Saltfork Craftsmen
Artist-Blacksmith Association
March 2012

Saltfork Craftsmen member Teresa Gabrish has expanded her artwork to include many new and unique copper pieces. This is a filigree butterfly on a hand made copper chain. She won a scholarship from Saltfork that she used to take both a fold forming and cold connection class.

Starting March 1st, Some of Teresa's work will be on display/for sell at The Branded Bear gallery in Medicine park.

Teresa has many classes planned for the upcoming year. She will be at the picnic and also the conference this year where you can learn fold forming and cold connections. You can find out about other classes Teresa is teaching by call Arrowhead supply in Oklahoma City.

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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:

It's the time of the year when we all have to be thinking about Spring, Taxes and most importantly, who we want to represent us on the board of Saltfork. This year we have three positions on the board that are up for re election/election. Current President and long time board member, Gerald Franklins position is one of those that will need to be filled. Gerald has decided that he want/needs to concentrate on other interest and has decided to not run this year. He will still be very active in the club and helping to promote Saltfork. The other two position are held by Dan Cowart and David Seigrist. These members have done a great job on the board and also the other committees that they have set on. They are both running again this year and I hope that you will vote them back in. I (Diana Davis and editor of the newsletter) have chosen to put my name on the ballot this year. There is also a place on the ballot where you can write in a members name. All board members must be in good standing with the club and have attended meetings in their region during the year. Be advised that just because you wrote their name in and they got a significant number of votes that does not mean that they **have** to set on the board. This is a totally volunteer board and no one if forced to participate.

I would like to see all four regions represented on the board in order to best serve the membership. At this time we were unable to get anyone from the SE region to agree but maybe in future elections we will be able to get a representative from that region.

There is a ballot in the back of this newsletter. Please cast your vote and mail it back to the secretary by the end of March. The result will be posted at the Picnic.

Please send in your ballot.

Diana Davis

President's Notes

Gerald Franklin

We have had some good meetings since the weather started warming up. It seems like many folks are glad to get out of the house and do some good forging and visiting. I started the month of February off at a Southeast meeting at Fort Towson. The turnout was a little light but we did have four forges going. The South/Central meeting was at my place so I didn't have to go very far. We had a very good turnout. The Northwest meeting was on the 25th at Mandell and LaQuitta Greteman's place in Foss. I made that one, too. So, it looks like again, for another month, I made all the meetings except for the Northeast. No slight to the folks up there, it's just that I have a hard time making three meetings and four is just that much tougher.

For the most part, I've noticed very good participation in the Trade Item program. The hosts are making good choices in their Trade Item selections and the members are going all -out in supporting the program. If you haven't been contributing to the Trade Item pool, I encourage you to do so. The program is strictly voluntary and the neat thing that I've noticed in the past is that the items on the tables represent a good cross section of the collective skills of our club.

Our annual State Meeting and Picnic is coming up on April 21st at Byron and Carol Donor's place in Norman. Make plans to attend. It should be a good affair.

It's time to pay dues and Secretary-Treasurer Dan Cowart reminds me that Pay Pal can be used for dues payment. If you use Pay Pal, however, you will need to send Dan an email telling him that you are paying your dues that way so he can post it to his books and inform Diana Davis so your newsletter subscription stays current.

There are still some meeting dates up for grabs for the remainder of the year so contact Diana Davis to sign up for one or two.

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:
Trade items
Lunch:

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:

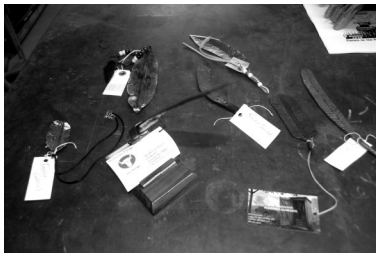
December 15 2012
Host:
Trade item;
Phone:

February S/C Meeting Notes

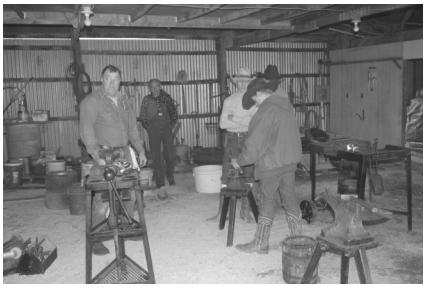
Gerald Franklin

We held the South Central meeting for February on the 18th at Gerald and Frankie Franklin's place east of Duncan. The weather was rainy and cool but not really too bad for February. We managed to get some needed moisture and it did make things a little dreary but it didn't shut us down much. We had coal and gas forges going in the shop and four coal forges going in the tractor shed.

As usual, Frankie fed us well with stew (two kinds), chili, and cornbread. As usual the attendees went all out in bringing side dishes and desserts. I think we ate enough cake, pie, and cobbler to put two or three dentist's kids through college. Frankie asked me to be sure and thank all who brought food because she didn't get to talk with everybody to thank them herself.



We had a total of eleven trade items. This month's item was a "feather" and we DID have some feathers. There were some really neat ideas expressed and it was great to see such good participation in the Trade Item Program.



There were several new members and some folks at the meeting that we don't see regularly and it was good to visit with them. We had at least two carloads of our Texas brethren (and sistren?) and the other regions within the state were well represented, too. All in all, it was a great turn out. I counted 43 head before we ate lunch and some more showed up just as we were finishing lunch. As I said earlier, we had four forges going in the tractor shed and two in the shop so there was anvil music going on pretty much all day.

Jerry Cathy held an impromptu to beginners class for 5 young men. They were learning fire tending and making S-hooks. Seth Bross, Jeff Hines, Wyatt Rice, Garett Rice and Dalton Rice were student for the day. Jeff Hines and Seth Bross joined Saltfork before the meeting ended.

NORTH EAST REGIONAL PAGE

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

June 9, 2012
Host:
Phone #
Trade item:
Lunch:

July 14, 2012
Host:
Phone #
Trade item;
Lunch:

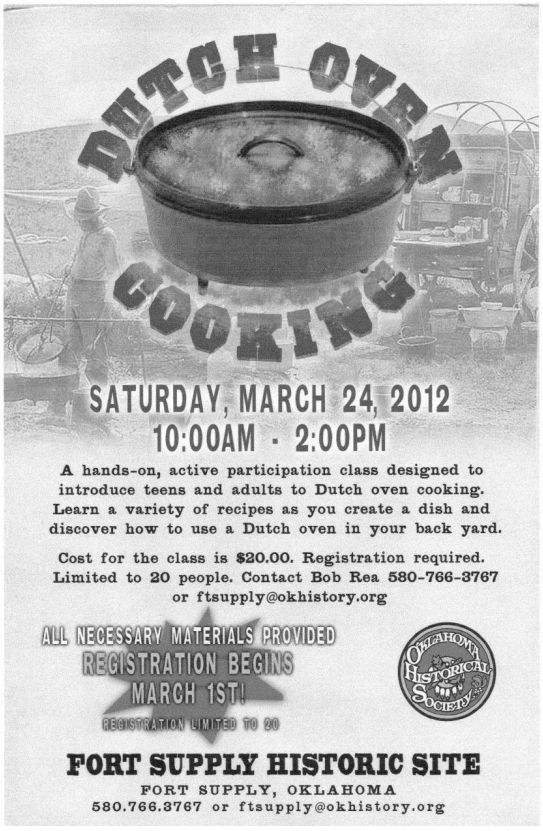
August 11, 2012
Host:
Phone#
Trade item
Lunch:

Sept. 8, 2012
Host:
Phone #
Trade item:
Lunch:

October 20-21 2012
State conference

November 10, 2012
Host:
Phone #
Trade item:
Lunch:

December 8, 2012
Host: Phone #
Trade item:
Lunch:



Gary Gloden hosted the meeting but no report was sent in.

Dan Cowart is hosting the March meeting for the NE Region. His trade items is a eating utensil. Bring a side dish/desert to help out with the meal. There is a map to Dan's place in the back of the newsletter.

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KGA

Custom Knife Show

Where: 615 E. Robinson
Norman, OK
When: March 3, 2012
9 AM until 6 PM
Admission: Adults $5.00
Children with
adults admitted free

Makers from Oklahoma, Kansas, Arkansas, Missouri, and Texas

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
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 #:
Trade item**;** something made from horseshoe

July 28, 2012
Host: Don Garner
Phone #:
Trade item: Hardy tool
Fairview shop

August 25, 2012
Host: Bob Kennemer
Phone #:
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

Northwest Meeting at Fairview

Gerald Franklin

The January 2012 Northwest Regional meeting was held on the 28th at the Major County Historical Society/Saltfork Craftsmen Blacksmith Shop near Fairview. Ron Lehenbauer was the host. The trade item was a punch or chisel for the Fairview shop.

We had about eight or nine punches and chisels made there at the meeting and there were a few made ahead of time and brought to the meeting. Ron Lehenbauer marked the tools that were made at the meeting and had a judging contest where each person looked at the punches and chisels laid out next to each other. Then they voted on which one they liked best. Mandell Greteman won the contest. The prize was an anvil which Mandell was pleased to win. He didn't need help loading the anvil, though because it was actually an anvil shaped punch made by Ron Lehenbauer.

I counted about sixteen people at the meeting. Some were new and I believe we signed up three new members. Two of them were from the same family so I guess the total "new memberships" was two, but three new members sounds better than two.

Ron and Eric Lehenbauer treated the crowd to a good lunch of "Forged Hot Dogs" (see pics). Cooking the dogs is an interesting process and if you've never seen it done you'd be surprised at the result. We ate really well and we appreciate Ron and Eric going to the trouble to feed us.

The next NW meeting will be at Fort Supply and the trade items is a Campfire tool. This will be the first time that we have been here and it would nice to have a good turnout.

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:

Southeast Regional Meeting

On Saturday, Feb. 4th we had the S.E. meeting here at Fort Towson Historic site. It was a very good meeting with a very good turnout. We had 31 to sign our sheet with a few that never got inside to sign up. The weather was overcast after a pretty good storm the night before, so a lot of folks didn't think we would have it. It turned out to be a beautiful day and everyone had a great time. We had several Saltfork regulars, including Gerald Franklin, Omar Reed, Howard Bost, Mark Hamill and Brandon Reid as well as some visitors from Ardmore and Gene Autry.

As always Robert Wallace prepared a very fine meal for the group and offered his knowledge of Dutch oven/campfire cooking to all who were interested.

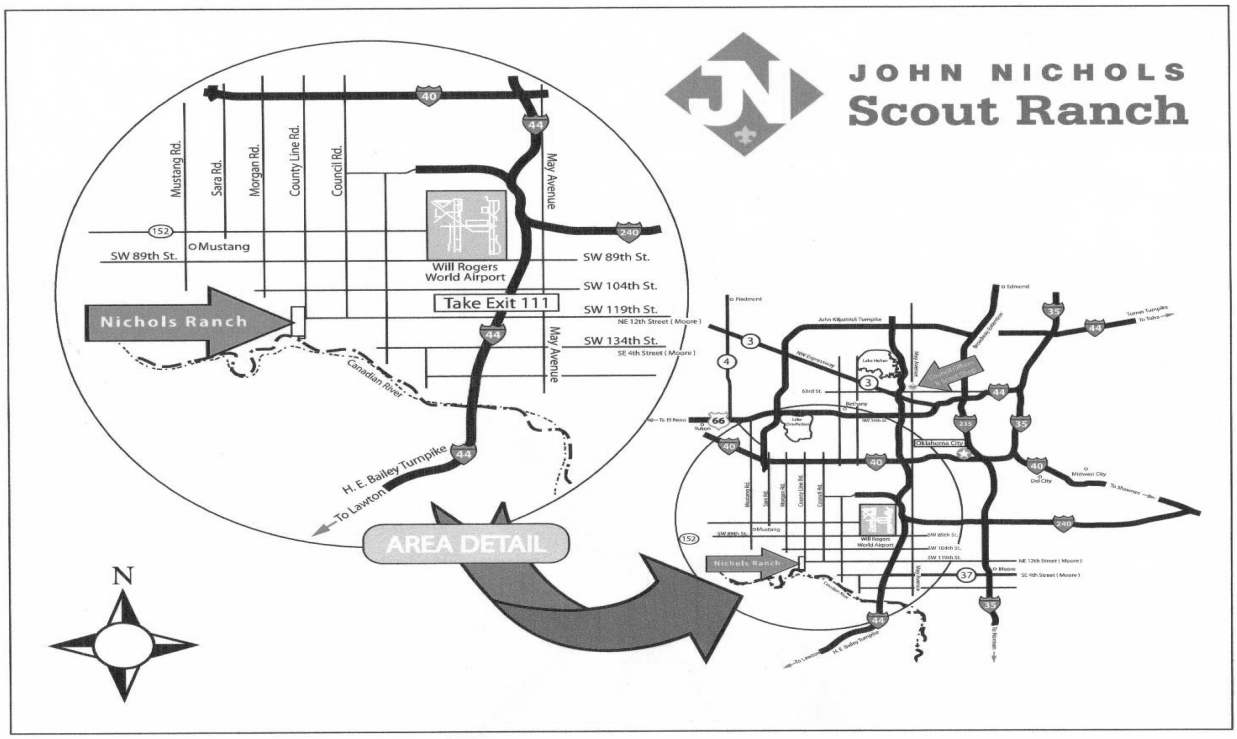
Howard made a squirrel cooker for Robert's grandson so he can help with the cooking. Gerald made several things with horse heads on them for the bystanders. It was a great meeting and we all had a good time.

I hope to see them all and more next month as we are going to have the same thing again. Right here. See everyone next month.

Eddie Horton

Demo opportunities:

- March 3rd, 2012 Last Frontier Council of the Boy Scouts District Camp-O-Ree. Large event drawing 100's of scouts. One day event where you should expect to share the craft, have a really good time , be well fed and make new friends. Set up and have a fire going by 8:30 am and the event closes at 5 P.M. Held at the John Nichols Scout Ranch SE of Mustang, Ok. To help out contact Jim Carothers (580)336-9213 of Perry Ok. Or contact Brian Clagg (scout leader) at 405-760-3500



- 2012 Rural Heritage Festival in Perry, Okla. April 28th. Contact Jim Carothers for more info.

- April 13-15 2012..Cimarron Council of the Boy Scouts Great Southern Plains Rendezvous. This is a large event drawing 100's of scouts, adult leaders and vendors. Saltfork participation in this event is a good opportunity for out membership to share the smithing craft with a group of young people and scout leaders. In the past Levi Rutledge, Jim Carothers and Fred Voss have demonstrated at this event.

  Bring your portable forge, tools, and some project steel. Or just show up and share our fire and tools. If you want to camp out, that will be OK too. There is plenty of room in this well equipped area. You should plan to provide your own meal on Friday evening.

  The William Scout Ranch is located off of Highway 412 twenty six and 1/2 miles west of the Super Wal-Mart in Enid or 3 miles east of the Hwy 8/Hwy 412 intersection. Cleo Springs -Aline turnoff. Look for a large radio tower on the N. side of hwy 412 and a Williams Scout Ranch sign with an arrow pointing south. Turn south down this road for about 3 miles and veer left following the signs to the GSPR event site.

  If you want more info you can contact Jim Carothers or the main organizer(JB Mingus at 580-548-4485)

- 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.

Gerald Franklin received this article from the author. We hope you enjoy it.

The Ring Thing

By Paul Novorolsky [Scholarship payback article: part 1 of 3]

Introduction

I recently had the privilege of receiving an UMBA scholarship to attend a class at the New England School of Metalwork in Auburn, ME. The class title was Fundamentals of Blacksmithing, Level 2 "The Ring Thing" taught by Mark Aspery.

The school had a very well equipped shop, and on-site housing at an extremely reasonable rate, and the lobster boil was a scrumptious treat.

I consider myself an intermediate level. I had wanted to take a course that challenged my skills, and this course fulfilled that desire.

It covered both design and practical aspects of making "The Ring Thing". The design work included determining how to create the tools, as well as how to approach forging a series of pass-throughs. The "Ring Thing" in and of itself has no real utility. It can be included as an element in a larger piece, but it is otherwise little more than an ornament. Nonetheless, forging and assembling one requires some skill and understanding of the materials and principals of blacksmithing.

We learned to plan the pieces and the work, as well as to calculate the amount of material and where to place our tooling. We learned how to make and adjust the tooling, as well as anticipating and accommodating some challenges. Some of the techniques learned are covered in this series of articles. In a few cases, there may be better ways to solve some of the challenges in assembling a piece like this. But some of the techniques we applied were new to many of us and perhaps weren't what might otherwise be a first choice at approaching a new assembly. But if we look at this project from the point of view that it was a vehicle to demonstrating and teaching these techniques, we can more readily accept and add these skills to our repertoire. This gives us more options in solving future challenges.

We covered a lot of material in the class, and I'd like to go over in sufficient detail to allow any of the reader to duplicate the process. As a result, the material will be published in a series of articles. This first article will cover making the ring itself. Later articles will present the selection and fabrication of the tooling.

In several of the following examples, drawings were used instead of photographs, as the sketches conveyed more detailed information and dimensions. The free Google Sketchup application was used for all generated CAD drawings.

The Ring Thing

The ring is about 3 5/8" in diameter at the **center** of the ½" round ring stock. We'll do most of our calculations based on that number. The ring is pierced in two places for the ½" square bar to pass through, and the ring passes through the ½" square stock in 2 places. So, the ½" square stock has 2 round holes to accommodate the ring, and one square hole, on the diamond to accommodate the central ½" square piercing.

While that sounds simple, the challenge is where to punch those holes so everything lines up for assembly. Figure 1 shows the approximate measurement and placement of the holes. Precision measurements are provided in a later segment. The drift for the square hole in the center is slightly less than 9/16", so the finished (and cooled!) hole will be slightly smaller than that dimension. Note the flats on the sides of the square hole. These were left flat, as there is insufficient material at the corner to fill it to make a point.

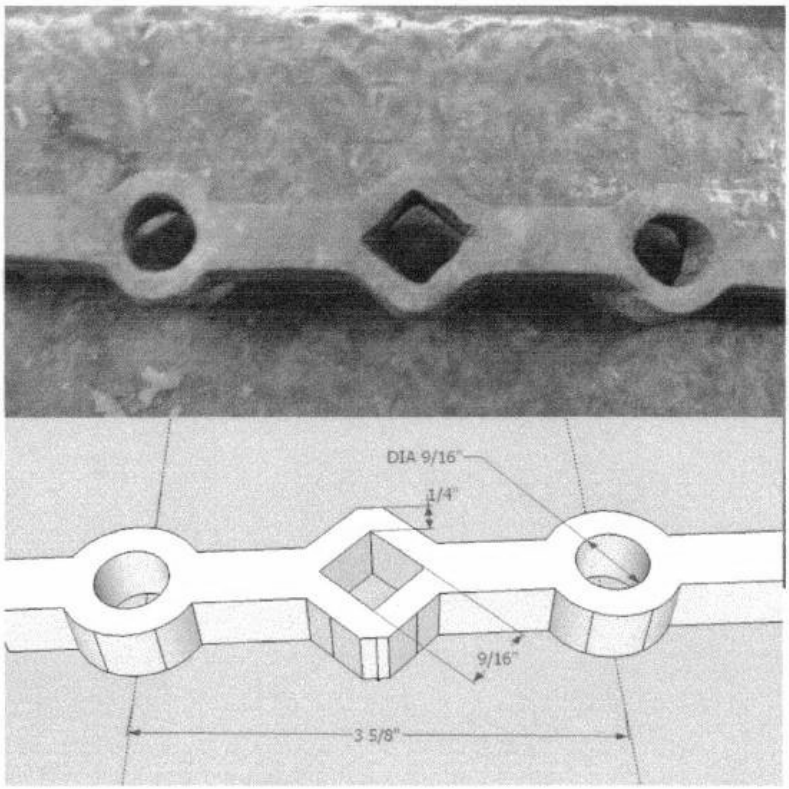


Figure 1

Ah, but maybe if we slit and drifted it instead of punching it, there would be enough material. Before we go there, consider that if there is no loss in the dimension from punching or slitting, the side walls would still only be ¼". The corner represents a diagonal across a ¼" thick wall. That diagonal is $1/4 \times \sqrt{2} = 0.35"$. So th $1/4 \times \sqrt{2} = 0.35"$ e diagonal is about 1/10" larger than the ¼" sidewall. This means unless we upset the piece, it there simply isn't enough material to fill an outside corner there. There are some other alternatives, like forging the walls down, but that would also result in some lengthening. So we left our outside corners with the flats on the edge.

The round holes are also slightly oversized for the ½" round bar. The ring makes an arch as it passes through the hole. This requires more space than just the diameter of the bar. The spacing of the round holes is chosen so the centers of the holes are slightly less than the 3 5/8" diameter of the ring. This dimension was selected so if the placement is slightly off, it is easier to draw the bar slightly between the holes to make a correction, than it would be to upset a segment.

As for the ring, it will have 2 square holes punched on the diamond. The choice here was to punch and drift one of the holes before inserting the round bar through the square bar, and the second hole after assembly. Before punching both holes are laid out, and the ends of the bar upset and scarfed for welding. Note however that the holes will NOT be laid out in the same plane, nor are they equally spaced from the true center of the bar.

Strategy/Explanation

The ring is made from 11½" of ½" round bar. This will make a ring just slightly less than 3 5/8" in diameter (diameter taken at the center of the round bar). Logically, to get the holes opposite each other, the distance between them should be the length of the bar minus the length of the 2 holes, divided in half. We'll call the length of the 2 holes ¾" each, as that's the size of our punch. So $\frac{11\frac{1}{2}-2\left(\frac{3}{4}\right)}{2}=5"$ apart, $\frac{11\frac{1}{2}-2\left(\frac{3}{4}\right)}{2}=5"$ near edge to near edge. Because we need to be accurate, we will mark our holes by marking an edge on which to align our slot punch. We could put it at the center of the hole, and center our punch on it by eye, but marking the edge will be more consistent.

There is one more thing to consider before marking those holes. This is the location of the forge weld in relation to the square bar that the ring pierces before the weld is made. The weld is performed with both holes punched and drifted into the ring. So the weld must fit between one of those holes and the square bar through which it passes. While we can slide the ring freely so that it rotates within the square bar, the thickness of the bar effectively shortens the exposed length of the ring. This works against us as we try to weld within that length. In order to give ourselves some additional working room, we offset the position of those holes so that there is a longer length of the ring available for welding on one end. We do this by marking a substitute center ½" from the true center of the bar, then make our measurements to this reference mark.

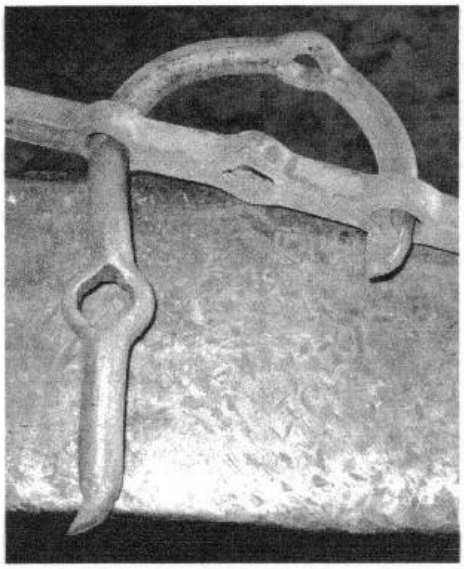


Figure 2

To complicate matters further, punching and drifting a hole along a radius is trickier than punching and drifting along a surface that can lay within our half round swage. Then, because our material is round, we can punch the hole "the easy way" and twist the bar to put it into alignment. What this means though, is that we need to mark the second hole so that it is in a plane 90° to the other hole. Then once the round bar is passed through the square bar, we punch and drift the second hole, twist the bar, and complete the formation of the ring, as is shown in Figure 2.

Layout

Round bar

On the round bar, scribe or make a light mark at the center (5 ¾" from either end) then make a reference punch mark ½" to one side of that center. The end of the bar that is now further from this mark will be referred to as the LONG end.

Then we measure out 2½" from that mark and make a punch mark here for one hole. Then measure 2½" in the opposite direction, and scribe a mark here. Then rotate the bar 90° around its axis and make a mark for the second hole. Be very careful with these measurements, as well as the placement of your punch when making these holes so that the edge of your punch results in holes whose edges are 5" apart.

Square Bar

The length of the square bar will be left unspecified. While we need a minimum of about 8" to work with; having a longer bar makes it easier to handle, as tongs aren't necessary. A 24" length is convenient, and provides enough material to make a "ring thing" on each end, if you are doing something like practicing for a public demonstration of the piece.

We've established that the centerlines of the round holes should be 3 5/8" apart, and we can easily agree that the square hole needs to be centered between them. We've also established that the marks for the round holes will be on the edge of the punched slot.

Let's consider which edge of the punch position to mark. If we mark the outside edge (the edge away from the center hole), the mark will be away from us when we punch the hole closer to us, assuming we are holding the long end of the bar. This orientation will make it difficult to easily see the mark, so we chose to mark the edges closest to ourselves. This means that one hole will be marked on the edge closer to the center hole, and the other marked on the edge furthest from the center hole.

Now we need to know where those holes are placed. The square hole is easy. Make a center mark about 4 to 5 inches from one end of the bar. This leaves enough material so that the hole nearest the edge has sufficient material to support the punching and drifting. The mark becomes the center of the completed ring-thing. The square hole will be punched with a ¾" punch, so make a second mark ⅜" from the center mark, on the long side of the bar. This will be where we align the edge of the ¾" punch.

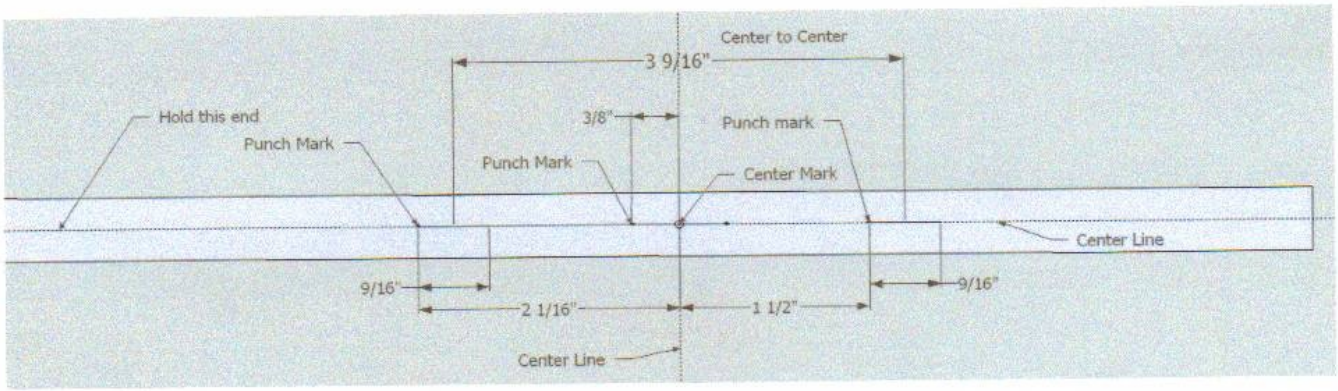


Figure 3

Measuring out toward the short end of the bar, we will mark for the first round hole. The ring centers are 3 5/8" apart. We will space our hole centers 3 9/16" apart, leaving a 1/16" for error, so we can draw the bar out slightly if needed.

Since the punch is about $^{9}/_{16}$", the $^{9}/_{16}$ inside edges of the holes will be about 3" apart. This places the inside edge of the far hole about 1½ " from the center. For the other hole, its inside edge will also be 1½" from the center, but we will be marking the opposite side, so we add the $^{9}/_{16}$ " for t $^{9}/_{16}$ he hole, placing the mark at 2$^{1}/_{16}$" from the center, on the long side of the bar as is shown in Figure 3

Punching and Drifting the Holes

Before we start making holes, a few things need to be said. First, the *slit, upset and drift* vs *slit and drift* vs *punch and drift* methods were discussed. I should have taken better notes on this, but I'll try to summarize the discussion from what I chose to learn from it. While all are acceptable methods, slitting gen-

erally seems to leave more "rag" in the center of a hole slit from both sides, where the metal tears apart. Of course, the slit is narrower, so less force is needed to drive it into the bar.

Punching provides more of a shearing cut when punched from both sides. We punched about half way through one side, and then finished the punch on the other side. This avoided the "flare" or spreading of the piece as the punch bottomed out on the anvil, and forces material to the sides of the punch, as well as allowing the hole punched in the first side to effectively become the bolster for the hole punched in the second side.

Punching from both sides this way took a little practice, but can be mastered fairly quickly. By having less rag in the center of the hole let the drift come into closer contact with the sides of the hole, and provided a tighter fit with the piercing bar without having to forge the sides of the hole back into position to compress the rag.

To punch from both sides, simply start punching, and stop just short of half way through the bar. Then turn the bar over, there will still be a slightly dark spot under the punched area, and there will be an easily recognized bulge. Center the punch in this bulge, and punch through. Try to complete the punch at a lower than red heat, which will help shear the biscuit, rather than stretching and tearing. A few practice holes were needed to gain confidence in locating the hole on the other side. But once you get it, you'll have a valuable skill.

When punching, we were taught to align the long edge of the punch along our line of sight, and beware of shadows. With even lighting, this orientation makes it easier to center the punch. The first blow should be somewhat light, to mark the position. Remove the punch, and if the hole is not where you want it, now is the time to correct it. Once you have the hole marked where you want it, proceed with heavier hammer blows. There are times when you will need to punch with the long edge perpendicular to your line of sight (even in this project). Extra care must be taken when starting the punched hole, as it is much easier to get it started off-center in this orientation.

Because the tips of the punches are fairly thin, they heat up quickly. So it is important to hold to the "3 strikes and out" rule. That is, no more than 3 hammer blows to the punch, then quench the tool tip to cool it. Be sure to tap the punch to remove any excess water before resuming punching. The water will not only cool the work, but it can also create a steam explosion as it comes into contact with the hot work piece.

Square Bar

Punch and drift the 3 holes in the square bar. The far round hole is punched and drifted first, as the end of the bar is stiffer before the other holes are cut and shaped. I made both round holes first, then the square hole. A bolster was not needed for the round holes, as the pritchel hole was close enough in size that it adequately supported the bar during drifting. If your pritchel hole is too small for this, a bolster plate may be needed for the round holes.

The square hole is punched, then drifted using a bolster plate so that the drift does not pull material down into the hardy hole. After the initial drifting, the piece is reheated, and the drift inserted in the square hole. It is then forged between the 2 'V' top and bottom swages to dress the sides of the square hole. Forge one side in the swage, then rotate the piece so the other side is up and forge again. The "point" of the hole's side will not be prominent, so it should be flattened to make it uniform and pleasing to the eye.

After both round holes and the square hole are punched, drifted and forged, the square bar should closely resemble that in Figure 1.

Round Bar

Before punching the round bar, the ends should be upset and scarfed in preparation for the forge weld. Be careful to keep the upset to a size that will pass through the round holes you just drifted in the square bar. Test this fit as you upset the bar. Also note that the scarfs will need to be at 90° to each other. The scarfs should be oriented so that the flat of the scarf is parallel to the axis of nearest hole (See Figure 2). Remember, one side of the bar will be twisted 90° after punching and drifting.

Punch and drift the hole at the LONG end of the bar, using the half-round bottom swage to support the bar and prevent a flat spot. Punch halfway through, then turn the bar over and carefully align the punch so that it is centered on the slight bulge that now appears in the bar. Drive the punch through the bar. When you feel the punch begin to bottom out, the slug should be loose. Move the bar over the hardy hole and knock out the biscuit. The second hole will be punched later.

Forming the Ring

After punching and drifting the one hole, it's time to start bending the ring around the 2-slot frustum of a cone. As there is a hole in the bar, this section will be weaker than the solid bar. So an attempt to bend it as it is will result in a sharp bend at the hole. To avoid that, a short piece of ½" square is inserted into the hole just prior to bending.

Take a long heat on the LONG end of the round bar. Then insert the piece of ½" into the square punched hole, and place the round bar against the cone with the square bar passing through the slots in the cone. Then, using one of the dog wrenches, anchor the bar to the side of the cone. Use the other wrench to gently bend the bar around the cone. Try to keep the ring fairly flat at this point, so it forms a circle, rather than a parabola. Take additional heats as needed and continue bending until the ring is slightly more than 180° in arc. The ring will be inserted into the square bar before more work is done, and having more than 180° of arch will help hold it in place as shown in Figure 4. The punch mark for the second hole can also be seen in the photo. The round bar in the photo twisted a small amount while bending. The slot will be punched perpendicular to the anvil's face and not directly on the punch mark in this case.

With the ring passing through the bar as shown, punch and drift the second square hole in the round bar. The positioning of the bar so that it is stable in the bottom swage is a bit challenging. A third hand

makes this easier. One suggestion was to turn the bar so the punched segment is parallel to the length of the anvil, and set the ¼" bolster under one end to hold it more or less level in the swage for punching, while holding the square bar between our legs. This had the disadvantage of now punching with the length of the punch across our field of view, making it more difficult to center it on the bar. A third hand here avoids this situation, and really does make this maneuver much easier.

With the second hole punched and drifted, it needs to be twisted so that the hole is in line with the radius of the ring. Heat the end of the bar and quench it to the hole, so that the hole is now cold, and will be protected against deforming. Place a piece of ½" square stock in the hole and carefully twist it so that the scarf will line up with the scarf on the other end.

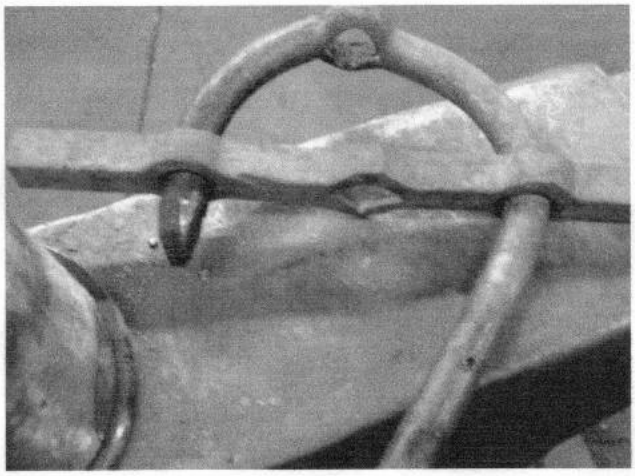


Figure 4

Reheat the end of the bar, and return to the 2-slot cone and carefully bend the rest of the ring around the cone. Be cautious around the punched hole so that it does not over bend, and be sure to align the ends so that the scarfs in properly positioned for welding. When you are generally satisfied with the shape of the ring, manipulate the ring so that the scarfs are positioned where they can be accessed for welding.

Bring the scarfed area up to heat and flux. Get the chain-makers swage ready, and bring the scarfs up to welding heat. Use the swage and horn of the anvil as you see fit to perform the weld and dress the weld and the rest of the ring to reshape it to round. Return to the slotted cone to shape the ring. Once the ring is reasonably round, use the 4 slot cone to re-drift the square holes. The hole in the center should not need to be re-drifted, but the holes in the ring were likely distorted in the bending and welding processes. The drift should only be driven from the outside of the ring toward the center. Avoid any temptation to drive the drift through the entire piece and out the other side. This will allow the cone to support the area around the holes, avoiding distorting the ring.

All that is left is to insert the remaining square bar though the center holes to complete the ring thing. While careful layout will get the holes close to alignment, there is sometimes some additional adjustment needed to get the fit. Much of this can be done on the "castle" cone. I'll leave the final adjustments for personal discovery, as I'm still learning the many things that can go wrong on the way to making "the ring thing".

Look for Part 2 next months newsletter...

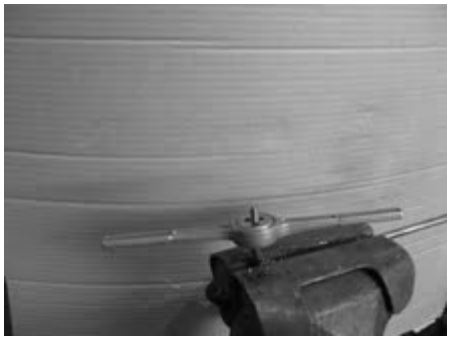
Outdoor Thermometer Stand

Gerald Franklin

This little stand will replace the suction cup that comes on many outdoor thermometers. The instrument stands further away from the window and doesn't pick up as much heat from the house.

It is made from ¼" round rod. The "clamp" portion is forged first and it made to fit the particular sill material on the house.

The upright portion was sized at about 7" tall in this case but yours may differ. The last step is to make a 90-degree bend at the top and thread for a ¼"-20 nut. This one has a wax finish. The thermometer is mounted using two nuts and two washers.



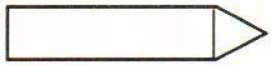
Reprinted with permission from editor of Hammer's Blow

Forged Leaves Forged Leaves Forged Leaves

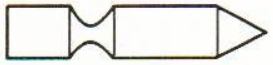
One of the most common decorations on iron work is leaves. They are easy to make and are almost unlimited in their design. Here is a basic leaf that seems to be adaptable to everybody's capability. Roger Quaintance of Amana, Ohio impresses his classes by showing how to do a leaf in three heats. The following steps let you decide how many heats it takes in your forge. Note that leaves can be made from any size and shape of scrap iron you have lying around, but here we will start with 3/8" round.

Step 1 - Make a tapered point at the end.

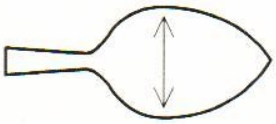
Step 2 - Place the bar over the edge of the anvil about 2" from the tip and neck down the stem part of the leaf.



Step 3 - Work the stem down to about 1/8" to 3/16" as round and as long as you will want it later on.

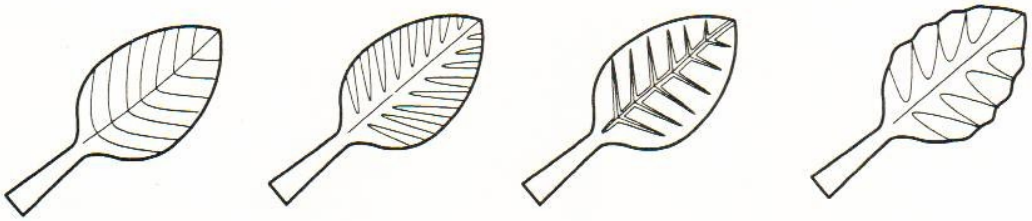


Step 4 - Flatten the leaf body leaving the tip pointed.



That is the basic leaf, flat and pretty uninteresting. With practice you can make them come out about the same size and shape every time, but you can also grind off the lumpy sides or file away unwanted parts until they begin to all look somewhat alike. Remember, no two leaves are exactly alike. (F. Wolf's book, *Kunstschmiedepraxis*, shows great photos of this process.) What you do with the leaf from here is what makes the difference. You need to give it some texture and some shape --in that order.

Step 5 - Texture the leaf. Some specific designs need thicker leaves in which case you would need to start with larger size stock.



Chisel in veins straight or curved.

Use a narrow hammer peen.

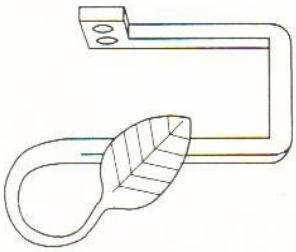
Make specific designs.

Step 6 - Shape the leaf to give it interest. Heat and dish in over the hardy hole and bring down the tip over the horn.

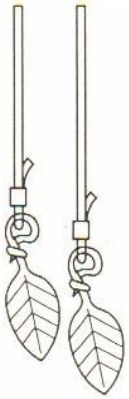
And . . . Still More Leaves

Here are several items that are commonly made with leaves as a major part of the decoration. You can think of a dozen more. For inside use, finish with floor wax, boiled linseed oil, varnish, paint, or whatever you like the best.

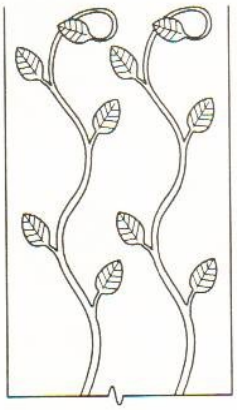
Plant Hanger
(try 3/8" round stock)



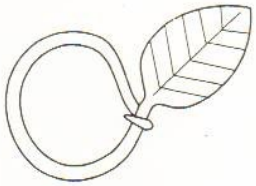
Curtain Tiebacks
(try 5/16" square)



Curtain - Drapery - Light Cord Pulls



Railing or Room Divider
Vine Decoration
(try tapering 1/2" round at bottom to 3/8" round at top)

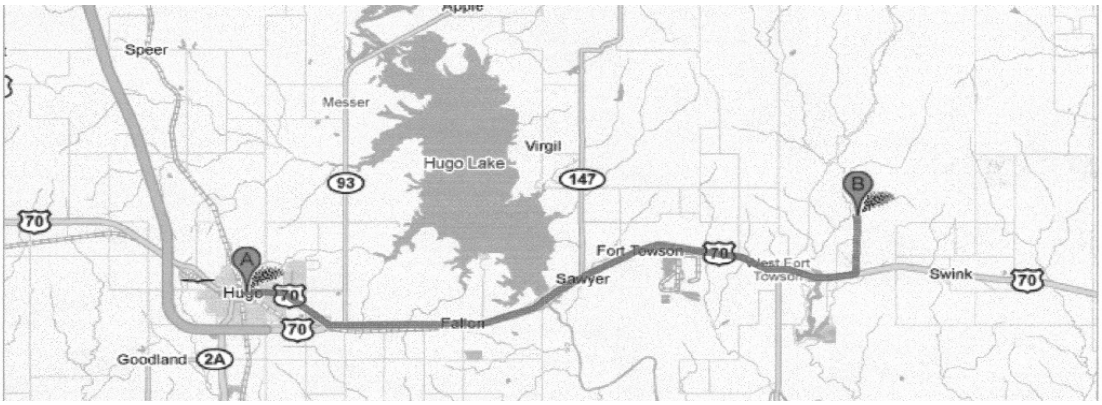


Key Ring
(try 1/4" round)

Leaf Hooks
(try 1/4" or 5/16" round)

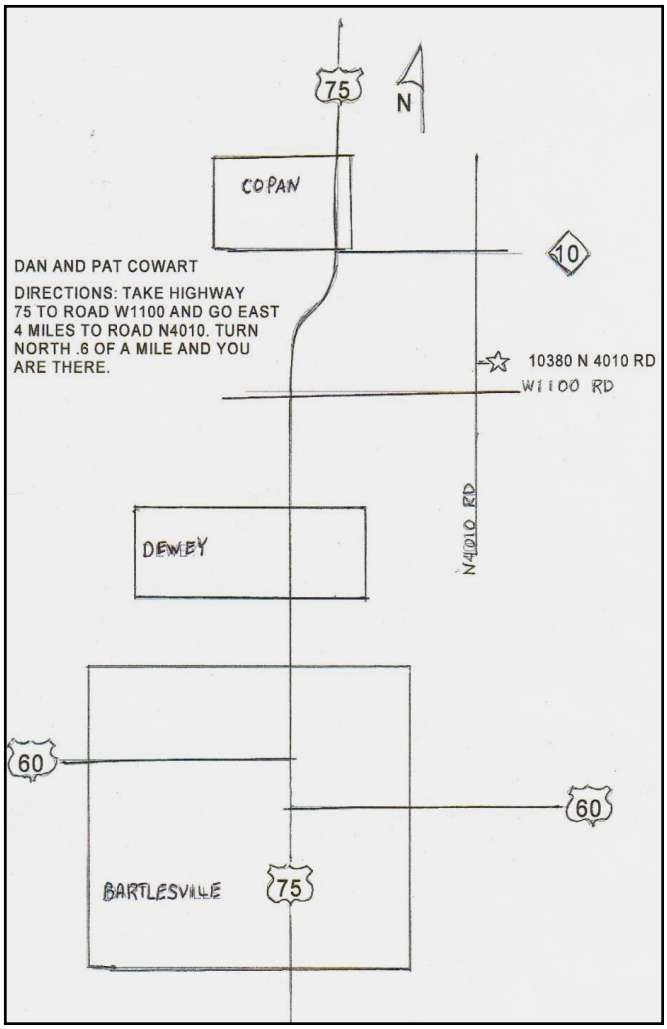
Map page:

Map and directions to Ft. Towson:

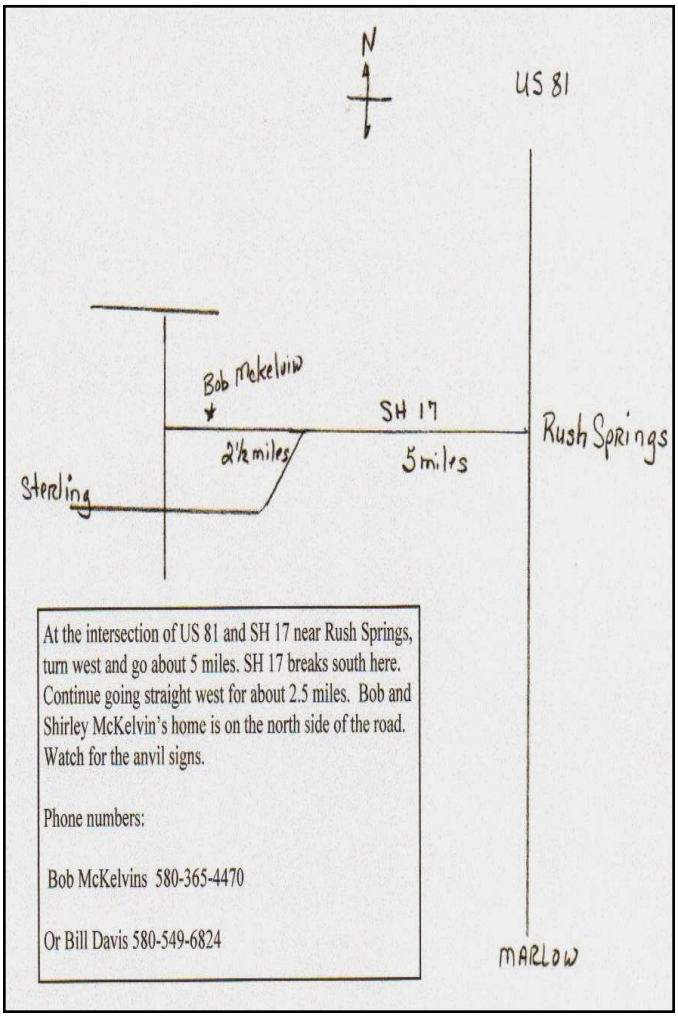


Ft. Towson is located east of Hugo, Okla. Just off Highway 70. From the junction of highway 70/ Jackson St. and US 271 go east approximately 14 miles to N4380 Rd. Turn left onto N4380 and go 1.7 miles

Map to Dan Cowart's Place (NE meeting location)



Map to Bob McKelvins place (SC meeting)



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. Enrollment info will be in the May and June newsletters. Cost: $10

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.

December 29, 2012 – ***Basic Blacksmithing Workshop*** at Gerald Franklin's shop near Duncan, OK. Enrollment info will be in the Nov and Dec newsletters. Cost: $20

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.

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 -327-5235or 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.**

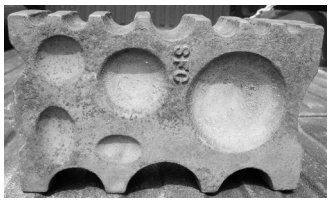
NW Region coal pile is located in Douglas, OK. If you make arrangements well in advance, Tom Nelson can load your truck or trailer with his skid steer loader for a fee of $10 to be paid directly to Tom. Tom has moved his skid steer and must now haul the loader to the coal pile to load you out, hence 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.

SCABA swage blocks
$80. plus shipping to members. (1st block)
$100.00 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.

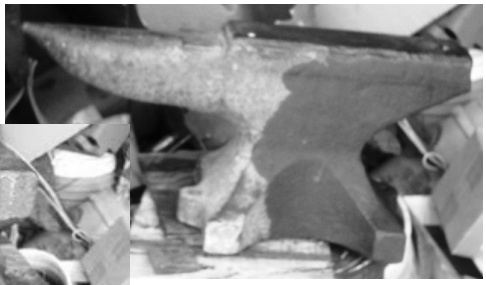
For Sale:
One 50# "Transition Style", Little Giant Power Hammer, In excellent condition. We are currently using it in our shop. It comes complete, ready to run with two sets of dies. $3750.00 fob Alva Okla. Pictures available on request.
Mike George at 580-829-1968 or
George.purchasing@yahoo.com

For Sale:
Arm & Hammer anvil, 400#, serial no. 34008, 1918
Kohlswa anvil, 100#, excellent condition.
Cast anvil, 100#, no name or markings, but does have tool steel face and is in good useable condition.
I have a few post vises—screws are in good condition, and several hand crank stone wheeled grinders, (great for demos) starting at $25.00.
Contact Tom Nelson at 580-862-7691 or tomn@pldi.net

For Sale;
Hossfeld Bender
Model No. 1 (on a stand)
Includes –36 dies and operating manual
Cost- $550.00
Contact: Gene Hall 918-232-9146

Swap and Shop continued:

For Sale: about 200 lb Fisher Anvil (needs work) $500.00



For more info contact:
Dennis Vincent
Big Cedar, Okla.
918-651-3295
228-224-2426
Or pennyswork@gmail.com
(this gentleman is not a member so this is a one time add)

Jim White has the following items for sale:

Champion #430 combination coal forge coal forge. 38x52” has #400 blower, steady rest, coal box, water trough

Shop Coal forge 32”x40” Has; tong rack, steady rest, water trough

Portable coal forge (3) legs 19” fire pan. Has tong rack, steady rest.

Canady Otto 12” blower on factory stand

Champion 12” blower on factory stand

Champion 6” blower pipe factory stand

110V. 6” blower with mounting bracket

Peter Wright 252lb anvil. 1 1/4” hardy hole 5/8” pritchel . X-good face and horn

Molock 25 lb power hammer, brass bearing (all) with grease zerks

Clarke table model drill press with quick adjusting chuck. 0”-1/2” capacity

All equipment in x-good condition and ready for use.

Call for more information and delivery options. Jim White 817-329-5297

2012 Annual Saltfork Craftsmen ABA Picnic

Before we know it April will be here and it will be time for another get together. This years Picnic will be hosted by Byron and Carol Donor at their home in Norman. The board and Byron will be finalizing plans for food and games that will be taking place this year. If you have any suggestion as to food you like or forging games you would like to see at this years picnic, please email or call one of the board members to let them know. I'm sure they will be glad to here from you.

One of the items that Gerald Brostek has going is the nail board. We had a nail tree at the last conference and it was a great hit, but some people done have room for such a large item, so Gerald Brostek came up with a beautiful cedar board to put the nails into. (see picture) He has been taking it around and getting people to make their best nail to put in the board. He still has a lot of room left and want everyone to get a nail made so that as many members as possible can be represented on the board. If you want to make a nail but live out of state and can't get to a meeting, please mail your nail to Gerald Brostek (his information is on the board of directors list) and he will gladly install it. Please keep the nails a reasonable size so that it doesn't split the wood when installed. The board will be at the picnic. There will be forges at the picnic also so if you need some help making a nail, there will be members there to help you. If you already have a nail made bring it and lets fill up the board. We want the board filled by the 2012 SCABA conference in October. It will be auctioned off at that time.

A nail making contest has been suggested for the picnic and the details are still being worked out but practice up on your nail making and bring your favorite hammer and enjoy. I'm sure it will be a lot of fun. I might even have to try my hand at it.

There will be some family type classes during the picnic. You will need to RSVP so enough materials will be on hand for everyone to participate that wants to. There will be a reasonable cost associated with each class to cover those materials.
Teresa will be demonstrating fold forming of copper and you will be able to make some items that can be made into jewelry. There is a $20.00 cost and a limit of 10 students.
Diana Davis will have some PMC clay and you will be able to make some charms to add to a bracelet. The cost of this class will be determined by the cost of Silver when ordered. I plan to order the silver clay about 15 days before the picnic in order to get it in time. You must contact me by April 1st. If you want me to purchase you the necessary supplies. I estimate the cost of the class to be between $30.00-40.00 dollars. This clay (when fired) become .999 pure silver. The charms you make will be about the size of a nickel and you should be able to get 4-5 charms from a 9gram pkg. They will be added to a silver plated chain that you can then add beads, etc to. It will be a lot of fun and will give you the basic skills so you are ready for the conference where we will be working with bronze clay.

The board usually provides the meat for the picnic with the members providing the sides and deserts. Watch the April newsletter for more details and please try to help out where needed. It you club too.

Mark your Calendars for April 21st and make plans to be in Norman Oklahoma for the Picnic…

Saltfork Craftsmen

Artists - Blacksmiths Association, Inc.

Board of Trustees Election March 2012

There are three Trustee terms expiring this year. The three trustees who's terms are expiring are:
Gerald Franklin, Dan Cowart, and David Seigrist
Dan Cowart and David Seigrist are candidates for re-election.
Gerald Franklin is not running again.

You may choose from the candidate list or you may write in any other persons who are members in good standing. Please vote for only three candidates by putting a check mark on the line next to their names.

Dan Cowart	Wann, Ok.	____
David Seigrist	Hollis, Ok	____
Diana Davis	Fletcher, Ok	____

Other : _____

These candidates are all good people. Any of them will be an asset to the Club and to the Board of Trustees. Please vote only once per membership. The election dead line is April 10, 2012. Please fill in your ballot as soon as possible and mail to:

Saltfork Craftsmen 2012 Ballot

Dan Cowart
10380 N. 4010 Rd.
Wann, OK 74083-2014

- -fold- -

Dan Cowart
10380 N. 4010 Rd.
Wann, Ok 74083

Saltfork Craftsmen 2012 Ballot

Dan Cowart
10380 N. 4010 Rd.
Wann, OK 74083

- -fold— -

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

ABANA | NEW & RENEWAL MEMBERSHIPS

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 – ☐ $55	Two Years – ☐ $105
Senior Membership (65+, US, Mexico, Canada,)	One Year – ☐ $50	Two Years – ☐ $95
Full-time Student (US, Mexico, Canada)	One Year – ☐ $45	Two Years – ☐ $85
Foreign	One Year – ☐ $65	Two Years – ☐ $125
Contributory Membership *(amounts above $55 / year may be tax deductible)*	One Year – ☐ $150 and up – $_____	Two Years – ☐ $295 and up – $_____
Public Library (US, Mexico, Canada)	One Year – ☐ $45	
Educational Institution	One Year – ☐ $250	

Saltfork Craftsmen Artist Blacksmith Assoc.Inc.
10380 N. 4010 Road
Wann, Okla.74083

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