

Saltfork Craftsmen

Artist-Blacksmith Association

September 2021



Brent Bailey



Lyle Wynn



The 2021 Saltfork Conference is just a month away!
(See Registration Information on Page 13)

Build a Variable Axis Rotating Table
(Part Two - Page 31)

**Saltfork Craftsmen
Artist-Blacksmith Association
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Editor's Notes:

2021 Conference Updates:

The 2021 Conference is proceeding with Brent Bailey and Lyle Wynn as this year's demonstrators.

We weren't able to have the 2020 conference due to covid mandates but as we head toward the end of summer, it looks like everything is remaining on track for this year's conference.

The last two years have seen a lot of last minute cancellations and tentative planning due to covid as well as an apparent slow down in general blacksmithing activity. However, we are planning to have the same gallery, toolbox raffle, and live auction this year as we normally do. We hope that you will bring some inspirational items to display in the gallery and, if you can, some donation items for the toolbox and/or auction. As always, the amazing generosity of Saltfork members keeps the club going and is appreciated by all!

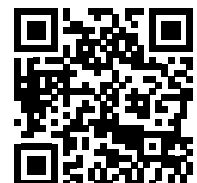
We will keep you posted and provide any important updates as soon as they are available. Look for supplemental communications including member e-mails, the Saltfork website, Facebook, and postal mail to get the most timely information as it becomes available.

-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,

We had a board meeting the first of August and we are proceeding with having the annual conference at this time. Everything seems to be on track to go ahead and hold the event.

We have two very good demonstrators lined up for the conference and the workshops after the conference.

I have seen a little new interest in the gate project. We have temporarily hung up the rings that have been turned in so far at the Route 66 Museum Blacksmith Shop until we get enough to make the actual gate.

We have been doing a little demonstrating around at different local events but not as much as we used to do. But I think things are picking up a little.

When we are working in the Route 66 Museum Blacksmith Shop at Elk City, we get a lot of visitors from across the country and a lot more from the east coast than we used to get. I guess they have cabin fever.

I hope everyone is doing well. Stay tuned for Conference details and updates and I hope to see you there.

Keep your tongs fitting tight!

Thanks, - Mandell



All Regional Meetings are Free to Attend and are Always Open to Any Member or Guest...

New to Saltfork or just want to check out Blacksmithing but don't know where to start? These meetings are a great place for new members or guests who just want to see what it is all about to come network with like-minded people. If you want some pointers on how to get started, there is always someone happy to help get you started hammering. And guests are always welcomed.

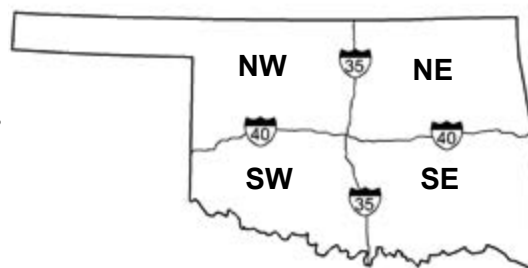
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the hard copy form in as soon as possible. If you mail a form, please call or e-mail to verify that it is received. E-mail is the most convenient for me, but you can also phone in the information if you prefer. The sooner the meeting is scheduled, the more time there is to get the word out to potential attendees. -Russell Bartling 918-633-0234 or rbartling@ionet.net

What's My Region?

The four main regions are currently defined within the state by being separated by I35 and I40. (For example, the NW region is anything north of I40 and west of I35.)

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

SCABA Regions



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

Safety

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

2021 Workshop Schedule

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.

BLACKSMITH BEGINNERS' WORKSHOP

WHEN: Saturday, 13 November, 8 A.M.
WHERE: Muldrow City Park

Saltfork Craftsmen will be hosting a beginners Blacksmithing workshop on Saturday, November 13th, beginning at 8 A.M. and running until complete. (About 3 P.M) All tools and materials will be provided. Projects will include, an S-hook, a forged leaf keychain, and a hot cut chisel. We will be covering the basic blacksmithing skills of tapering, drawing, scroll work, and heat treating. A hot lunch will be provided. Slots are limited so please reserve yours early. Cost for the course is \$40 per person. Minors under 16 must be accompanied by a responsible adult.

To make reservations, or for questions, please contact **Bradley Nance @ 918-774-4291**, or email at Bradley.nance@cnent.com

(Please note that due to insurance requirements, all participants must be members of Saltfork Craftsmen. Membership is \$ 30 per year, and covers all family members. Membership fees are payable at the time of the course or by contacting Teresa Gabrish, at Treasurer@saltforkcraftsmen.org)

Have an idea for a workshop or class? If you have an idea for a workshop that you would like to attend (or teach), please let the workshop coordinator know so that details for time and place can be worked out.

We have two workshop coordinators:

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

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

Coronavirus Safety Concerns/Event Cancellations:

With recent developments concerning COVID19, a large number of blacksmithing related events have been canceled for safety reasons. It will be more important than ever to stay posted with websites, social media, etc. and to double check before assuming events will be held.

-Russell Bartling, Editor

2021 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 2nd (Open)	Jan 9th (Open)	Jan 16th (Open)	Jan 23rd (Open)
Feb 6th (Open)	Feb 13th (Open)	Feb 20th (Open)	Feb 27th (Doug Hyde)
Mar 6th (Open)	Mar 13th (Open)	Mar 20th (Open)	Mar 27th (Mandell Greteman)
Apr 3rd (Don Garner)	Apr 10th (Diana Simon)	Apr 17th (Open)	Apr 24th (SCABA Picnic!)
May 1st (Open)	May 8th (Open)	May 15th (Open)	May 22nd (Rory Kirk)
Jun 5th (Open)	Jun 12th (Open)	Jun 19th (Open)	Jun 26th (Everett Timmons)
Jul 3rd (Matthew (Ragnar) Crowson)	Jul 10th (Open)	Jul 17th (Open)	Jul 24th (Open)
Aug 7th (Diana Simon)	Aug 14th (Open)	Aug 21st (Open)	Aug 28th (Open)
Sep 4th (Tracy Cowart)	Sep 11th (Open)	Sep 18th (JJ McGill)	Sep 25th (Ron LehenBauer as Host - Don Garner as Contact Person)
Oct 2nd (Open)	Oct 9th (Conference Setup)	Oct 16th (Conference Weekend)	Oct 23rd (Rory Kirk)
Nov 6th (Diana Simon)	Nov 13th (Open)	Nov 20th (Open)	Nov 27th (Open)
Dec 4th (Open)	Dec 11th (Open)	Dec 18th (Open)	Dec 25th (Christmas Day)

2021 Fifth Saturdays:

January 30th (Open)

May 29 (Boy Scout Meeting at Murray County Antique Tractor Show Grounds.)

July 31st (Beginner Blacksmith Workshop - Elk City)

October 30th (Open)

September 2021

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

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

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

Contact Tracy Cowart at 918-630-7025 or gtcowart@gmail.com if you have questions.

SE Regional Meeting Sept 11th: Open.

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

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

Lunch will be on your own. Directions are 7 miles north of Sulphur on Hwy 177 then east ¾ mile on Tractor Road.

If you need more information, contact Ricky Vardell at 580-512-8006 or JJ McGill at 580-369-1042.

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

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

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

Contact: Don Garner 580-302-1845 if you have questions.

October 2021

NE Regional Meeting October 2nd: (Open.)

SE Regional Meeting October 9th: Is reserved for the Pre-Conference Set Up Work Day in Sulphur, OK. Please come help get the site ready for the Conference if you can!

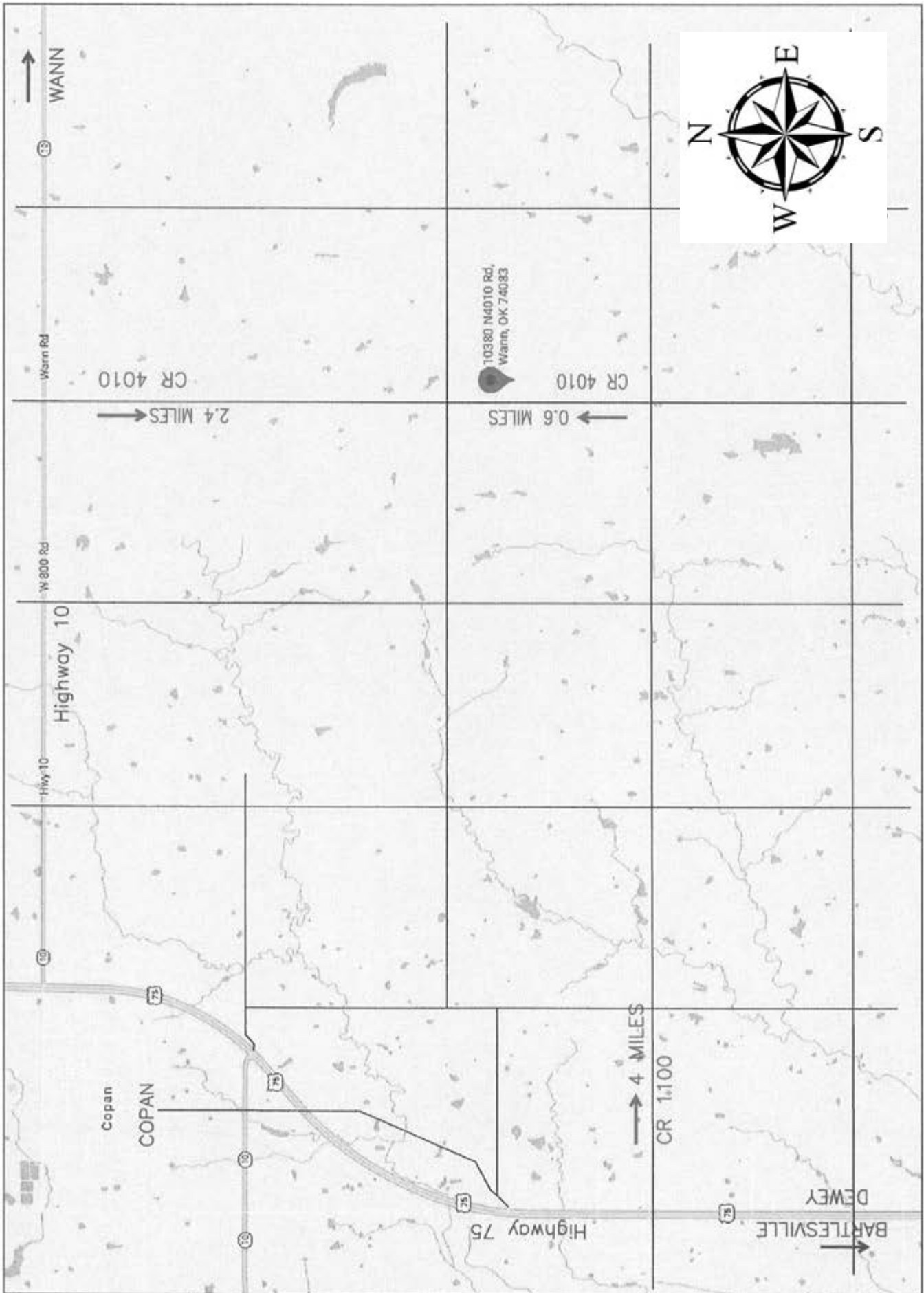
SW Regional Meeting October 16th: **Conference Weekend!**

NW Regional Meeting October 23rd: Will be hosted by Rory Kirk at the Route 66 Museum Blacksmith Shop in Elk City.

Trade item is a forged candle holder.

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.

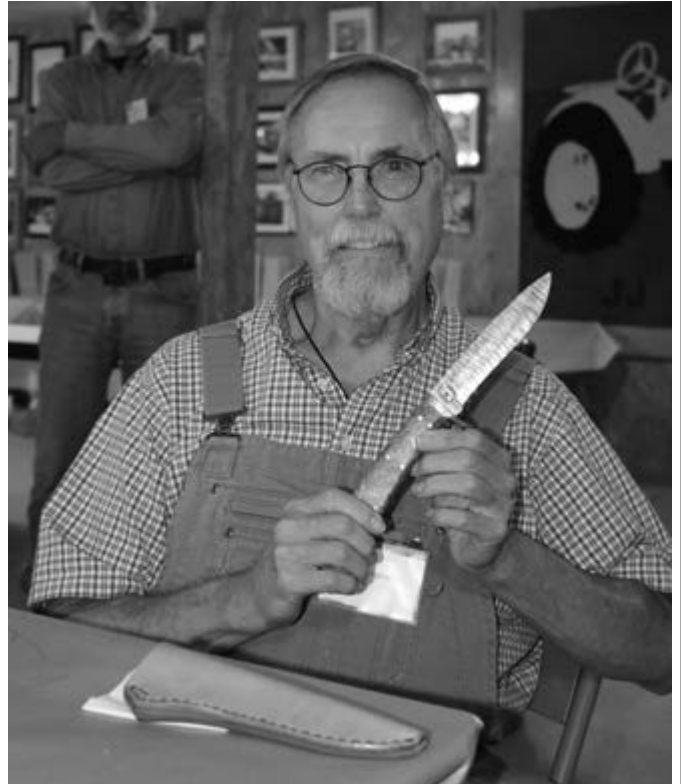


Saltfork Mourns the Loss of Charlie Groom

Saltfork member, Charlie Groom, passed away after being in a coma following complications caused from Covid.

As of press time, funeral information is not yet available. Watch for updated information by member e-mail.

Charlie was a long time member and liked by many who are saddened by this loss. Our thoughts and prayers are with the family. - Editor



Saltfork Craftsmen Organization and Members Featured in University Project

The Saltfork Craftsmen organization, and several Saltfork members specifically, were recently featured in a SWOSU school assignment project by Hayley Kirk (Rory Kirk's daughter.) Hayley is a freshman at SWOSU and is planning to complete a nursing degree. The project included designing and implementing a website with several pages describing Saltfork Craftsmen and her experience attending a blacksmithing meeting. If you are interested in viewing the project, you can access the website at:

<https://hayleykirk123.wixsite.com/my-site-4/project>

Be sure to investigate all of the tabs, and especially the "portfolio" tab, to see more detailed information.

It is good to see Saltfork reaching young hearts and minds. Great work Haley!

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

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

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

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

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

Here is a link to current Saltfork listings:

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



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



Oklahoma State Fair Needs Demonstrators!

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

Mark your calendars for the upcoming demonstration days:

Thursday, September 15 through Sunday, September 25, 2021

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

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

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

SALTFORK CRAFTSMEN 2021 STATE FAIR CALENDAR

SEPTEMBER

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

Scheduling: Richard Blasius 405-881-0804
Michele Blasius 405-550-9850

Demo Opportunity:

From: "Kitty Williams" <okierenniel@yahoo.com>

To: mandell01@windstream.net

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

Subject: Inaugural Celtic Festival

Greetings,

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

Thanks ever so much!

Kitty Williams
Vinita, Ok, USA

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

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

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

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

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



2021 Saltfork Conference



October 16th and 17th
Sulphur, OK

The Best Way to Register for the Conference is Online Through the Saltfork Craftsmen Website

Online registration is fast, safe and easy.

You do NOT have to have a Paypal account to register online! Watch for additional information by e-mail from Eric Jergensen or check the Saltfork Website. Website registration has extra benefits!

Location:

Murray County Antique Tractor Association Show Grounds
7 miles north of Sulphur on Hwy 177, 3/4 mile east on Tractor Road
Sulphur, OK

Family Classes

Family Classes for the Conference are to be determined. Complete information on the Family Classes will be provided in the August newsletter. Stay tuned for more details.

Conference Workshops October 18, 19 and 20th:

Workshops with the demonstrators - Brent Bailey and Lyle Wynn - are planned after the conference. The format will be similar to previous years. Each demonstrator will conduct a 10 student workshop over three days following the conference (Monday through Wednesday). The workshops will run concurrently so you will only be able to register with one instructor. This is an amazing opportunity to receive hands on instruction with instructors of this caliber.

Participants must provide their own (or arrange to borrow) safety gear and forging stations including anvil, forge, vice, and basic forging tools such as hammers, tongs, chisels, and punches etc. Specific tooling requirements for any tools that will not be provided will be made available before the workshops.

Exact details and cost for the workshops are being finalized with the demonstrators and will be announced. Expected approximate cost for each workshop will be around \$350 per student including meals. There may also be an additional material cost depending on final workshop arrangements.

Registration information and additional details will be announced. Watch for member e-mail updates and stay tuned to the Saltfork Craftsmen Website and Facebook pages.

2021 SCABA Annual Conference

Peoples' Choice Awards and General Gallery

Two Categories:

We will once again have **two categories**, one will be for work done using “**Traditional**” methods and the other will be “**Open**,” meaning open to use any and all methods of the artist’s choosing.

The intent here is to separate work that is done with methods generally considered traditional to blacksmithing, such as forge welding, joinery, punching, upsetting, drawing out, etc. from more modern methods such as arc/mig/gas welding, stock removal grinding, etc. These “modern” methods have become, in many cases, much faster and easier to use than the traditional methods due to modern machines and equipment. This separation is an attempt to allow a potential gallery submission to be judged against other work on a more equal footing than is practical with a single overall category.

If there are any issues that come up, the Board of Directors will make a judgment on how to place the piece in the Gallery. Mostly, any benefit of the doubt will go to the entrant.

General Gallery:

We would also like to see a general gallery of work from all levels on display. It does not have to be all new work or work submitted for the People’s Choice voting. It can be for sale or just for display. But we would like to have anything you are proud of making or that you find inspirational to be on display. Even work by beginners is often an inspiration so please don’t hold back thinking your work is “not good enough.” Keep in mind, there will be visitors that have never even forged an S-Hook or a leaf key chain. Any work probably has something to teach and inspire others. Please consider bringing your items to display! - *Editor*

2021 SCABA Conference RV Reservations:

It is not too early to make reservations if you plan on camping on site and need an RV hookup. Primitive camping is also available with access to clean toilets and showers if you prefer primitive camping. RV hookups are available for \$15 per RV per night (to the Tractor Club) for electric only service. Spots are already being reserved so contact J. J. McGill as soon as possible if you would like to make a reservation.

Contact J. J. McGill at 580-369-1042 or
jjmcgill88@yahoo.com

2021 SCABA Conference Tool Box

Brad Nance is constructing this year’s toolbox.

But we need tool donations to fill it!

Any donated tool is greatly appreciated, as proceeds from this drawing benefit the Saltfork club as a whole, but hand made tools are the most appreciated by those interested in winning the box. Either way, the winner of the tool box drawing will have a nice collection of usable tools that they will be proud to own.

Tickets for a chance to win the Conference Toolbox will be available up until the drawing at the auction on Saturday night. If you will not be able to attend the conference and want a chance to win the tool box while supporting the club, tickets may be purchased from the Secretary. Tickets are \$2.00 each.

Iron in the Hat

Gerald Franklin

Many of our newer members were confused at last year's conference as to what this "Iron in the Hat" (IITH) thing was all about. Since I have been appointed as the IITH coordinator for the conference, I guess it's one of my duties to explain the tradition and how we observe it at our conferences.

The Iron in the Hat activity is an old blacksmithing tradition (exactly how old is anybody's guess) that makes a little money for the sponsoring organization and provides an outlet for some of the things that an individual smith may not need anymore but another smith may "covet". Basically it's a raffle of sorts where items are donated, tickets are sold and drawn and the items then change owners.

Here's how it works at the Saltfork Conference. Members, merchants, and just good people donate items. We put the items out for display with a paper sack beside each item. Tickets are sold and buyers put one or more tickets into a sack corresponding to an item they are interested in. If you would really like to have a particular item, put several tickets into the sack. At a particular time a winning ticket is drawn from a sack and then taped to the item. Buyers then come by and check the tickets to see if they are a lucky winner. This is pretty simple, and there will be more information posted at the conference as to price, frequency of drawings, etc.

So, what makes it work? The short answer is "item donors and ticket buyers". You can help in both ways. Bring stuff to the conference to donate to the IITH table. This may be a piece of tool steel that you don't need, an extra pair of tongs (I know, NOBODY has an extra pair of tongs), supplies such as flux, rivets, old files, new files, etc. When you go to the hardware store and you see a set of screwdrivers, for example, on sale at a ridiculously low price, buy it and bring it to the conference for IITH. I have already had folks drop donations off with me so it's not too early to think about what you want to donate. Each year I manage to bring a few things and I used to wonder what would be appropriate. It finally hit me that if I would be interested in a certain item, chances are somebody else would be interested in it, too. So now when I'm standing at the bargain bin at Harbor Freight, I buy things that I'd like to have. Simple stuff like epoxy, sandpaper, soapstone, steel tapes, etc are always welcome.

So, we've talked about donors. The other part of the deal that makes it work is buyers. Even if you show up at the conference without anything to donate to IITH, you can buy tickets. They will be on sale by several sellers. You can't win if you don't play.

Not everybody who comes to the conference brings donations. Not everybody who comes buys tickets. Not everybody who buys tickets wins something but every little bit helps raise a buck for the association. It's not cheap to put on a conference and we've managed to keep registration fees low for many years. Think about this: if 100 conference attendees buy \$10 worth of IITH tickets, that's \$1000 that can go a long way toward paying for demonstrators, travel, materials, etc.

(This article is being repeated by request from the August 2018 Newsletter - Editor)

Blacksmith Tools Stolen!

Philip Simmons Artist Blacksmith Guild - (PSABG) South Carolina

I recently received a notice from Saltfork member, Jim Carothers, who moved to South Carolina not long ago to be with family:

“We’ve had some guys here in the Philip Simmons Artist Blacksmith Guild that have been robbed of all their smithing tools – hammers, tongs, punches, special tooling, etc... If you think members of Saltfork would be up for helping out, contact the PSABG.”

PSABG newsletter Editor, Barry Myers, provided this additional detail on the matter:

“Russell, thank you for your concern. Our guys, Ed ‘Curly’ Lawson and Pat Walters had all of their blacksmith stuff taken from their shop. I know little more than that, other than they seem devastated. Pat did say he still has his tool box, hacksaw, soapstone holders, rulers, bees wax-finishing waxes/oils, fire tools, grinding wheels, Sounds pretty bleak.

Some of our members have sent donations of money and others have said they plan to make tools...”

At the current time, there is no detailed list of tools being donated. If additional information becomes available, I will provide a newsletter update.

It seems like we have been asking for a lot of donations lately with the 2020 Saltfork conference being canceled and the 2021 conference almost here. But Saltfork members are a generous bunch. If you would like to help out, you can send donations (or contact for additional information) Ray Pierre with the PSABG:

Ray Pearre, PSABG Secretary/Treasurer
4605 Durant Ave
North Charleston, SC 29405

843-860-5529

Email: pearrecre@gmail.com

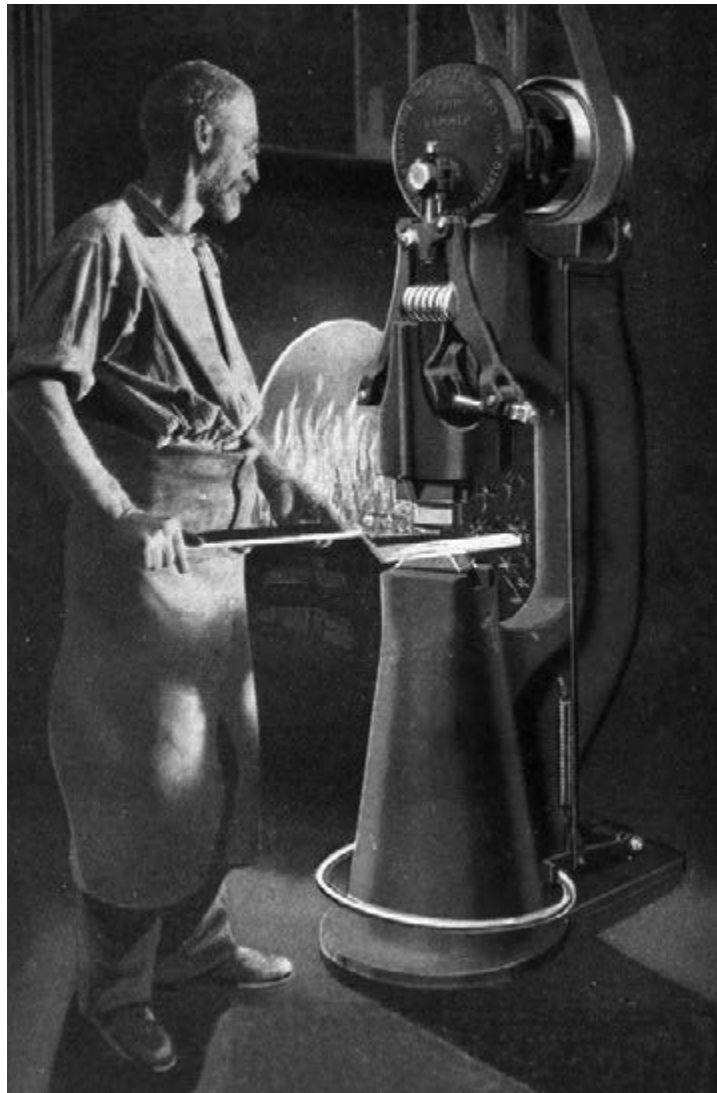
Thanks!

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

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

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

- Doug Klaus



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

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

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

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

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

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

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

No experience is required to attend this class. Past students have ranged from age 15 to 90, and from all walks of life. Anyone who wants to learn will benefit from this class. We approach the rebuilding process using tools that can be found in the average home workshop. If you are in the market to buy a power hammer, this class will make you an educated shopper. If you already own a Little Giant, or any other brand of power hammer, this class will teach you how to get the best performance possible.

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

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

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

Name: _____
Business name: _____
Address: _____
Telephone: _____
Email address: _____

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

POWER HAMMER INFO

Brand: _____
Size: _____
Serial Number: _____

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

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

Around the State...

NW Region July Meeting: No meeting was held.

NE Region August Meeting: On Aug. 7th, the NW District of the Saltfork Craftsmen had their monthly meeting at the Cherokee Strip Museum.

It was also “Family Day at the Museum.” We had wonderful weather and a great crowd came out and had a fun day of cake walks, sack races, rope making, gun fights, Rose Hill School mini sessions and of course some hammering. We had guests from OK, KS, TX and NC and they represented 30 different towns. Roadside Grill from Glencoe came and offered some mighty fine food.

I was busy with all the activities that day but the blacksmith shop looked like it was full most the day!

As always, thank you all for coming out and showing off your talents! - Diana Simon









Around the State (Continued)...

SE Region August Meeting: No meeting was held.

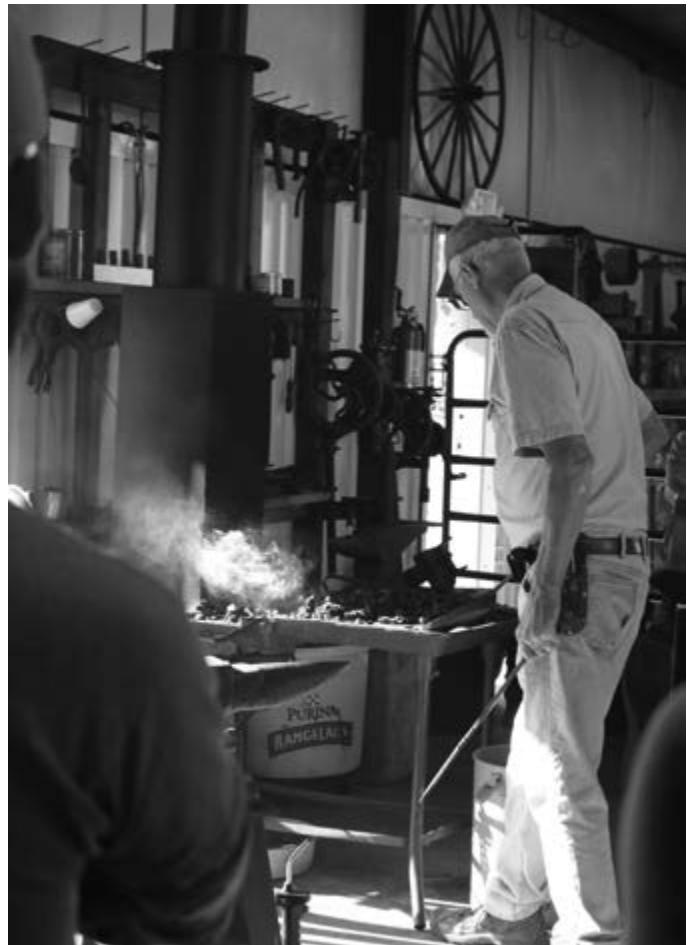
SW Region August Meeting: No meeting was held.

Beginner Blacksmith Workshop (July 31st):

The Beginner Blacksmith Class in Elk City went very well. We had more than a full class and scheduled a follow up class for the overflow.

It was a hot day but the evaporative cooler fan helped and everyone hung in there for a full day of forging. Everyone seemed to have a good time and I hope they carry on with their new trade or hobby.

I want to thank everyone who helped with the class and the meal. I also want to thank the Elk City Museum for providing a place to have the class. - Mandell Greteman















Member Gallery

Farrier's Hoof Knife by Gerald Franklin

Experimental hoof knife prototype made with steel from a circular saw blade.



Intertwined Horseshoe Hearts by Everett Timmons

Made by Everett Timmons (Borger, TX) for his son's wedding.



Create A Variable Axis Rotating Table (VART)

H. Kent Hepworth - Powell, Tennessee

(Part Two)

(Continued from Part 1 in the August, 2021 Saltfork Craftsmen Newsletter)

2) Construction of Hub/Spindle & Table Platform Sub-Assembly:

Figure 5 illustrates the original trailer 5-Lug Hub/Spindle and completed **Hub/Spindle & Table Platform** sub-assembly. Note: if a different hub/spindle is used modify the spindle, as required, to fit Spur Gear (Item C) and Table Platform (Item A).

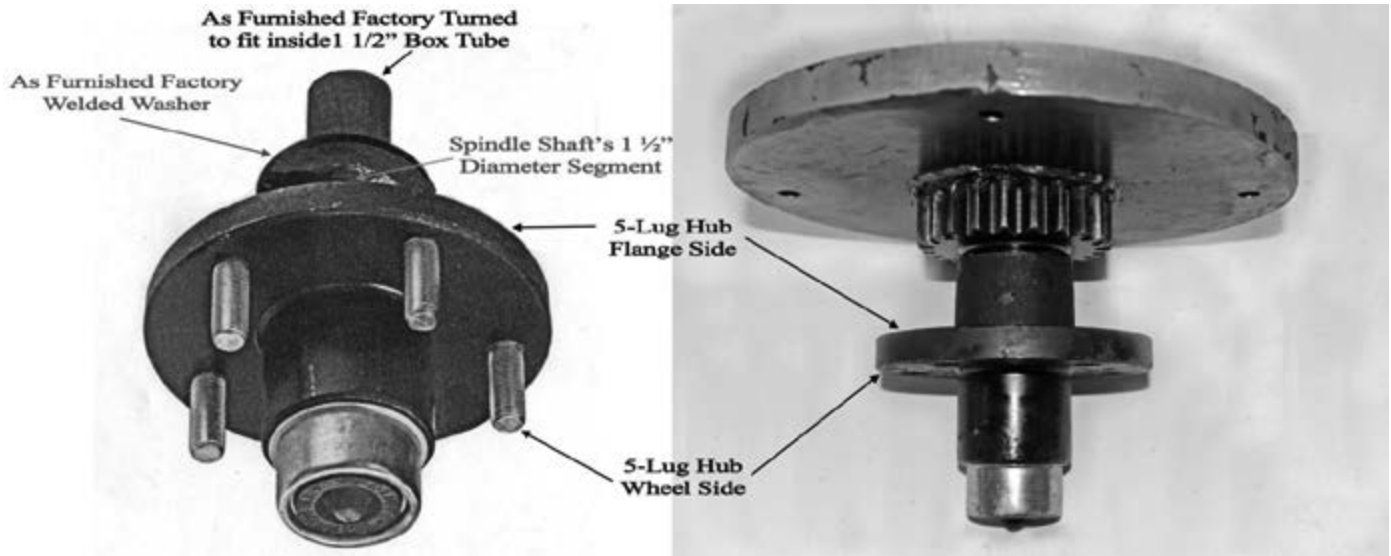


Figure 5
5-Lug Hub/Spindle and Hub/Spindle & Table Platform Sub-Assembly

- 1) Modify 5-Lug Hub/Spindle Assembly (Item G) (Figure 5):
 - a) Disassemble the 5-lug hub/spindle assembly (see Figure 6);
 - b) Cut-off *Factory Turned to fit inside 1 1/2" Box Tube* to the spindle shaft's 1 1/2" diameter segment welded washer;
 - c) Grind factory welded washer's diameter to match spindle shaft's 1 1/2" diameter.
- 2) Align and center the Spur Gear (Item C) axis with the spindle shaft's 1 1/2" diameter segment axis. Located hub side of spur gear to be flush with spindle shaft's step-up 1 1/4" seal to 1 1/2" segment (Figure 6).

Notes:

- a) Spur gear will extend beyond the spindle shaft's 1 1/2" diameter segment; also, the spur gear's bore is ~1.60" requiring shims for alignment & centering of axes and to constrain components for welding.
 - b) Step 3.1) in the **Forming the Table Lock Mechanism** should be completed before proceeding. This will reduce the effort in the forging and upsetting process in forming the Lock Bar's "involute engagement tooth."
- 3) Weld the spur gear to the spindle shaft all around exposed side and the cut-off end of the spindle shaft (step 2.1.b) (see Figure 6).
 - 4) Scribe a 12" diameter circle on the 7/8" Table Platform (item A). Using a plasma or "oxy/fuel" cutting torch cut the 12" circular disk and finish grind its edge.

Decision time- "Clamping System:" the following assumes the use of a four (4) clamp system (Items J, K & L) for holding down materials undergoing the processes of: chasing, repoussé, piercing, engraving, etc..

- 5) For clamping using Items J, K & L or similar components: On Table Platform scribe an 11" diameter circle and center punch at four (4) equal spaced locations.
- 6) Using a 27/64" drill and with a 1/2"x13 tpi tap at all four (4) locations.
- 7) On the hub side center of the Table Platform locate the spur gear and spindle assembly (Step 2.3). Insure the axis of each member coincide then weld securely (see Figure 6).
- 8) Reassemble the hub and spindle components to complete the Hub/Spindle and Table Platform sub-assembly (Figure 5)



Figure 6
Disassembled Hub/Spindle; Welded Spindle, Spur Gear and Table Platform

3) Forming the Table Lock Mechanism

- 1) To minimize Table Platform lock-up “play,” form an “involute engagement tooth” profile on one end of the Lock Bar (Item c).
Suggested process (see Figure 7):
Note: An “oxy/fuel” torch provides a convenient localized heat source.
 - a) Cut 3 1/2" length from 3/4" Square Bar (Item c).
 - b) Forge a rough “rectangular tooth” profile on one end of the Lock Bar.
 - c) Clamp spur gear in vice then “upset” the rectangular tooth using the gear’s teeth to form an “involute engagement tooth” on one end of the Lock Bar.”
 - d) Grind Lock Bar to: i) overall length ~3 3/4"; and, ii) original 3/4" square bar profile.

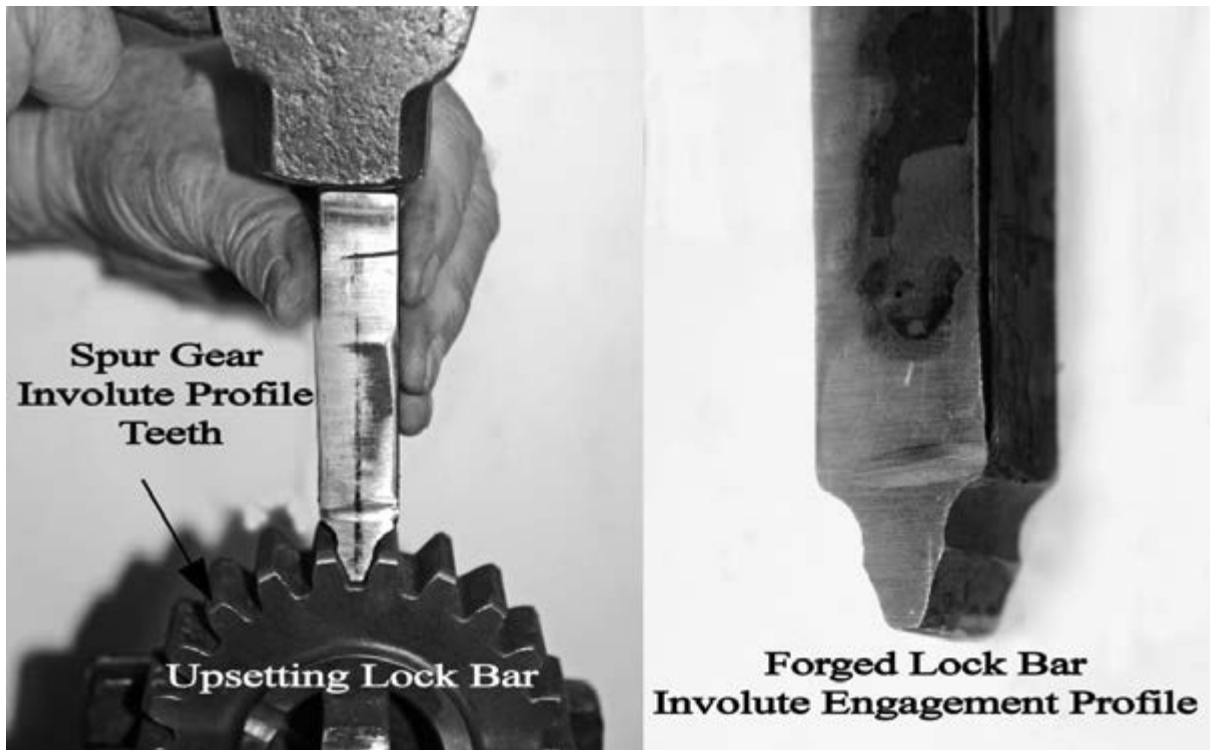


Figure 7
Upset Forging of an Involute Engagement Tooth Profile

- Notes: 1) There is substantial latitude in the fabrication of the elements comprising the Table Lock Mechanism (Figure 8). 2) Friction is sufficient to hold the lock mechanism in its “lock” or “free” positions. 3) Adjust mechanism’s friction by tightening three (3) screws (Items h, i and j) then fixing with lock nuts.
- 2) Lock Bar’s Extension: Cut 1” length of $\frac{3}{8}$ ” Square Bar (Item d). $\frac{1}{4}$ ” from end with #21 bit drill then tap #10-32 tpi then grind end profile. Offset the extension (see Figure 8) and weld perpendicular to Lock Bar.
 - 3) Mounting Bracket: a) Cut a $2\frac{3}{4}$ ” length of $2\frac{1}{2}$ ” x $2\frac{1}{2}$ ” x $\frac{1}{4}$ ” angle iron (Item a).
 - 4) Lock Bar Guide: Cut a $2\frac{1}{4}$ ” length of 1” 12 Gauge Square Tube (Item b).
 - 5) On a welding table’s edge place angle down the angle iron Mounting Bracket and locate Lock Bar Guide extended 1” and weld (Figure 9). Locate Lock Lever’s pivot: $\frac{5}{8}$ ” above and $\frac{3}{4}$ ” from outside corner, with #8 bit drill then tap $\frac{1}{4}$ ”x20 tpi.
 - 6) Lock Lever: Cut a 10” length of $\frac{3}{4}$ ” x $\frac{3}{16}$ ” Lock Lever (Item e). Illustrated on Figure 8:
 - a) $1\frac{3}{4}$ ” from end form 90° angle bend, center punch to locate pivot at bend’s center;
 - b) $1\frac{1}{2}$ ” from pivot towards short end, center punch to locate Transfer Link connection;
 - c) Pivot center point: drill $\frac{1}{4}$ ” clearance hole for $\frac{1}{4}$ ”x20 tpi screw (Item h);
 - d) Transfer Link connection: drill #10 clearance hole and counter bore for flat head #10x32 tpi screw (Item j);
 - e) Profile both ends of Lock Lever and bend long end to suit
 - 7) Transfer Link: Cut $2\frac{3}{4}$ ” length of $\frac{1}{2}$ ” x $\frac{1}{8}$ ” Transfer Link (Item f). Illustrated on Figure 8:
 - a) Profile both ends of rotary to linear Transfer Link;
 - b) At link’s center form a $\frac{1}{4}$ ” off-set;
 - c) $\frac{1}{4}$ ” from Lock Lever end, with #21 bit drill then tap #10x32 tpi (for Item j);
 - d) $\frac{1}{4}$ ” from Lock Bar Extension end, with #10 bit drill and counter bore for a flat head #10x32 tpi screw (Item i).



Figure 8
Table Lock Elements and Assembly

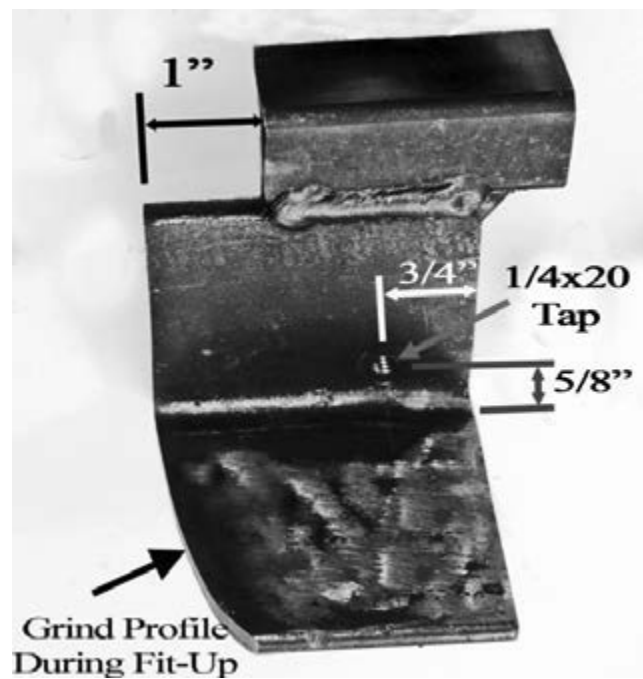


Figure 9
Mounting Bracket and Lock Bar Guide

- 8) Assemble the Table Lock Mechanism sub-assembly as shown on Figure 8. Adjust all elements to perform through their operational range.
- 9) Fasten the Hub/Spindle & Table Platform sub-assembly to the Top Plate with five (5) lug nuts using a “crisscross” pattern to uniformly tighten nuts. Choose a candidate position for the Table Lock Mechanism, (Figure 11); configure as:
 - a) Mounting Bracket’s vertical edge located flush with the Top Plate’s edge;
 - b) Lock bar’s involute engagement tooth is fully meshed into spur gear teeth;
 - c) Outline with a “Sharpie” pen the Mounting Bracket’s position on Top Plate; also, mark horizontal overhang on Mounting Bracket; remove then grind away overhang (Figure 9).
 - d) Return Table Lock Mechanism to its marked position to insure positioning and functioning are satisfactory (i.e. Lock Bar’s involutes match and are fully engaged in “lock” and fully retracts in its “free” positions).
- 10)
 - a) Mark two (2) mounting locations on Mounting Bracket base.
 - b) Remove the Table Lock Mechanism.
 - c) Center Punch mounting locations on Mounting Bracket and with a Letter Q bit (a $\frac{3}{8}$ ”x24 tpi tap drill) bore two (2) holes;
 - d) Replace Table Lock Mechanism in its outline position on Top Plate then securely clamp in place. Check mechanism’s functioning and adjust if necessary.
 - e) Maintaining Table Lock Mechanism firmly clamped position on the Top Plate remove Hub/Spindle & Table Platform sub-assembly. With the Mounting Bracket as a drill jig bore using a Letter Q bit two (2) mounting holes in the Top Plate.
 - f) Remove the Table Lock Mechanism and tap $\frac{3}{8}$ ”x24 tpi the Top Plate’s two (2) holes.
 - g) Enlarge Mounting Bracket’s existing two (2) Letter Q holes to clear $\frac{3}{8}$ ”x24 tpi mounting bolts (Item g) by boring with a $\frac{3}{8}$ ” drill.
 - h) Check functioning of the locking mechanism by reinstalling the Table Lock Mechanism and Hub/Spindle & Table Platform on Top Plate. Remove both sub-assemblies.

Welding 1/2” Hemisphere’s Top Plate to 12” Hemisphere Base:

All fabrication steps for the Top Plate (Item B) and Hemispherical Shell (Item F) are now complete. To form the hollow Hemispherical Base sub-assembly it is important in preparation for welding to insure the fit of the Top Plate (from Step 1.7) to the 12” hemispherical shell (interior diameter $\sim 11 \frac{3}{4}$ ”) [from Step 1.1] (Figure 10). In Step 1.3 the Top Plate’s “exterior face” was ground to a $11 \frac{7}{8}$ ” diameter with an inward 10° taper (“interior face” $\sim 11 \frac{9}{16}$ ” diameter). Protect the Top Plate’s five (5) stud’s threads with their lug nuts then lay the Top Plate “exterior face” down on the welding bench. Overlay the hemispherical shell on the Top Plate equalizing its overlap all around the Top Plate’s periphery. Firmly seat the overlap with decisively taps on the hemispherical shell with a wooden mallet.

Carefully turn over the assembly to prepare to weld the sub-assembly. To minimize heat induced warping, weld ~ 1 ” sections in a “crisscross” manner until the joints perimeter is fully welded (the “stitched” pattern can be masked with a “weave” welding pass). Figure 11, illustrates the assembled welded Hemispherical Base and Table Lock Mechanism sub-assemblies located on a spherical-sector ball joint wood stand.



Figure 10
Assembling Hemispherical Base with the Completely Fabricated Top Plate

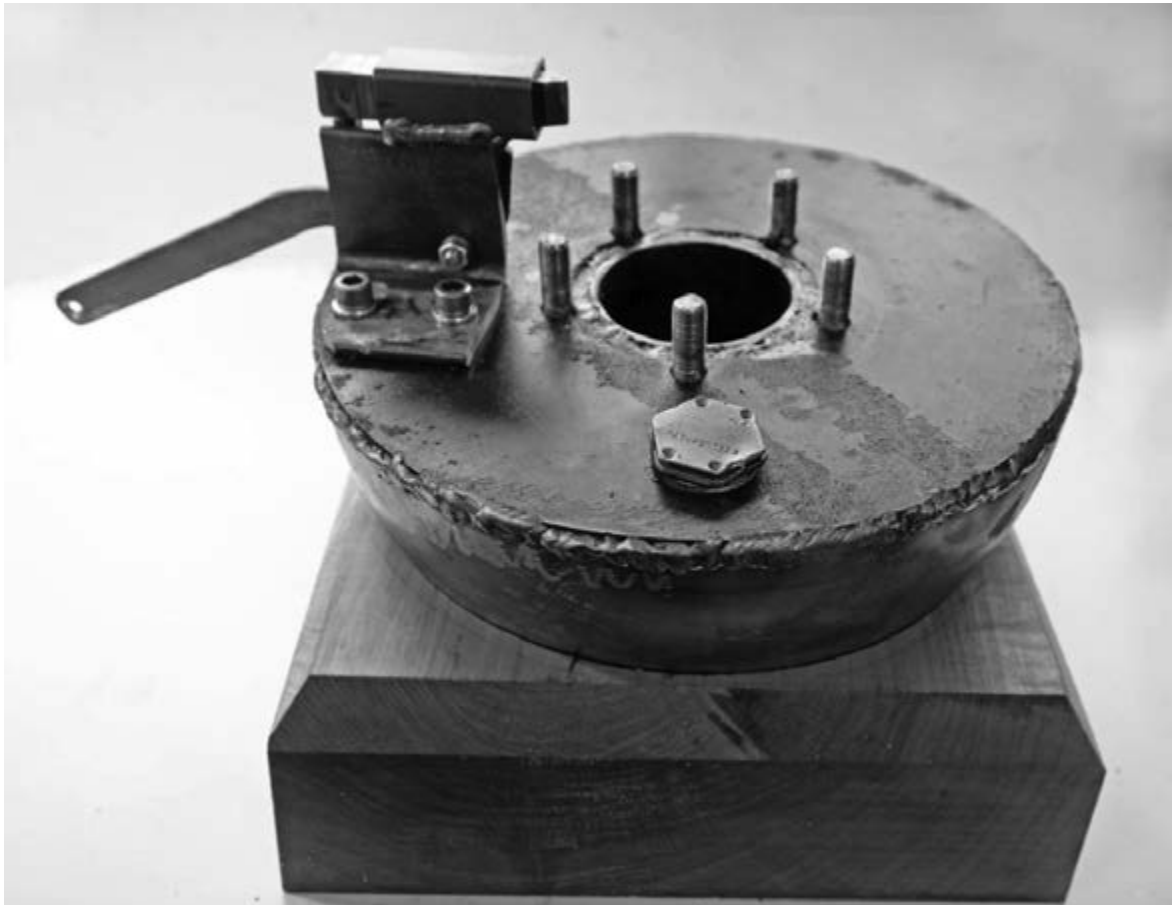


Figure 11
Hemispherical Base, Table Lock Mechanism, and Wood Ball Joint Stand

Concluding Remarks

As discussed earlier lowering of the VART's CG will provide a more stable table platform. This is accomplished by adding ballast into the cavity of the Hemispherical Base. Candidate ballast materials are: lead (710 lbs/ft³) or steel (484 lbs/ft³) in a pellet form (or substitute an alternative "heavy pellet"). Lead or steel pellets (termed "shot") are readily available in bulk packages from sporting goods stores and are sold as a shotgun shell reloading component (suggestion: use a smaller size shot such as #6 or #8 "bird shot"). The 12" VART fabricated in this article has 25 pounds of #8 "chilled lead" shotgun shot. Operating experience indicates this ballast quantity appears adequate. However, even with this quantity of lead ballast there remains a large void space in the hemisphere's cavity allowing for additional ballast to be added if needed for "heavier work."

Discussions with Ernie Dorrill noted his VART version has a 9" hemispherical base and table platform and it does not include a locking or braking system (however, his can be modified to include a band brake assembly). He noted that to date his repoussé, chasing and piercing applications have not required a separate brake/lock system. When additional table platform rotating resistance is needed Ernie just increases the pre-load on his VART's axle bearings.

There remains one additional sub-assembly to make this VART tool complete. That sub-assembly is the Ball Joint Stand. As shown on Figures 1, and 11, this VART's Ball Joint Stand is a 6" radius spherical-sector turned into a wood 12" square 4" thick Maple plank. Its fabrication is beyond the scope of this article since we are blacksmiths. My initial Ball Joint Stand was a 5" length of standard wall steel pipe (8 5/8" outside diameter and 8.071" inside diameter). This simple stand was satisfactory for light repoussé and chasing work; but, for heavier applications proved to have insufficient ball joint friction. Other VART tools I have observed used lawn mower tires as their Ball Joint Stand; however, according to Ernie this choice for all but smaller diameter hemispheres (8" or less) does not provide adequate support for heavier repoussé and chasing applications (i.e. allowing "rebound"). Obviously, since the inception of repoussé, chasing and piercing its practitioners have been using hemispherical bowls (filled with pitch, lead, etc.) perched on sandbags and other supports (for examples see: Corwin, Nancy Mēgan; **Chasing and Repoussé**; Brynmorgen Press; Brunswick, Maine; 2009; ISBN 978-1-929565-32-0; pp 33-34). As I think about other stand options, it occurs to me a blacksmith could forge a heavy tool steel chisel and use it to carve a suitably deep 6" radius spherical-sector in a wooden stump to serve as a Ball Joint Stand for their VART tool (I'm glad I didn't think of this option earlier!).

Acknowledgements

Appreciation is expressed to Peter Renzetti for the VART tool concept, its components and assemblies fabrication ideas. Ernie Dorrill showed the attendees of the 2009 AFC Conference the utility of the VART tool and that this tool is an asset for repoussé, chasing, piercing and engraving applications for blacksmithing, whitesmiths and bladesmiths. Special appreciation is expressed to Ernie since he serves as a mentor and provides inspiration for my journey into the repoussé, chasing and piercing aspects and the Gothic and Renaissance period of our blacksmithing craft!

*Special thanks to Mr. Hepworth for submitting this article for publishing in the Saltfork Craftsmen newsletter!
See more about the author on the following page - Editor*

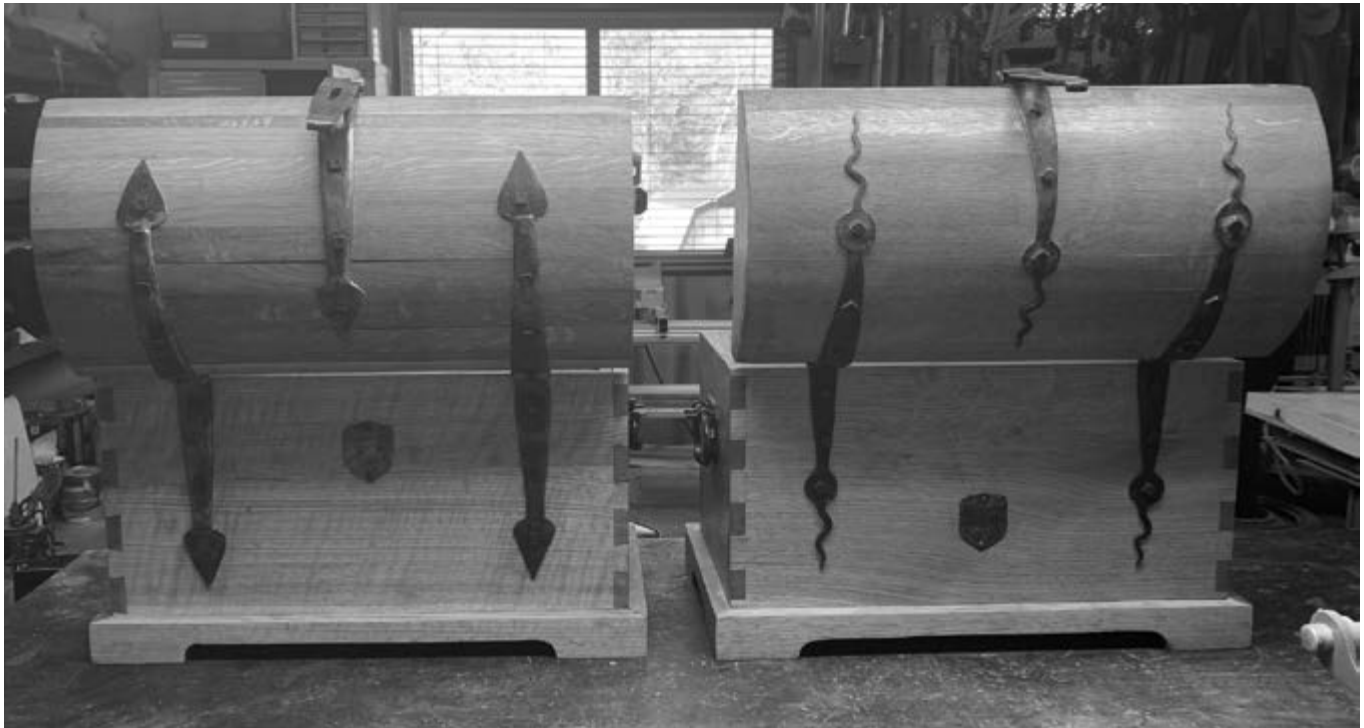
About the Author (H. Kent Hepworth):

You may recognize H. Kent Hepworth's name as the producer/editor of numerous high quality blacksmith and bladesmith related DVDs distributed by several blacksmith organizations and the American Bladesmith Society (ABS.)

Kent grew up in Muskogee, Oklahoma and attended Oklahoma State University before graduating from Arizona State University with a Ph.D. in Mechanical Engineering in 1968 and eventually retired in 1996 as an Emeritus Professor of Mechanical Engineering from Northern Arizona University. He spent 33 years (from 1979 to 2012) contracting and consulting with the Department of Energy at Oak Ridge, Tennessee, involved mainly with nuclear projects. Kent is a registered Professional Engineer licensed to practice in Arizona and Tennessee. He has authored a number of articles published in technical journals during his engineering career.

Kent moved to Tennessee in 1994 and picked up the hobby of blacksmithing. While attending regional and national smithing conferences, he began to video demonstrations for his own use. Soon, blacksmithing cohorts were asking for copies and Dr. Jim Batson asked him to video and produce DVDs for the ABS. You can find many titles that Kent produced from the ABS, Alabama Forge Council (AFC), Southern Ohio Forge and Anvil (SOFA), Southeastern Blacksmith Association (SBA), Blacksmith Association of Missouri (BAM), ABANA, and others.

Kent has a passion for preserving and sharing good blacksmithing techniques and skills. The following is a sample of some of his blacksmithing work and some projects that can be done with the VART tool:



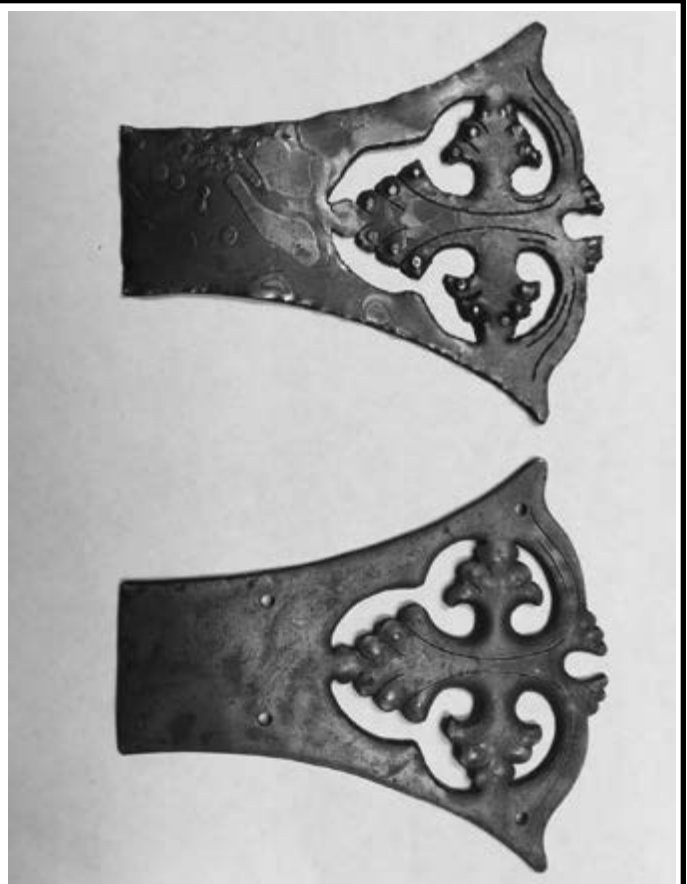
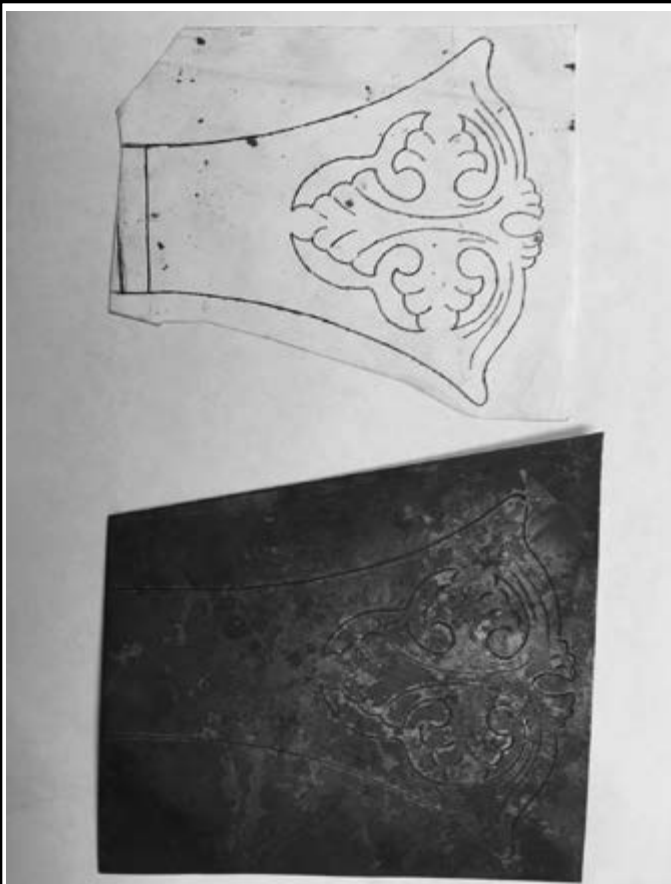
These are two "Pat McCarty" designed chests I constructed. The first was built at a "2010 John C. Campbell Folk School work shop." I have two children (now adults) and I overheard them arguing who was going to "inherit" the chest. So I constructed a second during 2019. The wood is "quarter sawn" White Oak and all the hardware was smithed by yours truly.



Gothic lamps "smithed" based on Ernie Dorrill's AFC 2013 Workshop. It is similar to Carl Close's table lamp (Carl's was larger and the shade was more complex and exotic!). Mine required about Four (4) years for me to complete. Why do long? I required several 'sabbatical leaves' to resolve how to resolve issues!



"Reindeer Bell" several made as Christmas gift for my wife and kids (chasing done while flat, using VART, before forming)



Ernie Dorrill "sheet metal chased, repousse and pierced kitchen hinge" using VART for chasing.



Ernie Dorrill inspired candle sticks (several made as Christmas gifts for wife and kids)



An unfinished lion's head mounted on the VART.

You can find out more about the candle holders and the other "Ernie Dorrill" projects shown here by purchasing the Alabama Forge Council 2009 Conference DVD set of Ernie demonstrating at Tannehill. If this kind of work interests you, I highly recommend this set. Visit the AFC website for contact info to purchase the set:

<http://www.alaforge.org/DVDs.html>

Thanks Mr. Hepworth for sharing photos of some of your work! - Editor





ABANA'S Education Committee Announces the National Curriculum

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

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

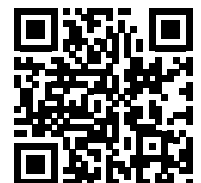
What is the National Curriculum? The NC is a departure point for those that seek a structured program of study that can be used at schools, conferences, meetings, and individual shops through one on one, small groups and self-guided study.

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



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

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



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

THE CALIFORNIA BLACKSMITH ASSOCIATION LEVEL III GRILLE (PART 3)



Upset Square corners (Part Three) Mark Aspery

I think that it is important to look at some of the pitfalls associated with this process before we look at forging the upset square corners needed in the grille or curriculum.

Over-bending

After you have bent the bar to start the corner, there will be a radius on the inside of the corner. As you upset the corner, this radius will become smaller and tighter. As a general rule, you can close the corner, but you cannot open it without forming cracks on the inside of the bend. The sharp inside radius will act as a stress riser and will tear or crack upon opening. Fig. 1.

When you make your initial bend for the corner, make the inside of the bend open of 90°, I would say something in the region of 110° to 115°.

As you work up the corner, maintain this open angle. This will mean matching the angle of the arm with your hammer face. If you fail to match the angle you run the risk of bending the corner past 90° and inducing a crack. This can be true even if you are holding the arm of the corner open with a pair of tongs while working in the vise.

Another factor of over-bending the corner is that you can arrive at a sharp inside corner before you have finished the outside of the corner. The result of finishing the outside corner drives the two sides that make up the inside corner past one another, causing a crack.

Over-forging

As you work up the sides of the corner towards the center punch mark in the bar, take care not to extend one side past the center-punch mark. There isn't much recovery from this action. Remember that the punch mark will fall on a 45° line from the inside to the outside of the corner. Fig. 3.

It is better to work equally on both sides of the punch mark and 'sneak up' on the corner.

What will also come under the heading of over-forging will be the delivery of blows that are too powerful: the force of the blow traveling past the corner into an arm of the material and upsetting that portion of the arm that holds heat.

Use light, rapid blows as you upset the corner. Remember you want a local upset within the corner only.

I work on the outside of the corner knowing that the energy of the blow will be used up as it travels through the corner. If you direct your blows onto the end of the arm, your energy is entering the bottom of the corner from the arm, with the effect of your blow being expended in the arm material first, rather than the corner material.

Match the hammer face to the arm

By holding the hammer at the angle of the arm that you are working on, you won't bend that arm and cause a closing of the corner angle to less than 90°. Fig. 2.

Location of the hammer's blow

The center of the hammer should not pass the inside edge of the opposite arm of the corner. If you allow the center of the hammer to pass the inside edge, you run the risk of chasing the corner with the hammer and thinning the corner material as you develop the sharp outside edge. Fig. 4.



Fig. 1. The bend has been taken too far. It is past the 90° position



Fig. 2. Hammer not aligned with arm. The toe of the hammer is causing a bend in the bar

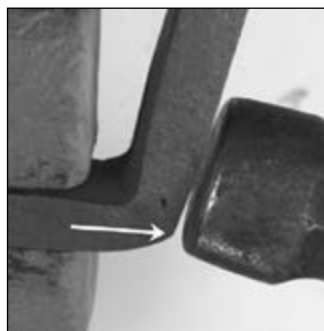


Fig. 3. Flat of arm extended too far. The punch mark will not be in the middle of the corner

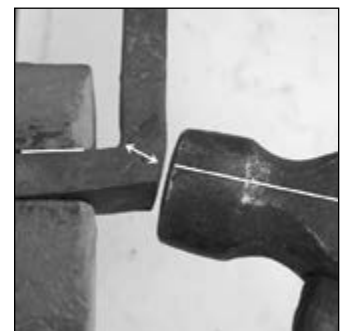


Fig. 4. Center line of hammer allowed past inside edge of opposite arm. The corner has been thinned

UPSET SQUARE CORNERS

There are two upset corners in each quadrant of the grille. They are spaced just far enough apart to be inconvenient.

I am going to mix and match my techniques for these two corners. The first corner I will work up solely at the vise. The second corner I will bend at the vise, working one arm. The other side of the corner I will work at the anvil.

The CBA Level III Curriculum calls for the use of scrolling wrenches (*CBA -level II*). You will need a scrolling wrench with about a $\frac{3}{4}$ " to 1-inch gap to make the initial bend at the corner, if you are going to use the vise.

The first step in making an upset corner at the vise is to position the stock horizontally in the jaws with the center-punch mark sticking out to your hammer hand side. The question is, "How far should the mark be from the edge of the vise jaws?" Fig. 6.

To determine this distance, place your scrolling wrench onto a piece of $\frac{1}{2}$ -inch square material and engage both tines of the wrench. Use your rule to measure the distance of the outer corner from the $\frac{1}{2}$ -inch square stock. This is the distance the center-punch mark has to be from the edge of the vise. This allows you to bend the material at the side of the vise without the scrolling wrench contacting with the jaws of the vise and interfering with the initial bend of the corner. Fig. 5.

Don't hold the stock any further than you have to from the side of the vise, as you will make a very lazy initial bend in your bar; something that you will have to correct as you work up the square corner.

I place the scrolling wrench upside down on the bar, as that helps reduce my tendency of pushing the bar down towards the floor as I make the initial bend.

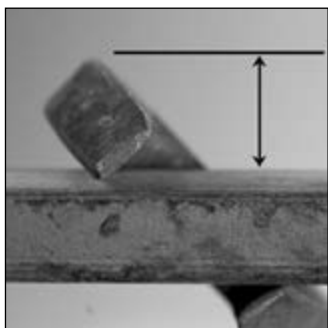


Fig. 5. Measure the height of your scroll wrench when applied to the bar

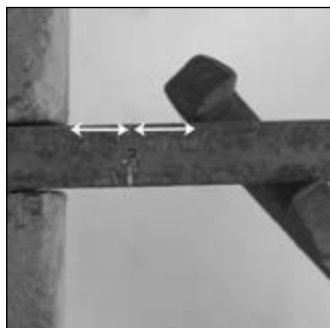


Fig. 6. Center-punch mark is height of scroll wrench from side of vise

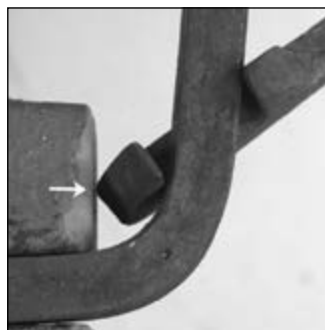


Fig. 7. Bend is correct. Note how scrolling wrench is touching the vise jaws



Fig. 8. Start the center of the hammer at the bottom of the straight section of arm

Push the bar away from you as you make the bend, leaving it open of 90° . I make my bend angle about 115° measured on the inside corner. Fig. 7.

Bending the bar away from you will allow you to pull material into the bend with the natural arc of your hammer swing as you work up the corner.

To prevent the corner from closing while I upset the material at the corner, I grasp the end of the bar with a pair of tongs.

Match the face of the hammer to that of the open arm of material.

Deliver light, rapid blows, starting at the bottom of the straight section of the arm. As you work, the bend should tighten with the length of the straight section of the arm increasing. Move your hammer down the bar so that the hammer is centered at the bottom of the straight material on the arm. Fig. 8.

Maintain the hammer angle and resist the tendency to bring the hammer to 90° of the other arm (locked in the vise). Doing so will close the corner angle and may cause cracking at the inside corner. Fig. 2.

Extend the flat section of the arm until it nears the center-punch mark. Bear in mind that the punch mark will be on a 45° angle from the inside to the outside of the square corner. Fig. 9.

As you close in on the corner, do not allow the center line of the hammer to pass the inside edge of the opposite arm.

Take another heat and turn the bar around in the vise so that the arm originally held in the vise is now pointing away from you and held by either tongs or your hand.

CALIFORNIA BLACKSMITH ASSOCIATION



Fig. 9. Extend the flat to just about level with the center-punch mark

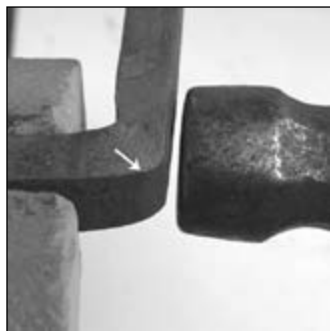


Fig. 10. When working the other side use the flat from the other side as your guide

Repeat the same process. Match the arm angle with your hammer while delivering light, rapid blows.

You will not have the center punch mark to guide you this time (it'll be on the bottom of the bar). You will have to look at the bottom of the flat section of the other arm for guidance. Fig. 10.

Do not meet the flat section of the other side; leave a gap and develop the other side of the corner first.

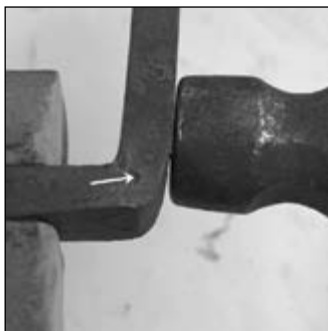


Fig. 12. Remove any bends before continuing with first side

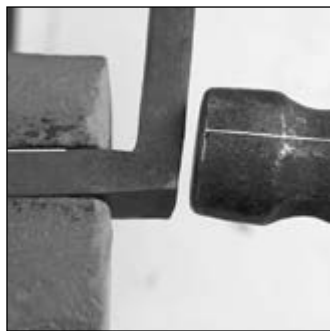


Fig. 13. After correcting for a growth in thickness at the anvil, carry on with side 2

Again, do not allow the center line of the hammer to pass the inside edge of the opposite arm.

Take another heat with the outside corner of the bar held down in the fire to localize the heat.

At this stage you should have a bar that is quite a bit thicker than the one you started with. I would take the time now to dress this increase in thickness at the anvil.

Work the original side of the upset corner. Straighten any bending. The center-punch mark should now be closer to its final resting place and can better serve to guide you as you finish the corner. Fig. 12.

As with most things, it's the last 10% that takes most of the work. You are now having to upset the full cross-section of the bar with minimum straightening taking place.

Be patient and don't let the hammer migrate towards the corner or you'll thin the stock at the corner. Fig. 13

Because this corner will lead directly into a scroll, it is left open of 90°.

If the corner wasn't leading into a scroll, the last thing you would do after you are happy with the upset is close the corner to 90°.

The second corner is started in the same manner. Due to the close proximity of the second corner to the first, only one side of the corner can be worked up in the vise, with the stock held horizontally.

You could of course work vertically in the vise with a set of vise jaws in place to prevent galling of the bar material.



Fig. 14. The second bend can be made accurately at the vise



Fig. 15. Extend the flat down to level with the mark and then move to the anvil

Clamp the long arm of the corner into the vise in such a way that you have to bend the material away from you to start the bend. Fig. 14.

Work up that side of the corner in the vise. Fig. 15.

To work up the second side of the corner I'm going to work vertically at the vise when I can and work at the anvil the remainder of the time.

Working from the top side of the corner is a very strong move, as the bar is now supported by the anvil. You will require fewer blows than you did before at the vise to achieve the same result.

ABANA Affiliate Newsletter - July 2021

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

Iron to Art Festival Tickets are on Sale:

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

- Member registration: After 8/30 (late registration) \$165.00
- Member Spouse registration: After 8/30 (late registration) \$75.00
- Non-Member registration: After 8/30 (late registration) \$245.00
- Non-Member Spouse registration: After 8/30 (late registration) \$90.00



ABANA would like to interest you in being a Craft Vendor at Iron to Art Festival: This is our inaugural event in Johnstown, PA and ABANA wants you!!!!!! We are expecting 500 + visitors to

ABANA Affiliate Newsletter (Continued...)

the conference with 5000 visitors to Johnstown itself over this new 3 DAY EVENT and ABANA wants YOU to get in on the action. Rent a 12x12 vendor booth for the low cost of \$250 (for all 3 days), comes with electricity and if you're performing live demonstrations for your craft you will receive an ADDITIONAL ½ space for free to showcase your skills. There will be visitors and exhibitors from far and wide, what a perfect venue to showcase your crafts and passions. See ABANA.org, Iron to Art, then click on the vendor icon and we will SEE YOU THERE!!

The Artist-Blacksmith's Association of North America is holding a special 'Affiliate's Day' on the last day of the Iron to Art Festival in Johnstown, PA on Saturday, October 16th. This day is open to the general public and ABANA expects over 1,000 attendees.

ABANA will provide to affiliates:

A table for each affiliate organization to put information out and sell small items

If a group would like to hold a membership meeting during that day, ABANA will arrange a meeting room

We ask affiliates to 'fly their banner' at the festival! Bring a banner and ABANA will hang the affiliate's banner at the festival

This is a great way to raise awareness for your organization, increase membership, provide opportunities for your members to sell their work, and meet to enjoy this inaugural blacksmithing event!

For planning purposes, affiliate leaders should email ABANA's Executive Director, Janie Grela at exedir@abana.org to reserve a table and list members who plan to attend. The general admission on Saturday is \$10 per person which should be reserved in advance on ABANA's website www.abana.org

A Reminder about ABANA Membership Options and Pricing:

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

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

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

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

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

The office has received a few checks in the mail using old forms which feature pricing and options no longer available. For example, the two-year membership option is no longer available.

ABANA Affiliate Newsletter (Continued...)

We regret any confusion this has caused to our valued members!

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

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

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

Membership benefits include:

Publications: Four quarterly issues of the Anvil's Ring

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

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

Eligibility for education grants and scholarships

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

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

Participation in ABANA Board committees

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

NEW AFFILIATE ALERT!!!!

ABANA would like to welcome Rutherford County Blacksmith Association from middle Tennessee as our newest Affiliate group. Welcome Ron and Association.

ABANA is creating a touchmark registry:

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

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

SCABA Shop and Swap

2021 Conference T-Shirt

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



Back of T-Shirt



Pocket

There are two shirts to choose from this year.

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

Port & Company[®] Tall Core Blend Tee. PC55T

Sizes range from Large Tall to 4X Large Tall.

COLOR INFORMATION										
Aquatic Blue PMS 2389C	Ash PMS COOL GRAY 3C	Athletic Heather PMS COOL GRAY 7C	Athletic Maroon PMS 209C	Carolina Blue PMS 7682C	Charcoal PMS COOL GRAY 11C	Dark Green PMS 560C	Dark Heather Grey PMS 7540C	Desert Sand PMS 2224C	Jet Black PMS NTR BLACK C	Kelly PMS 340C
Light Blue PMS 278C	Lime PMS 367C	Medium Grey PMS 2337C	Navy PMS 2180C	Orange PMS 177C	Purple PMS 7672C	Red PMS 200C	Royal PMS 2111C	Safety Green PMS 379C	Safety Orange PMS 021 C	Sapphire PMS 2185C
White	Yellow PMS 127C									

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

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

BELLA+CANVAS
LOS ANGELES

3413C primeplus

Bella + Canvas Unisex Triblend T-Shirt

Small to 3X: \$15 Each

4X to 6X: \$20 Each

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

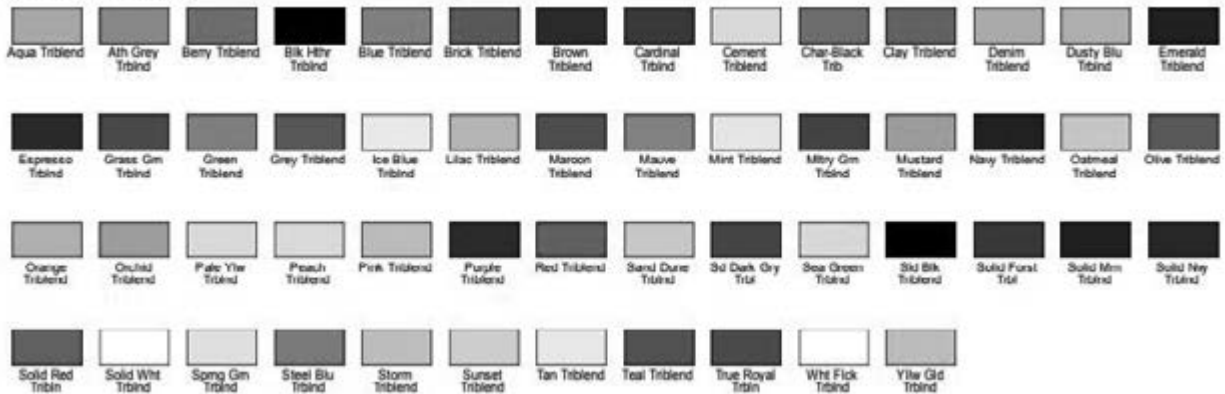
tgabrish@gmail.com

405-824-9681

Sizes range from an XS to a 4XL

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

53 Available Colors



Name: _____ **Phone:** _____

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

Make Checks Payable to Saltfork Cratsmen Artist Blacksmith Association

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

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

SCABA Shop and Swap

For Sale:

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

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



For Sale:

Water Jet Services - Saltfork Discount

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

Contact: **Ragnar at rtaswallson@yahoo.com or 918-855-8250.**

SCABA Shop and Swap



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

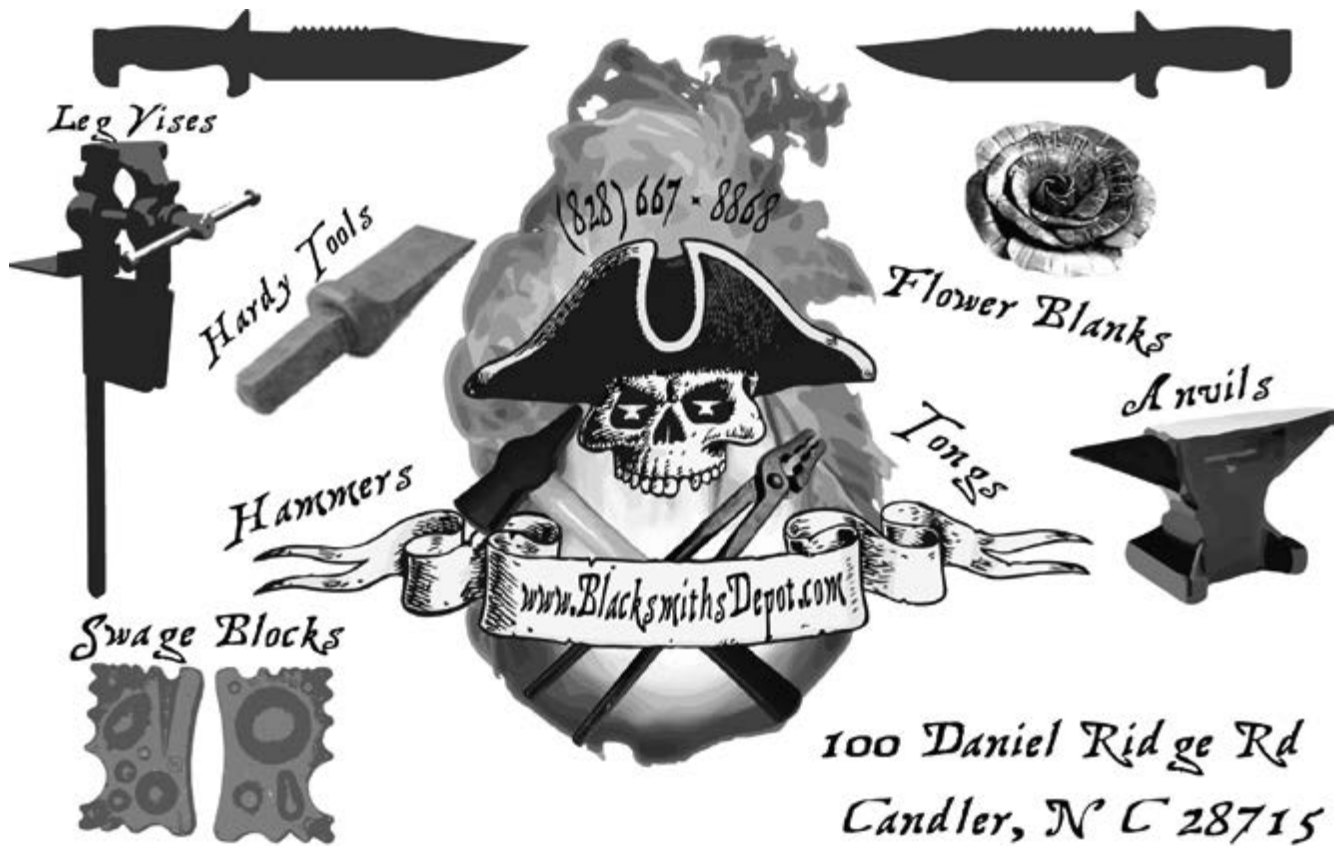


WWW.KENSIRON.COM

Ken's Custom Iron

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

SCABA Shop and Swap



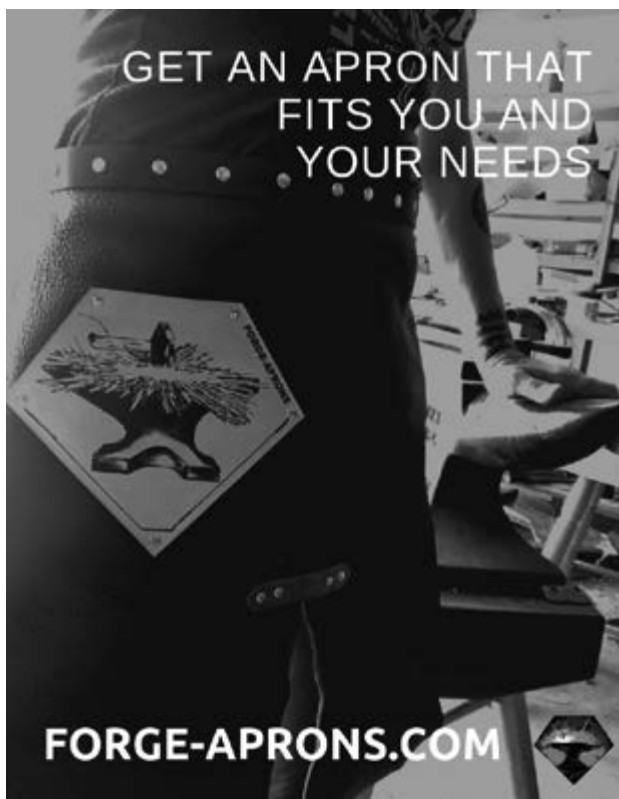
**Have a blacksmith related item
or service for sale?**

Or an item wanted?

Then this space is for you. Submit your item to the newsletter editor with your contact information, pricing and photos (if available) to be listed.

SCABA Shop and Swap

GET AN APRON THAT
FITS YOU AND
YOUR NEEDS



FORGE-APRONS.COM

KAYNE & Son -- Blacksmiths Depot

Custom Hardware, Inc.

100 Daniel Ridge Rd.
828-667-8868

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

Steve Kayne

- Tools for the Metalworker
- Hammers & Tongs
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BlacksmithsDepot.com - CustomForgedHardware.com



Ken's Custom Iron, LLC

37634 County Road 9
Avon, MN 56310
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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.

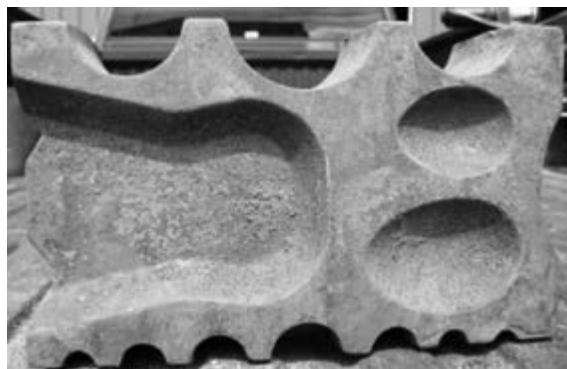
Have an Item for Sale? Item Wanted?

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 _____

Newsletter Preference:

☐ No Print Copy

☐ E-mail Alerts for New Newsletters

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

Signed: _____

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

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

www.saltforkcraftsmen.org

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

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

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