

# Saltfork Craftsmen

## Artist-Blacksmith Association

January-February 2023



**It is a new year, and there are plenty of spaces for meetings!  
Contact the editor to get added to the schedule.  
(page 6)**

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

**President/West Workshop Coordinator:**

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

**Vice-President/Conference Chair:**

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5399 Pete Nelson Rd.  
Davis, OK 73030 jjmcgill88@yahoo.com

**Director:**

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6520 Alameda  
Norman OK 73026 byrondoner@esok.us

**Director:**

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

**Director/East Workshop Coordinator:**

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106570 S. 4690 Rd  
Sallisaw, OK 74955 bradley.nance@cnet.com

**Director:**

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

**Director:**

Russell Bartling 918-633-0234  
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Sand Springs, Ok 74063 rbartling@ionet.net

**Assignments:**

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Norman, OK 73026 caroldoner@hotmail.com

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23713 E 860 Rd  
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Call or Text. If you get voice mail, please leave a message.

## Editor's Notes:

*I would like to apologize for my tardiness in getting the newsletter out recently. Mom is still relying on me to do most things for her. I am also starting full time work again on top of that, so most days I have no time or energy left. Hopefully as she gains her independence back I will get to do more with this, as I have ideas for things I would like to try.*

*A few things to note:*

*Annual dues have increased to \$40.00.*

*Please note that print copies of the newsletter are now a box you have to check on the renewal form instead of an automatic thing. Those that currently receive them will continue to do so for the dues they have paid. Just make sure to check the box if you want to keep receiving print copies when renewal time rolls around!*

*-Katie Mitchell, Editor*

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

There is a Board of Directors meeting scheduled for **2:00 PM Sunday, February 12th, 2023** at Byron Doner's shop in Norman.

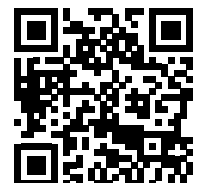
Board meetings are open to any member to attend. This is the best place to offer any comments, ideas or criticisms you have on how your club operates. Feel free to attend. If you plan to attend and have an issue that needs addressed, please send your topic(s) to the Secretary, Carol Doner, to get on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

*- Editor*

The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

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



## President's Notes:

Hello everyone. I hope everyone is doing well and didn't eat too much for Christmas. I hope everyone had a good time with family and friends over the holidays. We had a meeting at Elk City and had a good turn out with six people forging most of the day and helping two young smiths make hammers. I think they will serve them well for a lifetime, but you still can never have too many hammers. I hope everyone stays warm this winter, it is hard to stay motivated when your quench tank is frozen.

It has been cold and windy and hard to make myself go to the shop, but I do once in a while. I hope to see everyone at the picnic this year. It will be held at Bill Phillips' in eastern Oklahoma this year.

I have been trying to find coal for the club. Where we used to get it doesn't have any and they say they will not be getting any. They gave me a couple of numbers to call and I haven't gotten an answer yet. Well, we did it, we kept our anvils shining one more year.

Keep your anvil shining,

- 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. -Katie Mitchell, 405-816-0445 hope91.16@gmail.com

## 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.

# 2023 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, April 29th

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

Saltfork Craftsmen will be conducting a beginners Blacksmithing workshop on Saturday, April 29th, 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**

**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.



# 2023 REGIONAL MEETING SCHEDULE

NE Region (1st Sat)	SE Region (2nd Sat)	SW Region (3rd Sat)	NW Region (4th Sat)
Jan 7th (Open)	Jan 14th (Open)	Jan 21st (Open)	Jan 28th (Rory Kirk)
Feb 4th (Open)	Feb 11th (Open)	Feb 18th (Open)	Feb 25th (Skylar Parker)
<b>Mar 4th</b> (Diana Simon Cherokee Strip Museum)	Mar 11th (Open)	Mar 18th (Open)	<b>Mar 25th</b> (Mandell Greteman)
Apr 1st (Open)	Apr 8th (Open)	Apr 15th (Open)	<b>Apr 22nd</b> (Terry Kauk)
<b>May 6th</b> (Diana Simon Cherokee Strip Museum)	May 13th (Open)	May 20th (Open)	<b>May 27th</b> (Monte Smith)
Jun 3rd (Open)	Jun 10th (Open)	Jun 17th (Open)	Jun 24th (Open)
Jul 1st (Open)	Jul 8th (Open)	Jul 15th (Open)	<b>Jul 22nd</b> (Don Garner)
<b>Aug 5th</b> (Diana Simon Cherokee Strip Museum)	Aug 12th (Open)	Aug 19th (Open)	<b>Aug 26th</b> (Charles & Clay at Siel- ing Flourmill)
Sep 2nd (Open)	Sep 9th (Open)	Sep 16th (Open)	<b>Sep 23rd</b> (Everett Timmons & Don Garner)
Oct 7th (Open)	Oct 14th (Open)	Oct 21st (Open)	Oct 28th (Open)
<b>Nov 4th</b> (Diana Simon Cherokee Strip Museum)	Nov 11th (Open)	Nov 18th (SW - Open)	Nov 25th (Open)
Dec 2nd (Open)	Dec 9th (Open)	Dec 16th (Open)	Dec 23rd (Open)

## 2022 Fifth Saturdays:

**April 29th (Beginner's Blacksmith Class in Elk City)**

July 29th (Open)

September 30th (Open)

December 30th (Open)

# January 2023

NE Regional Meeting January 7th: (Open.)

SE Regional Meeting January 14th: (Open.)

SW Regional Meeting January 21st: (Open.)

**NW Regional Meeting January 28th:** Will be hosted by Rory Kirk at the Route 66 Blacksmith Shop in Elk City.

The trade item is three 3/8 chain links forge welded together (see August 2022's Newsletter for a good article on chain making).

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.

# February 2023

NE Regional Meeting February 4th: (Open.)

SE Regional Meeting February 11th: (Open.)

SW Regional Meeting February 18th: (Open.)

**NW Regional Meeting February 25th:** Will be hosted by Skylar Parker and Layton at the Route 66 Blacksmith Shop in Elk City.

The trade item is a spear.

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

Contact: Skylar Parker at 580-393-1215 if you have questions.

## March 2023

**NE Regional Meeting March 4th:** 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, but please bring a side dish or dessert to help out.

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

SE Regional Meeting March 11th: (Open.)

SW Regional Meeting March 18th: (Open.)

**NW Regional Meeting March 25th:** Will be hosted by Mandell Greteman at the Route 66 Blacksmith Shop in Elk City.

The trade item is anything with a forge weld in it.

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

Contact: Mandell Greteman at 580-515-1292 if you have questions.

## April 2023

NE Regional Meeting April 1st: (Open)

SE Regional Meeting April 8th: (Open)

SW Regional Meeting April 15th: (Open)

**SCABA Annual Picnic April 15th, details on next page (9)**

**NW Regional Meeting April 22nd:** Will be hosted by Terry Kauk at the Route 66 Blacksmith Shop in Elk City.

The trade item is...

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

Contact: Terry Kauk at 580-821-0139 if you have questions.



# SCABA 2023 Picnic!

The SCABA Annual Picnic is scheduled for April 15th at Bill Phillip's place, 14360 State Hwy 113, Indianola OK.

This is a family friendly event, so please attend and bring someone with you!

If you have any ideas for the conference t-shirt this year, please submit them by the day of the picnic! We are trying to get a head start on things this year.

Please bring chairs if you are attending.

Also, if you plan on competing in the contest, don't forget your hammer and punches.

Food will be provided, if you want a drink that is not water or tea you will need to bring it with you.

The terms for three SCABA directors are up this year. Byron Doner and Brad Nance are up for re-election. Mandell Greteman will not be running again and his term is up. Russell Bartling is resigning from his position, so that will also need filled.

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

Please contact the Secretary, any current Board member or the newsletter editor as soon as possible if you would like to run for a director position or if you would like to nominate someone (with their approval, of course.)

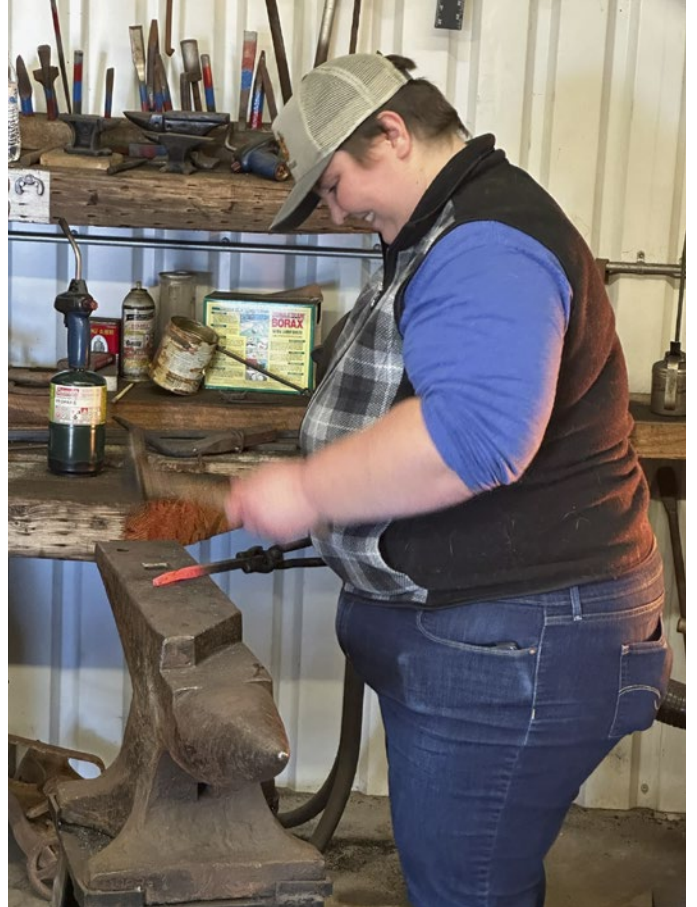
For the contest this year, each contestant will be given a piece of 1/2 inch square stock. You will punch a hole in it and drift it out to a ring 1 1/2 inches wide.

## Around the State...

The NW Region November Meeting was hosted by Skylar Parker at the Route 66 Blacksmith Shop in Elk City.









## Around the State...

The NW Region December Meeting was hosted by Skylar Parker at the Route 66 Blacksmith Shop in Elk City.





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**NE Region November Meeting:** No Meeting was held.  
**SE Region November Meeting:** No Meeting was held.  
**SW Region November Meeting:** No Meeting was held.

**NE Region December Meeting:** No Meeting was held.  
**SE Region December Meeting:** No Meeting was held.  
**SW Region December Meeting:** No Meeting was held.

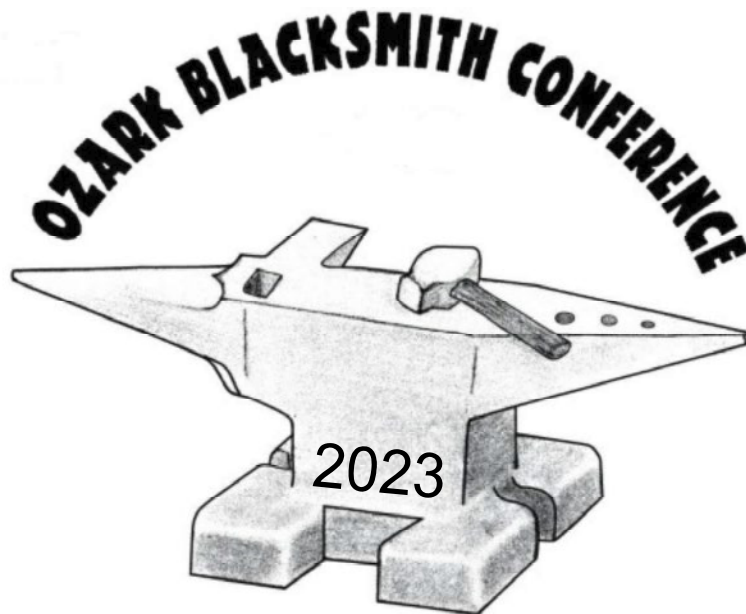


# 31<sup>st</sup> Annual Ozark Conference

April 27<sup>th</sup> - April 30<sup>th</sup> , 2023

Missouri State Fairgrounds  
Sedalia, MO

*pre-registration must be postmarked by April 1<sup>st</sup>*



**Inspiring Art, Knowledge, & Craftsmanship**

If you want more information, please let me know. The information I was given was 12 pages, and I am happy to send it to anyone that asks. -Editor




TICKETS  
-ARE-  
**\$50**  
for  
BOTH DAYS  
(INCLUDES LUNCH)

# LOUISIANA METALSMITHS

RSVP  
for our  
**CRAWFISH SUPPER**  
on  
SATURDAY  
(market price)

**FEATURING**  
*DEMOS*  
**BY**  
*SPECIAL*  
**GUEST**  
  
GORDON  
WILLIAMS  
  
*from* ZION  
BLACKSMITH  
SCHOOL



**AUCTION**  
*with*  
**FORGING**  
**CONTEST**  
*with*  
**RAFFLE**  
*with*  
**DEMOS**

*Saturday*  
*&*  
*Sunday*  
**MARCH**  
**11 & 12**  
*at*  
*Beaver*  
*Park*  
*Pavilion*


**GATES**  
**OPEN**  
*at*  
7:30 AM  
*with*  
**EVENTS**  
*from*  
9 AM 'til

**Fun for**  
*the whole*  
**family!**  
  
**VENDORS**  
**&**  
**TAIL-**  
**GATING**  
**SALES**  
*are*  
**WELCOME**

**RAFFLE**  
**TICKETS**  
*are*  
*available!*  
  
**\$1**  
  
**CHANCE**  
*to WIN*  
*our*  
**TOOLBOX**  
**DRAWING**

BANGIN' ON THE  
BAYOU  
XXIX

**Fun for**  
*the whole*  
**family!**  
  
**VENDORS**  
**&**  
**TAIL-**  
**GATING**  
**SALES**  
*are*  
**WELCOME**



CONFERENCE OF 2023

LAFAYETTE



## GUEST DEMONSTRATORS

Jake James  
Flavio Ortiz  
Leah Aripotch  
Ellen Durkan  
Jay Burnham-Kidwell  
David Roeder

- ▶ Hands-on Education
- ▶ Special Bladesmithing Area
- ▶ Youth Education Area
- ▶ Contests & Games
- ▶ Gallery
- ▶ Banquet and Auction
- ▶ Vendors and Tailgating
- ▶ On-site Meals
- ▶ On-site Camping

CALIFORNIA BLACKSMITH ASSOCIATION

# SPRING CONFERENCE

THE LIGHTER SIDE OF FORGING



2023



April 13-15, 2023

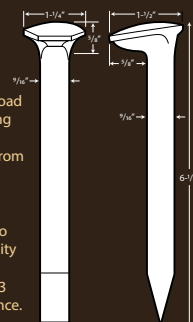
Vista Forge, 2040 N Santa Fe Ave, Vista, CA

The 2023 Spring Conference will host a great series of demonstrations, hands-on education, and fun contests and games for all skill levels, not to mention great food! The 2024 conference committee will host an epic family-style barbecue as well! Plan your trip now and check the CBA website for updates and registration

for info or to register:  
[www.calsmith.org/CBA-Events](http://www.calsmith.org/CBA-Events)

### featuring the Railroad Spike Challenge

The Railroad Spike Challenge lets blacksmiths forge a single common railroad spike into something new. What can you craft from a spike? Something Functional? Artistic? Inspiring? This is your chance to exercise your creativity and have your work exhibited at the 2023 CBA Spring Conference.



### All Entries Welcome

Find out more at  
[www.calsmith.org/event-5082026](http://www.calsmith.org/event-5082026)

## Member's Gallery



My first fork and spoon. -Editor

# Portable Stump aka End Grain Wooden Swage

Jim Carothers 01-04-2023

Back in the day when I did smithin' demonstrations or was teaching nearly every weekend at local museums, craft fairs, or blacksmith group meetings, I needed a stump for an end grain swage to form leaves, spoons, etc.

Those of you who have traveled with smithin' tools know this is a very heavy hobby. I wanted something light that I could put in my bucket of tools, something that would not take up a lot of space, and was easily replaceable anywhere.

These photos show what I came up with. Made from shop scrap, it's just a simple clamping band to hold a block of 4 x 4 wood and a welded-on U-Bent hardie that let me pin the tool to the anvil.

Once the block is used up on one end, I turn it over and go for the other. After that a quick pass across the well-used ends with a saw refreshes all.





## Ring In the New Year



Two Bells made by Bill Clemens – large bell is approximately 2 1/2 " and smaller one is approximately 1 3/4"

### Article by Bill Clemens

I began experimenting with making these bells over a year ago when a how to article appeared in an affiliate newsletter.<sup>1</sup> I quickly discovered that cutting out the bell blank was a stumbling block in making them. I first tried making them from thinner material than called for and found out that they don't form well from thin material. I then cut, ground, and filed one from the right material and was able to complete a bell but wasn't happy with the top half which seemed to be flat bent petals on a round hemispherical base. I next got a dozen blanks plasma cut at a local metal supply shop that only required some grinding on one side to remove the flash. I subsequently have had blanks laser cut and now after having made several dozen bells think I have the "how to" down well enough to offer this article to all.

### Tools

**Top Swedge** – Tailer hitch ball or ball bearing (2" for large bell 1 1/2 " for small bell) with 10-12 inch 1/2 - 3/4 stem welded on.



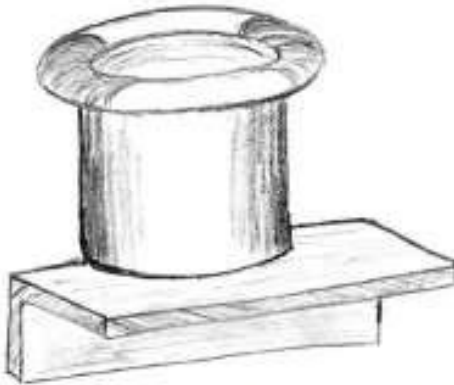
## Ring In the New Year—continued

**Bottom Swedge** – Pipe with top end flared using horn of anvil

Large – ID ~ 2 3/8" (3 inch thick walled pipe)

Small – ID ~ 1 3/4" (2 inch pipe)

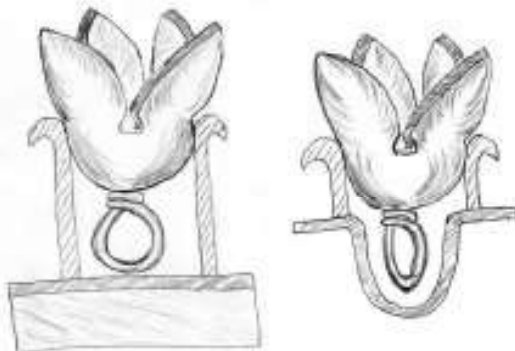
Add angle iron for use in vise or hardy stem for use on anvil.



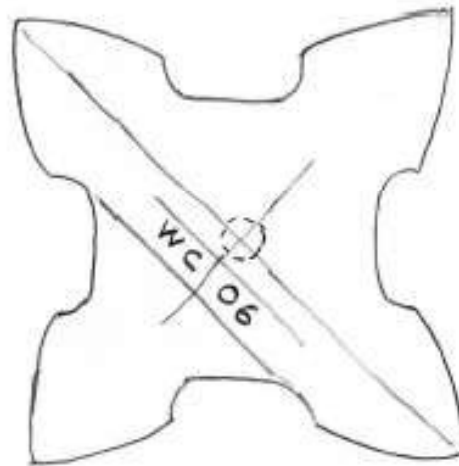
Shown below is a quick hardy stem made from flat stock 1/8-1/4" thick and the width of the hardy hole.



The space from the top of the flared pipe to the bottom of the tool needs to allow the bottom of the bell and ring to be inserted. This is a minimum of 2 3/4" for the large bell and 2 1/4" for the small bell



**Bell Blanks** – Cut (or have cut) bell blanks using the templates at the end of this article. Use 3/16" (or 7 Gage) for the large bell and 1/8" (or 11 Gage) for the small bell. Make a center punch hole on the inside of the blank for drilling the stem hole and touch mark the blank on the outside.



You may also decorate the outside of the bell at this point such as adding leaf veining to each of the 4 petals of the bell as shown here:



Dish each of the petals of the bell blank using a spoon swedge and ball pein hammer.

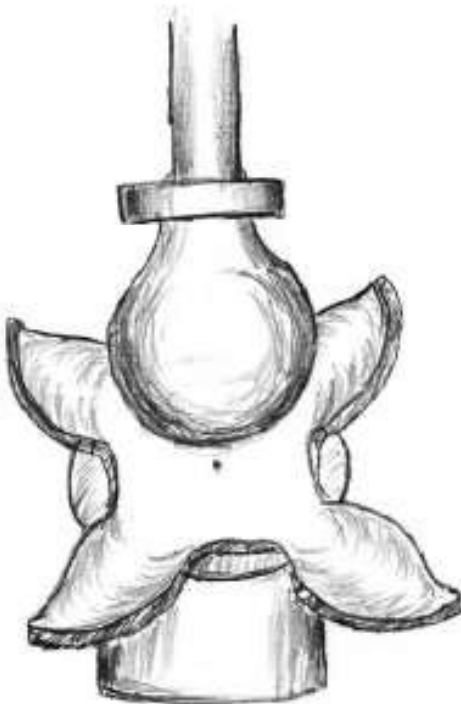


## OUR FRIEND'S FORGE

Newsletters from other blacksmith associations

### Ring In the New Year—continued

**Form Bell** – Heat the blank uniformly to a yellow heat and begin sinking it into bottom pipe swedge with the top ball swedge. This will take several heats as you are upsetting the material between the bell's petals.



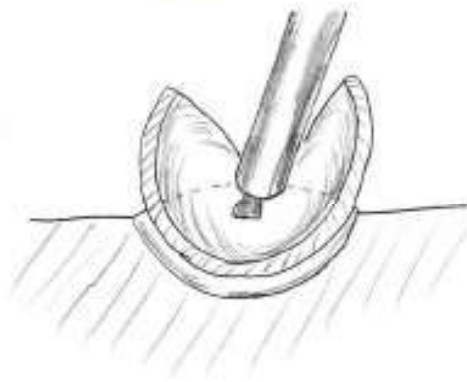
To help shape the bell use the top ball swedge on the anvil to smooth out and round the portion of the bell being upset between the petals.



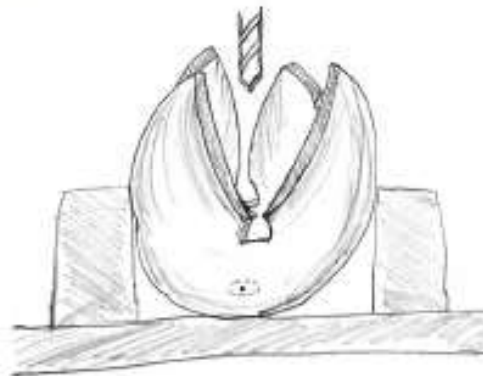
**Continue** sinking the bell until the ball swedge can just be removed from the bell.



Use the smaller ball swedge on the large bell or a 3/4 inch rounded end rod on the small bell to round out the area between the petals into a ladle swedge block.



**Stem** – Drill 1/4" hole in bottom of bell to accept stem





## Ring In the New Year—continued

Forge stem from 6 inches of 1/4 inch round. Head one end and taper 1 1/2 inches of other end to a blunt taper.



Heat the headed end of the stem and insert in the bell bending the stem at approx 90 degrees close to the bell.



Heat and flux the stem head and then wrap with copper wire. Preheat the bell and then reinsert the stem. Heat slowly to near welding heat watching until the copper wire melts.



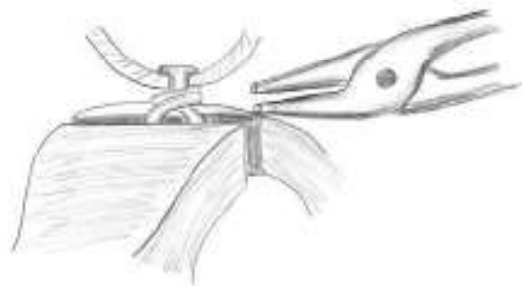
Remove from forge and hold head in place until bell cools and copper hardens.



Heat stem and form ring with scrolling tongs. Take care not to overheat the bell and break the copper braze.

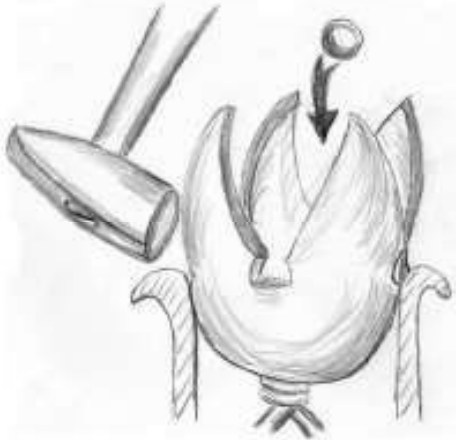


Heat tapered end and wrap around stem with scrolling tongs to finish ring.

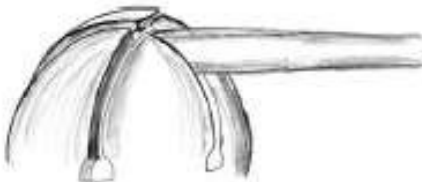


## Ring In the New Year—continued

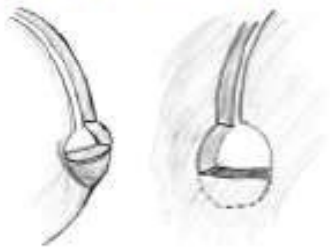
Place bell in forge with petals down and heat to bright orange. Set bell in pipe swedge, insert ball bearing (3/8 to 7/16" for small bell 1/2 to 5/8" for large bell) Hammer petals closed with gentle blows near their base.



Space petals with thin tapered chisel/fuller while using a hammer to close them.



**Completed** bell has a bulge where the metal has been upset between the petals and the hole at the end of the slots is not round but flat on the bottom. You may choose to leave the bell like this or remove it. It does not seem to have much affect on the sound of the bell. First file or grind the bulge flush following the contours of the bell. Next, with a round file or die grinder, round the bottom of the hole.



The bell should be heated again to critical temperature (nonmagnetic) and quenched to improve its ring.

**Options** for the bells include using a nut and bolt in place of the ring to fasten the bell(s) to a leather strap. You could also drill and tap the base of the bell to accept a bolt for this same purpose.

### Materials List for Bells

#### Tools

##### Top Swedge

Trailer Ball or Ball Bearing  
Large Bell - 2"  
Small Bell - 1 1/2"  
10-12" 3/4 round for stem

##### Bottom Swedge

Pipe with top edge rolled  
Large Bell - 2 3/8" ID  
Small Bell - 1 3/4" ID  
Angle Iron for base in vise  
Hardy Stem for use on Anvil

##### 3/4" round end Fuller

##### 1/2 - 3/4" wide thin tapered Fuller

#### Bells

Blanks cut using template on following page  
6" 1/4 inch round for stem/ring

##### Ball bearing for Ringer

3/8 to 7/16" for small bell  
1/2 to 5/8 " for large bell

##### Copper Wire to forge braze Stem to bell

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This article is based on a article by Steve Alling that appeared in the Nov-Dec 2005 issue of The Upsetter, the newsletter of the Michigan Artist Blacksmith's Association.

Reprinted from the January/February 2007 Newsletter of the Blacksmiths Guild of the Potomac.

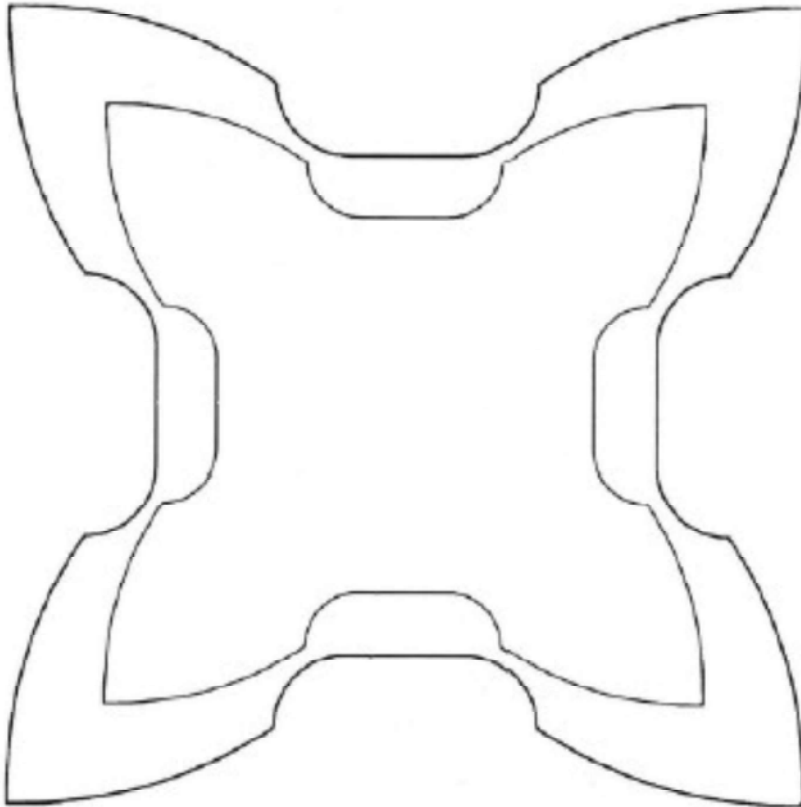
Bill Clemens, January 18, 1953—July 31, 2017

**Ringin' In the New Year—continued**

**Scale Drawings for Bell Blanks**

Large –measures 6 1/2 "diagonally corner to corner – use 3/16" (7 Ga) Stock

Small –measures 4 7/8 " diagonally corner to corner – use 1/8" (11 Ga) Stock



## Leaf Napkin Ring

Tim Mann, Arnold

Mario Baggiolini, Sonora

Material: 1/2" x 1/8" x 5 3/4" mild steel

Steps:

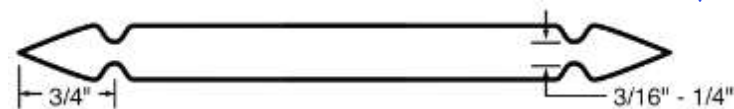
1. Radius ends of material to prevent "fish lips."



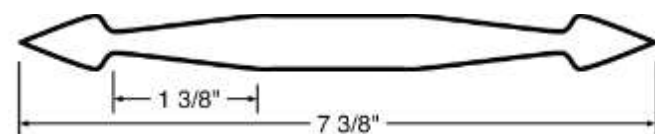
2. Forge short points on each end.



3. Fuller back about 3/4" and down to about 3/16" - 1/4" neck at each end.



4. Draw a long taper, approximately 1 3/8" long, back from the fullered ends.



The blank should be about 7 3/8" long overall.

5. With the rounding hammer, spread the leaves to a pleasing form.



### *The Saturday Afternoon Blacksmith Series*

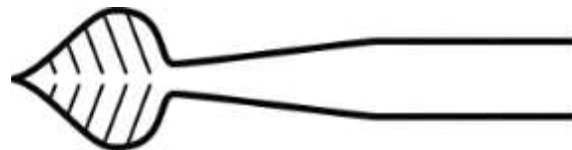
*This is one of our new series, projects that should be achievable by Level 1 students in an afternoon*

### Tools Required

1. Hammer
2. Tongs
3. Scroll tongs
4. Chisel (small)
5. Spring fuller (3/8")
6. Mandrel (1 3/8" dia.)
7. Rounding hammer
8. 16 oz. ball pein hammer
9. Block of wood



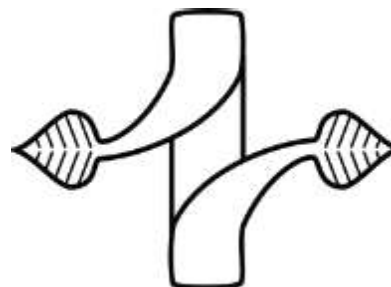
6. Chisel the veins into the leaves for a decorative touch (or not).



7. With a ball pein hammer, hammer on the backside of the leaf against a block of wood, to give it a negative form.



8. Over a mandrel hammer the blank to give it the ring shape, then with scroll tongs twist the leaves so that they are perpendicular to the ring.



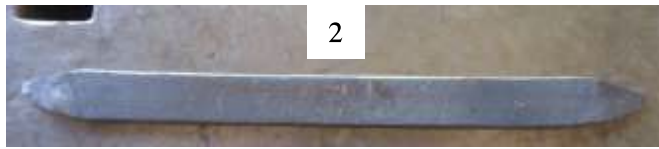
9. Wire brush and hot wax.

*This article is reprinted with permission from the California Blacksmith's newsletter, Nov-Dec 2022*



## Photo Essay:

*Following by Step Numbers*



*This article is reprinted with permission from the California Blacksmith's newsletter, Nov-Dec 2022*

## Shape & Form:

### Forging to Shape vs Forging to Form

Mike Chisham, Petaluma

Before a blacksmith can begin their journey into the transformation of hot metal into works of art, he/she must learn one basic concept. The difference between forging to shape as compared to forging to form.

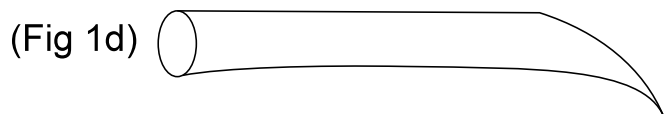
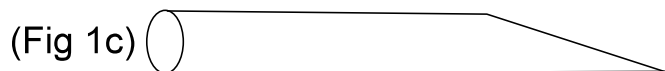
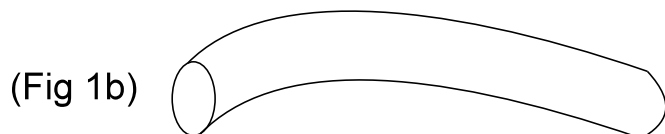
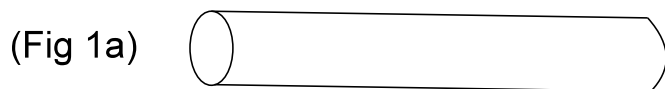
Let's start with a basic concept. Let's look at figure 1.

Fig 1a: shape is straight and form is round.

Fig 1b: shape is curved and form is still round.

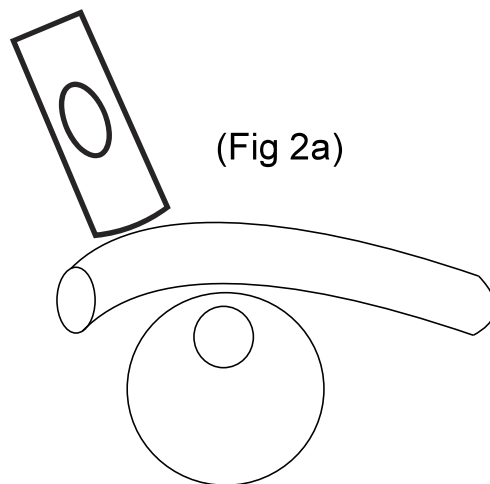
Fig 1c: shape is straight and form is round on one side and a long flat taper on the other.

Fig 1d: shape is curved and form is still round on one side and a long flat taper on the other.



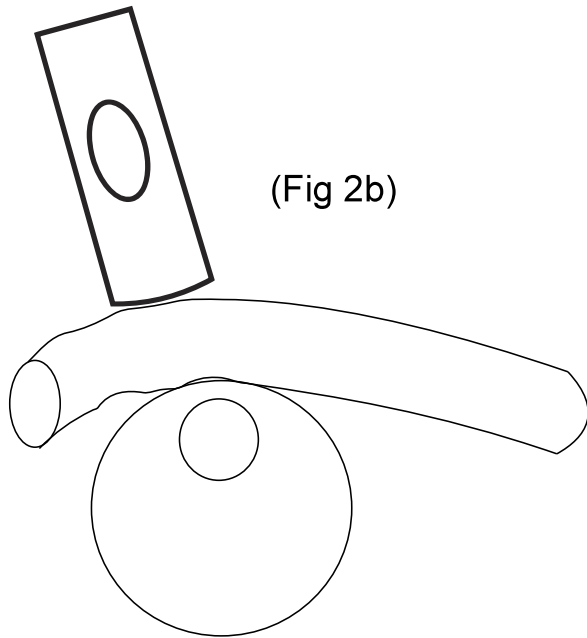
When forging hot metal, you either forge to form or you forge to shape. It's not a good practice to forge to form and shape at the same time, though it can be done.

A hint to determine whether you are forging to form or to shape is to listen to the sounds you are emitting as you strike your metal. When the metal of your hammer contacts the metal of your anvil, you will hear a ring ring sound. This I term as a metal to metal sound. Metal to metal means you are changing the form of your metal. When your hammer is metal to air, you will hear a clunk sound as opposed to the ringing sound. If your metal is not being transformed into a different form, which happens when you hear the ringing sound, then you are changing its shape and not changing its form. Then you will hear the clunk clunk sound as you forge your metal.

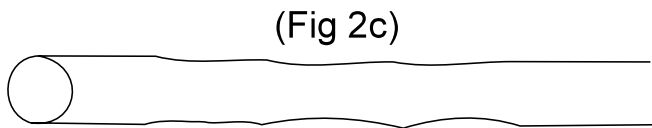


Let's apply this to some simple, everyday type forgings. (Fig 2a) Let's take your round rod. As you forge it over the horn, you are trying to achieve a curved shape that mimics the roundness of the horn. You want to change its shape into a curve but still want to maintain its round form. As you hit your metal and your hammer blow is a little ways off the horn of the anvil, or metal to air, you will hear a clunk sound as your metal takes on a curved shape while still maintaining its round form.





(Fig 2b) If your hammer blow contacts the metal of the horn, then you will be changing shape somewhat, but at the same time you will be changing the form of your metal. It will now be a round form that has rounded divots on the horn side and flat spots on the top side where it was compressed between your hammer and the metal of the horn. Metal to metal, characterized



by the ring ring sound. (Fig 2c) After forging metal to metal over the horn and you straighten your metal and return your metal to a straight shape, you will see how much you changed it's form while thinking you were only changing it's shape.

Listen to your tools, they know exactly what's happening. They never lie!

**From Mike Chisham**

While talking about a new project, I found myself repeating a phrase I learned from Francis Whitaker. "There is never enough time to do things right the first time but there is always enough time to do it right the second time. But you only make money the first time around".

Another line he used a lot was, "Measure twice, cut once".

From Frank Turley, Santa Fe, New Mexico.

"If you want to get around, you have to soar". When forging to obtain a round point, he has a formula of which many smiths live by. First you forge a Square point. Then you forge the four edges to form 8 facets. Once you correctly forge to an 8 sided point, it will appear to the eye as round, thus And Round.

So if you want to get a Round, you have to Square, Octagonal, And Round.

Somewhere along our paths, Francis Whitaker and I came up with a collaborative litany that I still remember to this day:

"If your eye can't see it, your hand can't make it.

If your hand can't hold it, your hammer can't hit it.

What ever you can't remember.....forget it!"

Francis, like Samuel Yellin, was big on what I call Mentalurgy. Forging in your mind. Figuring out what and how to do it before physically doing it.

# SCABA Shop and Swap



## Anvil for Sale

145 Hays Budden

Excellent Condition

\$750, with \$100 for delivery

Call Justin  
870-260-2473



## Forge for Sale

Champion 400 blower and forge table -all in good shape-no cracks  
\$400 James Coldren 580-761-8235 Coldrenj.s@gmail.com



# SCABA Shop and Swap



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# SCABA Shop and Swap

## Limited Edition SCABA Anvils

Limited Availability!

Small Anvils - \$500.00 (plus shipping) --- Large Anvils - 700.00 (plus shipping)

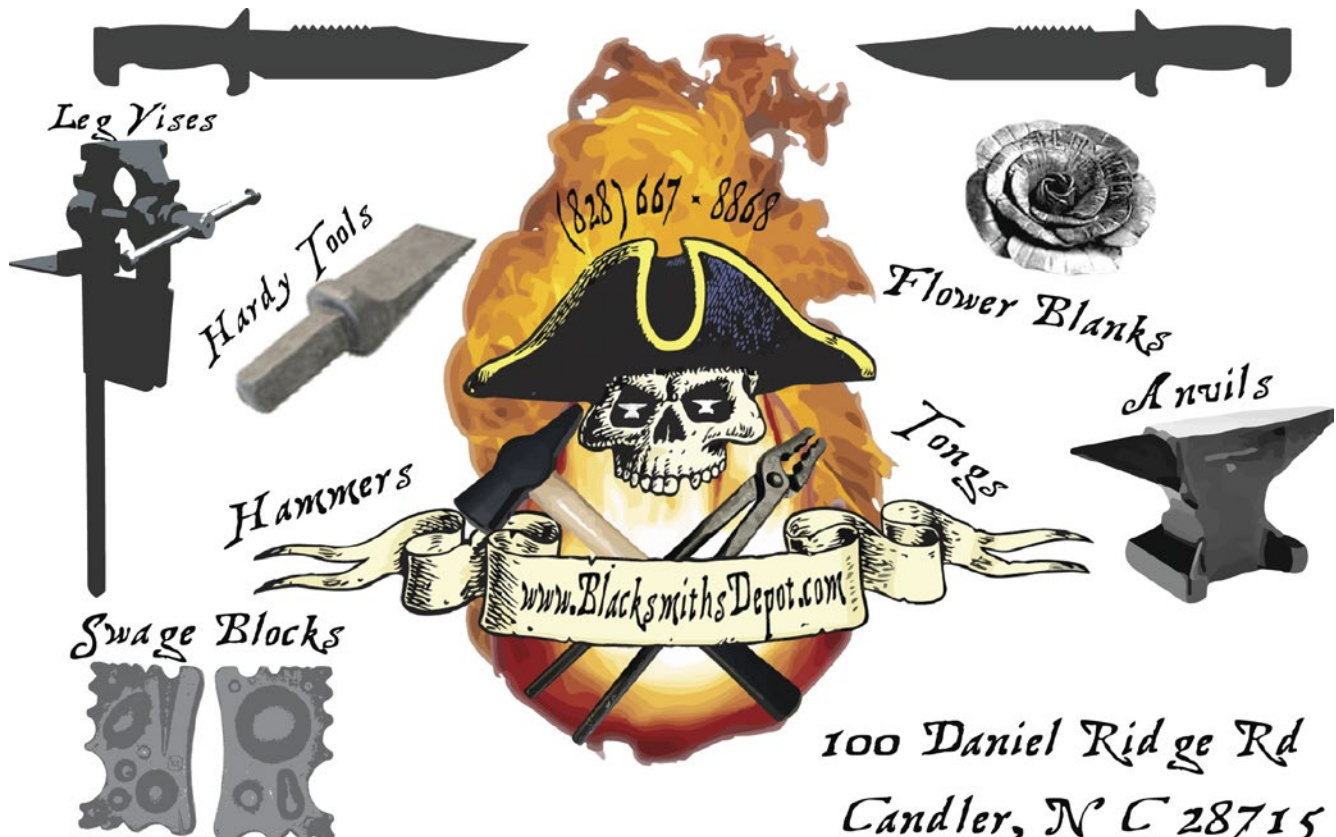
**Contact Byron Doner**  
**405-650-7520**

## For Sale:

### Water Jet Services - Saltfork Discount

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

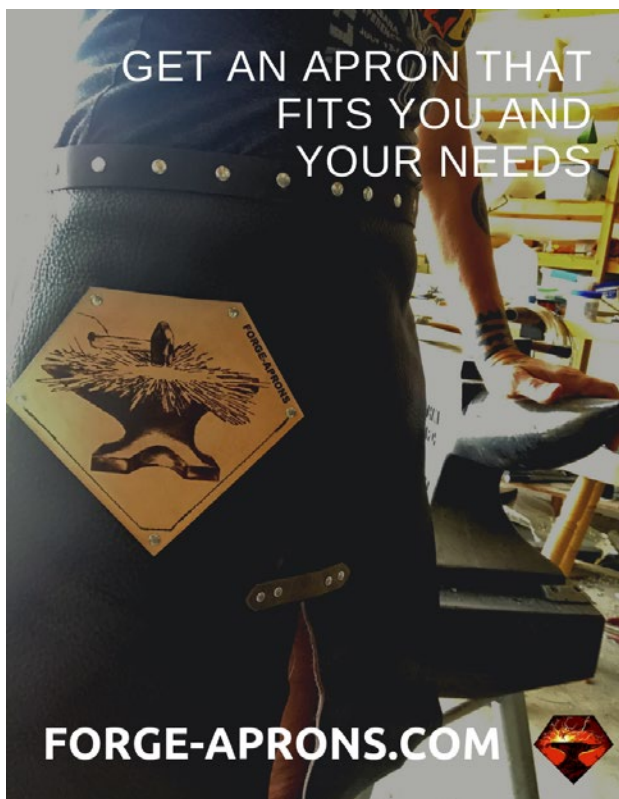
Contact: **Ragnar** at [rtaswallson@yahoo.com](mailto:rtaswallson@yahoo.com) or **918-855-8250**.



*100 Daniel Ridge Rd  
Candler, N C 28715*

# SCABA Shop and Swap

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# SCABA Shop and Swap

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

## Limited Quantities of Quench Oil Available!

Please contact one of the following people if interested:

Mandell Greteman 580-515-1292

Brad Nance 918-774-4291

Byron Doner 405-650-7520



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

## 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](https://www.paypal.com/paytoemail?email=clay@otelco.net). E-mail me at [clay@otelco.net](mailto: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.



# 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

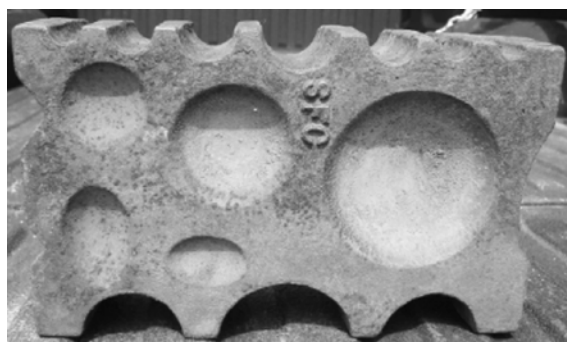
Librarian: Don Garner 580-302-1845 (Cell)  
Call or Text. If you get voice mail, please leave a message.

**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 Swage Blocks

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

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



## SCABA Floor Cones

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

\$375.00 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!

2022 25th Anniversary SCABA T-shirts  
\$25

Stonewashed Blue  
(no pocket)

1 - XL, 1 - 3XL

Deep Royal (Tall)

1 - 4XLT

Smoke Grey (Tall)

1 - 2XLT

Royal (pocket)

1 - 4XL

Sand (pocket)

1 - 2XL, 1 - M

Please contact Carol Doner if interested (text preferred) at 405-760-8388.



### Also Available

Coffee Mugs - \$5

Winter Caps - \$10

Car Tags - \$5

Old T-shirts are \$5.

If interested, ask Carol about sizes and years available.

### 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 the editor 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:

☐ Print Copy

☐ E-mail Alerts for New Newsletters

I have enclosed \$40.00 for dues for one year membership from the date of acceptance.

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

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

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

[www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org)

You do NOT need a Paypal account to use your credit card and registration/renewal is immediate.



## Saltfork Regional Meeting Hosting Form

Region: \_\_\_\_\_ NE \_\_\_\_\_ SE \_\_\_\_\_ SW \_\_\_\_\_ NW

Date: Month \_\_\_\_\_ Day \_\_\_\_\_ Year \_\_\_\_\_

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

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

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

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

Trade Item: \_\_\_\_\_

Lunch Provided: \_\_\_\_\_ Yes \_\_\_\_\_ No \_\_\_\_\_

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

**Return to: Saltfork Craftsmen Regional Meeting Coordinator, Kathrine Mitchell**

14141 S. Hiwassee Rd

Oklahoma City, OK 73165

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

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