

Saltfork Craftsmen

Artist-Blacksmith Association

May 2022



**‘Raising a Bronze Raven’s Skull’ by David Robertson
(Page 21)**

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Artist-Blacksmith Association
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Call or Text. If you get voice mail, please leave a message.

Editor's Notes:

Well, I have made a couple of leaves, but I had this idea the other day and made a heart instead. Of course, I have already been told to make one hundred leaves to practice (which I may be taking seriously), but when some of the guys saw my heart I was told that I needed to make one hundred of those as well. If I keep trying new things, I am never going to keep up with these hundreds of items to forge! (Knowing me, I will keep trying new things anyway.)

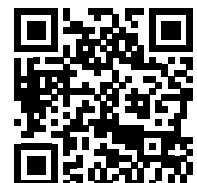
In other news, I am looking forward to the Crossroads Forging Conference. I am planning on attending, and I hope to see you there!

-Katie Mitchell, 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:

Well, another month has gone by and the weather can't make up its mind. It is like me when I am trying to clean up my shop. I can't decide what to keep and what not to keep since I keep everything--I might need it sometime.

Well, as you have probably heard, ABANA has called off the conference in Texas. I guess that means we will have to have a better conference than ever. We will look forward to seeing everyone at our picnic and conference.



It seems like we are getting more in line like it was before Covid. I hope everyone is doing well. I have been forging about every day for a little while; it seems like it takes me twice as long to make something as it used to. Maybe I will get better if I keep working at it.

I talked to Gerald and he is making another car. He might need to work on an electric car to stay up with the EPA. I hope Katie is not having too much trouble with the newsletter.

Keep your anvils on a good stand,

- 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.

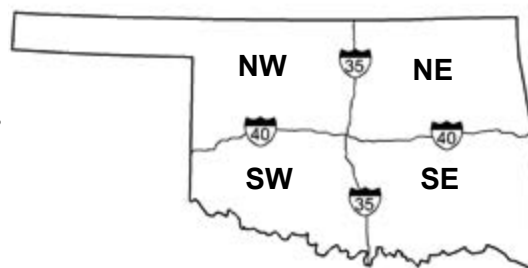
Want to host a meeting? The meeting hosting form can be found on the last page along with membership application form. If you want to host a meeting in any area, please fill out one of the host forms on the website under the calendar section or in the newsletter and e-mail the information or mail the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

2022 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, June 11th

WHERE: Route 66 Museum Blacksmith Shop, Elk City, OK

Saltfork Craftsmen will be conducting a beginners Blacksmithing workshop on Saturday, June 11th, beginning at 8 A.M. and running until complete. All tools and materials will be provided.

Slots are limited so please reserve yours early.

To make reservations, or for questions, please contact:

Rory Kirk @ 580-497-6426

BLACKSMITH BEGINNERS' WORKSHOP

WHEN: Saturday, June 18th

WHERE: Muldrow City Park

Saltfork Craftsmen will be hosting a beginners Blacksmithing workshop on Saturday, June 18th, 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 Carol Doner at Treasurer@saltforkcraftsmen.org)

2022 Workshop Schedule (cont.)

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.

Looking for Interest: *Tire Hammer Class*

We are thinking about arranging a tire hammer class. If anyone would be interested in attending that sort of thing, please contact Mandell and let him know. If there is enough interest, we may have one (likely in the fall when it is a bit cooler).

Mandell Greteman - **580-515-1292**

Save the Date:
Crossroads Forging Conference
May 12 – 14 2022 8:00 AM – 5:00 PM
<https://tx-ture.farm/crossroads-forging-conference/>

The location has changed! It is now located where the ABANA conference was going to be held, North Texas Fair & Rodeo 2217 N Carroll Blvd, Denton, TX 76201

The Crossroads Forging Conference is a grassroots event organized by a small group of blacksmithing enthusiasts and professionals in order to promote, celebrate, learn and teach the art of blacksmithing.

Admission is free, but registration is required (see website above).

The schedule is on page 12.

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.

-Editor

2022 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 1st (Open)	Jan 8th (Open)	Jan 15th (Open)	Jan 22nd (Doug Hyde)
Feb 5th (Open)	Feb 12th (Open)	Feb 19th (Open)	Feb 26th (Rory Kirk)
Mar 5th (Regional Meeting OPEN) (Beginning Blacksmith Workshop-Elk City)	Mar 12th (Open)	Mar 19th (Open)	Mar 26th (Dorvan Ivey)
Apr 2nd (Open)	Apr 9th (Open)	Apr 16th (Open)	Apr 23rd (Everett Timmons)
May 7th (Diana Simon Cherokee Strip Museum)	May 14th (Open)	May 21st (Ray Kimbrell)	May 28th (NW-Mandell Greteman) May 28th (SW-JJ McGill, Boy Scouts)
Jun 4th (Open)	Jun 11th (Open)	Jun 18th (Open)	Jun 25th (Don Garner)
Jul 2nd (Open)	Jul 9th (Open)	Jul 16th (Open)	Jul 23rd (Terry Kauk)
Aug 6th (Diana Simon Cherokee Strip Museum)	Aug 13th (Open)	Aug 20th (Open)	Aug 27th (Open)
Sep 3rd (Open)	Sep 10th (Open)	Sep 17th (Open)	Sep 24th (Ron LehenBauer as Host - Don Garner as Contact Person)
Oct 1st (Open)	Oct 8th (Conference Setup)	Oct 15th (Conference Weekend)	Oct 22nd (Monte Smith)
Nov 5th (Diana Simon Cherokee Strip Museum)	Nov 12th (Open)	Nov 19th (Open)	Nov 26th (Open)
Dec 3rd (Open)	Dec 10th (Open)	Dec 17th (Open)	Dec 24th (Open)

2022 Fifth Saturdays:

January 29th (Open)

April 30th (SCABA Annual Picnic!)

July 30th (Open)

October 29th (Open)

December 31st (Open)

May 2022

NE Regional Meeting May 7th: Will be hosted by Diana Simon and the Cherokee Strip Historical Society at the new Blacksmith Museum and Shop. 2617 W. Fir Ave, Perry, OK 73077. The shop is located approximately 1/4 mile east of Exit 186 from I-35 on north side of the road (Hwy 64 or Fir St.)

Tom Nelson will be setting a wagon tire at this meeting and may need some help from fellow blacksmiths.

The trade item is whatever you want to bring or make.

The meeting is planned to start at 9:00 AM. Lunch will be provided.

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

SE Regional Meeting May 14th: (Open.)

SW Regional Meeting May 21st: Will be hosted by Ray Kimbrell at his home shop: 522 NE 124th St., Lawton, OK, 73507.

Directions to RK Forge:

Option 1: From I-44, take the Gore BLVD exit to go East on Gore (exit 37). Go east approximately 7 miles to 124 th street. Turn left.

Option 2: Take exit 36 (Lee blvd HWY 7) Go east to Trail Road. Turn North 1 mile to Gore. Go east 1.2 miles to 124 th st. Turn left

Go to end of road to white house on left.

He only has one anvil and a pair of forges (one coal and one propane), so feel free to bring your own setup.

The trade item is a fire poker for a campfire or fireplace.

Lunch will NOT be provided, but feel free to bring finger foods or snacks if you like.

Contact Ray Kimbrell at 580-591-1191 or odd.outdoordude@gmail.com if you have questions.

NW Regional Meeting May 28th: Will be held by Mandell Greteman at the Route 66 Museum Blacksmith Shop in Elk City.

The trade item is a pair of vee jaw tongs for 5/16" or 1/4" material.

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

SW Regional Meeting (Alternate Date) May 28th : 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. The Boy Scouts will arrive Friday night and leave Sunday afternoon. Anyone interested in helping out can stay the weekend or just come Saturday. Any smiths that would like to help out educating and working with the young Scouts are greatly appreciated.

Directions: 7 miles north of Sulphur on Hwy 177 then east ¾ mile on Tractor Road. Contact JJ McGill at 580-369-1042 if you have questions.

June 2022

NE Regional Meeting June 4th: (Open.)

SE Regional Meeting June 11th: (Open.)

SW Regional Meeting June 18th: (Open.)

NW Regional Meeting June 25th: Will be held by Don Garner at the Route 66 Museum Blacksmith Shop in Elk City.

The trade item will be a pair of hold downs for the anvil. One 3/8" and one 1/2" to fit the pritchel hole.

Lunch will be provided but please bring a side dish or desert to help out. Contact: Don Garner 580-302-1845 if you have questions.

July 2022

NE Regional Meeting July 2nd: (Open.)

SE Regional Meeting July 9th: (Open.)

SW Regional Meeting July 16th: (Open.)

NW Regional Meeting July 23rd: Will be held by Terry Kauk at the Route 66 Museum Blacksmith Shop in Elk City.

The trade item will be a ladle.

Lunch will be provided but please bring a side dish or desert to help out. Contact: Terry Kauk at 580-821-0139 if you have questions.

August 2022

NE Regional Meeting August 6th: Will be hosted by Diana Simon and the Cherokee Strip Historical Society at the new Blacksmith Museum and Shop. 2617 W. Fir Ave, Perry, OK 73077. The shop is located approximately 1/4 mile east of Exit 186 from I-35 on north side of the road (Hwy 64 or Fir St.)

The trade item is whatever you want to bring or make.

The meeting is planned to start at 9:00 AM. Lunch will be provided.

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

SE Regional Meeting August 13th: (Open.)

SW Regional Meeting August 20th: (Open.)

NW Regional Meeting August 27th: (Open)



William (Bill) Davis

September 13, 1955 - April 15, 2022

William (Bill) Davis, 66, of Fletcher, Oklahoma passed away on April 15, 2022.

William (Bill) Edward Davis was born on September 13, 1955, in Lawton, OK to Thomas Paul and Juanita (Lowery) Davis. He graduated from Sterling High School in 1973. Bill married Diana Fitts on January 19, 1974 and raised two children on a small farm east of Sterling. Bill worked as a master machinist and production manager for Southern Machine Works in Duncan, Oklahoma. During his free time, he served as a founding member of Acme Volunteer Fire Department in Grady County during the late 1980s and early 1990s. He found a passion for working with mules which led to him breeding, and training mules for riding and pulling wagons. He enjoyed taking his mules trail riding and camping near Caprock Canyon in the west Texas panhandle. Bill also found enjoyment in learning and teaching the art of blacksmithing. He has put on demonstrations at the State Fair along with other members of Salt Fork Blacksmithing club.

He is survived by his wife Diana Davis; Daughter: Teresa Gabrish; Son: Jeremy Davis and wife Susan Davis; Grandson: Brandon Davis and wife Mary Davis; Granddaughter: Harley Davis; and numerous nieces, nephews, cousins, and other family and friends.

He was preceded in death by his Mother Juanita Davis; Father Thomas Paul Davis; brothers: Tommy and Cecil Davis.

An Online Guestbook is available at FletcherAndElginFuneral.com.

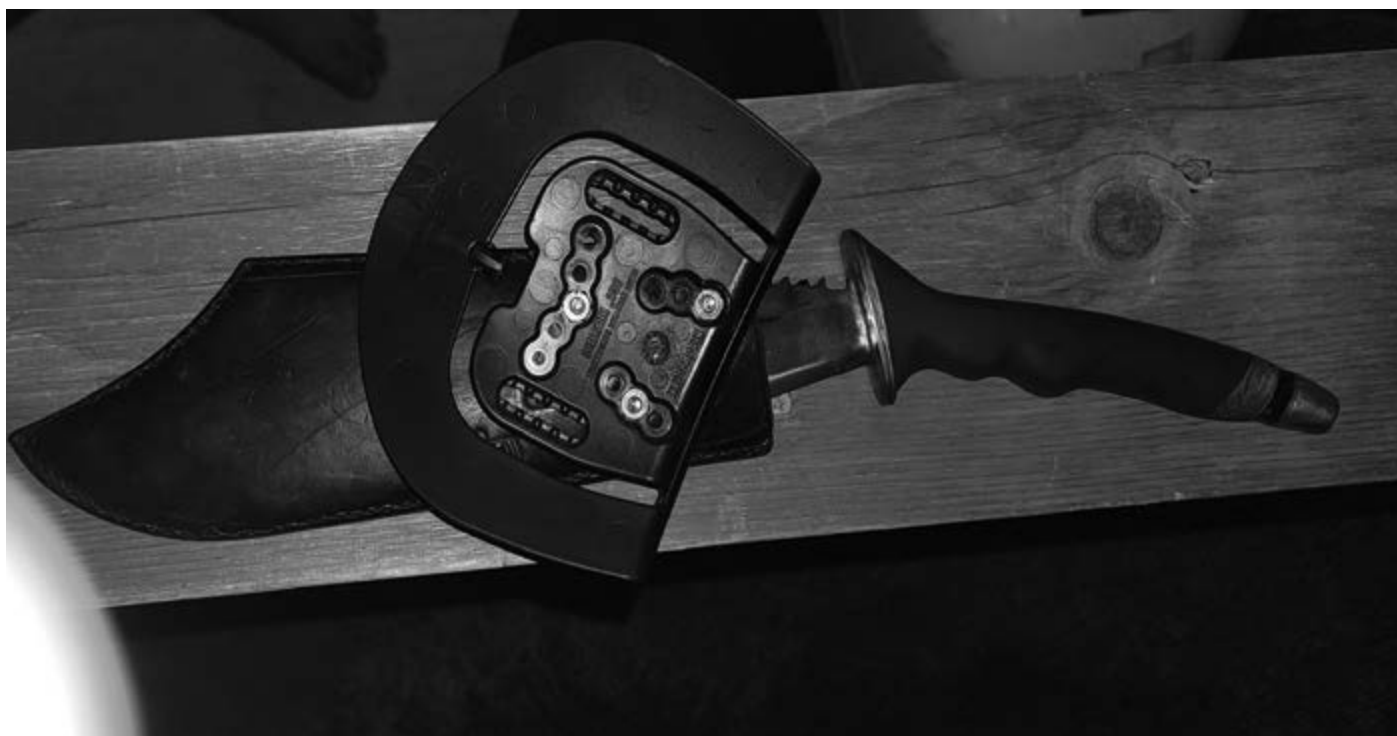
Member's Gallery



Member's Gallery (cont)

This is my first real project. Still learning a lot and haven't used these skills in a while. I messed around as a kid around the rodeo a lot and learned some basic blacksmithing from family. My father taught me some leather working, but this was all over 30 years ago. Now retired from the Army, I can pursue these designs I've been saving for years. The knife and sheath are completely made from scratch. I used an old conceal holster I had to attach it to. I don't normally wear belts, so this is perfect for me.

Ray M Richardson



CROSSROADS FORGING CONFERENCE

SCHEDULE

THURSDAY, MAY 12

8AM - REGISTRATION
9AM TO 12PM - PALMER ROBBINS DEMO
12PM TO 1PM - LUNCH
2PM TO 5PM - COTTON ELLIOTT DEMO
9AM TO 5PM - TEACHING TENT

FRIDAY MAY 13

8AM - REGISTRATION
9AM TO 12PM - MARK LING DEMO
12PM TO 1PM - LUNCH
1PM TO 2PM - IRON-IN-THE-HAT
2PM TO 5PM - KURT FEHRENBACH POWERHAMMER DEMO
5PM TO 8PM - PAY-PER-PLAY TIMED FORGING CONTEST
9AM TO 5PM - TEACHING TENT

SATURDAY, MAY 14

8AM - REGISTRATION
9AM TO 12PM - SUE HOWERTER DEMO
12PM TO 1PM - LUNCH
1PM TO 2PM - LIVE AUCTION
2PM TO 5PM - LYLE WYNN DEMO
9AM TO 5PM - PRIMITIVE IRON SMELT
9AM TO 5PM - TEACHING TENT



Around the State...

NW Region March Meeting: The March meeting was hosted by Dorvan Ivey at the Route 66 Museum Blacksmith Shop in Elk City.











NE Region April Meeting: No Meeting was held.

SE Region April Meeting: No Meeting was held.

SW Region April Meeting: No Meeting was held.

ABANA's National Curriculum - Level II

Zoom Tutorials and Coaching by ABANA's Education Team

Join us for a series of 5-Zoom tutorials given by ABANA's National Curriculum Instructors. Each tutorial will be about 2-hours with small-group coaching sessions in-between tutorials.

Course starts June 2nd, then every 1st Thursday of the month.

Register now at an introductory offer of \$100 for the entire course. Participation is limited to 20 students.

Please contact <frankannighofer@abana.org> for details and registration.



Mark Aspery, NCI, will partner with Becky Schimpff for the first presentation. Mark will present **Punching and Drifting**, as well as a look at the **tooling required** to complete both tasks, and Becky will look at **tenons**.



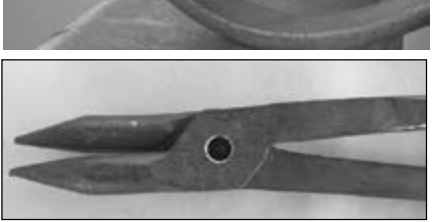
Victoria Ritter, NCI, will take a deep dive into forge welding, from the basics to welded collars, as she presents the **Basket Handled Poker**. The tutorial will take a look at forge welding in a gas forge



Becky Schimpff, NC Level II Instructor, will look at **Tenons**, the pitfalls associated with creating them, and the required tooling. **Square Corners** are the subject of Becky's second show, as she partners with John Williams.



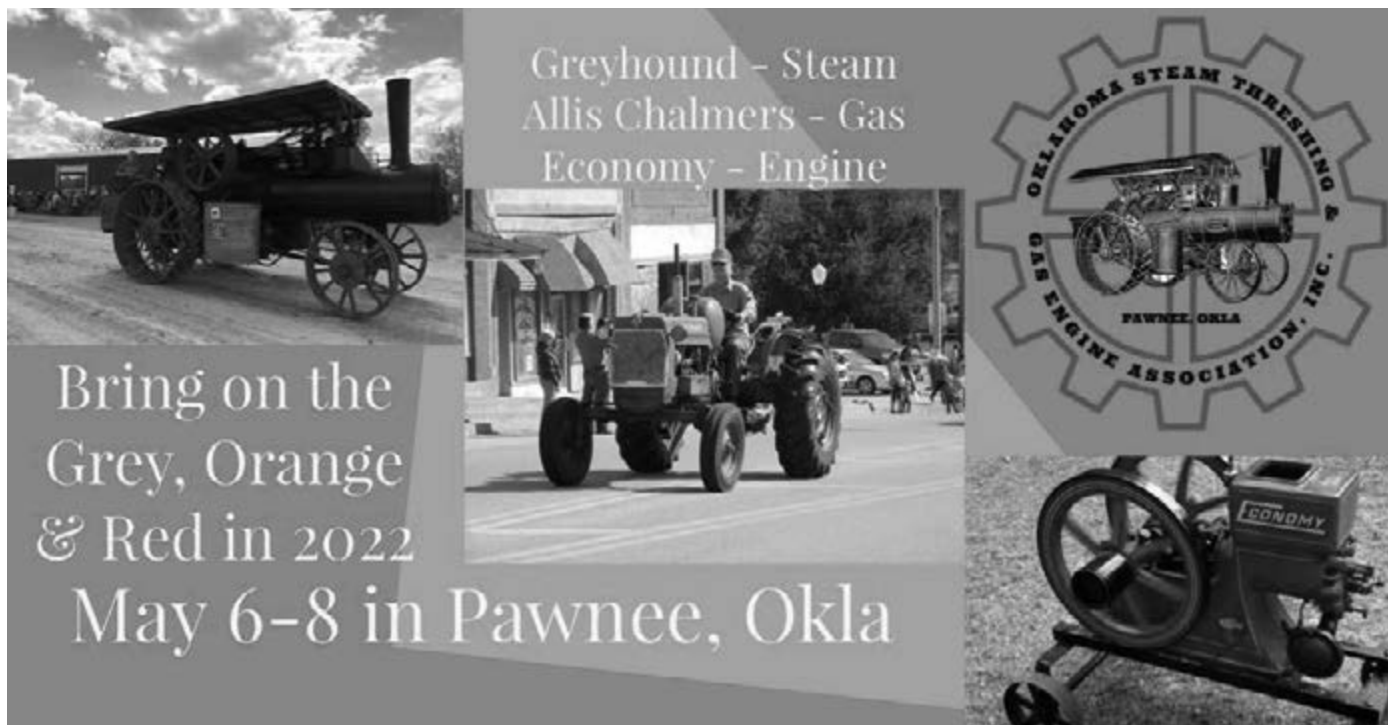
John Williams, NCI, will look at what it takes to make your own **Bottom Tooling** from creating the **Heading Block** to forging the bottom tools.



Frank Annighofer, NCI, will tackle **hand-forged Scroll-Work** including the four scrolls needed in ABANA's Level II Grille

Russ Evertz, NC Level II Instructor, will present **Scrolling Tongs** and the **Scrolling Fork** for his presentation

ABANA is committed to furthering blacksmithing education across a variety of platforms. Currently, ABANA is partnering with ABANA affiliates to bring the National Curriculum instruction to a local level. If you are interested in becoming an ABANA instructor, please contact the ABANA Education Committee at: frankannighofer@abana.com



Oklahoma Steam and Gas Engine Show

May 6, 7, and 8, 2022

Steam Park Grounds

Pawnee, Oklahoma

Gates open at 8am

\$10 single day per person. Free with club membership.
Kids under 12 are free.
Friday is School Day. School Groups Accompanied by a teacher are admitted free.

Exhibits include:

Antique Power Exhibits
Saw Mill
Machine Shop
Wheat Threshing
Corn Grinding
Shingle Mill

Schedule of Events:

Demonstrations running off and on all day:

100 Ton Corliss Steam Engine in the Power House
(listed on the national register of historical places)
Steam Powered Sawmill/Shingle Mill * Blacksmith
Cornmeal Grinding Demonstration and Discussion
Baker Fan Horsepower Testing at the Prony Brake * Rock Crusher
- Working Gas Engines Display - Line Shaft Driven Machine Shop
- Food Vendors * Arts & Crafts * Retail Vendors * Live Entertainment

Friday

09:00 a.m. National Anthem
10:00 a.m. Old Time Threshing Lecture & Demonstration
11:00 a.m. *Steam Plowing – North Field
11:00 a.m. Powerhouse Demonstration
Noon Steam Whistle
Noon Bluegrass Music Pavilion
12:45 p.m. Steam Games
02:00 p.m. Powerhouse Lecture

02:00 p.m. Old Time Threshing Lecture & Demonstration
03:00 p.m. Parade of Power
04:30 p.m. Tractor Games
Dark *Spark Show at Prony Brake

Saturday

09:00 a.m. National Anthem
10:00 a.m. Sanctioned Kiddie Tractor Pull
10:00 a.m. Old Time Threshing Lecture & Demonstration
11:00 a.m. *Steam Plowing – North Field
11:00 a.m. Powerhouse Demonstration
Noon Steam Whistle
Noon Bluegrass Music Pavilion
12:45 p.m. Steam Engine Games
02:00 p.m. Powerhouse Lecture
02:00 p.m. Old Time Threshing Lecture & Demonstration
03:00 p.m. Parade of Power
04:30 p.m. Tractor Games
Dark *Spark Show at Prony Brake

Sunday

08:00 a.m. Worship Service
09:00 a.m. National Anthem
10:00 a.m. Powerhouse Demonstration
10:30 a.m. Old Time Threshing Lecture & Demonstration
11:00 a.m. *Gas Tractor Plowing on Grounds
Noon Steam Whistle
Noon Parade of Power
03:00 p.m. Final Steam Whistle

*Subject to equipment and weather conditions

All events subject to change

April 16 Hammer In Bob Hunley's Shop

258 N CR 800 E, Sullivan, IN 47882

Driving Directions: The best way to come is to go to Dugger first. Then turn North off highway 54 on 800 E. near the train tressel and the liquor store. (at the juncture of 54 and 159). Go North through 2 stop signs and we are out in the country on the right. We are 1.2 miles from highway 54. It's a newer tan house with a tan and black pole barn. The Blacksmith shop is in the pole barn.

Chili, crackers and coffee. Please bring a side dish or dessert

IBA Conference: June 3, 4, 5 Tipton County Fairgrounds

Featured Demonstrators:	Nathan Allen & Pat McCarty		
Saturday Only Demonstrators:	Jeff Reinhardt & Darren Bender-Beauregard		
Friday Night Demonstrator:	Chuck Henderson		
Spouses Program:	Connie Retter		
Forging Contest	Beginners Area	Tailgating	
Gallery	Iron-in-the-Hat	Auction	

Skills

Being technical information

Raising a Bronze Raven's Skull By David Robertson

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I recently had a commission come in for a forged funeral urn. For such a small object there is a great deal to consider with it. I sat down with the client to discuss appropriate ornamentation for it and it was decided that a raven's skull would be the primary ornamentation. The box itself made out of steel with the raven out of copper or bronze as a contrast.

The material I used was sold as sheet bronze approximately 1.3mm thick. I will call it bronze but I do not know the exact alloy. If you are trying a similar sheet metal raising project, start with sheet copper that way you know what you are working with.



Nearly finished raven's skull.

I have planishing, polishing, and some detail work to finish off but rough form is there.

This project is a combination of hot dishing and forming and cold dishing and raising.

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Most of us have done some hot dishing of sheet steel. This is pretty straight forward using a bottom dishing form and a rounded hammer appropriate size and shape to hammer the curve in from one side and smooth out. This is basically what I started with. Then I got into the detailed sheet metal work

I first cut a basic paper plan of what I guessed the shape was that I needed. Leaving a bit extra as it is always easier to cut away than add on.



Next comes the hot dishing. The next photo shows what roughing it out hot is like and the bottom tool I used for this and a small ball peen hammer. This was the fastest operation of all. Essentially generating the depth I wanted and working out any small wrinkles hot.



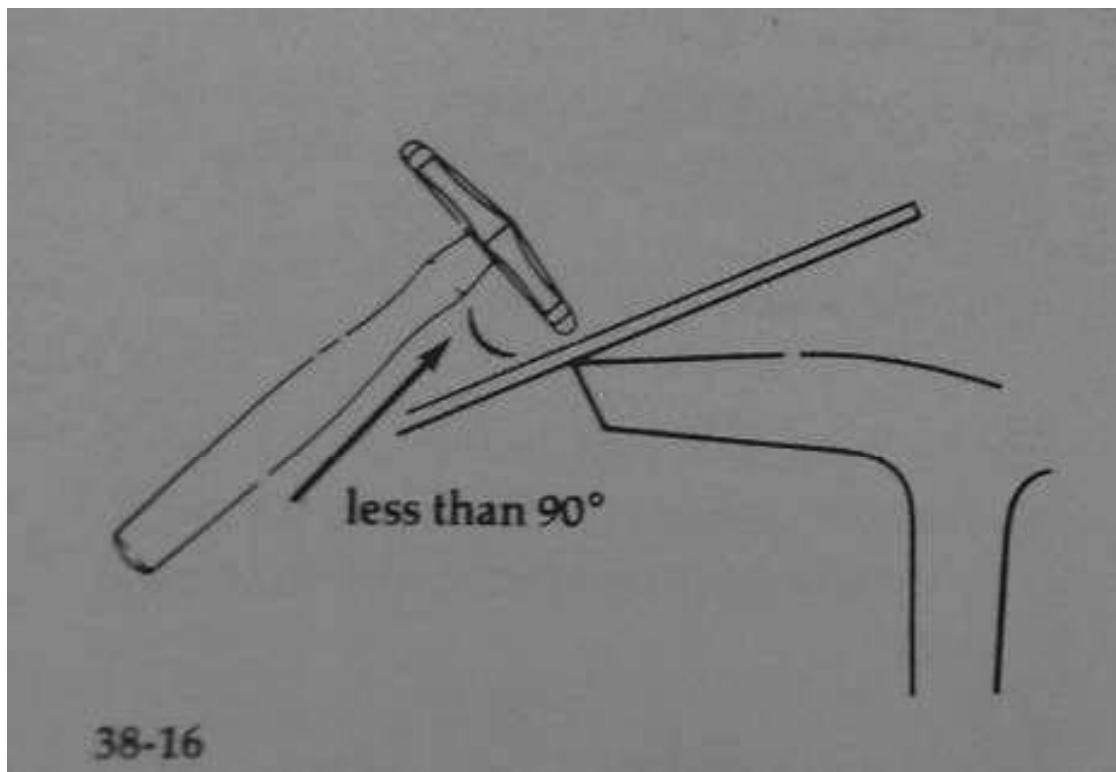
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Once the dishing was as deep as I could take it I had to tighten the curves by raising.

Previously I have only done a very small amount of raising just to sort of learn the technique. Raising is light work but takes a very long time.

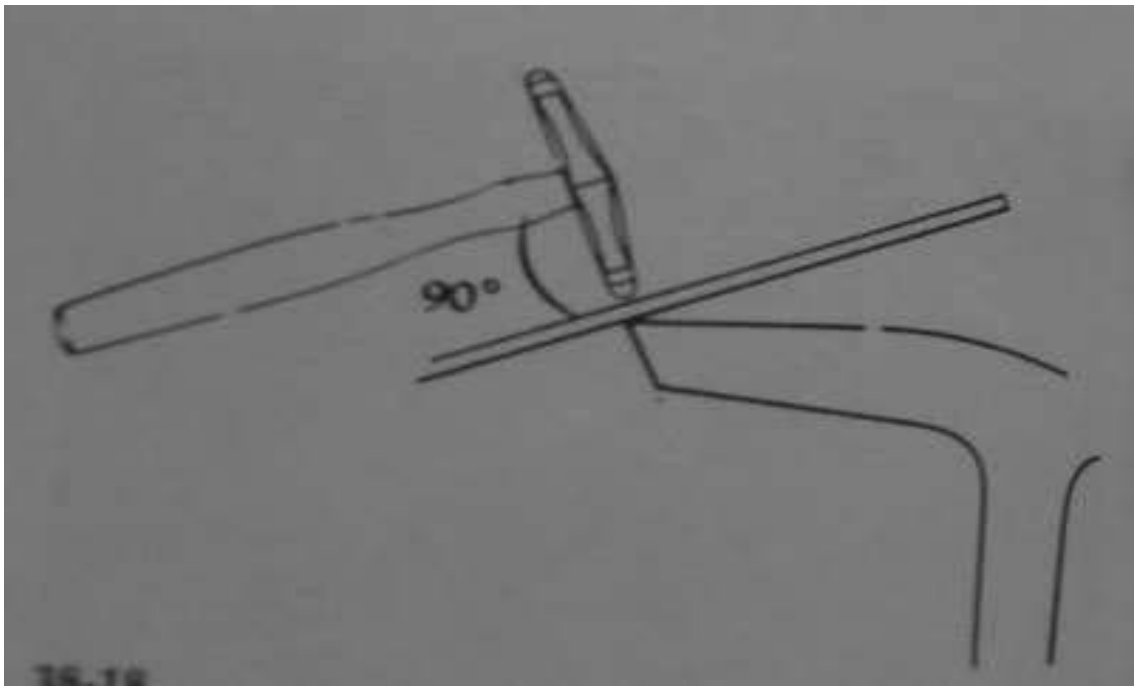
The general concept of raising is that you support the sheet material on an angle with a stake and then use a hammer roughly the shape of a blunt cross peen to hammer the sheet down (maybe 1/2 to 1 mm) so that it contacts or near contacts the bottom stake. Hopefully the diagrams below will make it a bit more clear. You then repeat in arcs starting from the centre point of your circle and working outwards. You work in overlapping rows until you reach the edge then you anneal and repeat until you have the desired curve. One piece of advice I got was to think of it as slowly working a wave of the metal out to the edge of the piece. Changing the angle of the hammer up and down and left and right changes the shape of the curve developing. Work out any wrinkles as soon as they develop.

Raising is tricky and takes some practice. I would suggest starting with something simple like a bowl.

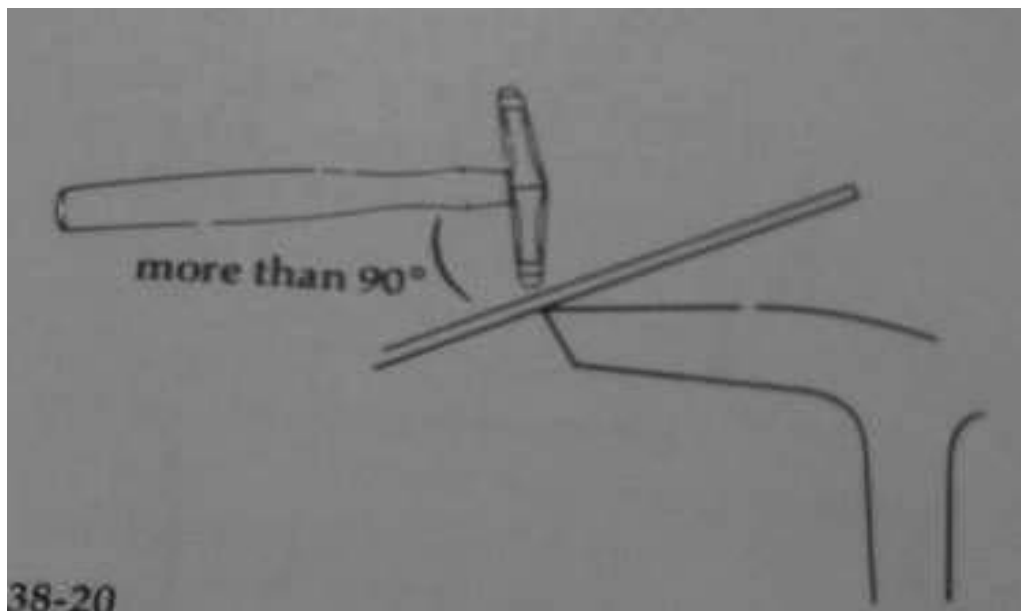


With the hammer striking at less than 90 degrees to the angle of the metal the sheet thins. This is mostly considered incorrect in raising the form. If worked too far it is possible to start poking holes in the thinner sheet when starting to use the punches for the chasing.

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When the hammer strikes at 90 degrees the metal is just displaced not stretched or upset. This is the most common way to do raising and is considered the correct use of the technique.



With the strike angle greater than 90 degrees you end up upsetting the metal and shrinking your piece. If you have extra metal upsetting may not be an issue and may be important if you have more detail work to do in one area, that will later cause thinning.

It turned out that I did not have a stake the right shape for the raising that I needed to do. The beauty of blacksmithing is just make the tool that you need.

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This is the stake roughed out from a piece of Nascar axel purchased at Quadstate Southern Ohio Forge and Anvil Blacksmith Conference. This is a really tough steel that has high impact strength. Really any shock resistant tool steel would work fine. Even mild steel in a pinch but expect deformation. 4140 would be a classic example of suitable steel.

I wanted a curve and a sort of flattened ball on the end. The stake gets clamped in the leg vise at different angles as needed. Stakes often fit into a socket or even into the Hardy hole of the anvil. I wanted more versatility of angle so the clamping in the vise.



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The picture *above* shows the stake clamped and the raising hammer at the angle I was using it at. Remember the texture you leave on the surface of the stake is the texture you get on the inside of the object you are raising. Copper smiths and silver smiths often polish the working surfaces of their stakes and hammers to mirror smooth. I did not as I could accept a rough interior to the skull.



The other really useful stake is simply a piece of hardwood clamped in the vise. This piece is about 6 inches long and about 1 inch square. Flat on the end shown and a Vee notch cut in the other end.

I used it for flattening, curving and as a backing for some chasing to define the eye sockets.

The chasing was done with a combination of small hammers and smooth punches and chisels.

The image *below* shows outlining the eye socket on the wooden stake. The punch I am using is a smooth rounded tear drop shape. This allows blending the individual punch marks with multiple passes and works well with curves.

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I found the bronze had to be annealed often. It would stiffen up and that is when you get cracks developing. Remember with non ferrous metals it is heat up to colour and quench to anneal. If you were working steel heat up to showing colour and slow cool.



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The previous image shows the inside of the skull roughed out by first hot dishing then cold raising. The beak was in early stage of forming using a Vee stake and a sharp cross peen hammer to create the trough.

With the top half of the skull formed I had to look at the lower jaw and base of the skull. I did not create a pattern before as I really had no idea what dimensions I would end up with on the top portion. The paper at the right was rough fit to the top piece leaving extra.



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The above image shows the lower jaw/beak part way along in formation. Virtually the same hot dishing first then raising techniques to get the fit. Clear view of the stake I was using.



The fit is coming along. Small refinements with each pass. The eyes had been plasma cut out then reworked to create the sunken look. The nostrils are same technique but I left to the end so that the bronze had maximum support.

The top image on the next page shows the series of hammers that I used. Also the primary dishing tool used with the small ball peen second from the right. Each hammer is a different size and got into a different shaped spot. Sometimes just a very few hammer blows to adjust shape were needed. The hammer on the left was the primary raising hammer.

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The stakes and punches that I used. From left to right.

- Hatchet stake to form clean bends in a line
- Vee stake for deep trough formation of the beak
- The raising stake I ended up making for the majority of the work
- Straight radiused punch (think of a cold chisel rounded off smooth and not sharp)
- Tear drop punch
- Bent narrow stake for bending tighter radiuses (think smooth rounded cold chisel hammered to 45 degree angle)
- Wooden stake (flat one end Vee notch other end)
- Specialty offset flat punch (used to get inside the nostril to flex the bronze into a curve)

When doing chasing the finer the detail the smaller punches. Most of the punches were made out of truck spring.

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Copper and bronze are wonderful to work and give a high contrast to forged steel. Read up on chasing and dishing and raising and start with a simple project to see if this is a type of smithing that suits you. Although not quiet it is very light work.

Line drawings from 'Silver Smithing' by Rupert Finegold and William Seitz, 1983, ISBN 0801972329 : page 339 / 340 / 341 – Other images by the author.

David Robertson has been blacksmithing full time since 1993 and currently works and teaches from his shop in mid-western Ontario. He has a passion for making tools, jigs, and organic forms in his work. *(He is an experienced teacher, and a regular contributor to the Iron Trillium.)*
www.ArtistBlacksmith.com

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Folding Knife Storyboard

by Geoff Feder



Originally published in the Winter 2021
New York State Designer Blacksmiths
Anvils Chorus

This article is reprinted courtesy of the Virginia Blacksmith's newsletter Mar-Apr 2022, Originally from the Anvils Chorus Newsletter Winter 2021.

California Blacksmith *Online*

Photo Essay: Calla Lily Francis Leidinger, Davis

Stock as shown: 1/4" x 3/4".

However: I've used as small as 1/4" x 1/2" - that's your choice. This photo essay shows the steps involved. Adapt the process to your desired final size.



1. Taper the tip, and make a neck centered about 1 1/2" back from the tip. Maintain thickness at 1/4".



2. Draw and lengthen the neck.



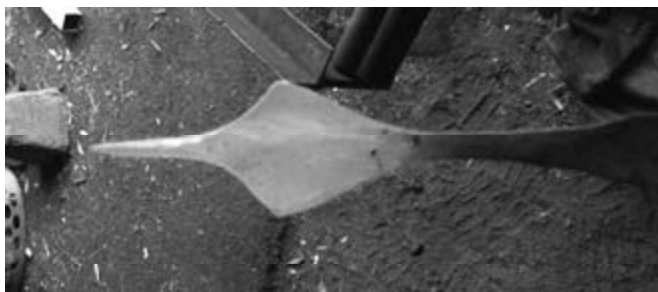
3. Make a nice concave taper on the end. Make the necked-down section parallel.



4. Use the cross peen to spread and thin the center section.



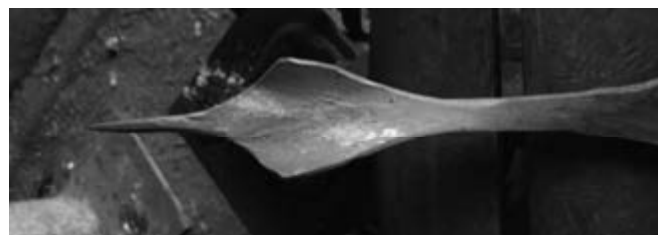
5. Spread the "wings" more. Make the transition (left edge in above picture) concave.



6. Round the tip. Smooth the section behind the tip.



7. Side view of step 6.

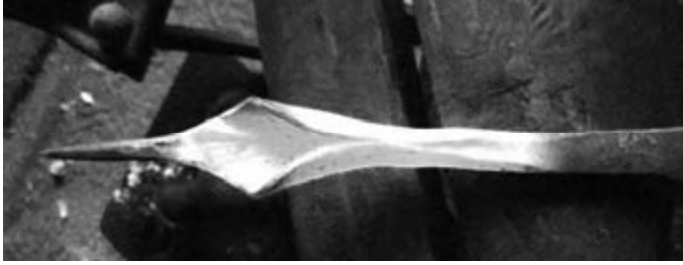


8. Begin to curl the outer edges of the wings.

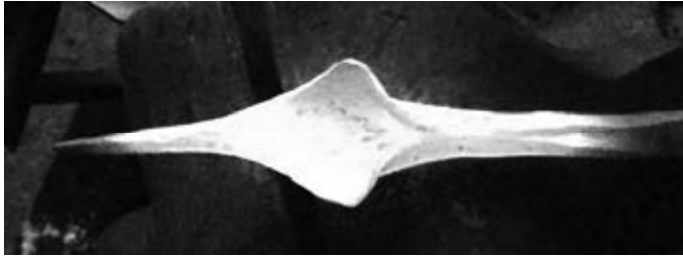


9. Side view of step 8.

Calla Lily



10. Roll over and round the lower part of the lily..



11. Spread the outer tips of the flower.



12. Forge the stamens



13. Insert the stamen, ready to forge braise.



14. Brass shavings for forge braise. (Copper works well, also).



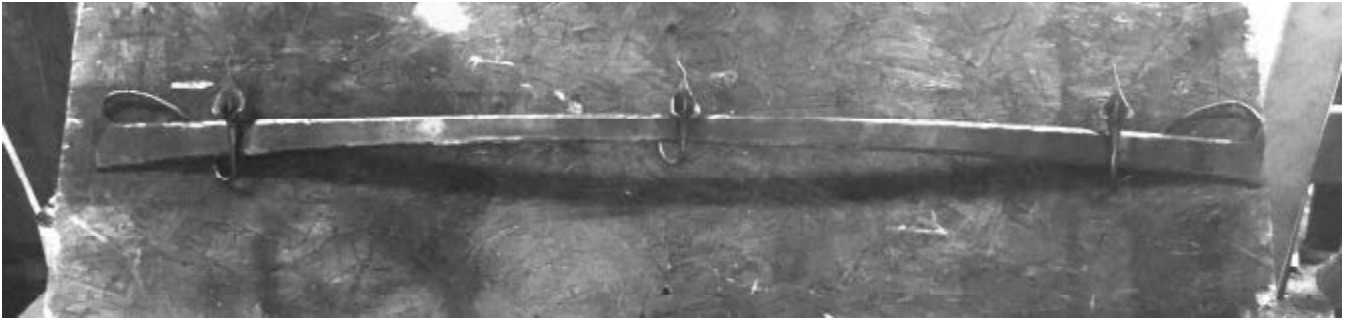
15. Insert the shavings and borax flux for brazing, *Make sure to keep upright so that the shavings don't fall back out!*

To forge braise: heat slowly in an open fire (if using coal be sure to use gas welding goggles to protect from glare and infrared). Watch for the brass to melt until it flows.



16. After brazing, ready to clean.





Sample application of this process: wall-mounted pot rack.

To clean: pickle overnight in vinegar.



About Francis

Francis has been smithing for 28 years. Having started out with John McLellan, Francis has focused on ornamental steelwork. He has a shop (Straight Line Forge) outside Davis doing private commissions, and can also be found at the Davis and Napa farmer's markets.

Francis has often taught workshops on making kitchen utensils. He is planning to conduct a workshop on a wrought iron BBQ fork at the 2022 Spring Conference.



May/June 2022

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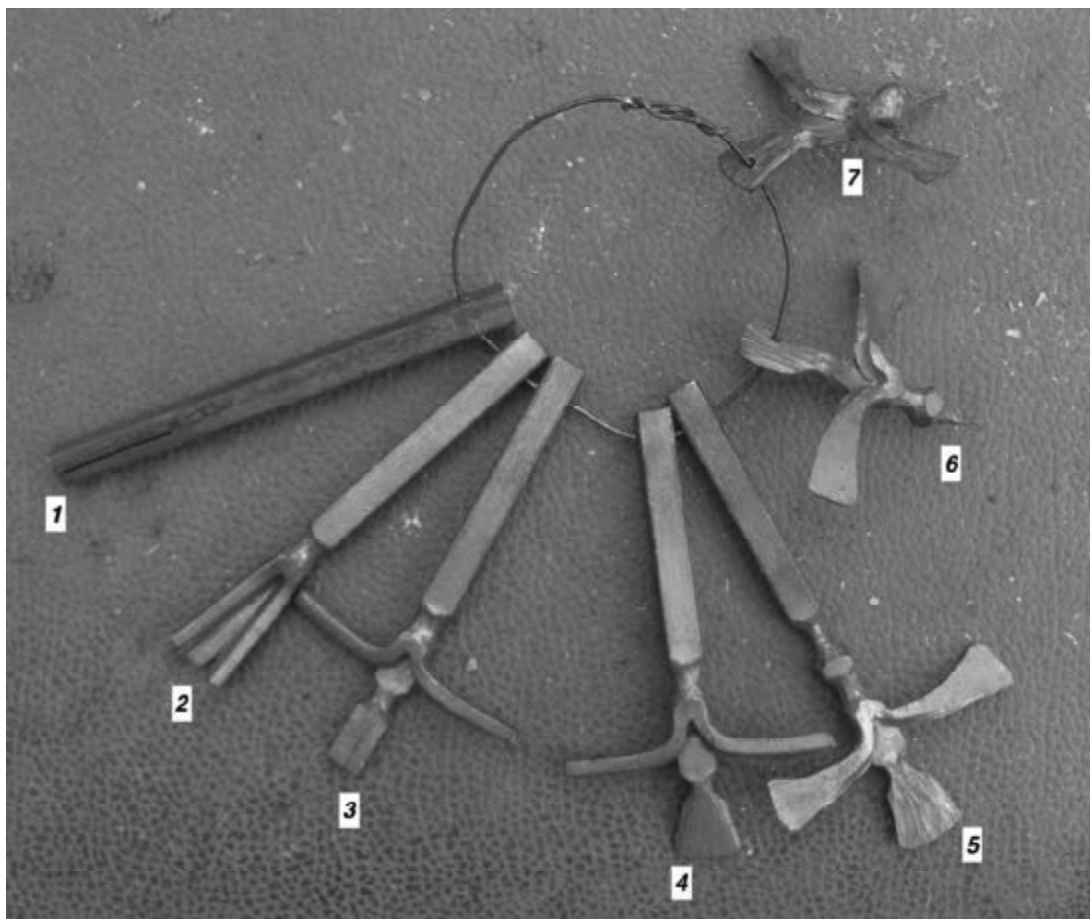
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Hummingbird

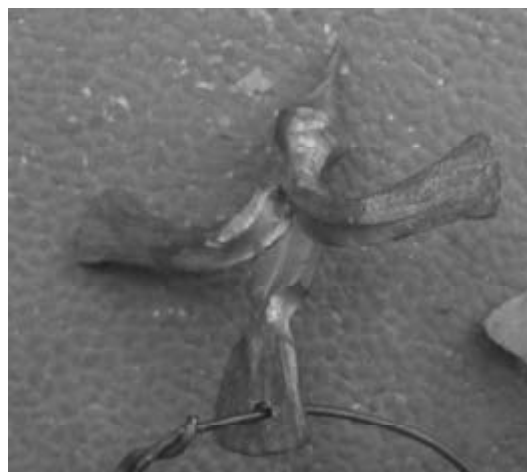
Dan Perkins, Auburn

Storyboard Shown at Oktoberfest 2016



1. Saw cut on one end
2. Split one side for wings
Fuller (make a round fullered section) to form neck.
3. Spread wing material, then fuller to isolate tail and head. Again, make a round fullered section.

4. Pein tail to spread and texture
5. Pein wings to spread.
Fuller to isolate head, form beak.
6. Cut beak material, then draw out beak.
7. Texture wings.



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Forging Non-Ferrous Metals

By Jim Guy

There are a number of beautiful examples of ironwork that uses copper or bronze as a way of adding color or contrast to traditional iron work. This is something that I feel will add another dimension to my work. The "Forging Non-Ferrous Metals" class at John C Campbell has provided a good grounding in the basics to make that happen. The instructor, Lucas House, led us through forging aluminum, silicon bronze, naval brass, copper, and stainless steel. Each day begun with a forging demonstration of one of these metals, leaving us the rest of the day to work with a metal of our choosing. Lucas also reviewed other topics which are important to completing any nonferrous work. These included silver soldering as an alternate means of joinery, finishes and patinas.

What surprises me is that once you overcome some key differences with these metals, the process used to forge it is very similar to steel. As a result, the following descriptions will focus on identifying these differences such as the right forging temperature and how the metal behaves.



Figure 1:
"J" hook in aluminum, copper, naval brass & silicon bronze

Silicon Bronze

The most common silicon bronze alloy used by blacksmiths is 655 (also known as C655 and C65500). Silicon bronze is corrosive resistant and has relatively good strength.

Forging temperature: Forge silicon bronze at a dull red in a light area.

Forging tips and Observations: Silicon bronze does not generate scale. There is a great deal of blacking that must be removed before a finish is applied. Transfers heat quickly but not as quick as aluminum. Fractures when heated too hot. Works like steel when at temperature.

When buying silicon bronze: It is typically priced by pound regardless of shape. Round stock is always cheaper than other shapes.

Copper

The copper alloy used in class is copper 101, a low oxygen alloy with a copper content of 99.99%.

Forging temperature: Slightly cooler than silicon bronze, a faint red.

Forging tips and Observations: Will conduct heat instantly. It is a most forgiving metal that can basically forge cold. Copper blackens when forged but does not form scale.



Figure 2: Snail (Copper and Stainless Steel)

Naval Brass

464 Naval has many good qualities such as a pretty color, corrosion resistance.

Forging temperature: Slightly cooler than silicon bronze, a faint red (basically the same color as copper's forging heat)

Forging tips and Observations: Work small points cold. Butter soft at the high end of forging temperature NOT forgivable. Will fracture if forged too hot or too cold.

Aluminum

We used 6160 aluminum in our forging. This is one of the most common alloys of aluminum for general purpose use.

Forging temperature: Aluminum at the correct forging temperature does not give any visible sign of temperature. Identify the correct temperature when: a black sharpie marker line on the metal disappears or a piece of wood chars or smokes. Aluminum may feel like it hits a sticky place on the anvil surface.

Forging tips and Observations: Aluminum does not generate scale. There is some blacking, but not much. Transfers heat quickly (in other words, keep your tongs handy!) Fractures when worked too hot. Aluminum can work-hardened (bar stock comes work hardened unless ordered annealed).

Anneal by heating and let cool (may air cool or quench immediately after heating, doesn't matter).

Annealed aluminum can be forged cold to some extent.



Figure 3: 3" Aluminum rod forged at too high a temperature

Stainless Steel

Forging temperature: Forge stainless steel at a bright yellow, almost white.

Forging tips and Observations: Stainless requires more heat than steel. It is harder to move metal at forging temperature than steel. It does not transfer heat quickly and blackens when forged.

Joinery: Traditional joinery techniques apply to all these metals (such as collars, rivets, mortise and tenon joints). Most can be welded via TIG and MIG.

Finishes: Finishing the metals discussed above follow a similar process. First remove oxides, then apply a patina (optional step) finally apply a finish.

Oxide removal: The only option for aluminum is to brush off the black oxides with a stainless steel brush. Use an acid bath with the other metals, it will save a lot of time.

The class used muriatic acid undiluted for its acid bath. Take two plastic containers big enough to hold the items to be cleaned. Put muriatic acid in one and water in the other. Soak the items for an appropriate amount of time, up to a couple of minutes for naval brass, silicon bronze and copper. Then dunk them into water to remove any residual acid and stop further etching. After an acid bath, brush with a brass brush or fine steel wool to remove any remaining black oxide and to polish the surface. Stainless steel is a bit different. You will need to wire

brush stainless before the acid bath to remove any loose black oxide, then let sit in the acid bath overnight.

Warning: etching stainless steel after etching copper or silicon bronze in the same acid bath will copper plate the stainless steel.

Aluminum will dissolve in muriatic acid if given enough time (5 to 10 minutes). However, if you just dip it in quickly, will etch a nice gray finish.

Patinas: Copper, naval brass and silicon bronze do not really need patinas and will naturally develop a pleasant patina over time (silicon bronze will turn a nice dark brown).

In class, we used patinas from Sculpt Nouveau.

Traditional Black Magic for copper, naval brass and silicon bronze. And Birchwood Casey Aluma Black A-14 for aluminum.

When using patinas, don't just use it out of the bottle. Put it in a cup to minimize contamination. From there, just wipe it on and then wash it off.

With steel: wash off immediately. With silicon bronze, wipe off after a few seconds and then rub with steel wool. Naval brass turns black instantly! We used liver of sulfur in our recent copper class. This seems to behave similar to the Sculpt Nouveau patinas. Directions for all of these patinas recommend using them hot. We didn't in class and had good controlled results.

Finish: Most finishes used on ironwork can be applied with these metals: clear lacquer, min-wax wipe-on poly, beeswax and Johnson's paste wax are all good. Consider using no finish to allow natural weathering.

Sources for Metal:

Online metals (<https://www.onlinemetals.com/>)

Atlas metals supply (<http://www.atlasmetal.com/>)

Sources for Finishes and Patinas:

Sculpt Nouveau (<http://www.sculptnouveau.com/>)

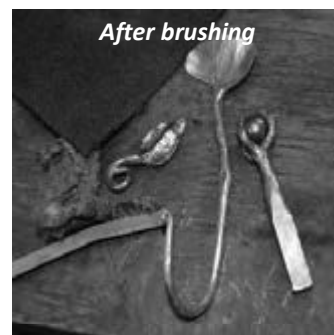
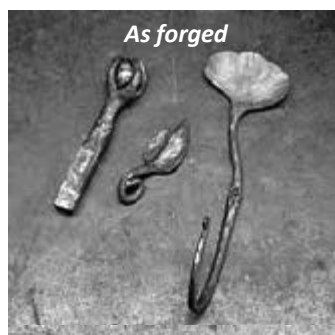
Traditional Black Magic: used in class on naval brass and silicon bronze.

Birchwood Casey Aluma Black A-14: used on aluminum

Source for: Silver solder and supplies and patinas:

Rio Grande (<https://www.riogrande.com/>)

Muriatic acid is available from Home Depot and Lowes. Look for the product used for cleaning floors or adjusting swimming pool pH levels.



SCABA Shop and Swap

For Sale: Coal Forge - \$300 OBO

Very nice heavy duty forge with removable hood. No blower.

33" Tall, 32" Wide, 33" Deep

Contact: Mark Carter (Before 10:00 PM) at 405-613-5215



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.**

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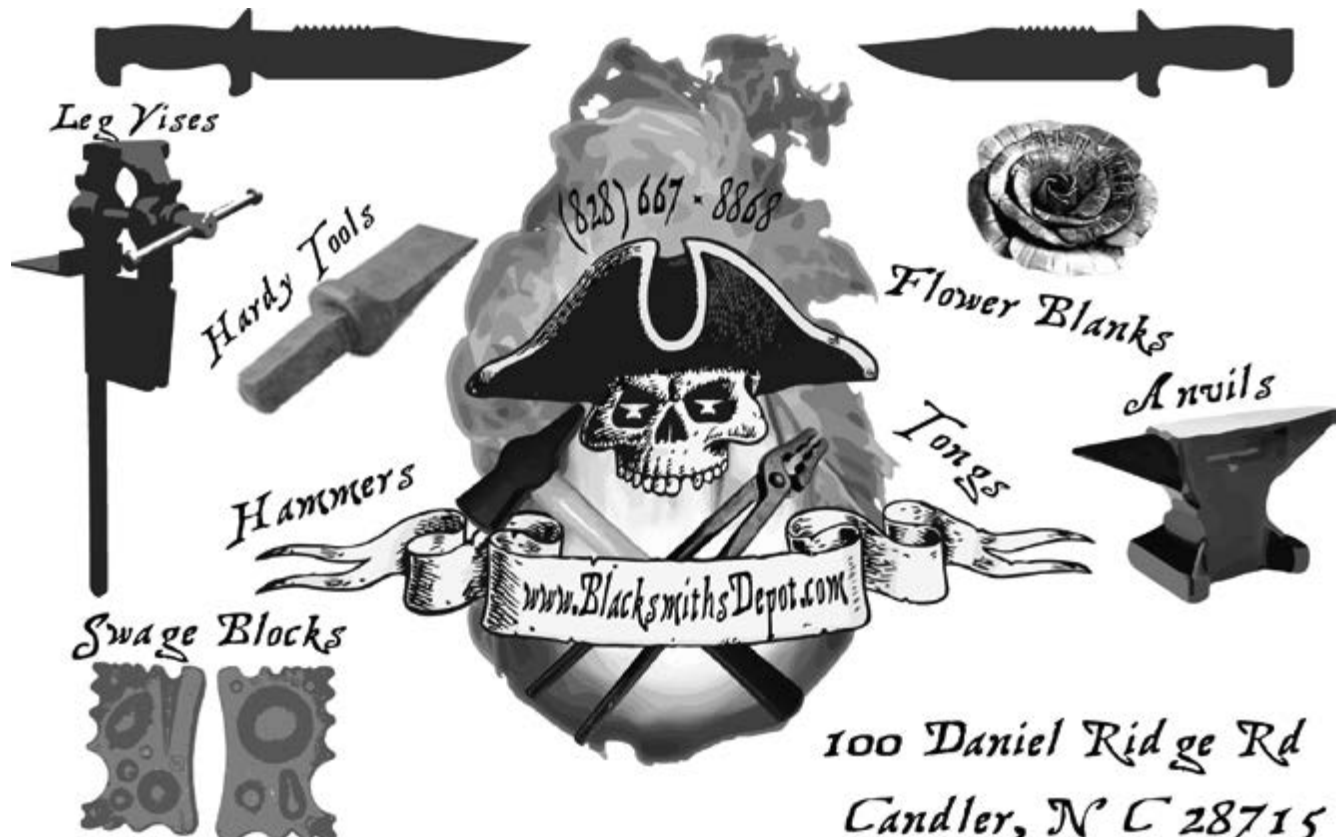
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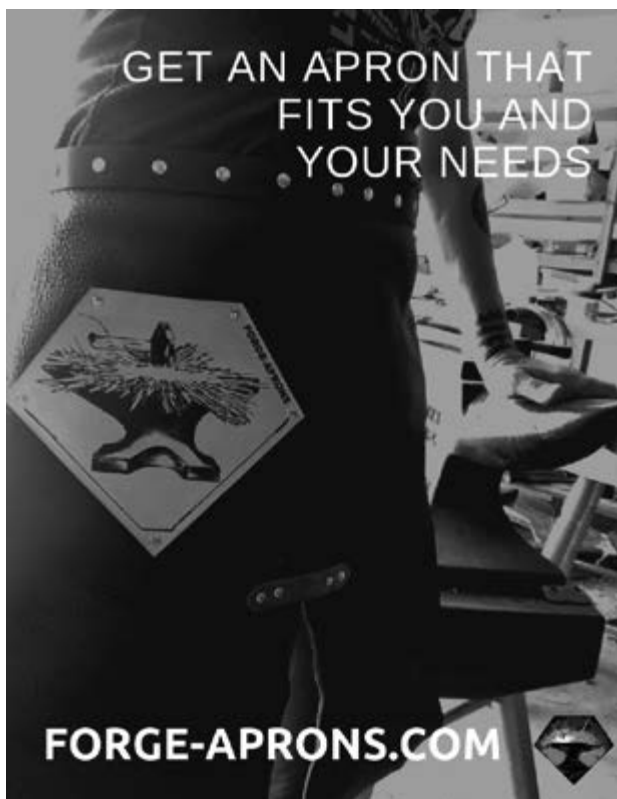
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Bill Davis Forge Welded Tomahawk DVD

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

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\$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.



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(Please Print Clearly!)

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e-mail _____

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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.



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Region: _____ NE _____ SE _____ SW _____ NW

Date: Month _____ Day _____ Year _____

Name: _____

Meeting Address: _____

Host Phone (Best Number to Contact) (_____) _____

Host e-mail _____

Trade Item: _____

Lunch Provided: _____ Yes _____ No

Please provide detailed directions and/or a map to meeting location if possible. Meetings are scheduled on a first come basis.

Return to: Saltfork Craftsmen Regional Meeting Coordinator, Russell Bartling

70 N 160th W Ave

Sand Springs, OK 74063

You can also send the information in an e-mail or text or fill out the online form available on the website in the top banner of the Calendar Tab: www.saltforkcraftsmen.org/Calendar.shtm

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