

# Saltfork Craftsmen Artist-Blacksmith Association

October 2010



**Saltfork member Omar Reed demonstrating at the Governor's Mansion during September Fest the weekend of the 11th.**

## Northeast meeting

The north East Saltfork Craftsmen met at Pawhuska on September 11 for their monthly meeting. We had a very good meeting and the weather favored us. Laura Krukoske made her first nail and is on her way to becoming a blacksmith. Cindy free gave a great tour of the Bronze Horse again this year. She also fed us a good meal with fried chicken and fixens. There was a good turnout and the trade item was something with a feather. Pat Cowart took some good pictures and are shown here.



## South/Central meeting

The Sulphur Tractor Club, otherwise known as the Murray County Antique Tractor and Implement Association, again allowed us to hold the South Central meeting at their annual show on September 18. Several Saltfork members came to forge, watch, and visit while Don Beigle and I kept the forges hot for the tractor show crowd. Ken Doner came down with his professional photographer's eye and provided some nice photographs for the newsletter. He left his little brother, Korny, at home to cover the State Fair.

This is a particularly good event for us since it gives the club a lot of exposure. There are also several other features that appeal to us smiths, such as an extensive flea market area, a large hit and miss engine display, and, of course, plenty of tractors and equipment. We would have liked to see more Saltfork members there, but the Oklahoma State Fair and other events give us plenty of other things that decrease meeting attendance. We did manage to sign up a new member, Charles Matthews from Mustang. We welcome Charles to the club.

We were also asked to provide some demonstrators for their school kid's day on Thursday, September 17. Don Beigle and I set up for this demo. The MCATIA folks reported that there were over 800 school children there for this special day.



## Oklahoma Draft Horse & Mule Association annual plow day.

On September 11th, Seiling Oklahoma was the host for the annual ODHMA plowing day and was sponsored by Larry Daugherty and his wife Artie.

Not only were there draft horses pulling the old plows, disks and giving wagon rides, there was also sorghum making. Sorghum was made using an old mill and a draft horse walking in a circle to power the mill. Some of the ODHMA guys have built a cooker to boil down the cane syrup. The sorghum came out pretty tasty. Patty and Gary Wright brought their chuck wagon. There were several other Dutch oven cooks and fresh hand cranked ice cream too.

Even if it was a 200 mile round trip for us, we both had a fun day. Saltfork member Levi Rutledge joined us for a time as well.

Jim Caruthers



## President's Notes

Well, another busy month has passed. As with last year, September has given us a full slate of smithing activity around the state. We Saltfork folks have supported tractor shows, community activities, the Oklahoma State Fair, and our customary regional meetings all while continuing to prepare for the 14<sup>th</sup> Annual Conference in Perry on October 16-17.

Again, our support of the Oklahoma State Fair was significant. We provided over 400 hours of demonstration, set-up, and tear down time. This is the club's biggest event in terms of club wide involvement and the number of days. Eleven straight days of demonstrations gave us the opportunity to interact with a large chunk of the Oklahoma population. Many of our members gave up a lot of their otherwise free time to go to OKC to help wave the Saltfork flag. When you see them around, give them your thanks because they certainly deserve it.

You particularly need to thank Byron Doner who coordinated the entire State Fair demonstration effort. He's the guy who made sure that our demonstrators got their free tickets and parking passes, had coal to burn, and water to drink. He also managed the sign-up list and filled in as a demonstrator when nobody else was available.

Our 14<sup>th</sup> Annual Conference is right over the horizon and it is shaping up to be another real winner. Our Demonstrator Selection Committee (David Seigris and Bill Davis) have put together another fine slate of demonstrators. Gordon Williams and Darryl Nelson have been booked for about 18 months. Gordon is a high-energy demonstrator who will keep you on the edge of your seat with his interesting projects and rapid-fire style of teaching. Darryl Nelson is without a doubt, one of North America's foremost animal head artists. It is common knowledge that if you want to see animal heads done in an absolutely amazing fashion, you need to watch Darryl Nelson.

As always, we'd like to see some of your work displayed in the Gallery. This year, Diana Davis has set up an interesting feature for our Gallery. Attendees will be afforded the opportunity to vote on their choice of the best Gallery entry. The winning entry will be awarded the "People's Choice Award". Long-time Saltfork member, Tommy Dean, suggested this award. Our thanks go out to Tommy and Diana for putting this event together

You don't want to miss this conference so send your registration in now. Early registration helps us with meal planning and other support items as well. If you can spare the time, come up early and help with the set-up of the Noble County Fairgrounds facility. Also, plan to bring a few donation items for the Iron-in-the-Hat raffle and the auction.

So, as you can see we have another great conference on tap for you.

See you there.

Gerald Franklin

## Basic Workshop Schedule

Basic Workshop Schedule Oct 30, 2010 at Elk City's Rte 66 Museum

Oct 30, 2010 at Bill Phillips' Ranch near Indianola, OK

Projects include S-hooks, leaves, a forge welded flux spoon, a hot cut and center punch, steak turner and more.

Cost is \$20, which covers all materials and lunch.

To register for either of these classes, email Gerald Franklin at [franklin@myrhinomail.com](mailto:franklin@myrhinomail.com) or call 580-467-8667. Your Saltfork membership must be a current to enroll.

## **Demo opportunities**

Please check out the request listed below. Try a public demo. At least once, you might find you like it.

**Date: Sept 28– October 2nd...Red River Valley Fair in Paris Texas.** Event contact person is Rita Haynes, Executive assistant of the Red River Valley Fair Association, 570 E Center St. Paris Texas. Contact Rita Haynes at 903-784-7971. Demo is under a covered pavilion so is protected against the weather and is patrolled by police so is relatively secure. You can expect to be able to sell small ticket items or just demonstrating. The website for the RRV Fair Assn. is <http://www.rrvfair.org/>

**October 2nd 2010 AMBUCS "Winning on the Trail" Benefit** at the Chisholm Trail Heritage Center in Duncan, Ok. Starts at Noon. Sales tables are welcome (encouraged) This event has been well attended in the past. Point of contact is Gerald Franklin, 580-467-8667.

**October 9th 2010..8 am-4pm...** Tyner Tractor Club Gathering at the **Blackwell Fair Grounds**. SCABA contact person is Jim Carothers at 580-336-9213. Event contact person is Chuck Webb at 405-747-5007 or Truman Stiner at 580-363-3309.

**November 6-7 2010...Women in the Outdoors event at Tenkiller State Park.** They need someone to come and teach 4 classes of 3-4 hours each. The Event contact person is Leann Bunn, Tenkiller SP. The SCABA contact person is Gerald Franklin at 580-252-6002. The curriculum for the class is usually a drive in hook or similar item. Gerald is asking for help on this event.

## 2010 State Fair of Oklahoma

Saltfork Craftsmen were once again represented at the fair this year. This is our second year to participate at the fair in the “Oklahoma Frontier Experience” area. This is a section of the fair dedicated to teaching fair goers about Oklahoma history and early way of life. I think that the crowds were larger this year than last and maybe by the time we get a third year behind us we will be an even larger draw for that area. I know that we gained several new members during the fair and the two days that I worked we educated a lot of kids and adults alike that Blacksmithing is alive and kicking in Oklahoma. This is one of our best opportunities to reach a large number of people in one location. We would have to travel a lot of miles and do a lot of small town celebrations to reach the same number of people.

Aside from the Wild West show, the blacksmiths were the largest draw, Even the bowl turner didn't have as large a crowd as we did. He would even close down and leave for hours at a time because he didn't have anyone around. The Wild West Shows were at 1:00 and 7:00 pm with smaller shows that started about 30 minutes to 1 hour before. During the day, fair goers would come by in small groups and watch the smiths work. But about the time the show would be getting ready to start , large crowds would stop by the Blacksmith shop to watch and ask questions of the workers sometimes only leaving when the Wild West show had started.

Byron Doner and I worked together on Friday keeping one forge going all day. Byron would forge for an hour or so while I talked to people and made sales and then we would swap or one of us would take a break for lunch what ever the case would be. I feel that this worked out best for us as it gave each person a break from the hammering and heat of the forge. On Saturday it was Terry Jenkins, Byron Doner, Bill Davis and Myself. We had two forges going all day with Byron and Bill swapping off as Terry Jenkins is use to forging all day long and he only took a break for lunch. Being that I wasn't needed that much I took a quick tour of some of the building close by. I find as I get older, I don't enjoy fighting the crowds like I did when I was younger. Go figure. I quickly came back to help out in the booth.

On Friday, Byron made a crab from a horseshoe like the one that Tony Cable demonstrated earlier in the week. On Saturday, as a challenge from Byron, I did try to make a crab from a horse shoe. I threw it in the slack tub and didn't retrieve it until Bill and Byron left to go get something to eat. Them, without an audience, I finished it up. I think it looks like it is a victim of a tragic boating accident.

Sunday is the last day of the fair with tear down being on Monday. We hope that those that wanted to work at the fair go to if not please let Bryon Doner or Diana Davis know that you are interested in being a State Fair of Oklahoma demonstration opportunity worker. We plan to be at the fair again in 2011.



Kent Hadick working on Friday 17th.



State Fair project leader..Byron Doner

More scenes from the fair.



Mark Carter and Kent Hadick on Thursday the 16th



Byrons crab from Friday.



Mine from Sat.



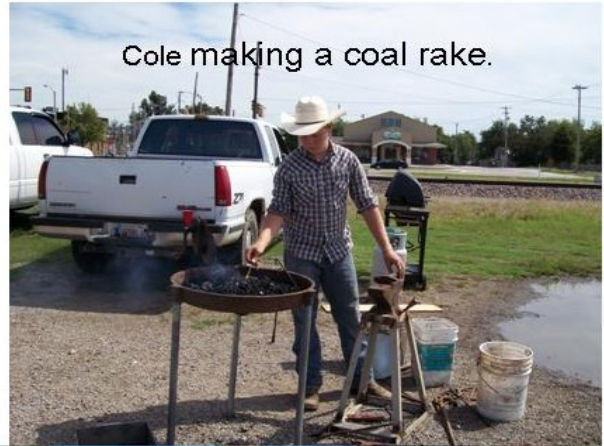
Terry Jenkins and Bill Davis from Saturday 26th.



Saturday, September 25, 2010 Saltfork Craftsmen was represented at the Chelsea, OK Jamboree. Dan Cowart and Mike Krukoski had two forges going all day and had several people who made items such as hooks, rakes and one rail spike knife. Below are some pictures that were taken. Mike, Christina and Laura who manage the open air market in Chelsea on Saturdays in the spring and summer are all three learning the blacksmith trade.



Smell that rose.



Cole making a coal rake.



Christine with her hook.



Larry making a hook.



Laura making a nail.



Article submitted by Dan Cowart.

## Tool Box???

This list needs some filling out. We need members to step up and make a tool for the box. Don Garner has the box ready to be filled up. ***PLEASE contact Don and let him know if you will be bringing a tool for the box or if you need to ship them to him.***

This is a starter list for the tool box that SCABA will be raffling off this year at the Conference in October. Get started making a tool or two today. Don Garner is in charge of the tool box this year. If you want to help sell / buy some of the chances Diana has the tickets. If you want a chance on this box , they are \$2.00 each and you can mail your money in along with your contact information. You don't have to be present at the time of the drawing and the club will ship the box/tools anywhere in the lower 48

## State fair project.

Below is a list of the workers at the fair. Give them a big "Thank You" for their hard work. This was 11 days of promoting the Saltfork Craftsmen Organization.

Thur. 16— Gerald F. Byron Doner, Mark Carter, Kent Hadick  
 Fri. 17—Tony Cable, Kent Hadick  
 Sat. 18th—Ron and Eric Lehenbauer.  
 Tony Cable, Byron Doner  
 Sun. 19th — Ron and Eric L. Tony Cable  
 Mandell Greteman.  
 Mon. 20th - Mandell Greteman. Don Garner.  
 Hilario Jimenez, Byron Doner  
 Tue. 21st —Mark Carter, Byron Doner  
 Wed. 22nd —Doug and Linda Bliss,  
 Fred Hunholz, Byron Doner  
 Thurs. 23rd —Mark Carter, Fred Hunholz  
 Byron Doner  
 Fri. 24th —Diana Davis, Byron Doner  
 Sat. 25th —Terry J., Diana Davis, Bill Davis,  
 Byron Doner  
 Sun. 26th.—Terry Jenkins. Gerald Franklin,  
 Byron Doner

Tool/Item	
Box	Don Garner
Hardware for toolbox	
Cross peen hammer	09 left overs
Straight peen hammer	09 left overs
Rounding hammer	09 left overs
Tongs:	
¼ v-bit	
3/8 v-bit	
½ v-bit	
¾ v-bit	
¼ flat	
3/8 flat	
½ flat	
¾ flat	
Scrolling	
Side grip	
Pick up tongs	
Fire tools (Shovel, rake, poker)	Mark Carter
Hot cut hardie	
Cold cut hardie	
Twisting wrench	
Treadle/Hand Hammer Tooling	JC Banks
Set of punches and holder	
Center punch	
Chisel, large	
Chisel, small	
Chisel, hot slit	
Slitting chisel	
Hold Down	Dan Cowart
Flat wire brush w/handle	
File, flat bastard cut w/handle	
File, half round w/handle	
Set of monkey tools	Gerald Franklin
Rivet backing tool	
Rivet setting tool	09 left overs
Hacksaw Square, bevel gauge	Ma
Bolster plate	David Seigrist
Square	
Dividers/Compass	
Scribe	Gerald Franklin
Bending forks	Tommy Dean
Spring swage (necking down)	
Flux spoon	Jim Carothers
Metal folding ruler 24" or 72"	Dan Cowart
Soapstone	Diana Davis
Ball tool (round blunt nose punch)	Gerald Franklin
Hook Ruler	Gerald Franklin
Iron Mountain Flux	
Finishing Wax	Jim Carothers
Nail Header	
Dual Caliper	
Total value to date:	

## SCABA Shop and Swap

### For Sale:

Army surplus round nosed pliers, make good scroll pliers for small items. They are 6" long \$5.00 each plus shipping. I also tie brooms on your handle or mine. \$25.00 plus shipping. Diana Davis 580-549-6824 or Diana-copperrose@hughes.net

Bridge anvil, fairly good conditions, \$150.00  
Contact Dustin Sypher for more info.  
tallgrassforge@yahoo.com

### Wanted:

Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or o Mike-Marideth@sbcglobal.net

## Club Coal

Saltfork Craftsmen has coal for sale. Coal is in 1-2" size pieces The coal is \$140.00/ton or .07 /pound to members **No sales to non-members.**

### NW Region coal location:

Bring your own containers. Contact Tom Nelson at 1-580-862-7691 to make arrangements to pick up a load. **DO NOT CALL AFTER 9 P.M.** If you make arrangement well in advance, Tom can load your truck or trailer with his skid steer loader. Otherwise you will need to bring a shovel. The coal can be weighed out at the Douglas Coop Elevator scales.

**NE Region coal location:** Dan Cowart also has coal to sell. He can be contacted at ddcowart@gmail.com or CowartPat@gmail.com

**Show pride in your organization by displaying one of our tags on your vehicle. We still have the Saltfork Tags on sale while supplies last. You can order one for \$5.00 each. Contact the editor for more info.**

**We have coffee cups for \$9.00 and caps for \$10.00. Dan Cowart has them or they will be available at the conference.**



## JACKPINE FORGE



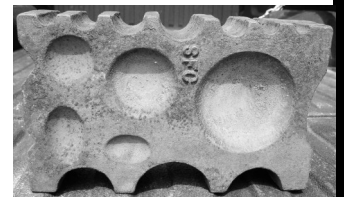
Nathan L. Robertson

Custom-made Blacksmith Tools

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### SCABA swage blocks

\$80. plus shipping to members. (1st block)  
\$100.00 plus shipping to non-members  
Contact Bill Kendall for more information



### LITTLE GIANT

PARTS—REPAIRS—INFORMATION

QUICK CHANGE DIE SYSTEM



Pictured: Lower Base with Flat Interchangeable Die Top

Also available for 25 and 50 LB:  
Upper Die Base Drawing Die Top  
Texturing Die Top Half Round Die Top  
Rail Cap Die Top Half Collar Die Top  
Full Collar Die Top

Photos of all dies are on our website:  
www.LittleGiantHammer.com  
or contact us at:  
Little Giant  
420 4<sup>th</sup> Corso  
Nebraska City, Nebraska 68410  
402.873.6603

New SCABA Floor Cones are now available from Bill Kendall, Byron Doner and Gerald Franklin. The price is \$200 plus shipping and handling.

# Forging Acorns From Steel Pipe

By Steve McGrew

Spokane, Washington

To forge acorns from 1" pipe, you need two important tools: a "pipe stake" and a "spring pipe fuller".

## Tooling- A Pipe Stake

A pipe stake is made by welding two 5" sections of 1.5" round bar to a flat plate, and welding a 3" piece of 1" x 1" bar to the plate to serve as a tang to fit your hardie hole or to clamp in your post vise.



Fig 1. A pipe stake.

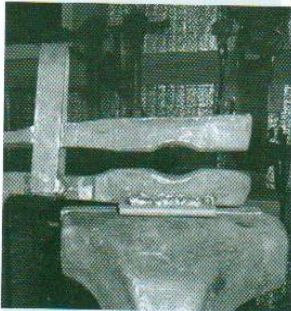


Fig 2. A spring pipe fuller.

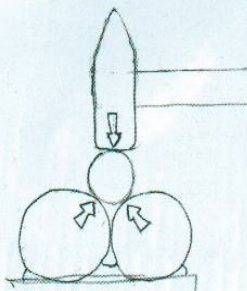


Fig 3. The pipe stake concentrates the force of the blows in three directions.

## Spring Pipe Fuller

The spring pipe fuller jaws need to match the size of the pipe you will be forging. The width of the opening needs to be about 1.5 times the pipe diameter, and the height of the opening should be about one-fourth of the pipe diameter.

The edges of the jaws should be rounded. The shoulders of the tool, which will meet when the tool is closed, should also be rounded. The pipe stake can be mild steel. The spring for the fuller can be water-quenched mild steel, but it's a good idea to use tool steel for the jaws of the spring pipe fuller, because it takes quite a beating.

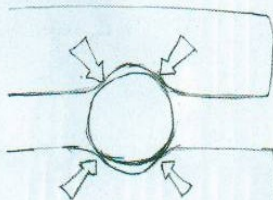


Fig 4. The spring fuller concentrates the force of the blows in four directions.

In order to forge pipe, it is important to hit simultaneously from at least three directions, toward the axis of the pipe. The pipe stake ensures this, providing two "anvil" supports that hit upwards as the pipe is struck downwards by your hammer.

A spring pipe fuller actually hits the pipe from four directions (provided the opening is sufficiently V-shaped).

It's possible to forge a pipe using the step between the horn and

face of your anvil, too, because the step provides two impact points.

## Materials:

About 8" of 1" black iron pipe.

**WARNING:** Do not use galvanized pipe! It produces toxic zinc vapors when heated, which can cause "metal fume fever." A well-known blacksmith has died from complications due to zinc poisoning.

About 12" of 1/4" diameter mild steel rod.

## Forging the Cap Overhang



Fig 6. Using the spring pipe fuller.

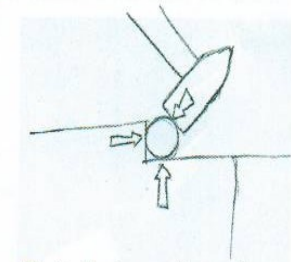


Fig 5. Forging on the anvil step.



Fig 7. The nut end is quenched to the neck.

The first step in forging an acorn is to forge the overhanging part of the cap.

Use the spring pipe fuller to neck down the pipe at an orange or yellow heat about 1-3/4" back from the end of the pipe. Always rotate the pipe about a quarter turn between blows. If you let the necked-down portion get too far out of round, it may be difficult to correct. Neck it down to about half its original diameter.

**WARNING:** When you quench pipe, make sure it is pointing in a safe direction, i.e., away from your body. It is very likely to blast scalding water for 10 or 15 feet! To prevent this, always plug the end of a pipe before heating with some form of cap. A wad of dry



Fig 8. Drive the cap end over the nut end.

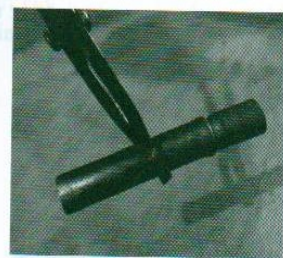


Fig 9. Rolled-over cap end.

paper stuffed into the pipe works, and can be burned out when the forging is finished. If left unplugged, the pipe can conduct hot gasses towards the smith when heating in the forge, as well as direct hot



Fig 10. Forge the nut tip down to nearly 1/4" diameter.



Fig 11. Insert a 1/4" rod through the pipe.

steam up the smith's arm when it is quenched.

At an orange-to-yellow heat, quench both ends of the pipe. The end that will be the nut should be quenched all the way to the neck, and the end that will be the cap and stem should be quenched not quite to the shoulder above the top of the neck. Work quickly at this point, because the neck and shoulder will cool quickly. The purpose of quenching is to minimize distortion of the pipe except at the shoulder that will become the acorn's cap.

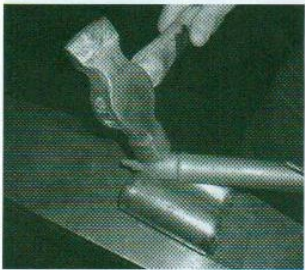


Fig 12. Continue forging the tip to shape.



Fig 13. Forge the tip on the anvil's edge to clamp the rod.

Now drive the cap end into the nut end. The hot shoulders of the cap end will swell slightly and roll down over the cooled nut end.

Now use the pipe stake to forge the short end of the pipe down



Fig 14. Neck the stem down above the cap.



Fig 15. Finish the neck in the flat part of the jaws.

to a shape suitable for the nut of the acorn. As soon as the hole at the end is nearly down to 1/4" diameter, insert a 1/4" rod through the pipe, then forge the nut all the way to its tip. Just forge the tip of the nut down small enough to clamp the rod firmly in place. The rod gives your acorn some extra strength, prevents a hole from remaining at the tip of the nut, and helps if you plan to forge weld the acorn's stem to a branch and leaves later.

To complete the acorn, form the stem on the cap. Do that by using the spring fuller to neck the pipe down again, just above the rolled-over portion. Neck it down as far as it will go in the opening of your fuller, then move to the shoulder of your pipe fuller to neck it down to the final size.

Draw out more of the pipe to form a longer stem if necessary. Cut off the unused portion of the pipe.

Finish forging the stem and the tip of the nut, using the edge of your anvil. Forge the tip thinner and thinner until the end of the rod drops off.

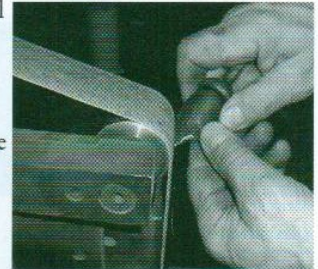


Fig 16. Grind the scale off the nut.

Sand or grind the scale off the nut, leaving the cap rough. If you want to get really fancy, you can use a suitably shaped bolster to hold the acorn, and a "v" punch to texture the cap further. Apply wax or acrylic spray to prevent rust, and you're done!

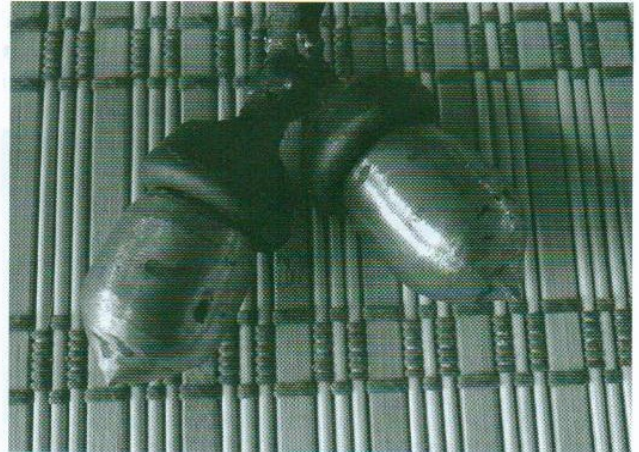


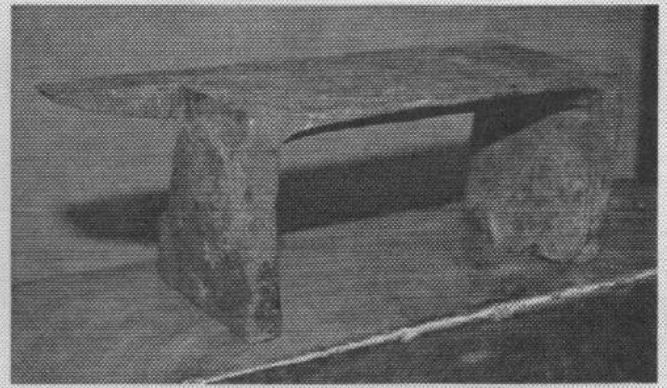
Fig 17. The completed forging.

# Anvil Bridge

by Tom Latané

With the help of Louie Fisher, who works in my shop one afternoon a week, I recently made a tool for which I have felt a need for some time.

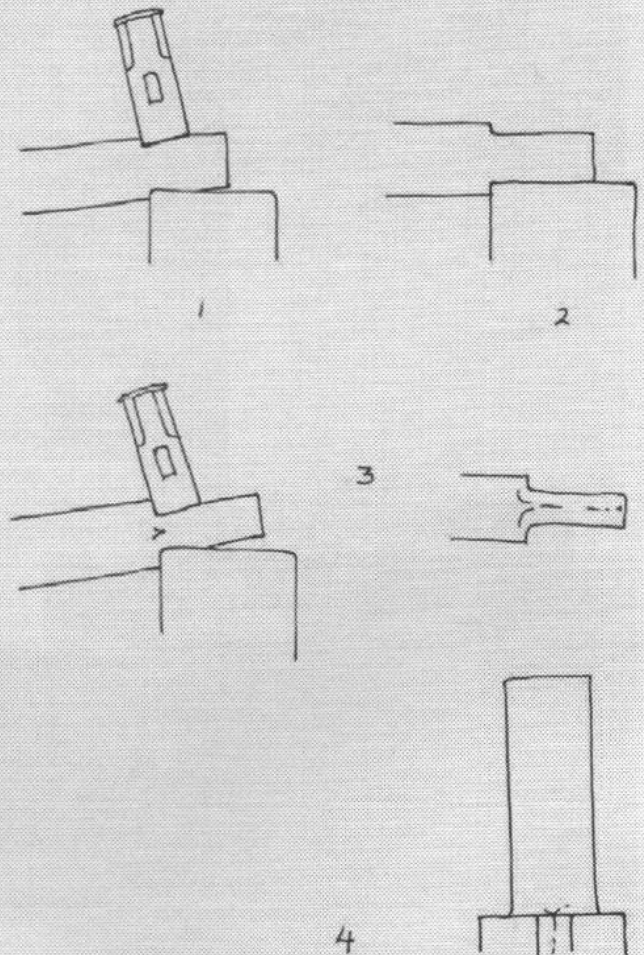
The forging of hinges and other scrollwork with chisel-split branches has always been difficult. Using the edge of the anvil has meant spreading the split members ninety degrees apart for dressing, then working them back together at the desired angle. Working over a tinsmith's hatchet stake held horizontally in the vise always involved a lot of repositioning the stake after hammering.



An anvil bridge provides the acutely angled edge backed up by the mass of the anvil. I designed mine to have one edge beveled like the hatchet stake, one square edge, and a small spur with a longer taper. I considered making the spur a small square horn but thought that the thinner edge might be handier when this tool was in use.

We began with a piece of leaf spring three inches wide and a half-inch thick.

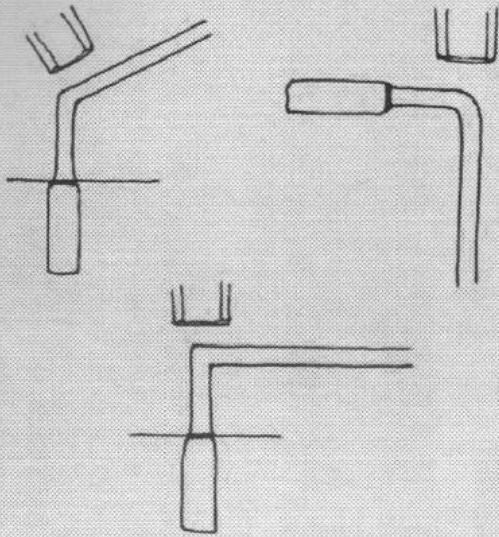
1. Using a set hammer over the edge of the anvil, we created shoulders establishing the top of the tenon.
2. The remainder of the tenon was forged to the depth of the shoulder.
3. This was repeated several times until the width of the tenon had decreased to an inch and the thickness increased to an inch. Some upsetting can be done if the thickness does not increase enough. Longitudinal folds do not compromise the strength of the tenon.
4. With the tenon fit to the hardy hole, the material was cut to a convenient length and the shoulders upset to seat well on the anvil face.



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5. The next step was to forge a right angle bend, toward the horn, about 2/12" above the anvil surface.
6. I marked a spot 2 1/2" from the far end and chisel cut the spur away from the side which would not be beveled. The spur was short leaving a full width at the end for the foot.
7. A second right angle bend was then formed leaving the spur material in the same plane as the bridge top. The foot was then upset or drawn out to create a level bridge top and solid contact for the foot.

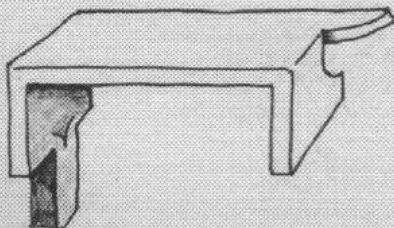
8. A cross pein hammer was used to draw out the edge of the bridge with as little gain as possible in length. A curve in the bridge top resulting from stretching of the beveled edge can be corrected by upsetting the beveled edge from the ends or drawing out the opposite edge.
9. When the heavier forging was all done and the bridge was adjusted to sit solidly once again on the anvil face, the curved end of the spur was cut and it was forged to the desired taper. The bridge was not hardened or tempered.



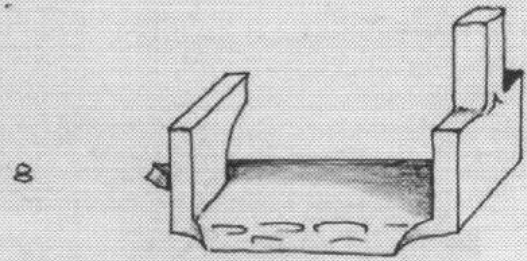
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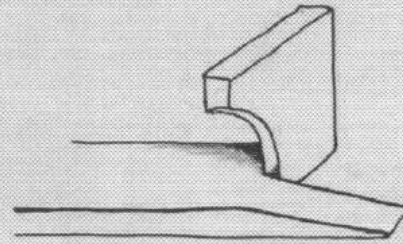
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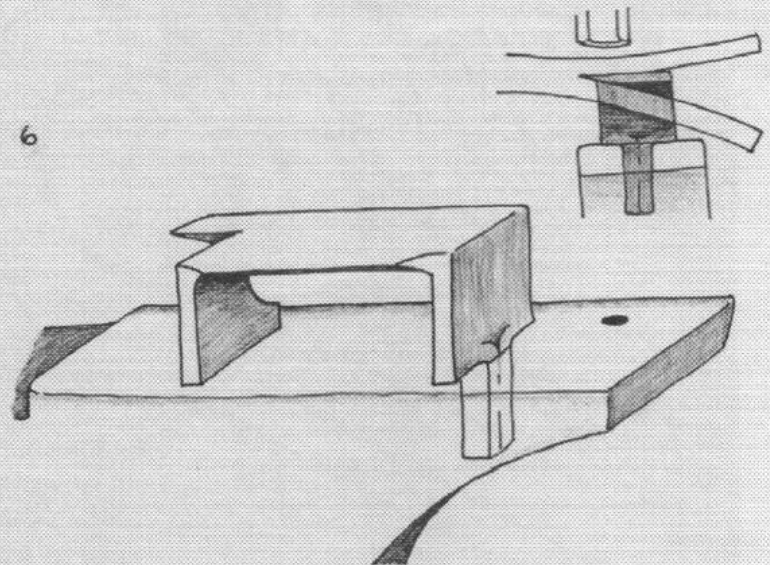
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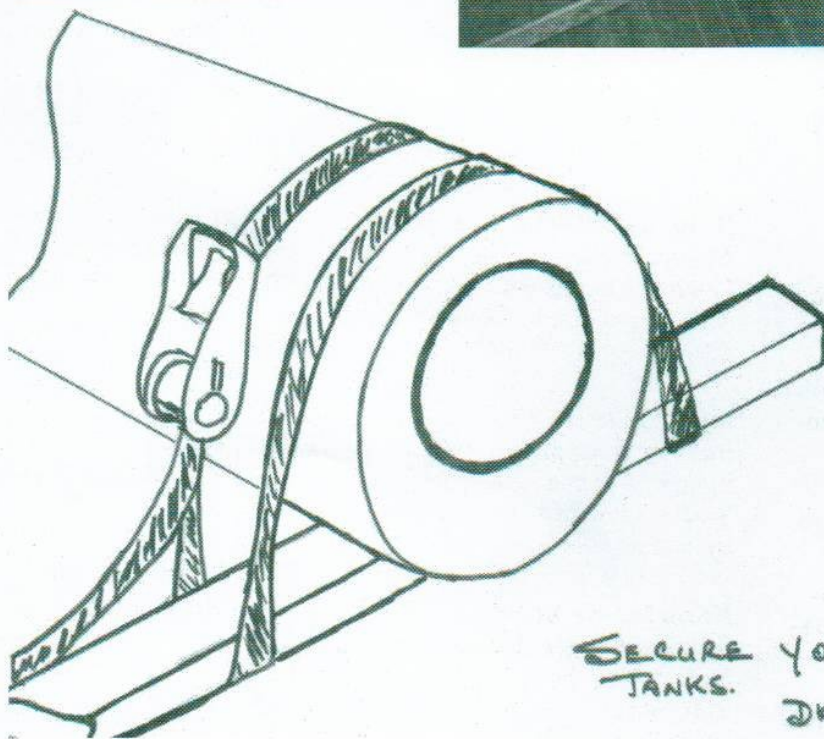
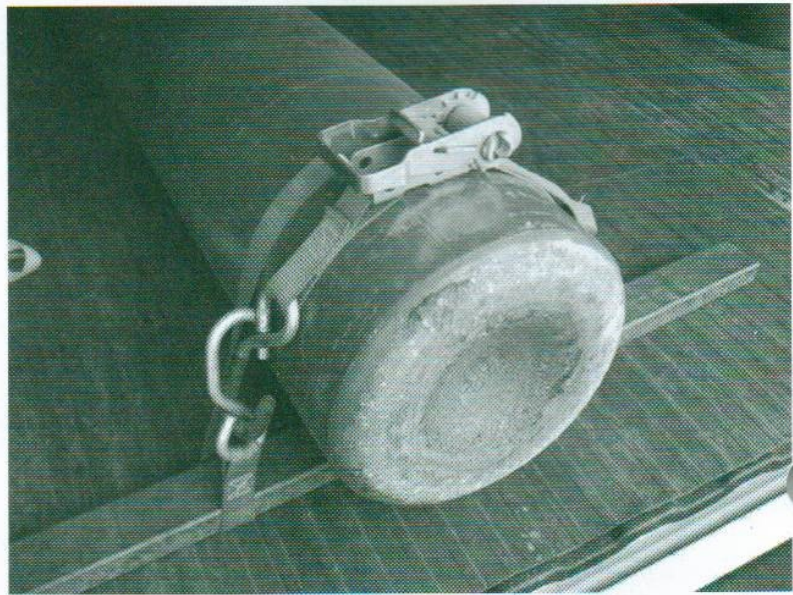
## Hauling Welding Cylinders?

By Doug Kluender

Has this ever happened to you?

You run out of gas in the middle of a job and decide to go the welding supply to get your cylinder filled. You load it in the truck and tie it in as best you can. About the second corner you hear "clunk, clunk, BAM" and feel the truck take a 6" sideways hop—the result of the cylinder coming loose from its bindings.

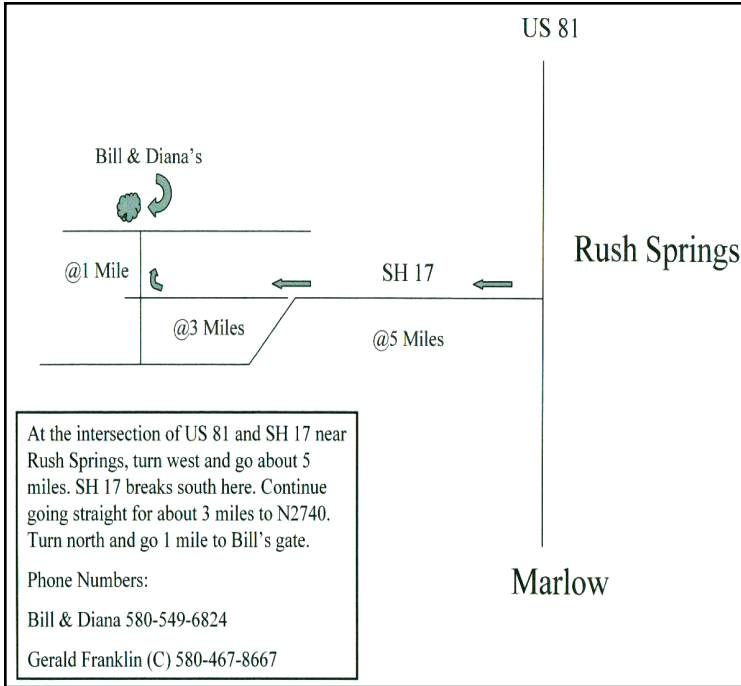
This solution requires a piece of scrap tube or bar 20"–40" long and a tie down strap. Of course it works best if you have a non-slip rubber mat in the bed of your truck.



SECURE YOUR  
TANKS.  
DK 2010



## Maps and Directions to meetings

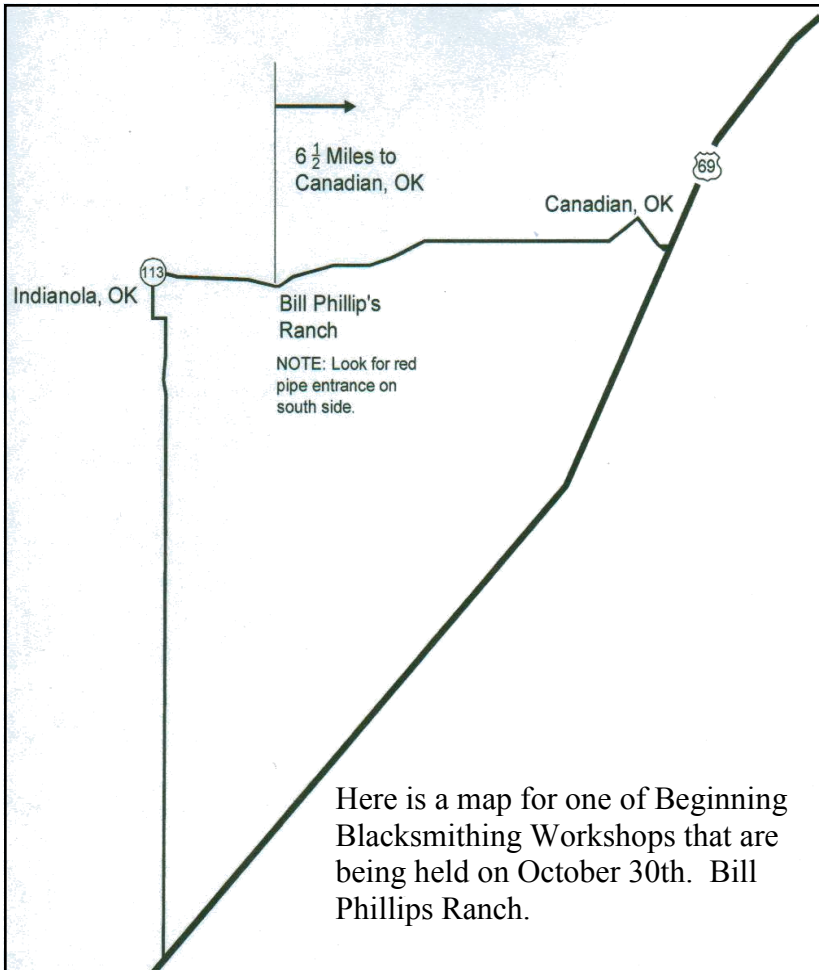
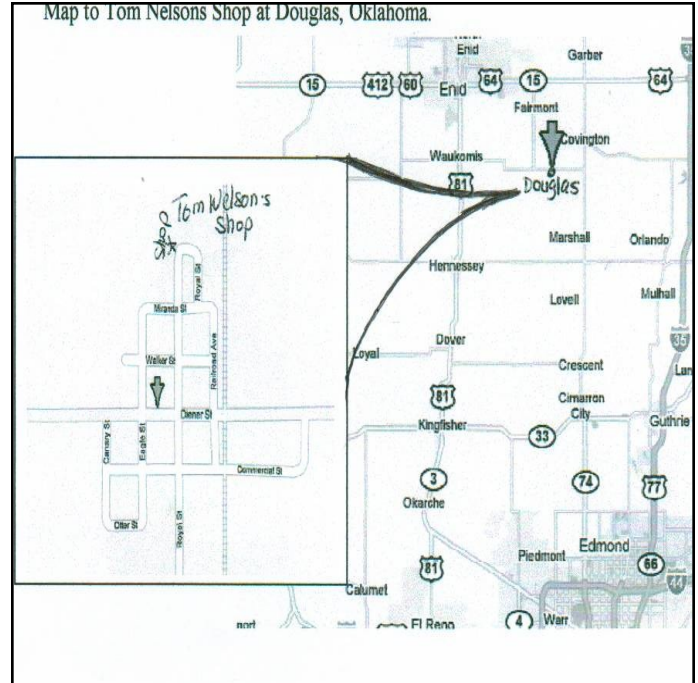


At the intersection of US 81 and SH 17 near Rush Springs, turn west and go about 5 miles. SH 17 breaks south here. Continue going straight for about 3 miles to N2740. Turn north and go 1 mile to Bill's gate.

Phone Numbers:

Bill & Diana 580-549-6824

Gerald Franklin (C) 580-467-8667



Directions to Matt Goyer's place.

Exit hwy 169 at 96th N and go east to 177th St east Ave. (Approx. 3 miles).

Turn Right on 177th St and travel approximately 1/2 mile (up a slight hill). Take the 1st Right. (onto 90th N ) We are the 3rd house on left.

Address 17578 E 90th St. N.

918-272-8424

Matt doesn't have a lot of equipment so bring yours and enjoy a day of forging.