

Saltfork Craftsmen Artist-Blacksmith Association

June 2012

Last year's design winner →



16th Annual SCABA Conference is fast approaching. t-shirt design contest starts **NOW**. Get your design caps on and come up with the winning t-shirt design. Contest details on page 13. Send in as many designs as you want. Last years winner was awarded \$75. in credit to Pieh Tools.

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

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The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization of amateur and professional artist and craftsmen, publishes this newsletter monthly. 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

Notes from the Editor:

I hope everyone is have a safe summer so far. Looks like we are in for another HOT one so be careful about heat related illnesses.

First off this month I need to apologize to Linda Morefield for not get information in the May newsletter about her meeting. We did get the information out the everyone that has a *correct* email address registered with us. If you have an email address and you want to be notified about last minute events with the club please update your information with the editor.

I did get a few phone calls complaining about the contents of the newsletter. It seems one felt that the information was lacking in some areas. He didn't elaborate so I don't know where changes need to be made. If anyone feels that information is being left out of the newsletter I welcome their input. Constructive Criticism is welcome, Criticism is not. Everyone needs to remember that I am the Editor, that means that I take what people send me and "Edit" it to work in our newsletter format. If an event is not in the newsletter there could be two reasons. 1st..it didn't make it to me by printing deadline and will be in the next newsletter if it doesn't get lost on my desk and 2nd. No one sent me any information about the event. I am not going to make up an article. If you attended a meeting, take the initiative to send me an email and tell me about it. I have printed several peoples views of the same event in past articles. I appreciate everyone that sends me information for the newsletter. I can't make every event in the State. They don't pay me enough and I have a family just like you and have obligation to them same as you.

OK, I'm off my soap box for not. Hope to here about events that you attend or know about so everyone can find something cool to do this summer.

DD



From the Prez

Gerald Brostek

For those of you who do not know me, I would like to introduce myself. I was born in 1942 up north. After serving 4 years in the United States Marine Corps, I worked for seven years in the steel mills of northern Ohio where I got addicted to hot steel and how it could be manipulated. I eventually met Bob Patrick and formed a partnership. We operated a Blacksmith shop in southern Missouri during the early 1970s. I joined ABANA in 1974 and attended my first Blacksmith Conference at Carbondale that year where I really got addicted to the craft. Bob and I struggled greatly trying to make a living as blacksmiths in a rural Missouri. I finally had to pull up stakes and head for Oklahoma to find work in the oil fields. I retired from the U.S. Army Corps of Engineers where I served as Navigation Maintenance Manager. I have been forging metals intermittently for the past 40-some years. I joined Saltfork Craftsmen in 2006 on the advice of Bob Patrick who told me “there are some pretty good smiths in Oklahoma.”

As your new President I want to continue what Saltfork’s past President’s, Officers, and Directors have done in promoting our craft, sharing our knowledge, and educating our new and inexperienced members.

One of my goals as your president is to encourage some “new blood” into the Saltfork Craftsmen ABA. We will need folks to fill Board positions in the future. We need someone to serve on the Conference Committee, and Workshop Coordinator as well as folks to teach or co-teach workshops. Many of those who now serve are ageing as I am. I would like to see some of you younger folks step up. Not to worry, you will get plenty of help and guidance as I have received in my first few days as President.

This is your Saltfork Craftsmen ABA. Please consider getting more involved to help preserve our great and noble crafts. You don’t have to be the best crafts person, just have a desire to help move us forward in a positive way. Feel free to contact me any time and let me know if and how you would like to serve. Thank-you, and “God bless our Craftsmen and Craftswomen”.

SOUTH CENTRAL REGIONAL PAGE

Meeting dates

January 21, 2012

Host: Byron Donor
Phone #
Trade item: heart candleholder

February 18, 2012

Host: Gerald Franklin
Phone #: 580-252-6002
Trade item: feather

March 17, 2012

Host: Bob McKelvin
Phone #
Trade Item: pitchfork with three tines
Lunch: Hot Sandwich, bring a side dish/desert

April, 2012 (ANNUAL PICNIC)

Host: Byron Donor
Norman, Ok.

May 19, 2012

Host: Linda Morefield
Phone #
Trade item:

June 16, 2012

Host: Larry Mills
Trade items anything with three scrolls
Lunch: provided, bring a side dish

July 21, 2012

Host: Richard Simpson
Phone # 405-344-7413
Trade item: Campfire tool

August 18, 2012

Host: Charles McDevitt
Phone # 580-439-8931
Trade item: something from a horse shoe

Sept. 15, 2012

Host:
Phone #:
Trade item:

October 20-21, 2012 SCABA Conf. Perry, Okla.

November 17, 2012

Host: Bill and Diana Davis
Phone #: 580-549-6824
Trade item:

December 15 2012

Host:
Trade item;
Phone:

The S/C meeting was hosted by Linda and Heather Morefield at their home in Medicine Park. If you have never been there it is a nice place to go spend a summer day. There is a swimming area for both young and old and lots of places to sit down and enjoy a dip of home made ice cream or a nice meal. The town is steeped in history. It was built as a resort for the "well to do". It fell into disrepair in the 60's and 70's but is now coming back to life. Linda and Larry Morefield moved to Medicine park and Larry set up his blacksmith shop next to their home. Larry was a member of Saltfork until he passed away about a year ago. Heather, Larry and Linda's daughter worked in the blacksmith shop with Larry and learned her many talents from him. She plans to keep a working shop there at the home while she complete her art classes at Cameron. Linda and Heather offered for sale the tools that Larry had accumulated that Heather didn't need anymore. Many of the members that came to the meeting left with some nice antiques or tools. She still has three Bill Epps tapes that if you are interested in you can contact the editor. They are VHS tapes.

We need to thank the Marauders for a nice lunch of Beans and cornbread. There was also fried peaches if you were lucky enough to have room for them after the beans.

Heather is planning to host next May's meeting so mark it on your calendar to be in Medicine Park on the Third Saturday in May. The trade item is already decided. (I like having all this information well ahead of time) it will be a piece of garden art. So you have a year to plan out the perfect rain gauge holder or bird feeder or just a piece of artwork. Looking forward to see what shows up.



NORTH WEST REGION

January 28, 2012

Host: Ron Lehenbauer

Phone#

Trade item; punch/chisel/tool for shop in Fairview

February 25th, 2012

Host: Mandell Greteman

Phone #

Trade item: eye punch

March 24, 2012

Host: Eddie Horton

Phone #:

Trade item; Campfire Tool

Location; Fort Supply

April 28, 2012

Host: Tom Nelson (held in Perry at the

Phone #

Trade item:

Lunch: Sack lunch or on own

May 26, 2012

Host: Fred Voss

Phone #

Chisholm trail museum in Kingfisher

June 23, 2012

Host: Gary Seigrist

Phone # 580-225-3007

Trade item; something made from horseshoe

July 28, 2012

Host: Don Garner

Phone # 580-661-2607

Trade item: Hardy tool

Fairview shop

August 25, 2012

Host: Bob Kennemer

Phone # 580-225-3361

Trade item: cooking Utensil

Sept. 22, 2012

Host: Ron Lehenbauer

Fairview Threshing Bee

Trade item;

October 20-21 2012

State conference

November 24th 2012

Host: Roy Bell

Lunch:

Trade item: bell

December 22, 2012

Merry Christmas

Dorvan Ivy hosted the April meeting for the NW region. Here are some pictures of the event. Wish to thank Laquita Greteman for the photos.



Tom Nelson hosted the May meeting for the NW Region at the Rural Heritage festival that is held at the museum in Perry Oklahoma each spring. Turn out was very light. Here are some pictures of the event. Watch some local children do a May pole dance, they had a cake walk, dutch oven cooking, and a few other displays of early American crafts.



Gary Seigrist will host the June meeting for the NW region at the Route 66 museum in Elk city. Lunch is provided, bring a side dish. Find other details in list at left.



SOUTH EAST REGION

January 7th 2012

Host; Bill Phillips

Phone:

Lunch: provided, bring side/desert

Trade item: steak turner

February 4, 2012

Host: Eddie Horton (Ft. Towson)

Phone #: 580-873-2634

Trade item: Heart

March 3, 2012

Host: Eddie Horton (Ft. Towson)

Phone #: 580-873-2634

Trade item: Leaf or Flower

April 7, 2012

Host:

Phone #:

Lunch:

Trade item:

May 5, 2012

Host: Bill Phillips

Phone #

Lunch: provided, bring side/desert

Trade item: spoon

June 2, 2012

Host: Ronnie Smith

Phone:

Lunch: provided, bring side/desert

Trade item: critter

July 7, 2012

Host:

Phone #:

Lunch:

Trade item:

August 4, 2012

Host: Eddie Horton (Fort Towson)

Phone #:

Lunch: Mr. Wallace Dutch oven cooking

Trade item:

Sept. 1, 2012

Host: Bill Phillips

Phone:

Lunch: provided, bring side/desert

Trade item; knife

October 20-21, 2012

SCABA Conference

November 3, 2012

Host:

Phone #:

December 1, 2012

Host:

The May Southeast Regional meeting was held at Bill Phillips Ranch near Indianola Ok. The trade item was a spoon. Several were made or brought.

Ten members as well as several guest showed up. Three forges were fired up and in use most of the morning with folks forging knives, spoons and nails.



Wade Stewart showed his hand made 2" x 72' belt sander/grinder and explained how he made it.

Several used it during the day and found it to be a great and very useful tool. We feasted on beef stew and had Cherry cobbler, cake and other deserts.



By Gerald Brostek, Saltfork Craftsmen ABA

NORTH EAST REGION

North East Regional meeting in May

Hosted by Ed McCormack near Okmulgee.

27 members and guest showed up at Ed (Iron-man) McCormack's whop near Okmulgee, Ok for the May meeting. Two forges were fired up and several smiths were sharing the fires. Fourteen trade items were made or brought. A writer from the local newspaper showed up and took many photos and interviewed some folks.

One of the guests, Roger Taylor, turned loose of his twenty dollar bill and became a member. Welcome aboard Roger. Roger is looking for a small coal forge. If anyone has one to sell you might contact him. 918-304-9131.

It was a busy day with the large turnout and folks looing at the years of collecting done by Ed. It was almost "too much to look at" in one day. The iron-man has quite a collection of anvils, blacksmith tools and other such stuff from earlier times. Iron-man is a very talented man and creates some unique 'works of art'.

By Gerald Brostek Saltfork Craftsmn

Meeting dates:

January 14, 2012

Host: Bill Kendall
Phone # 918-742-7836
Trade item: ladle
Lunch: provided, (possibly chili), bring a side/desert

February 11, 2012

Host: Gary Gloden
Phone# 918-321-5015
Trade item. leaf
Lunch: provided, bring a side dish or dessert

March 10, 2012

Host: Dan Cowart
Phone: 918-440-0653
Trade items: spoon, fork or knife
Lunch: provided, bring a side dish

April 14, 2012

Host: Omar Reed at Fort Gibson
Phone: 918-478-4088
Trade items: cooking item
Lunch: provided, bring a side dish

May 12, 2012

Host: Ed. McCormack
Phone #: 918-733-9844
Trade item; something made from horseshoe
Lunch: provided, bring a side dish

June 9, 2012

Host: Mike Krukoski
Phone # 918-789-2484 or cell 636-297-0329
Trade item:
Lunch: supplied, bring a side dish

July 14, 2012

Host:
Phone #
Trade item;
Lunch:

August 11, 2012

Host:
Phone#
Trade item
Lunch:

Sept. 8, 2012

Host: James Maberry
Phone # 918-440-0653
Trade item: something with a leaf on it
Lunch: supplied, bring a side dish

October 20-21 2012

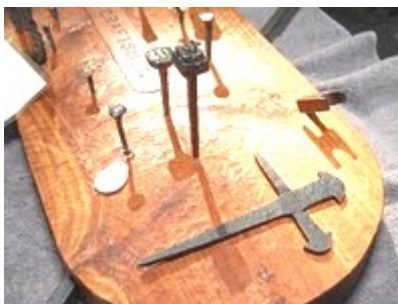
State conference

November 10, 2012

Host: Matt Goyer
Phone # 918-272-8424
Trade item:
Lunch: lunch provided, bring a side dish

December 8, 2012

Host: Charlie McGee
Phone # 918-245-7279, cell 918-639-8779
Trade item: ladle
Lunch: provided, bring a side dish



Demo opportunities:

- ◆ June 2nd, Eddie Horton and Mark Hamill are demo-ing for the Hugo Homecoming in front for the Old Frisco Depot. Everyone is welcome to come by and help out. Usually have a good turnout.
- ◆ Annual Chisholm Trail Event in Yukon, Ok. June 2 . In the past Jim Carothers has set up on Friday and done demos for historical re-enactors, Boy Scouts and other workers on set-up day. Jim will try to be there on Saturday only this year do to work obligation.
- ◆ Pawnee Bill's Wild West Show held annually the last 3 weekends in June at the Ranch Site museum. Located on the west edge of Pawnee, Ok. Saltfork has had a blacksmith or two every weekend at the event for many years. It is a fun place to demo as well as enjoy the side and main shows. Smiths can bring their own forges and tools, there is a good place to spread out in the shade just outside the old Pawnee Bill Ranch blacksmith shop. The original shop is open for our use as well. Bring a portable box fan if you plan to use the shop forge. You will need to bring your own project steel and coal for the day. Come join the fun on Saturday June 16, 23, or 30.

Demo smiths are needed for the last 3 Saturdays in June (16, 23, 30) Jim Carothers can do the first and last weekend, but not the weekend of the 23rd.

The museum contacts for the event are Erin or Ronnie Brown ebrown@okhistory.org or 918-762-2513

The Month of May found the Saltfork Craftsmen at the Muskogee Castle. This is an event that is held every weekend in May. These guys work very hard especially in the Oklahoma heat and in costume also. They must love what they do or they wouldn't keep doing it year after year. Dawnavan Crawford comes down from Alaska each year in March to help the blacksmith at the Norman fair and the Muskogee Castle. Tell these guys, along with the all the men and women who do public demonstrations, how much you appreciate them helping to promote the club and further our mission to educate the public about blacksmithing and other art forms.



Chuck Wait and Terry Jenkins



Dawnavan Crawford



Aubrey Washington

Saturday April 21, 2012 was a beautiful day in Cunningham, Texas and perfect for a damascus-making demo at Wes Davis shop. If you've never been to Cunningham, it is a 30-minute drive from Paris into the far southeastern corner of Lamar County and the countryside was awash with green grass, bluebonnets and wildflowers. The clear blue sky and a cool breeze made the day absolutely delightful. Wes called me earlier in the week advising he was going to demonstrate making damascus for the Fort States Iron Munchers out of Texarkana and invited me to come. I'm glad it worked out, as I've wanted to know more about knife making in general for a long time.

Wes has a beautiful place with a well-appointed knife shop, adjacent workshop and forging area. The knife shop contains 4 belt grinders, each for a specific purpose, milling machine, surface grinder, engraving setup, etc. The forging area has a fan-blown propane forge, 126# Chinese air hammer, hydraulic press and hydraulic roller, all of which he demonstrated along with samples of his work. These included various damascus pattern knives and daggers, all very beautiful. Wes does all the work on a knife from making the billet, shaping the blade, polishing, finishing and affixing the handle. He obtained Journeyman status from the ABS in 2007 and showed us the blade he will present for his Master stamp in the near future.

The forge actually has 2 fans. As it turns out, 1 fan is for the forge and the other deflects hot air coming out of the forge so you can stand in front of the glowing hole and not be knocked over by the heat. Hopefully one of my pictures shows this. I don't recall if this was Wes' idea or not, but it is a pretty neat idea and one that many Saltfork members might consider adding to their propane forges. It really makes working around the forge much more comfortable as you don't get that blast of hot air in the face all the time. He stated that both fans should be somewhat larger in CFM capacity than what he is using. However, for a 1 burner home-made forge that is fairly large in terms of square area, it brings steel up to heat pretty quickly.

He buys his steel from a knife supplier and the steels he used were 1080 on the outside and 15N20 on the inside. Alloys are alternated, beginning with 1080, 15N20, 1080, etc. He said the 15N20 layer amounted to about the kind of steel in a good band saw blade. He welded a billet of 21 pieces of steel into a stack about 1 1/2" high w/ a handle, stuck it into a bucket of kerosene (he uses kerosene for flux), lit the fire and proceeded to draw the billet into about a 16" X 1-1/2" x 1/2" strip. This was then ground clean, cut into 4 sections, re-welded, re-fluxed and the process started over again. I think he wound up with 168 layers.

This was the first time I had seen a hydraulic forging press in person. It is extremely quiet with the only sound being the hydraulic motor, and is very quick in operation. It works just like a trip hammer except that he uses the dies the long way and compresses the entire length of the billet at once. After a few press cycles, the hydraulic roller is used to extrude the billet and bring it to a uniform thickness overall. This is usually accomplished in one heat. He alternated using the air hammer with the press and roller. I don't know if this is his normal practice or if it was for demonstration. At any rate, it is effective and the result is a billet that is uniform in thickness throughout.

Next step is to pattern the damascus and for this he uses a die in the hydraulic press that presses the steel layers into the "ladder" design. The excess material is ground off, the billet cut into desired lengths (more than one knife blade is usually obtained from 1 billet) and the steps proceed to the finishing process.

I had to leave at this point but the day was an introduction into a new (to me) variation of blacksmithing. I may never make a knife but I made new friends, renewed some old ones, and learned a lot about forging and knife making. I need to add this about Wes; he is quick to give credit to others and points out that he had help along the way.

The day was well attended by both visitors and the Four States bunch, names are included below. Perhaps you can put names and faces together. Wes and his wife, Marla, served a BBQ brisket/hotlink/sausage dinner with all the trimmings. Marla made an icing covered brownie for desert that was absolutely out of this world. Thanks Wes and Marla!

Four States members included: Wes and Marla Davis, Calvin and Terry Moore, Paul & Diana Smith, Bob & Barbara Nipper, "Cowboy" Hall, Charles Smith and Jerome Le Grand. Others attending were Clint Dorries, Don Gentry, Jerry Rickey and James Allcorn.



2012 Duncan Natural Resource Day

Gerald Franklin

On May 15, I set up to demo at the Stephens County Fairgrounds in Duncan. We were part of the 2012 Duncan Natural Resource Day sponsored by the Stephens County Conservation District and the USDA Natural Resources Conservation Service. Our guests for the day were thirteen classes of fourth graders from the Duncan Public School system.

In addition to our smithing demo, there were several other exhibits set up. I didn't get to see all of them but the ones that I did see were pretty good. There were exhibits dealing with soil erosion, fish and wildlife management, fire prevention, etc. Some Halliburton chemists were demonstrating some of the chemical aspects associated with cementing oil wells had the most interesting one that I saw. I'm not real sure what blacksmithing has to do with natural resource conservation, perhaps because we were some of the earliest re-cyclers. You ever see a smith worth his salt who didn't prowl through a junk pile looking for materials to forge into something new?

We were set up inside the livestock show arena so weather really wasn't a factor. The students cycled by in fifteen-minute intervals and I had to make something that was simple so that I could finish the project while the group was there. I chose the old stand-by items: S-hooks, drive hooks, and nails. This was another good school demo but I was more than a little numbed from hearing myself do the same spiel thirteen times in one day.



S/C regional meeting in June

Host: Larry Mills

Place: Chestnut Forge

Address: 3510 Charleston Rd, Norman, OK

Phone: 405-401-9739

Date: 16 June

Time: 8:00-4:00

It's Freeeee

Some S7 and 5160 to be given away

Pastries and Fruit available in AM, Lunch at 12 contact Linda to help with the side dishes

Nonparticipants may want to bring Lawn Chairs.

Activities

Open Forging all day

Demonstration with hands on instruction morning and afternoon

Best Scroll Competition

Tailgating encouraged

Iron-in-the-hat proceeds go to the club scholarship fund.

Trade Item, anything with 3 scrolls

Hot News

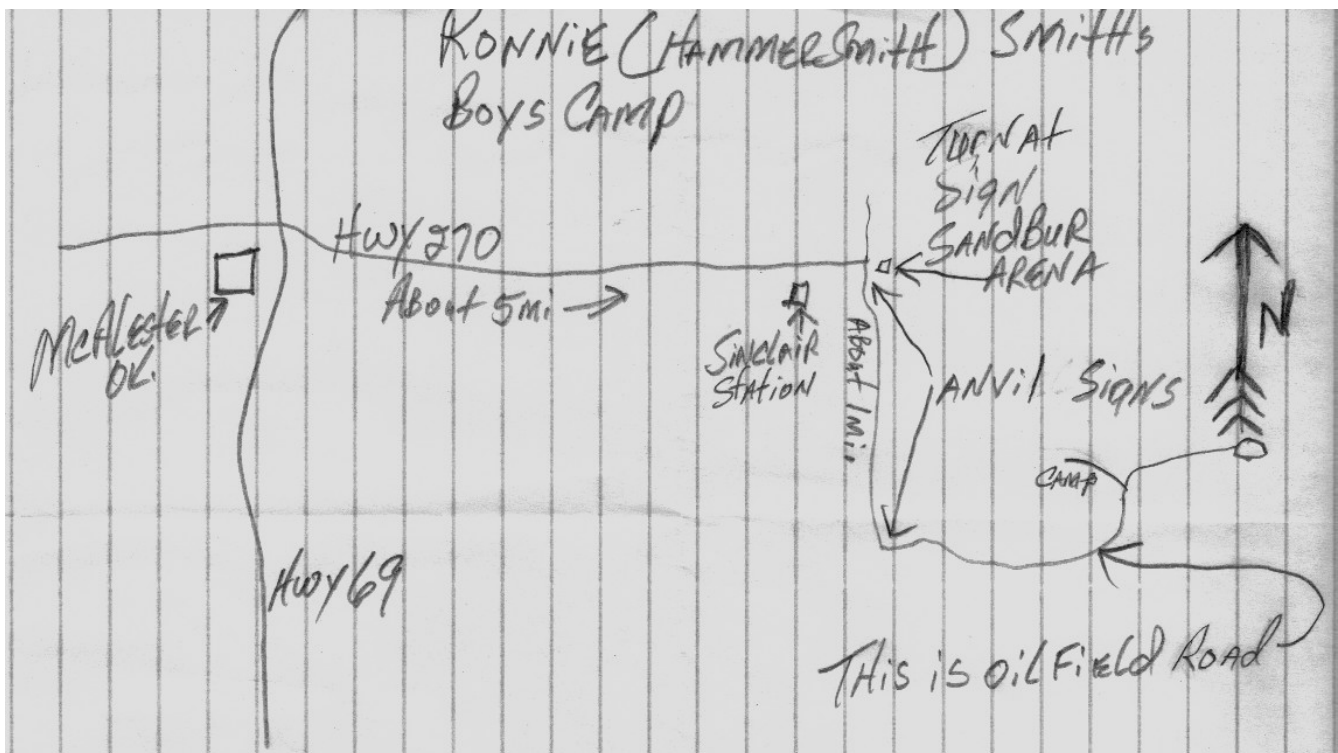
Klingspor Abrasives Rep. will be onsite with 2x72 belts of various grits and other abrasives available to try

We are opening a gallery and are interested in displaying your work

Directions to Larry Mills. S/C regional meeting June 16th.

Coming either from the North or South on I-35 take exit 112 on to W. Tecumseh Rd. Turn (L) east and travel 1.9 miles to Charleston Rd. Turn Right and 3510 is approximately 262 ft down the road and on the right..

Map/directions to meeting for the SE region on June 2nd.



Workshop Schedule 2012

Gerald Franklin

The 2012 workshop schedule has been fleshed out. Take a look at the following list and mark your calendar for any workshops that you think you may want to attend. Enrollment will open on the 10th of the same month the workshop is being held. Complete enrollment information will appear in the newsletter the month before the workshop is scheduled.

March 31, 2012—**Basic Blacksmithing Workshop** at Elk City in the Route 66 Museum Blacksmith shop. Instructors are Don Garner and Dorvan Ivey. Cost is \$20.00 which includes materials and lunch. Sign up open immediately. Contact Bob Kennemer to register. 580-799-1878 or 580-225-3361

March 31, 2012 – **Basic Blacksmithing Workshop** at Bill Kendall’s shop in Tulsa. Instructors will be Bill Kendall and Dan Cowart. Enrollment opens at **NOON on March 10**. Email Dan Cowart (ddcowart@gmail.com) then to get your name on the list. You may also call Dan at 918-440-0653. Again, you won’t be able to enroll before **NOON on March 10**. Cost: \$20.

⇒ June 30, 2012 – **Decorative Punch Workshop at Gerald Franklin’s shop near Duncan, OK. Learn to make and use various punches and chisels to enhance your work. This is a “cold shop” workshop with no forge work. Class size will be limited to ten students. To give everyone a chance to get the word about the class, enrollment will not be taken before 12 noon on June 5th. Enroll by emailing Gerald Franking at franklin@myrhinomail.com or by calling 580-467-8667 Cost is \$10. which includes materials and lunch.**

September 29, 2012 – **Veining Hammer Workshop** at the Major County Historical Society’s shop in Fairview, OK. Mike George will guide you through forging a veining hammer for use in repousse’ and leaf work. Enrollment info will be in the August and September newsletters. Cost: TBA.

This page will be in each newsletter as a reminder of the workshops that are available to the membership. Please take note of the locations, registrations times and cost for each.

T-SHIRT DESIGN CONTEST

We are having a T-Shirt design contest to come up with a T-Shirt for the Perry, OK Conference in October. Below is the design from last year.



The design must include:

Saltfork Craftsmen Blacksmith Conference

16th Annual

October 20 and 21, 2012

Perry, Oklahoma

Save the file as a jpg if you create a design. Include your name, address, phone number and E-mail with your submission. You may send a CD or E-mail your work to:

SCABA

10380 N. 4010 Rd.

Wann, OK 74083-2014

ddcowart@gmail.com

918-440-0653

The deadline is July 13, 2012.
winner will receive a monetary award

Demonstrators for the 2012 conference are Lucien Avery and Eric Ryser.

Current 2012 SCABA membership

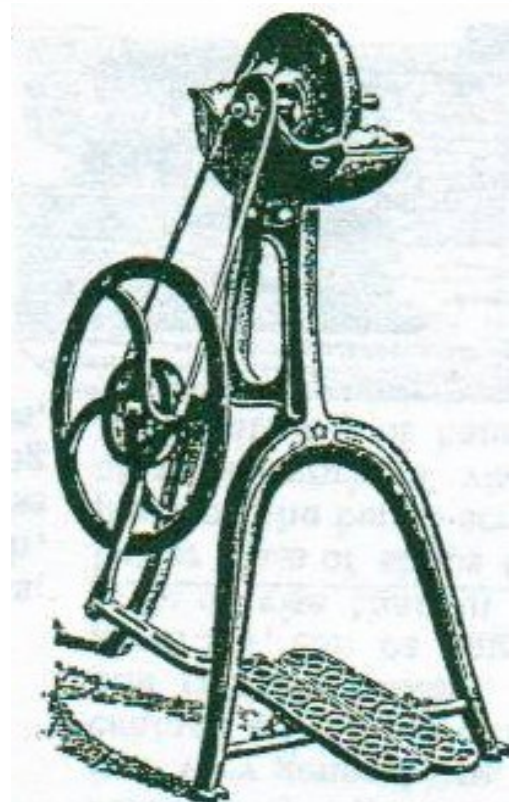
| last name | First name | City | State | Email | Phone | spouse |
|--------------|---------------|---------------|-------|--|--------------|-----------|
| O'Bryan | Dodie | Pawnee | Ok | scout@skally.net | | |
| McDevitt | Charles | Comanche | Ok | bjmcdevitt@pldi.net | 580-439-8931 | Barbara |
| Clowdus | Lynn | Meno | Ok | menosmithy@pldi.net | 580-776-2225 | Eileen |
| Martin | Gary | Edmond | Ok | gmartin10@cox.net | 405-359-8342 | June |
| Cowart | Danny | Wann | Ok | ddcowart@gmail.com | 918-440-0653 | Patti |
| Doner | Byron | Norman | Ok | bryrondoner@esok.us | 405-329-5635 | Carol |
| Edwards | Michael | Calumet | Ok | sandburforge@pldi.net | 405-893-2316 | Darlette |
| Epps Bill R. | #36428-177 FP | Yankton | SD | | | |
| Garner | Don | Thomas | Ok | | 580-661-2607 | Deana |
| Gloden | Gary | Sapulpa | Ok | ggforge@wildblue.net | 918-321-5015 | Diane |
| Heinrichs | Allen | Norman | Ok | wooddude58@att.net | 405-364-8157 | Sheryl |
| Malsom | Bill | Bartlesville | Ok | billmalsom@hotmail.com | 918-333-4398 | |
| McGee | Charlie | Skiatook | OK | littleironworks@gmail.com | 918-245-7279 | Karen |
| Sheldon | Frank | Princeton | Tx | | 972-658-3251 | |
| Stubbs | Jim | Norman | Ok | blacksmithingone@gmail.com | 405-209-3329 | |
| Tanneberg | William | North Freedom | WI | | 608-370-3517 | |
| Taylor | Terry | Centerton | Ar | tataylor40@gmail.com | 479-795-2521 | Bonnae |
| Adam | Turnner | McAlester | Ok | | 918-389-4882 | |
| Alford | Vic | Coweta | Ok | valford@valornet.com | 918-486-3460 | Catrena |
| Allcorn | James | Paris | Tx | jallcorn@suddenlink.net | 903-785-2608 | Cindy |
| Anderson | Danny | Whitesboru | Tx | | 940-736-1233 | |
| Armstrong | Andrew | Henryetta | Ok | okponyman@hotmail.com | 918-527-2232 | |
| Avers | Nathan | Muskogee | Ok | nathanavers@suddenlink.net | 918-360-4497 | Maria |
| Banks | JC | Creede | CO | jcreenebanks@gmail.com | 719-658-3062 | Renee |
| Banks | Dennis | Elk City | Ok | banks309@cableone.net | 580-225-7580 | Teresa |
| Barnhart | Roy | Colcord | Ok | | 918-326-4322 | Sharon |
| Bartlett | Lynn | Tulsa | Ok | govbart2@cox.net | 918-272-3500 | Elizabeth |
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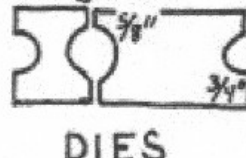
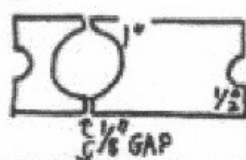
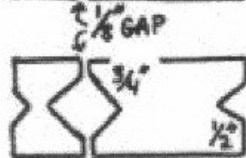
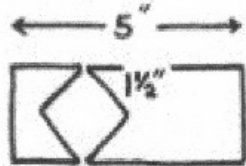
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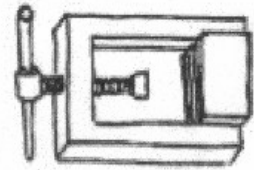
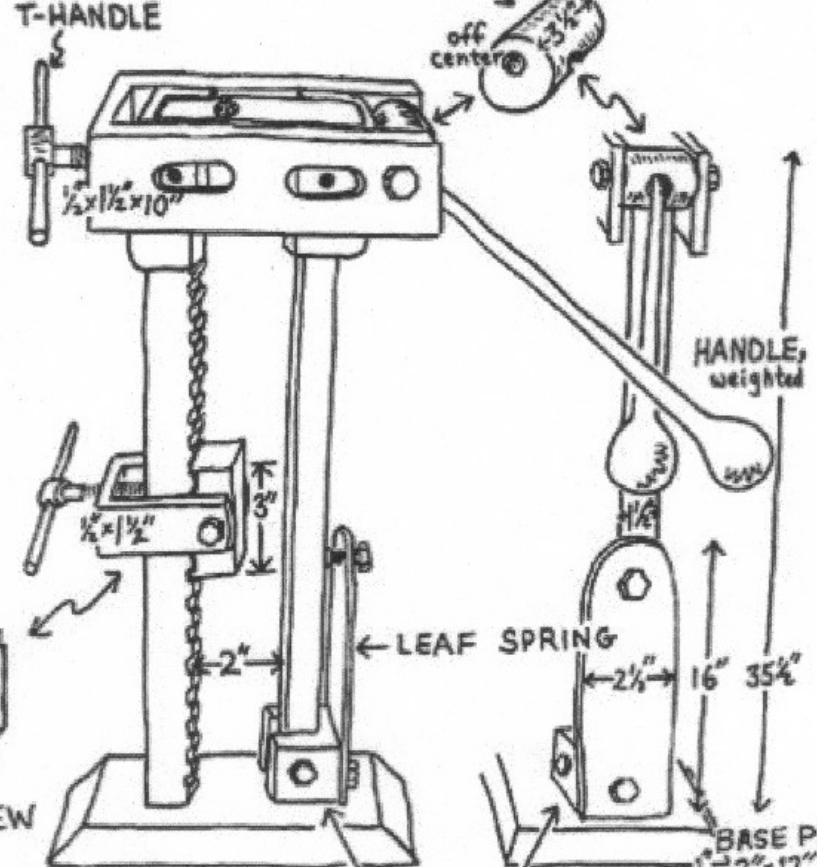
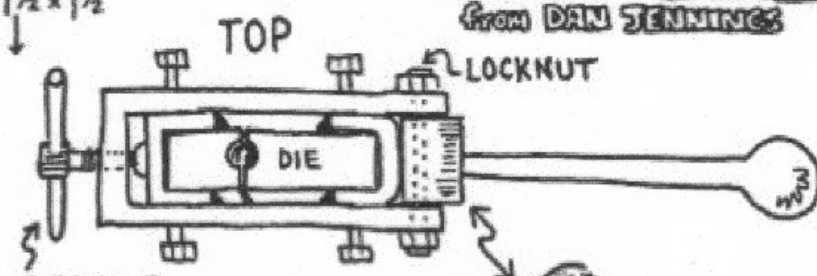


UPSETTING VISE

From DAN JENNINGS



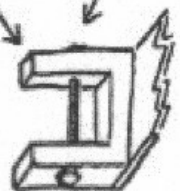
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TOP VIEW

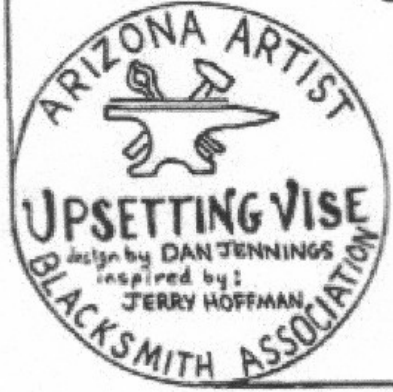
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TOP VIEW

BASE PLATE
2" x 12" x 12"



illustrations by d.w. harvey

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Patinas on Copper

By Dominick Andrisani

Copper is a wonderful metal for the creative blacksmith. It is soft under the hammer, corrosion resistant, and its natural color is quite attractive. An added plus is that copper can be chemically treated to achieve a wide range of surface colors called patinas.

The project I wanted to make was a wood and copper candlestick holder resembling a flower on a tall stem. Wood, which formed the base and stem of the flower, was turned on my wood/metal lathe. The copper flower consisted of three layers of sheet copper (21 gage, .028" thick) cut into the outline of petals and hammered into a three dimensional shape. The inner layer of petals held the candle. It was on these copper petals that I wanted to put various different colored patinas.



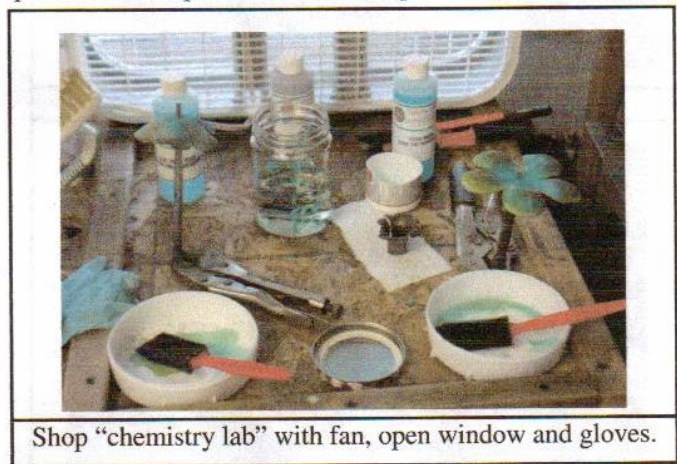
Natural chemicals in the air and rain (acid rain) will create a patina on copper and bronze by oxidation over an extended period of time. Shown below are three pieces of copper from an old gutter that oxidized over many years. From this you can get some sense of the colors that naturally occur and of the generally non-uniform coloring that is typical with patinas.

Manmade patinas are typically created in the shop by a multi-step chemical process that is not particularly obvious. To learn how to correctly handle chemicals be sure to consult the three references.



Natural patina on three pieces of copper gutter.

To safely apply chemicals that cause patinas you need the right chemicals and a safe place to apply them without hurting yourself. The figure below shows the corner of my shop that I converted into a "chemistry lab". Note the fan and open window required to insure adequate ventilation.



Shop "chemistry lab" with fan, open window and gloves.

I bought a "Patina Sample Kit" of chemicals in 6 oz. bottles from the Sur-Fin Chemical Corporation for \$95 (Reference 3). This consisted of 6 different patinas, 2 lacquers, and a metal cleaner (Brush N. Clean). The products I used for this article are shown in the following photograph.



An array of chemicals and metal cleaners.

The first step in getting a consistent patina is a thorough cleaning the metal. I cannot overemphasize how important this step is. **Clean the copper well.** The pieces of copper I needed to clean had been hammered, work hardened, and annealed several times, and had lots of black scale on the surface and pounded into the surface. I followed this multi-step cleaning procedure.

- Don gloves and never touch the copper with bare hands once cleaning is started.
- Clean the copper in a mild acid pickle (like pH Down available at your favorite pool store) then rinse thoroughly in water.
- Use a non-chlorine abrasive cleaner to get the last of the surface scale off the copper. At this point the copper was perfectly clean and shiny.
- Brush on "Brush N Clean" and wipe off with a clean wet cloth.

With the metal cleaned and in my gloved hands, I went to my "chemistry lab" to apply the chemicals to bring out the patinas. I used these chemicals from Sur-Fin: "Verde Green Patina" for the outer layer of petals, "Blue Green Verde Patina" for the middle layer of petals, and "Superantik 30 Antique Finish" on the inner petals. After several failed attempts with the green patinas, I learned the following successful coloring procedure.

- With all chemicals and metal at room temperature, apply the chemical with a brush. Then wipe it off with a paper towel or clean cloth. Wiping off is important so that there is not too much oxidation that will simply flake off or wash off in the next step.
- Wait an hour or so for the patina (greenish color) to form. Rinse thoroughly in running water. Use your gloved fingers to rub the patina as you rinse. If the patina is going to rub off you might as well do it now.
- Set the copper aside and wait another hour. The patina will again form from residual chemical that remained after rinsing, and this time the patina should be more lasting. Rinse again under water and rub as before.
- Repeat this process until you get a patina that will not disappear when rubbed during rinsing. If the patina is not vibrant enough, apply some more chemical and start the coloring procedure over again.
- As a final step I applied a NC-8 Flat Lacquer (from Sur-Fin) to the completely dry colored copper. The results are shown below. *Imaginate and Patinate!*

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1. Charles Lewton-Brain, *Patinas for Small Studios*, published by the author, 1985 (available in the IBA library), revised 2007, available from Brain Press (<http://www.brainpress.com/Books.html>).
2. Richard Hughes and Michael Rowe, *The Coloring, Bronzing and Patination of Metals*, Watson-Guptill Publications/Whitney Library of Design, 1991.
3. Sur-Fin Chemical Corporation, Los Angeles, CA, 323-262-8108, www.surfinchemical.com.



Lower side of petals. Green patina was used on the left.



Upper side. Blue-green patina was used on the right.



Finished flower with three different patinas.

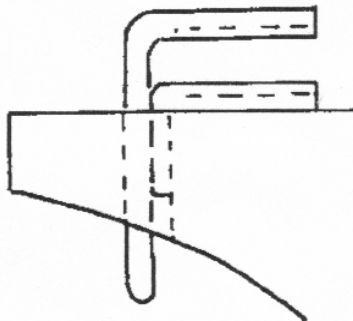
Forge a Pepper

by Robb Gunter

Some years ago while working in SWABA's State Fair Exhibit, a young lady said, "Bet you can't forge a chili pepper." The challenge was on! I told her to come back in an hour and we'd see about that. With a piece of 3/4 inch black gas pipe and a piece of 3/8 inch rod for a stem, the first attempt began. Although somewhat crude, it was rewarding when the young lady came back and had to say her words. As it turned out, she paid a healthy price for it. With a bit more practice I got the bugs worked

Shop Tip

Ed Justi
Pine Grove, California
CALIFORNIA BLACKSMITH
ASSOCIATION



Here is a tool setup for fullers that I came upon quite by accident.

The lower fuller has a short tail which is drawn as wide as the hardie hole, but only half as deep. The upper fuller is drawn to slide behind the lower one.

Like the U-shaped spring fullers, this one does not bounce around (or off) the anvil when struck. Also, the long rear tang allows for taller stock, while keeping both fullers parallel.

out and here's the recipe for growing your own chilies:

Start with:
3/4 inch or 1 inch of black iron (gas) pipe 18 inches to 24 inches long — plenty of handle.

Plug or tape off the end not going into the fire.

Heat 3 inches evenly — turning the pipe in the fire — to a good yellow (don't burn it).

Fuller the pipe with either a 3/8 inch rod fullering tool or a fullering jig, 1 inch from the end, turning the pipe with each hit. Fuller down until a 3/8 rod will just fit inside.

Fuller a small groove in the 3/8 inch rod 1/4 inch from the end.

You're ready for a fluxing heat. Both pipe and rod must be carefully heated yellow. Brush and flux the rod.

Use a plumber's 1/2 inch radial wire brush to clean the inside fullered pipe. Flux quickly and insert rod to the fuller mark.

Close the fullered pipe down on rod in fullering jig. This needs to be done quickly and returned to the fire before the flux cools too much.

Slowly bring to a welding heat allowing the pipe and rod to soak at welding heat to insure temperature is inside fullered area.

Forge weld in the fullering jig with quick light taps — turning the pipe between each hit. A second welding heat can be taken if necessary.

Allow pipe with welded stem to cool. Cut pipe and stem as shown in Sketch #2.

Forge stem to a short taper — avoid hitting septal area.

Shape the septal — on a real chili it is 5 lobed or somewhat pentagonal.

Take a good yellow heat over entire fullered area and stem. By selectively quenching the stem and septal area, upset it down on to the pipe. Insert the stem in the pritchel hole of your anvil and hammer the other end of the pipe. Allow the pipe

just below the septal to swell somewhat, as this looks more normal. (Sketches #3 and 4.)

After upsetting septal and before curling the stem — use a small radius grooving chisel to define ridges on septal which point to each lobe. (Sketch #5.)

Curl the stem.

Hacksaw off the pipe 6 inches to 6 1/2 inches for 3/4 inch or 7 inches to 7 1/2 inches for 1 inch pipe (measuring from the septal).

In a swedge block, taper the open end of the pipe from yellow heat, turning the pipe between each hit to avoid any folds. Make the taper relatively short at this point — the taper can be smoothed and made longer after the pipe is closed and forge welded.

The chili can be tapered and forge welded onto a rod at this point to make an interesting tool handle (3/4 inch pipe makes the best handle).

After forge welding hot rasp the closed end to a small hemispherical radius.

With a coarse 3/8 inch square file, shape a cleft in the radius end. Most chili peppers have a 2 lobed end, much like a bell pepper has 4 or 5 lobes (see sketch #6).

Lengthen taper for a smooth transition back toward stem and septal. Wrinkling the pepper: Sketch #6 shows two primary wrinkles which line up with cleft in the end and are 180 degrees apart.

I found it most helpful to buy a chili pepper or two in the grocery store and study the real thing.

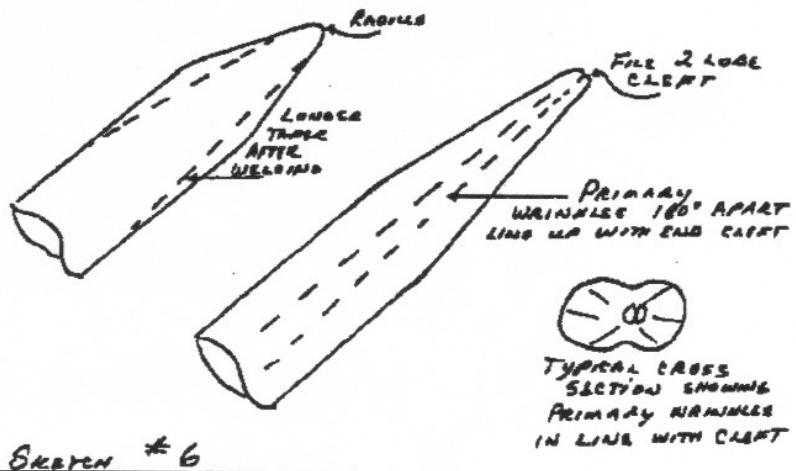
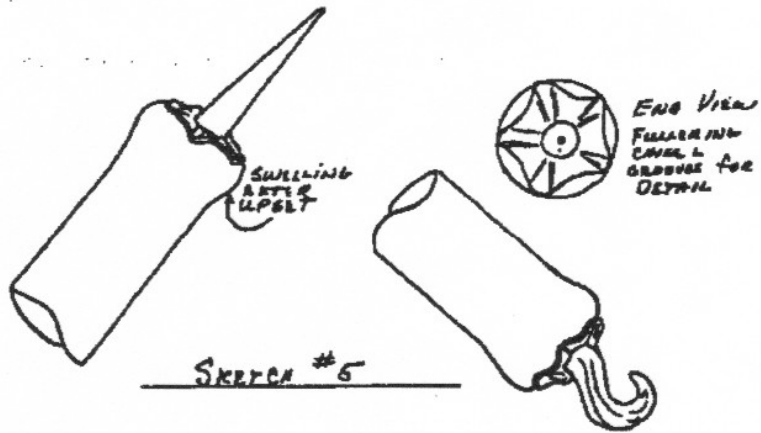
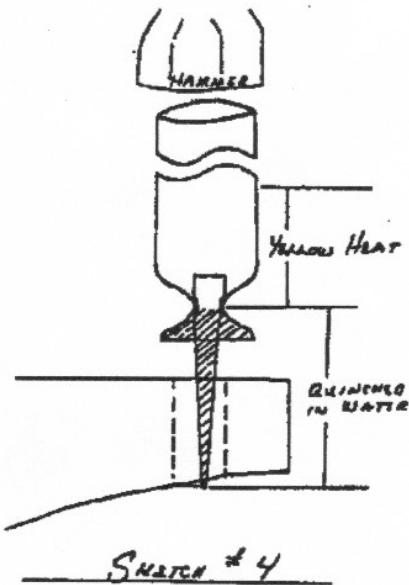
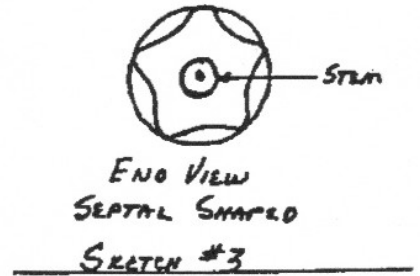
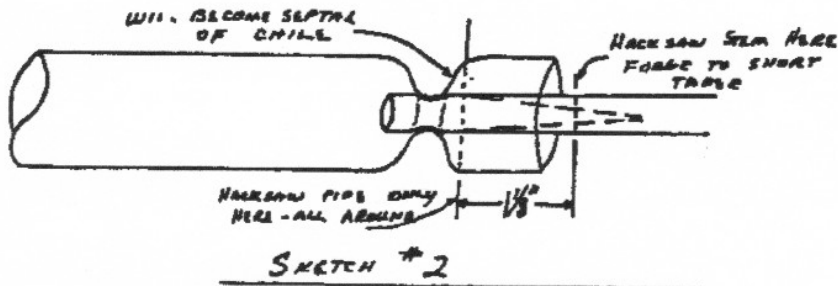
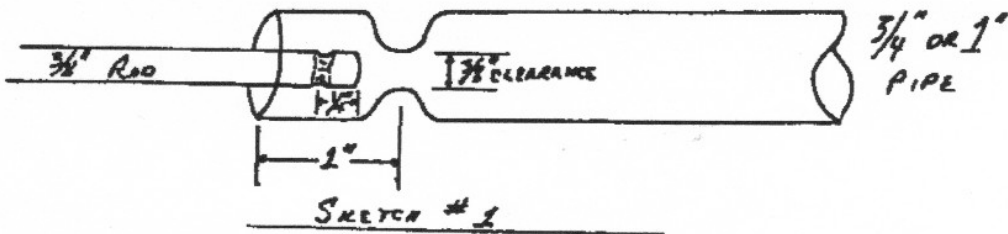
A nice final touch before waxing is to use a fine brass wire brush at black heat on the stem and septal for contrast.

Amazingly enough, in most chilies, as a result of forge welding, there are even seeds inside when you shake the chili.

I've had lots of fun using the chilies by themselves or as handles on fireplace tools, barbecue sets and door pulls. Let me know what other ideas you come up with.

— Reprinted from the Pounders Press
by way of the Forge Facts.

NEWSLETTER of the BLACKSMITHS ASSOCIATION OF MISSOURI

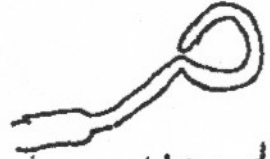
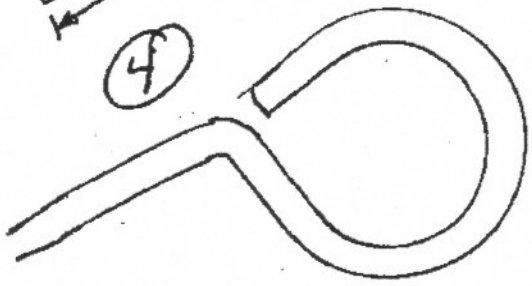


COOKING TONGS

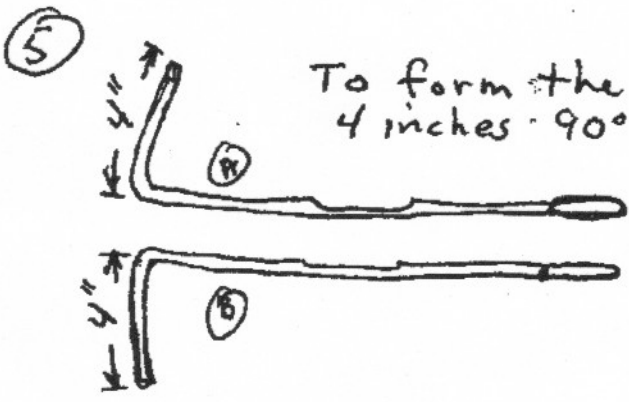
- ① Start with two $16\frac{1}{2}$ " pieces of $5/16$ " round stock
- ② Flatten the middle of both for 2 inches



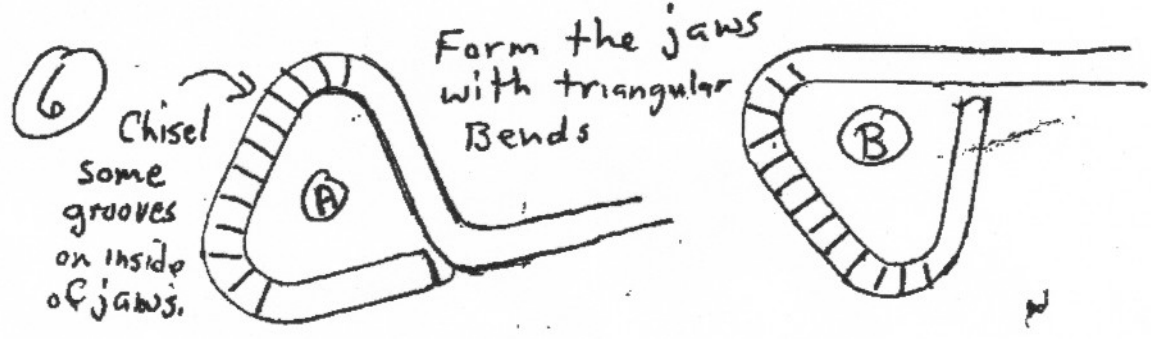
- ③
- Jaw End
- 4" 3 1/2" 3" 4" 7"
- Handle End
- Bend both ends in opposite directions. Do it for both pieces.



Use the last 4 inches to form the loop handle. Do it the same for both pieces.

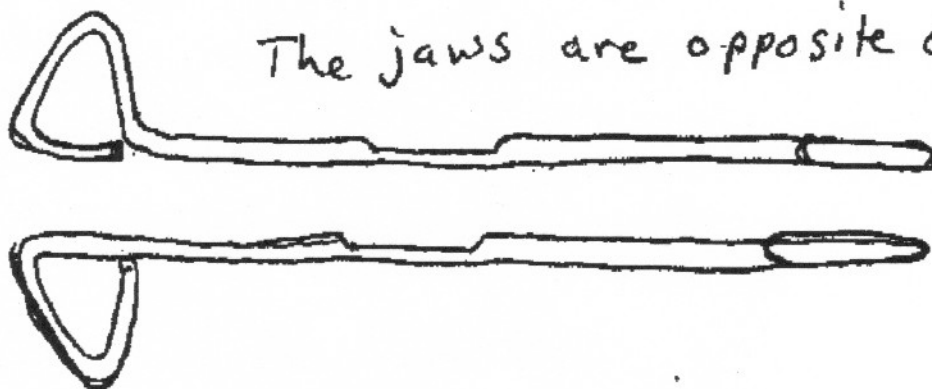


To form the jaws bend the first 4 inches 90° from the handle bends. Each piece should be in opposite directions.



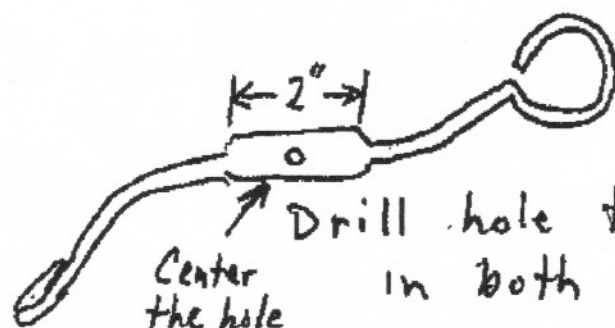
Cooking Tongs (cont.)

⑦



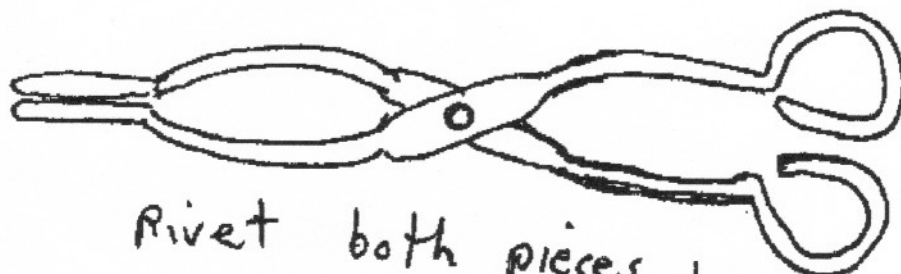
The jaws are opposite each other

⑧



Drill hole to fit your rivet
Center the hole in both pieces.

⑨



Rivet both pieces together
You may have to heat and
fine tune the fit.

⑩

Now you're ready to start grilling.

SCABA Shop and Swap

For Sale:

6" round nosed pliers (great for putting scrolls on small items) \$5.00 each. Brooms tied, \$25.00 on your handle
Contact Diana Davis at Diana.copperrose@gmail.com

For Sale:

24"(wide) x 1"(thick) Ceramic fiber blanket (similar to Kao-wool) \$1.00 per inch of length. Twisted solid cable 1/2" diameter \$2.00 per ft.

Contact Larry Roderick at 940-237-2814

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 pile is 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 (\$.07 per pound) should be made directly to the Saltfork Treasurer.

NE Region coal location: Charlie McGee has coal to sell. He lives in the Skiatook, Oklahoma area. His contact information is:

littleironworks@gmail.com or (home) 918-245-7279 or (cell) 918-639-8779



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 We just got in a new shipment of caps for \$10.00. We have "Fat head" hats for those having trouble finding a hat to fit.

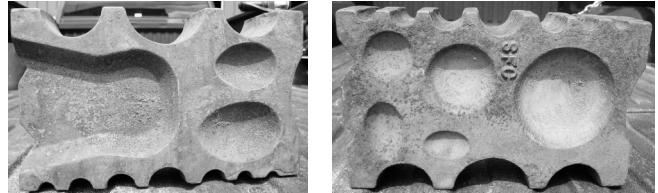
Please note that due to increases in cost we have had to raise our prices on the swage blocks.

SCABA swage blocks

\$100.00 plus shipping to members. (1st block)

\$120.00 plus shipping to non-members

Contact Bill Kendall for more information



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

For Sale:

One 50# "Transition Style", Little Giant Power Hammer, In excellent condition. We are currently using it in our shop. It comes complete, ready to run with two sets of dies. \$3750.00 fob Alva Okla. Pictures available on request.

Mike George at 580-829-1968 or
George.purchasing@yahoo.com

SCABA membership application

New _____ Renewal _____

January 1 2012—March 31— 201__

Please accept my application

Date: _____

First Name _____ Last Name _____

Married? ___ Yes ___ No Spouses Name _____

Address _____

City _____ State _____ ZIP _____

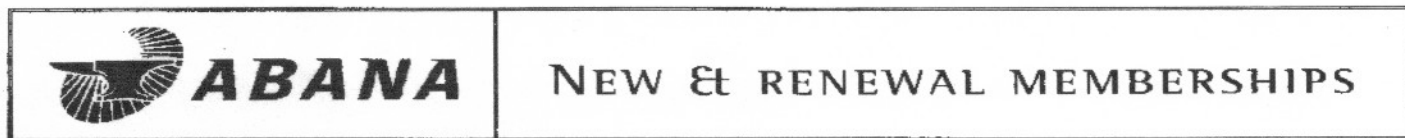
Home Phone (____) _____ Work Phone (____) _____

E-Mail _____ ABANA Member? ___ Yes ___ No

I have enclosed \$20.00 (per year) for dues to March 30, 201__

Signed _____

Return to: Saltfork Craftsmen Membership, Diana Davis 23966 NE Wolf Rd. Fletcher, Okla. 73541



Name : _____ Membership ID # _____
(For renewals. Optional but very helpful)

Business Name (optional) : _____

Street : _____

City : _____ State/Prov : _____

Zip/PC : _____ Country : _____

Phone : _____ Fax : _____

E-mail : _____ Website : _____

Membership Type: New Renewal

| | | |
|--|---|--|
| Regular (US, Mexico, Canada) | One Year — <input type="checkbox"/> \$55 | Two Years — <input type="checkbox"/> \$105 |
| Senior Membership (65+, US, Mexico, Canada,) | One Year — <input type="checkbox"/> \$50 | Two Years — <input type="checkbox"/> \$95 |
| Full-time Student (US, Mexico, Canada) | One Year — <input type="checkbox"/> \$45 | Two Years — <input type="checkbox"/> \$85 |
| Foreign | One Year — <input type="checkbox"/> \$65 | Two Years — <input type="checkbox"/> \$125 |
| Contributory Membership <i>(amounts above \$55 / year may be tax deductible)</i> | One Year — <input type="checkbox"/> \$150 and up — \$ _____ | Two Years — <input type="checkbox"/> \$295 and up — \$ _____ |
| Public Library (US, Mexico, Canada) | One Year — <input type="checkbox"/> \$45 | |
| Educational Institution | One Year — <input type="checkbox"/> \$250 | |

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