to securely hold pieces that would otherwise be too hot to handle. There are a larger variety of tongs than any other tool, each size being sized to hold primarily one size and shape of material.

Note: The word “Tongs” is a noun and is the proper way to refer to one or many pair of these stock holding tools. The word “Tong” is a verb and refers to the act of using the “Tongs” or to “tong or pick up a piece of material.”

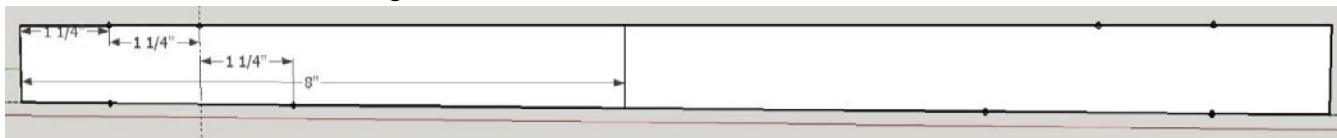
Properly forged tongs need to hold work securely... or they are dangerous!

**V-Bit tongs** are very good for holding square and/or round stock of a certain size and can be adjusted slightly for holding different size of stock.

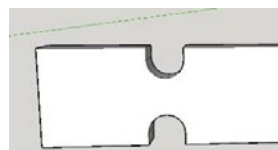
These tongs are made from flat bar with a twisted jaw and can be modified slightly to hold many different sizes and styles of stock. With a slight modification to the jaws they can be used for holding flat bar which will be indicated later on.

- Start with 16" of 3/8" X 1" laying out the jaws with a center punch on both ends.

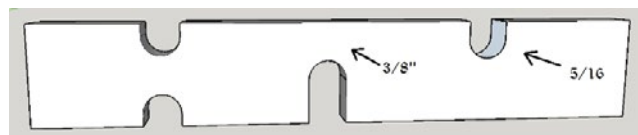
Note: Holding the center punch as close to the edge as possible will cause a small dimple to protrude from the side of the flat bar making it easier to locate the mark when the stock is hot.



- Take a good yellow heat and using a guillotine style tool (or the reins of a set of tongs) fuller in from both sides at the first punch marks down almost 3/8" deep. Do this and the following fullers in multiple steps, using the fuller for 3-4 hammer blows then flatten the sides that spread out.



- Using a piece of 3/8" round bar or fuller, drive it down at the second punch mark leaving about 3/8". Turn it over and at the third punch mark drive it down about 5/16" deep.



- Draw down behind the third fuller mark to start the reins tapering down gradually for about 4" or so down to approximately 3/8" square ending up close to 10" total for each rein. Also round off the corners of the section between the 2<sup>nd</sup> and 3<sup>rd</sup> fullers or the “boss.”

Note: Forge down to the bottom of the fullers carefully as to not leave a cold shut where the bottom of the fuller meets the drawn down section.

Note: At the point of forging in the illustration, the stock can be cut then drawn down and scarfed for forge welding on 3/8" round bar for reins.



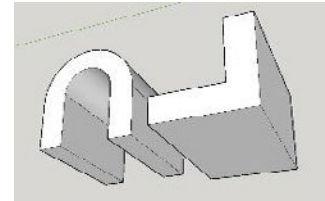
Bill Corey  
Indiana Blacksmith Association



- Now draw out the section between the 1<sup>st</sup> and 2<sup>nd</sup> fullers to approximately 3/8" square, then forge off the corners to octagon, then those corners to hexadecagon, then those corners to a triacontadigon (or basically round.)



- Take a good yellow heat on the shank of the bit (between the bit and boss) and twist the bit 90 degrees. At this time the direction does not matter.
- Now using either the step of the anvil or a V-Swage and a cross peen hammer forge the bits into a V shape unless you are opting for the U-shaped bits to hold flat stock. For those forming the bits will come after setting the rivet.

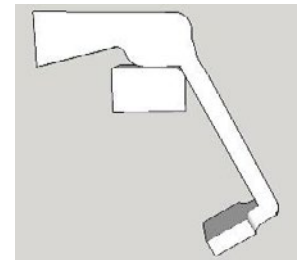


As 3/8" is fairly thick for the bits, they can be drawn out either lengthwise to make a longer bit or in width to make a wider v-bit. They can also be widened out and then forged into a U=Shape around the size of stock wanting to be held for use holding flat bar as was mentioned above.

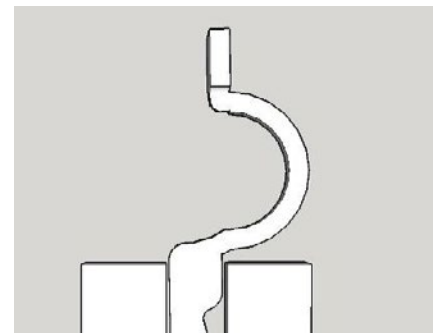
- Next using a rounded edge on the far side of the anvil forge the bit over at a right angle.



- Next using the same rounded edge on the far side of the anvil set the bit just past the edge and using a rounded face hammer forge the shank of the bit down.



- Then holding the boss in the jaws of a vice and holding the bit with a pair of tongs, strike the shank of the bit with a rounded face hammer shaping it into an arch.
- Take a good yellow heat and in the center of the boss punch and drift a 3/8" hole. (Or to what ever size of rivet that will be used.)



- Perform all of the above steps on the opposite end of the original stock then draw out the rein area completely.
- Cut the reins in at the mid point.
- At this point make sure each half of the tongs are formed identical.
- Then rivet the two halves together.
- Using the size of stock that these tongs will hold align and forge to fit that stock.

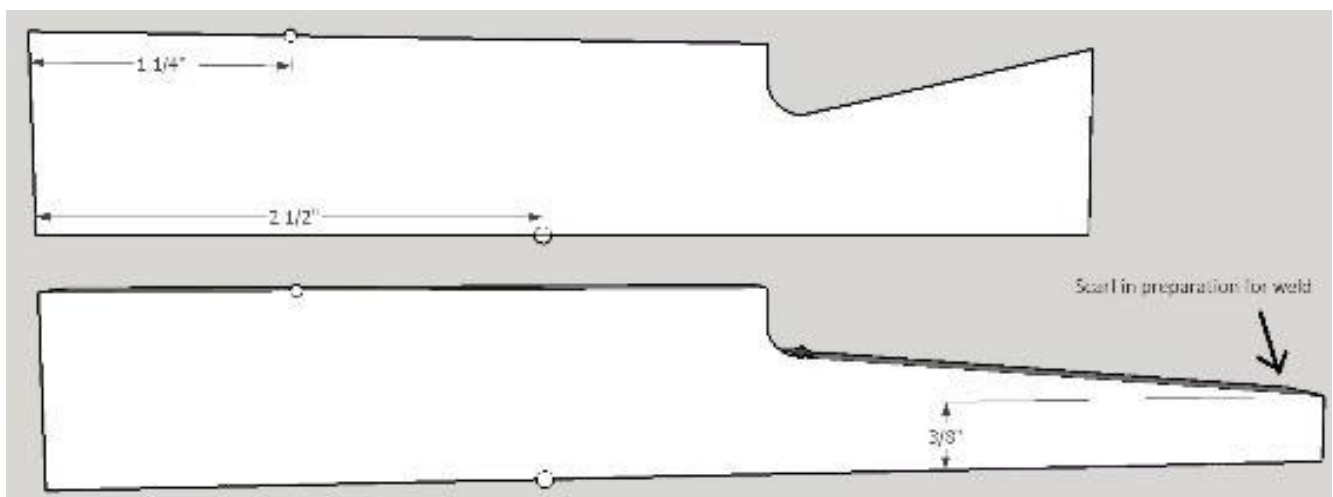
## Welding on reins

As is stated above, after drawing out from the fuller at the back end of the boss you can weld on reins. I prefer 3/8" round bar for reins and for these tongs I use a 10" length. You can size these to whatever length you like, maybe longer for using around a gas forge or shorter if you prefer shorter tongs.

A couple of things I have found that helps me is 1, I start my forging on the bits at the final punch mark or at the back end of the boss then draw this down and get it ready for welding. This helps ensure that the small areas of the forged down bits don't get damaged when reaching welding heats in the fire. (It also is easier to scrap the piece when I mess it up since I haven't done all of the bit forging already.) Also 2<sup>nd</sup> a piece of 10" long 3/8" round bar is approaching to hot to hold when forge welding onto the bit so to not need to use two sets of tongs for the weld I leave the 3/8" stock 20" long and then cut it at the mid-point when I'm ready to finish up the tongs prior to riveting.

As these instructions are not meant to state how to forge weld, I will not elaborate on the finer points such as how to scarf.

- Step one is to take a short heat on each end of the 3/8" round bar and upset the ends to prepare them for the weld unless the reins are in two pieces then of course just upset the end being welded on to the bit.
- After upsetting scarf each end in preparation of the weld.
- On the section of the bit just behind the boss, draw the stock down from the fuller to a width of just about 3/8". This section should draw out to about 3" or so. Then scarf that end also.
- Bring both the rein and bit to a welding heat and good luck.
- Perform the same steps to the other bit and then continue with your forging.



If the V-Bit was used and drawn out to make the bit longer at this time a square file can be used to file a V-Notch across the bit so that stock can be held at a right angle to the tongs.

Now use these tongs to make more tongs.!

Bill Corey  
Indiana Blacksmith Association



# SHOP *BUILDING* TIP - Pulling Wire

By Jim Carothers

Some of you may not have occasion to pull wire through conduit, but if you do here's a tip worth remembering.

A short length of chain on a wire pulling tape makes pulling wire through conduit a lot easier than tying or splicing wires together – think stiff section. I have been putting a few chain links between each wire; just seems to flow through turns easily.

I'm probably not the first one to think of using a chain for pulling wire, but it occurred to me one day when thinking about the 178' pull from the meter to the barn.

My neighbor & I easily pulled three No. 1's and a No. 8 through sixty feet of 1-1/4" EMT ( 3 ninety degree turns and two small offsets ) to run 100 AMP power from the barn main panel to the subpanel in the new shed – blacksmith shop.

Hopefully that is the last 1-1/4" EMT I have to bend. Even with that hoss of a bender and a 6' handle it is pretty hard to bend.

My wife, Sherill, & I did the long pull meter to barn by ourselves using the chain idea and a made-for-the-job pulling rope - plus a bottle of pulling lube.

Jim C.



## SHOP *BUILDING* TIP (continued...)





# Memorial Cross by Jason O'dell

I made this for my fathers grave. He passed Feb. 17, 2021

Thank you, Jason O'Dell







## Chris Miller Demo

Written by Mike McLaughlin Pics. Mike M., Bob Stormer

Chris Miller demonstrated a floral/botanical themed arrangement.

Materials: 3" x 6" x 1/4" flat plate. 1 pc., 3/8" round 11" long 1 pc., 1/4" round 11" long 1 pc., 1/8" round 11" long 1 pc., Precut Flower blank 1 pc.

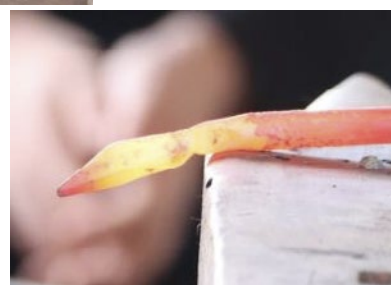
Tools: Rounding or Ballpeen hammer, Crosspeen hammer, Hotcut chisel, Texturing hammer, V-block, Wood block for dishing.

Base Plate. Drill 1/2" hole in center. Heat and texture all over with Rounding hammer. Chamfer the edges of the plate with rounding hammer. Chris said it leaves facets which help catch the light. Keep plate flat as you are going along. Wire brush.

Leaves. 3/8" round. Taper one end to a point appx. 1.5 inches. Isolate the leaf from the stem using the edge of the anvil on a radiused corner. Then draw out the stem using the horn. Chris uses a rounding hammer. He explained that the combination of the round horn and rounding hammer works as a fuller to help move mass. Remember square, octagon, round. Draw out about 3". Then use texturing hammer on the stem. It gives it more interest.

Spread out leaf. Start at the high point then work the edges Chris uses a rounding hammer Stay away from the Tip. Then chisel in the veins using a hotcut chisel. Heat the leaf lay it vein side down on the wood dishing block and use a ballpeen to shape it.

Do the same to the other end of the bar. You now have a leaf on each end of the bar. Next will be bending the bar 180 degrees so the stems are pointing the same direction. Chris heats the bar in the middle, using a hot cut hardy he finds the approximate center of the bar then slides it over off center, so the ends are not the same length. Cut most of the way through. Then bend so the stems are next to each other.

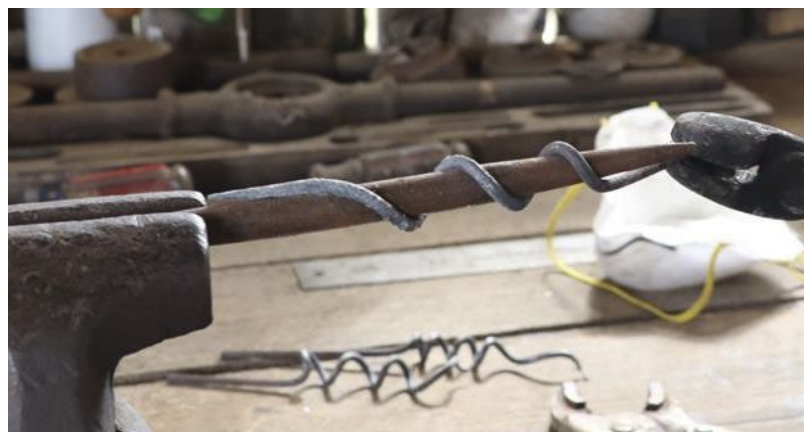


Flower Blank. Heat flower blank. Chris uses a hammer with a small peen. Use the peen of you hammer to texture each petal. Different sizes of hammers will give you different textures. Don't be afraid to experiment with what you have. After texturing use a V-block to shape the petals. Wire brush to remove scale.



Stem for Flower.  $\frac{1}{4}$ " round. The  $\frac{1}{4}$ " rod was just a little bigger than the hole, so he just gave it a short taper to fit into the hole. Chris either tack welds or creates a tenon to attach the flower to the stem. This one would be tack welded from the back. He attaches the flower after welding the bundle together..

Squiggly-Q. Taper one end of the  $\frac{1}{8}$ " round. Keep it hot to keep from splitting the end. Clamp a mandrel in the vise. His was  $\frac{1}{2}$ " to  $\frac{5}{8}$ " round and tapered on one end. He clamps the bar near the vise with vise grips and twists it around the mandrel. Chris says it is easier to do using a torch.

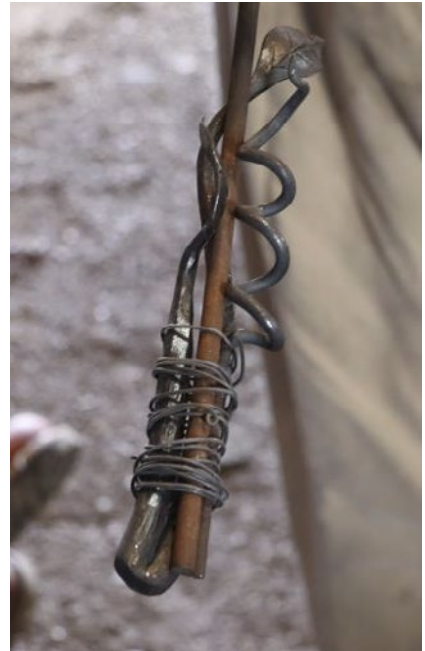




Next is forge welding the bundle of stems together. Chris uses wire to hold everything together while forge welding. Heat it, flux, and weld together. Chris uses Iron Mountain Flux. Forge it down to fit in the hole you made in your plate. Wire brush. Attach the flower to the end of the flower stem.



Arc weld the bundle into the plate from the underside. The bundle will now look Higgly-Wiggly. To remedy that will take a torch, scrolling pliers and tongs. Bend



everything around until you get a shape that you like. Use a brass brush to give highlights. Finish with some clear spray paint.

Tooling Notes: The texturing hammer Chris uses is an old ballpeen with grooves cut in the flat face using an angle grinder with a cut off wheel.



The anvil hold down is a piece of square plate with grooves in it. It has a shank in the middle that is smaller than the hardy hole. It has a spring attached to it that hooks on the stump. It is very easy to attach and remove. I should have taken better pictures of it.



*This article is reprinted with permission from the Blacksmiths Association of Missouri newsletter Mar-Apr 2021*

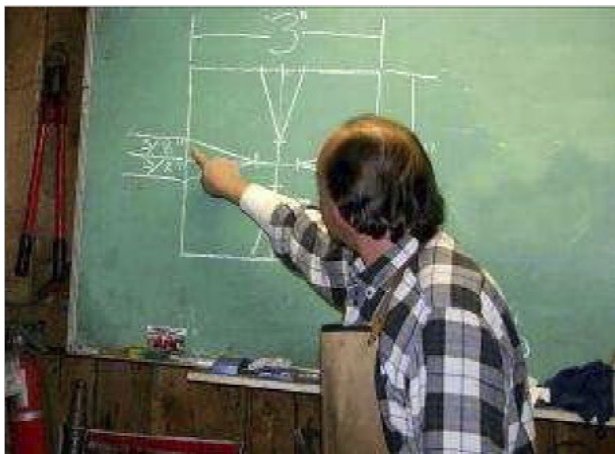
# Steve Crist Demonstrates Four-petal Flowers

Bob Dixon Gumm

The BGOP was recently introduced to the art of creating "double" four-petal flowers by Steve Crist. Steve uses the flowers on tables and other items that he creates in his forge, and I think you will agree that the results are stunning. Steve mentioned that he was introduced to the four-petal process by Mike Boone at the Central Virginia Blacksmiths' Guild. Although I view the flowers as double petal dogwood flowers, they can be perceived as any of a number of varieties.



While Steve used three inch blanks for his demonstration, he brought in examples of four inch and other sizes that he created. Steve has purchased blanks in the past, but now makes his own blanks in his shop. Using the three inch pattern for our discussion, Steve begins by crossing the four corners of the square to determine the center. In order to correct any drifting of the center during the forging process, Steve prefers to mark the center with a punch instead of drilling a hole. Next, he drills four holes at  $\frac{3}{8}$ " from the center to act as stop points when cutting the triangles. How does Steve cut the blanks? He has a metal band saw that is set up for cutting steel plate. However, one can also use a hacksaw or a cutting wheel to do the job.







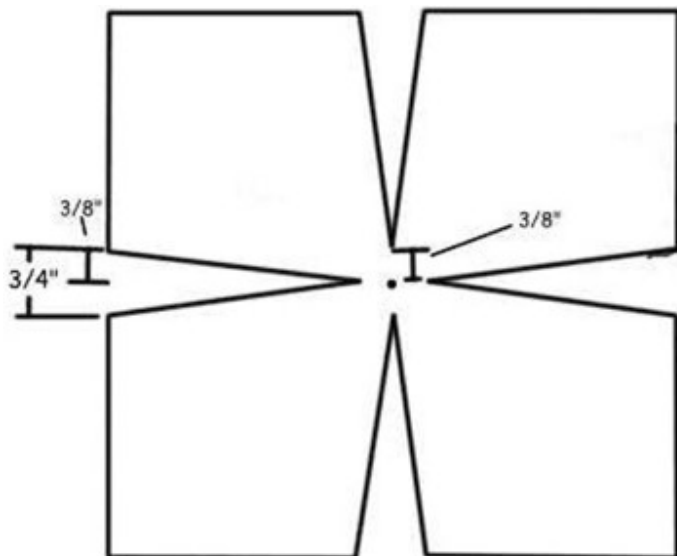
It's time to forge the petals. Steve brings the blank to an orange heat, and with a medium weight cross peen hammer, carefully draws out the edges of the petals. He uses farrier's tongs to hold the blank. He typically gets one petal completed during a single heat, and can begin another petal when things go well. Once he has attained the desired outline and texture of the petals, Steve rounds the petals. He has several hardy swages that he purchased for the project, but noted that a wood block also works. When using hardy swages, it is important to keep them scale-free. One step that he emphasized is that one petal is shaped at a time, and once the petal is complete, the piece is placed on the anvil and the center is tapped down. This makes it easier to bring the piece to the final shape.



Once two pieces are completed, Steve punches a hole in the center for the pistil. The pistils are created using a custom fuller that he manufactured for the job. He mentioned having used mild steel fullers in the past, but found that they lost their definition after numerous heats. Now he uses tool steel, and is very careful to remove scale while he's working. Once the pistil is finished, Steve cuts threads on the stem using a die. BGOP member Bill Wojcik remarked during the demonstration that there are several ways to purchase taps and dies. The least desirable is to purchase multi-piece tap

and die sets. Some of them are poorly manufactured, and it is more economical to only buy the tools that you will actually need and use. In the long run, it is better to spend your money on individual high quality parts.





### **Four-Petal Flower-** For article on pages 3-4.

*This three inch pattern is provided to help you construct the four petal flowers. For best results, transfer the pattern onto wood or plastic. Be sure to drill a hole at the center of the pattern.*

Steve Crist was introduced to this process by Mike Boone, probably at Dan and Judy Boone's place in Louisa, VA. Then Steve demonstrated this for BGOP in Northern VA, leading to this article being published in the Jan/Feb 2012 BGOP newsletter. Then the Michigan Artist Blacksmith Association reproduced it in the Sept/Oct 2020 issue of The Upsetter, which made its way back to me in Louisa, VA so I could reproduce it here.

## Flower Stamen by Bill Kirkley

The stamen is often made up of multiple filaments. This article describes a method of recreating that look.

Weld the end of a piece of 1/4" cable to anchor all of the wires. Weld that end of the cable to a 1/4" rod.

Unwind the cable. Pull it through a hole drilled in a piece of steel to the desired filament length. Cut it off with an abrasive disk. Pull it through the flower and weld it in place. This is a really unique use of cable. Thanks Bill!



Originally published in the May June 2016 On the Anvil newsletter of the Philip Simmons Artist Blacksmith Guild

*This article and the previous article are reprinted with permission from the Virginia Blacksmith April 2021 Special Edition. This set of articles has a bit of history with republishing (See the Virginia Blacksmith Editor notes above.)*



# ABANA Affiliate Newsletter - March 2021

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

Greetings from the Artist-Blacksmith's Association of North America —  
“ABANA encourages affiliate leaders to forward this newsletter directly to its club members and/or include any or all content in your club's newsletter.”

## Submitting Content for the Anvil's Ring and the Hammer's Blow

ABANA produces two of the finest blacksmith publications in the world and the editors of the Hammer's Blow and Anvil's Ring are always looking for interesting articles and pictures. The Anvil's Ring is looking for pictures of your finished projects, no matter what your skill level is, to include in a future “Members Gallery” center fold feature. Also, if your club, organization or even an individual member is doing something special in your community to promote our craft as blacksmiths, we would like to highlight it in one of our quarterly publications. If you have something of interest, please contact Anvil's Ring editor Mark Kochan [areditor@abana.org](mailto:areditor@abana.org) or Hammer's Blow editor Nathan Griffith [hbeditor@abana.org](mailto:hbeditor@abana.org)

## Education Calendar

The Education Calendar and a list of schools will be in the Spring addition of the Anvil's Ring. Please take a look at it for learning opportunities around the country.

## Reprinting Articles and Copyright Laws

Communication is important and as stated above we want you to share any part of this newsletter with your membership. Unfortunately, not all information in this world is free to reprint or post and we need to make sure there is no copyright infringement as we put together our own publications, be it paper or electronic. Check out this article from the ABANA website which addresses some of the copyright issues. <https://abana.org/wp-content/uploads/affiliate-resources/Copyright.pdf>

## Conference in Texas

Although the next big ABANA event is the Iron To Art Festival to be held at our new Headquarters in Johnstown PA in October of this year, <https://abana.org/abanas-iron-to-art-festival-2021/> be planning down the road. The ABANA 2022 Conference is a little more than a year away and will be held in Fort Worth, Texas May 11th through the 14th 2022. <https://abana.org/2022-abana-conference/>

From the safety checklist, “Aprons, while optional, gives protection from flying or hot objects”. Take care and don't let the apron cause other problems like getting caught in or on other machinery. [https://abana.org/wp-content/uploads/2021/02/Safety\\_First-2-16-21.pdf](https://abana.org/wp-content/uploads/2021/02/Safety_First-2-16-21.pdf)

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

## 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.

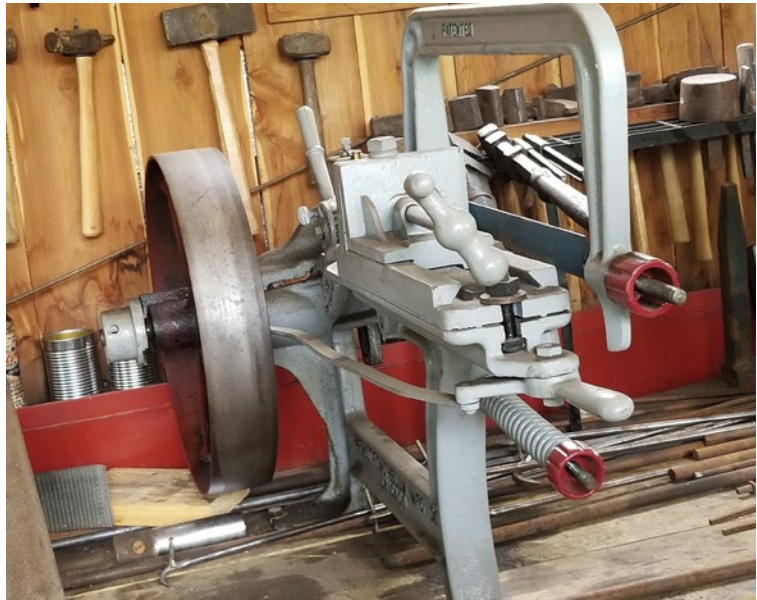
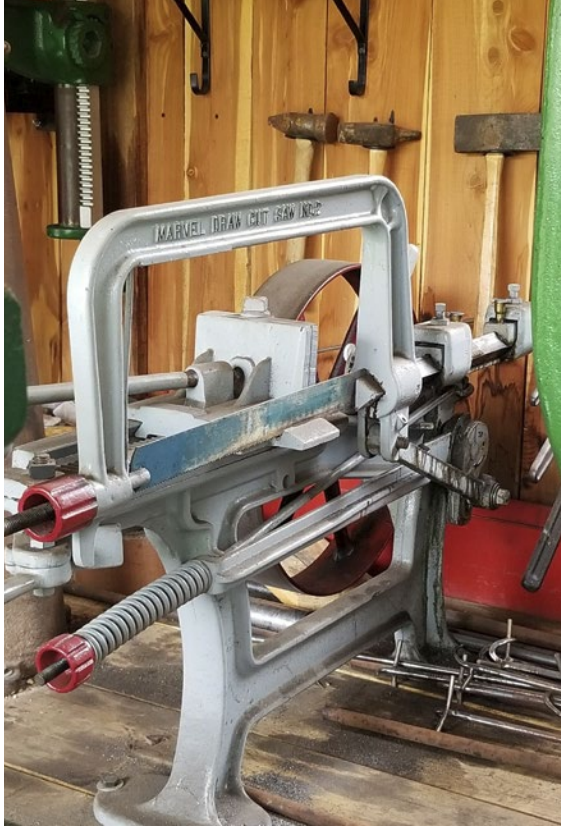
Contact: **Ragnar at [rtaswallson@yahoo.com](mailto:rtaswallson@yahoo.com) or 918-855-8250.**



# SCABA Shop and Swap

## 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.**



## Wanted to Buy:

WANTED: 25LB Little Giant (or similar) Power Hammer. Hoping for a good deal. Not much in the way of cash but will work/barter/trade to offset cost.

Email: [Colby.J.C.96@gmail.com](mailto:Colby.J.C.96@gmail.com) or Call/Text me, **Colby Henzel: 918-640-0848.** I get a lot of spam calls so please leave a voicemail if I miss your call. I will return your call ASAP. Thank you.

# SCABA Shop and Swap



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



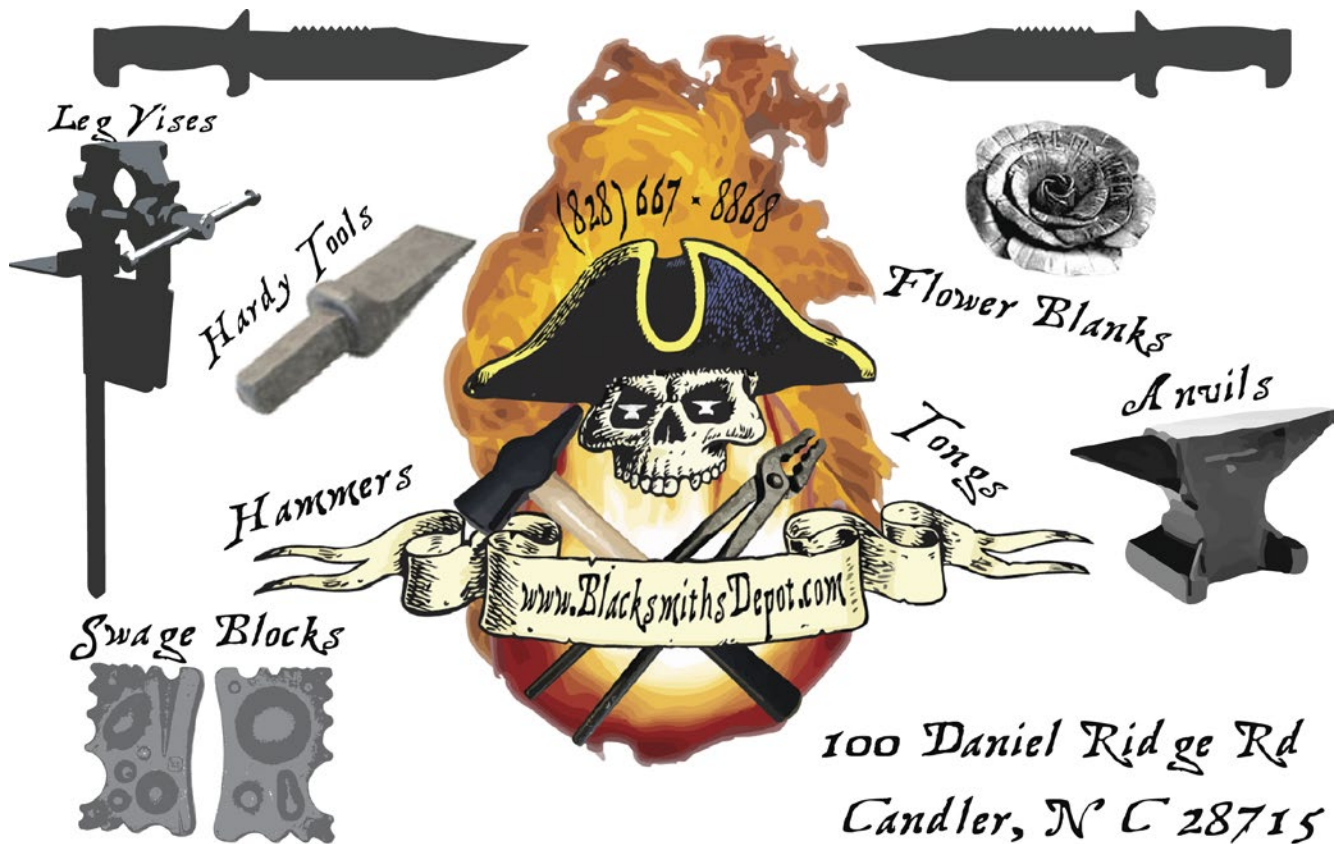
[WWW.KENSIRON.COM](http://WWW.KENSIRON.COM)

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:

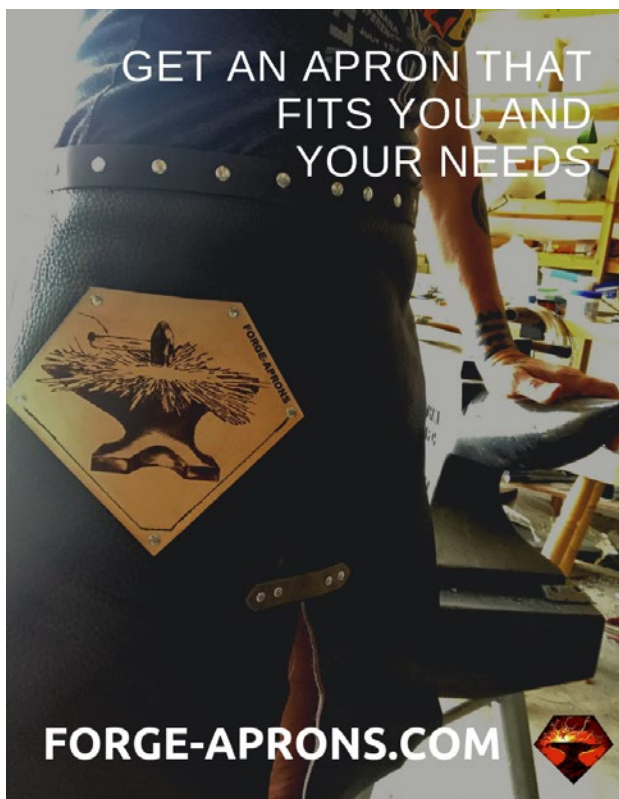
\$1,200 for everything from the base plate up. Two rounding dies included as standard. Has 1/2 HP 115V Motor. Contact: David Barfield - 580-595-1476






# SCABA Shop and Swap

GET AN APRON THAT  
FITS YOU AND  
YOUR NEEDS



**FORGE-APRONS.COM** 

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[BlacksmithsDepot.com](http://BlacksmithsDepot.com) - [CustomForgedHardware.com](http://CustomForgedHardware.com)



**Ken's Custom Iron, LLC**

37634 County Road 9  
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[mail@kensiron.com](mailto:mail@kensiron.com)

## **Blacksmith Supply**

Modern Tool For the Modern Blacksmith  
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**John Elliott**

[jelliott@blacksmithsupply.com](mailto:jelliott@blacksmithsupply.com)  
804-530-0290

P.O. Box  
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.com

## **Raker Knives & Steel**

**Ray Kirk ABS-MS**



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# SCABA Shop and Swap



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

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

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



## Reeder Products Inc.

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

## Bill Davis Forge Welded Tomahawk DVD

This DVD is now available to members for a minimal cost (cost of DVD's is minimal to cover reproduction and shipping if applicable.) Contact the SCABA Librarian, Don Garner, if you would like to get a copy of this DVD.

Don Garner: 580-302-1845

(Call or Text. If you get voice mail, Please leave a message.)



## For Sale:

### Tire Hammer Plans by Clay Spencer

Send a check or money order for \$30 US to Clay Spencer, 73 Penniston Pvt. Drive, Somerville, AL 35670-7013. Or send \$32 US to Paypal.Me/ClaySpencer. E-mail me at clay@otelco.net. PDFs will be e-mailed outside US. Phone 256-558-3658

### Beverly shear blades sharpened

Remove your blades and send in USPS small flat rate box with check for \$41 US to 73 Penniston Pvt. Drive, Somerville, AL 35670-7103.

**For Sale:** I have numerous old tools and collectible items of various kinds including blacksmith related tools and equipment. Too many tools to list them all. Inventory is always changing. Contact: Craig Guy (SCABA Member), Piedmont, OK  
Cell Phone: 405-630-7769 (Call or Text )

# SCABA Shop and Swap

## SCABA Library DVD's Available:

This is a partial list of the DVD titles available to members from the SCABA Library. Contact the Librarian (Don Garner) if you would like to obtain a copy of any listed title or if you have questions on any other titles that may be available. Additional titles are listed on the website. DVD's are available for a very minimal cost to offset the blank disc and cases or sleeves. Shipping cost applies if you need these delivered by mail.

- Robb Gunter Basic Blacksmithing parts 1,2,3 and the controlled hand forging series
- Clay Spencer SCABA conf.2013 pts. 1,2 and 3
- Jerry Darnell 18th century lighting, door latches and hinges
- Brent Baily SCABA conf. 2011
- Mark Aspery SCABA conf. 2011
- Robb Gunter SCABA conf. 1998
- Robb, Brad and Chad Gunter 2009 joinery, forging, repousse, scrollwork, etc.
- Bill Bastas SCABA 2002 pts. 1 - 6
- Jim Keith SCABA conf.2007
- Power hammer forging with Clifton Ralph pts. 1 - 5
- Doug Merkel SCABA 2001
- Bob Alexander SCABA 2008
- A. Finn SCABA 2008
- Bob Patrick SCABA 2004
- Gordon Williams SCABA 2010
- Daryl Nelson SCABA 2010
- Jim and Kathleen Poor SCABA 2001
- Ed and Brian Brazeal SCABA 2006
- Ray Kirk Knives SCABA 2002
- Frank Turley SCABA 1997
- Frank Turley SCABA 2003
- Bill Epps SCABA 2003
- M. Hamburger SCABA 2007

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

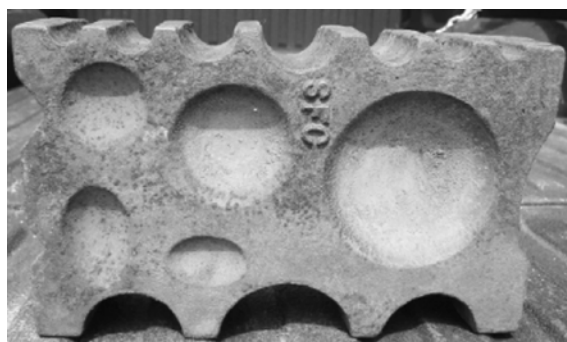
## **Have an Item for Sale? Item Wanted?**

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

## **SCABA Swage Blocks**

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

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



## **SCABA Floor Cones**



\$275.00 plus shipping.

(Same price to members and non-members.)

To order swage blocks or cones, contact our distributor:

**Nolan Walker at  
Nature Farms Farrier  
Supply in Norman,  
OK.**

**405-307-8031**



# SCABA Shop and Swap

## Club Coal:

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

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

**No sales to non-members.**

**NW Region coal pile located in Douglas, OK.** If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of \$10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence the \$10 charge. You may opt to load your own coal without using Tom's loader. The coal can be weighed out at the Douglas Coop Elevator scales. Contact Tom Nelson (580-862-7691) to make arrangements to pick up a load. Do not call Tom after 9 PM!! Bring your own containers and shovels. Payment for the coal (\$.15 per pound) should be made directly to the Saltfork Treasurer.

## NW Region Coal Pile in Thomas:

Don Garner now has a new pile of club coal available for sales to SCABA members. The shop is at 23713 E 860 Rd in Thomas, OK. (One mile west, then one mile north of Thomas.) Contact Don at 580-302-1845 (Cell Phone) to arrange details for purchases.

## NE Region coal location:

**\*\*\*\*NOTICE:\*\*\*\***

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

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

## SCABA T-Shirts!

2018 Saltfork Collector T-shirts are available with the 2018 Conference Logo. \$5.00 (plus shipping if applicable.) Contact Josh Perkins to check sizes and quantities that are still available.



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

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



## Have an Item for Sale? Item Wanted?

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



## SCABA Membership Application

For Annual Membership

(Please Print Clearly!)

Date \_\_\_\_\_

New Member \_\_\_\_\_

Renewal \_\_\_\_\_

First Name \_\_\_\_\_ Last Name \_\_\_\_\_

Married? \_\_\_\_\_ Yes \_\_\_\_\_ No \_\_\_\_\_ Spouse's Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ Zip \_\_\_\_\_

Phone (Best Number to Contact) (\_\_\_\_\_) \_\_\_\_\_

e-mail \_\_\_\_\_

ABANA Member? \_\_\_\_\_ Yes \_\_\_\_\_ No \_\_\_\_\_

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

Signed: \_\_\_\_\_

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

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

[www.saltforkcraftsmen.org](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)



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