

# Saltfork Craftsmen Artist-Blacksmith Association

July 2010



Gerald Brostek (left side) from Muskogee Oklahoma represented Saltfork at the ABANA conference in Memphis, Tn. Gerald had two rings selected to become a part of this years ring project at the conference. Byron Hanson (far right) made the frame.

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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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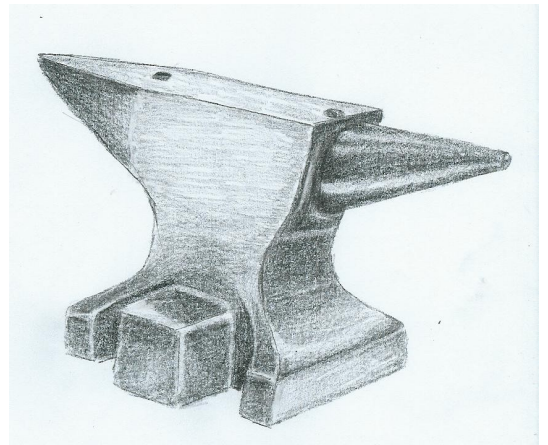
**MEETING SCHEDULE  
July**

**SE regional meeting (July 3rd) open.**

**NE Regional meeting (July 10th)** Hosted by Clayton Hall. Map in back of newsletter. Trade item is a spork/eating utensil. Lunch is provided but you might bring a side dish to help out.

**SC Regional meeting (July 17th)** Hosted by Alex Scrudder at Max Scruders shop in Mountain view. Alex and Ann are planning to make brisket so bring a side dish to complement it. The trade items is anything made from a horseshoe.

**NW Regional meeting (July 24th) open**



Saltfork Crafters-

I'm sorry for the delay in saying "Thank You", I sent a Thank You card the first part of May but it was lost in transit.

We truly appreciate everything you have done for us.

Rick, Teresa  
+ RJ Ayer

Saltfork Crafters-

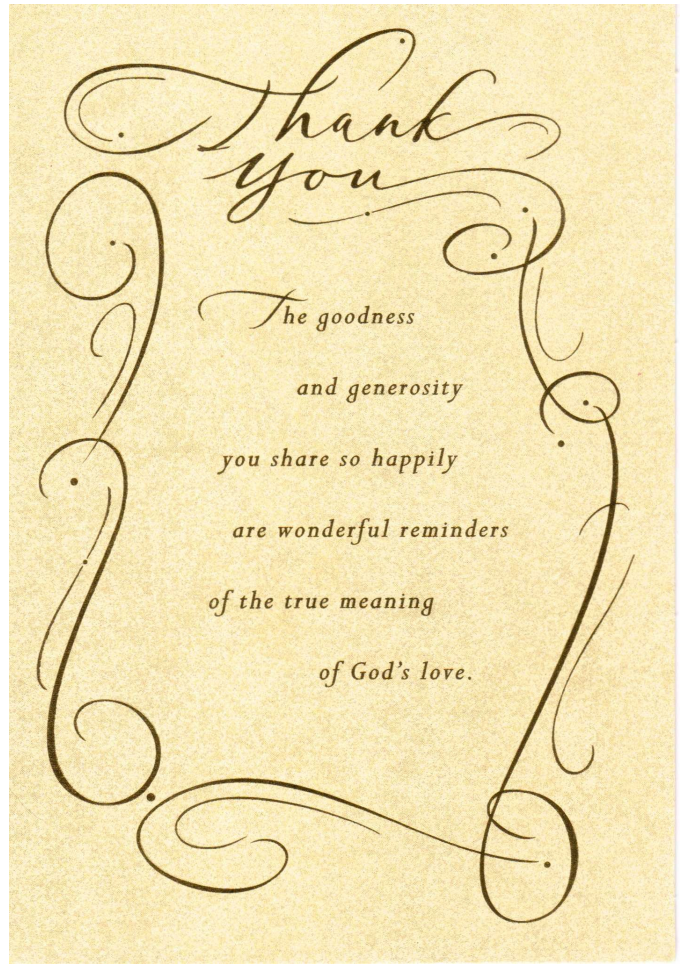
Thank you for your work in setting up the auction and the generous check.

Your check made it possible to pay the last few bills from the original procedure.

We appreciate your thoughtfulness, prayers and generosity.

Thank you for being  
the blessing you are  
to all who know you.

Thank you again,  
Rick, Teresa  
+ RJ Ayer



## President's Notes

Gerald Franklin

I want to start this month's notes off with some really good news. We have cone mandrels. Our foundry poured two samples in time for Mike George to pick them up and bring to the ABANA Conference in Memphis. After we had a chance to inspect the samples, we contacted the foundry and asked them to complete the order. The foundry called me today (Jun 23) to tell me that they are ready. We are arranging for pickup. Check the website for availability. The sale price will be \$200.

Saltfork was well represented at the ABANA Conference. I counted close to twenty SCABA members from four states in attendance. In addition to having a good contingent of members there, our club sponsored one of the demonstrators, Darryl Nelson. SCABA member Gerald Brostek again did himself (and his club) proud with his participation in the Ring Project. Gerald actually had three rings selected for the so-called "auction frameworks". This is quite an accomplishment and is evidence of Gerald's smithing abilities and his craftsmanship. Congratulations, Gerald!

The "Nail Stump" at the ABANA Conference had a lot of participation and was interesting to look at. It's basically a log that is set up for folks to drive their hand-forged nails into. There were some really creative and well-done nails displayed. Gerald Brostek suggested that we set up a stump at our conference in Perry. We'll give it a try so watch for more info in future newsletters.

We had four regional meetings in June. The first SE meeting was held in conjunction with a community event in Hugo, OK and was hosted by Mark Hamill. Bill Phillips hosted the second SE meeting of the month at his place near McAlester. The South-Central regional meeting was hosted by Byron and Carol Doner in Norman. Ron Lehenbauer hosted the Northwest meeting in conjunction with the tractor show in Fairview on the 26th. As I write this, the NW meeting/tractor show hasn't happened but I'm sure that it will be as well attended as the earlier meetings were.

We were able to say good bye to J.C. and Renee Banks (who are moving to Colorado) at Byron Doner's meeting on the 19<sup>th</sup>. We presented Renee with a very nice "rose-scroll" wall hanging made by David Seigrist. We were pleased to present J.C. with a tool box that was expertly built and carved by Don Garner. Mike George provided the hardware for the box. Members around the country provided tools for the box. This was a superb box and collection of tools and J.C. said, "I'm like a kid at Christmas." I'll have to agree that he certainly looked like a kid at Christmas as he looked over his new collection.

Plans are underway for our participation in the 2010 Oklahoma State Fair. Byron Doner is putting together the list of demonstrators, so if you can help out, get in touch with Byron to sign up for one or more days. Remember that we need three or four people for each day. There is also a large chuck wagon event, the Battle in Saddle at the State Fairgrounds on July 10<sup>th</sup>. They have requested demonstrators for that event and Byron Doner has the sign-up list for that event, too.



## S/C Regional meeting

Byron and Carol Doner hosted the meeting for the S/C region for the month of June. He had a great turnout with 30+ showing up. One of the items on the agenda was to present JC and Renee with going away presents and “Thank You” s for all the hard work that JC has done for the organization. Don Gardner made and beautiful box and Mike George made all the hardware for it. Members and friends made or supplied the tools that were place in it.

Everyone had a good time visiting and checking out Byron’s new Anyang hammer he purchases from James Johnson of Alvord Texas.



Byron and Carol fixed a delicious lunch of brisket, ribs and fixings. Everyone found someplace either inside at a table or outside under a shade tree and concentrated on the great food.

The trade item was something made from a horseshoe. There were several nice items brought or made during the meeting.



Carol had a cake fixed for JC and Renee Banks.

JC said that they would try to come back to Oklahoma whenever they could.



# Saltfork Entertains at Hugo Homecoming

Story and photos by James Allcorn

Hugo Oklahoma's 2010 homecoming served as the backdrop for the June 5 SE Saltfork meeting. The day was bright, clear and hot. Three forges were in operation, just across the railroad tracks at the restored Frisco Depot, now occupied by a Hugo museum and restaurant. Mark Hamill, Howard Bost and Omar Reed cranked their forges while Eddie Horton, Cedric Cope, Ed McCormick and James Allcorn looked on and provided encouragement.

The upstairs section of the old Frisco Depot was hosting a "meet and greet" for the homecoming crowd and our smoke was a good attraction with some 60 plus visitors making their way across the tracks to find out what was on fire. After finding out that it was a blacksmithing demonstration, just about everyone replied, "Oh, my (insert name of relative) was a blacksmith!" We had a good time visiting and talking with the homecoming visitors and I think they really enjoyed us being there.

Howard Bost would have taken the prize (if we had given one) for "most original" forge and anvil. The forge appears to have been made of a combination of buggy wheel and plow disc with the anvil being carved out of a piece of railroad track. Mark's and Omar's forges worked just as well but just were a bit more traditional in design.

Ed McCormack had on display a large Bowie type knife he had made from (I think) a horseshoe rasp. He also displayed a large sledge hammer which he had drawn out one of the hammer's faces into an interesting array of various shapes, grapes, leaves, etc. I've seen a lot of knives and hammers but never any quite like the ones Ed made and I regret not getting a picture of them.

(Southeast Saltfork meeting, June 5, 2010; Hugo, Ok.; Hugo Homecoming.)



Omar Reed tends the fire, Ed McCormick cranks the blower while Cedric Cope and Eddie Horton provide moral support.



Howard Bost works on a figurine



Mark Hamill at his forge.

# Southeast Regional Meeting

Gerald Franklin

Bill Phillips hosted the second Southeast Regional Meeting in June at his ranch near Indianola, OK. I said “second” SE meeting because, we also had a SE meeting in Hugo during June. This meeting was held on a “NE” date because earlier in the year, Dan Cowart had asked attendees at one of his meetings to fill up the list for meetings for the rest of the year. Since nobody signed up for the June NE date, Bill signed up for it.

The trade item was a bird or some other animal and there were some nice specimens of critters laid out on the table. I didn’t get an exact count but I believe there were around eight items traded. I brought a hummingbird and so did Dan Cowart. I went home with Dan’s but I don’t know who wound up with mine.

The Phillips crew put on a mighty feed with grilled hot links, Polish sausages, and hot dogs with plenty of fixings and side dishes. If anybody went away hungry, it was their own fault.

There were several forges going throughout the day and several new smiths were able to try their hand at forging new stuff. I really believe that we “set the hook” on some new members and I’m looking forward to seeing their smithing interest grow.



## Conference planning....

October will be here before we know it and there is a lot to get done. If you are interested in helping this year you can contact Dan Cowart or Gerald Franklin to see what committees still need help. We will be setting up starting at 8:00 AM on Friday October 15th. Help is always needed with unloading forges, anvils etc. and moving bleachers in the demo area.

Someone to help set up the Gallery and Auction area on Friday afternoon. I would like to see if anyone can build two or three pillars (something that can be disassembled for storage) that can be used in the gallery for some of the larger freestanding items. Approximately 3 ft tall with a top area of no smaller than 12" sq to no larger than 18" sq. Painted a cream or light beige. These dimensions are flexible. Use a sheet of MDF, make cuts to limit waste. Contact me and I can discuss with you in more detail what I have in mind.

The gallery and auction can't happen with out you getting out to the forges and making items to display in the gallery or putting in the auction. Remember that the gallery is not just for ironwork, we have included a fiber craft and jewelry areas in the past and look forward to adding other arts to our display and auction. If you enjoy making it, we want to see it.

We also need members to go out and solicit items for the iron-in-the-hat. These items are always fun to win. There is also the tool box which is our largest raffle item. Tools are needed to fill the box. There is a starter list in the back of this newsletter but you can make anything for the box you would like.

We have several family classes set up or in planning.

- ◆ Teresa Gabrish will be doing a wire wrapping pendant class The cost is \$30.00.
- ◆ Saturday morning Diana Davis is planning a glass fusing demo. There will be a small fee for anyone that wants to try to create a piece (only if the piece comes out of the kiln intact) Hopefully if all goes well with the glass fusing, there will be some finished product to make pendants out of using a wire wrapping technique.
- ◆ Saturday morning Carol Doner and Diana Davis are offering a quilt block class.(There will be a small fee for this class, supplies and fee will be in the next newsletter)
- ◆ Sunday morning Diana Davis will be trying some silver casting using broomcorn. (demo only)
- ◆ Sunday morning Carol Doner is offering a 10-minute table runner/placemat class. If you are interested in the table runner/placemat class bring 2/3 yard of your focus fabric and 1-yard of another fabric that blends with it. (no charge for this class) Bring a sewing machine if you have a portable one and any necessary tools. We will have some machines available if you don't have one.
- ◆ Ladies that are interested in sewing will enjoy signing up to go on a trip to a quilt shop in Stillwater on Saturday where we have arranged for a sewing workshop. This is also a great opportunity to pickup some nice fabric for upcoming projects. The quilt shop will provide everything needed to do the workshop. It will be a table runner and the cost will be between \$12-15.00. We will leave the conference by car pool and arrive in Stillwater about 12:00 noon to enjoy a light lunch (on your own) at the local Subway. They have a large selection of soup, salads and sandwiches. Estimated cost of lunch is between \$7-10.00 depending on how hungry you are. We are scheduled to arrive at the quilt shop at 1:00 P.M. and be there for a couple hours. There is another quilt shop in Stillwater (Sew n Sew) that we may go by if we have time. We will return to Perry in plenty of time to enjoy the evening meal and get ready for the auction.

**Very important planning...get you hotel room booked.** Even though we don't have to worry about the homecoming games or hopefully the pig auction this year, you need to get a room booked now. Many of us are staying in the Super 8 but there are several nice places to stay in Perry or you can make arrangements to camp on the fairgrounds. Just bring some earplugs as I think the trains are on a "on the hour every hour" schedule.

We always have a very nice tailgating area set up under the trees. Bring any unneeded equipment and trade it for some you need. Nathan Robertson is planning to be here again this year with his nice selections of new forged hammers and Roger Degner will bring his blacksmithing CD's.

Watch for more information in upcoming newsletters.....

Editor



## Nail stump....

At this years conference we thought we would try one of ABANA's ideas by introducing a nail stump. Bill Davis went out searching among the fallen trees, from the Ice storms , that are still scattered in fields and along creek beds. He was looking for one with just the right limb number and spread. He found two possibilities and finally settled on a walnut limb. He then proceeded to remove the bark in preparation for applying a sealant.



Bill is using a draw knife to remove the bark..



Right now it has a bit of a lean to one side. Bill will set it up on a platform and mark the legs for cutting to bring it straight. It will be allowed to dry out some more and then a wire brush will be used to remove the rest of the under bark. Because this is a young branch it will not have to dark wood typical of black walnuts. With a finish it should remain a light cream color. Forged nails should show up really nice driven into it.



The plan is to put the stump into the auction on Saturday night so get your nail made. The more unique the better.

## SCABA new floor cone.....

As this newsletter is being printed, Gerald Franklin is making arrangements to travel to the foundry to pick up our first order of floor cones. We took two to the ABANA conference and everyone that saw them thought that they were a good size at a reasonable price. We have Jim Carothers to thank for all the effort in making this happen. He has worked for the past two years to get the leg work done. There have been others that have kept the idea alive and helped Jim in his efforts to see this project completed.

The floor cones will be located around the state to help reduce the need of shipping for as many members as possible. The cones will cost \$200.00 each. There is no discount for members as the board has held the cost to the lowest possible amount.

The height of the cone is 36" with a taper from 1 1/4" at the top and increasing to 10" at the base. It has a 12" diameter flange around the bottom. It has a tong groove down both sides.





## TRIVET of the MONTH



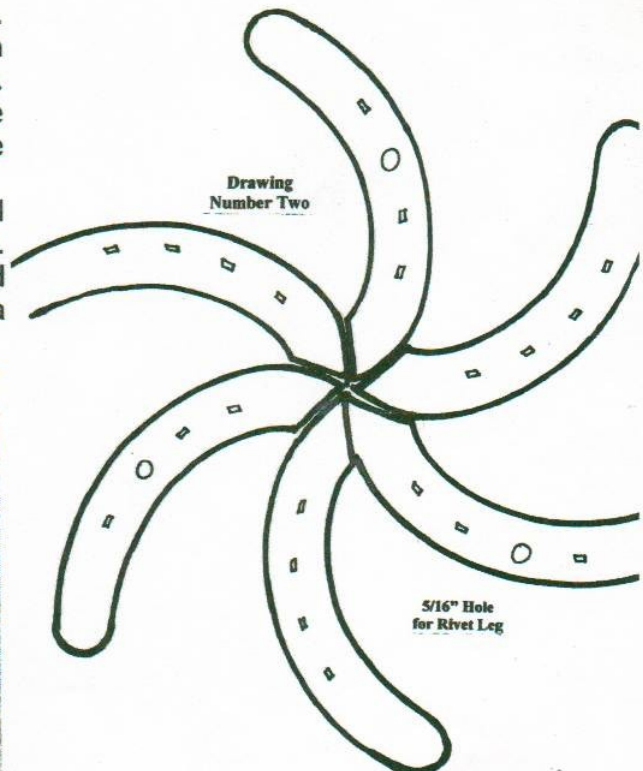
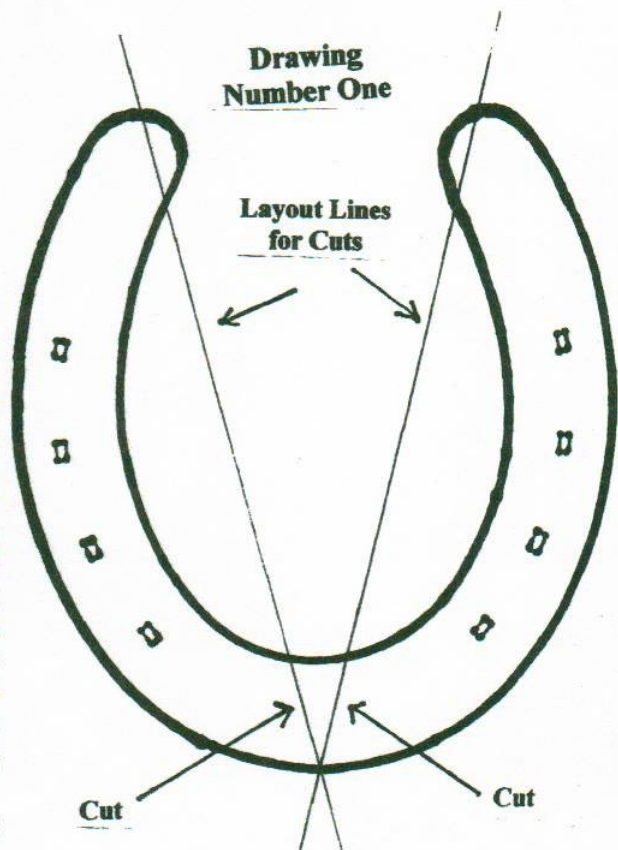
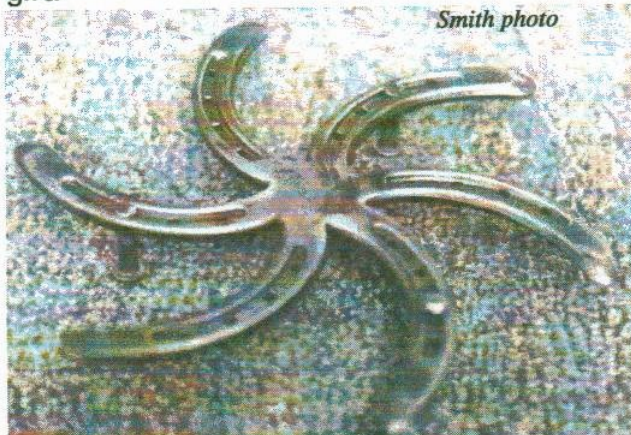
"Reuse the Shoes"  
by Doug Merkel

Don't throw away those used horse shoes. Instead of using plain bar stock for small items consider using new or used horse shoes to add a little texture and meaning to those forged items many of us give away during shows or as gifts. Here is a trivet that is made out of horse shoes.

You need six (6) shoes all of the same size and six (6) 5/16" x 1 1/2" rivets. Cut the horse shoes in half by removing a small wedge of metal with your saw, hot cut or cold cut. The right halves make one trivet while the left halves make a second trivet. See drawing one. Line up the pieces as shown in drawing two to make a pin-wheel. Clamp to table, weld together the centers on both top and bottom, grind level and wire brush.

Pick out the same nail hole on three of the arms and drill a 5/16" hole through the shoe from the back (side of shoe without the crease). Go slow so that the drill bit does not catch on the edges of the crease as it comes through. Put in the rivet from the back and weld in place from the back. Turn it over and peen over the edges of the rivet.

Wire brush, use a torch to color the metal and apply a wax finish or finish of your choice. Do the same with the other halves and you end up with two trivets. One for you and one as a gift.







# Sketch Book

By Diana

flower pot hook by Bill Epps

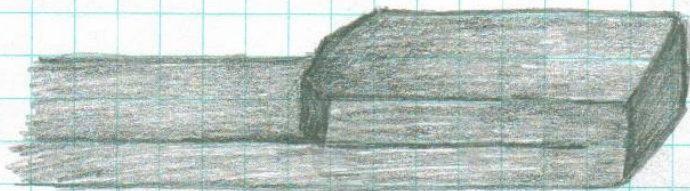
Start with 1" of  $\frac{1}{4} \times \frac{3}{4}$  flat stock



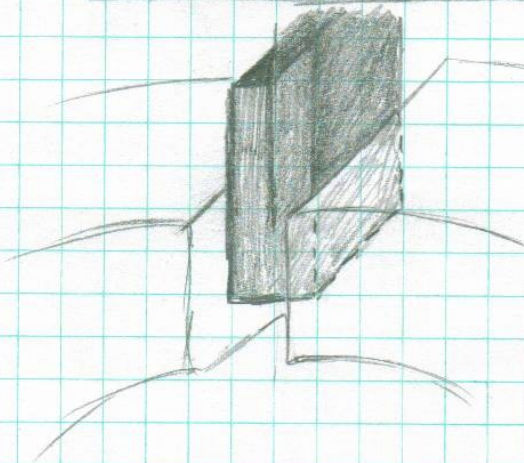
Bring one end to a forging heat and form bevels on each corner.



Bring area 2" from same end back up to forging heat and fold back over onto itself.

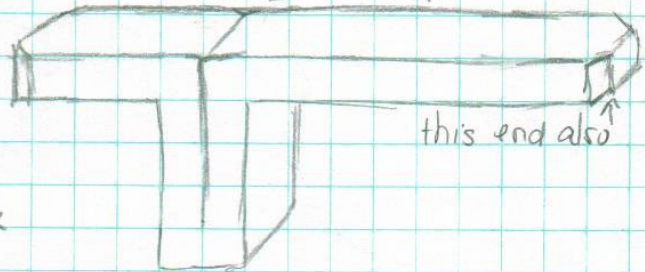


square up this fold



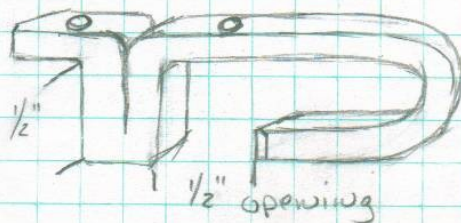
Heat and place about  $\frac{1}{2}$ " of folded end in a vise and quickly fold the end over in opposite direction at  $90^\circ$  angles

Repeat Bevel on



this end also

Heat and fold long side over anvil to form hook.



Drill Two holes for mounting.

Will hold terracotta pots



## ABANA Conference 2010

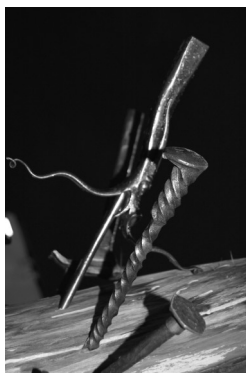
SCABA was well represented at the ABANA conference held in Memphis TN. this year. Gerald Brostek made three rings and was lucky enough to get two of the chosen. (picture on front cover) The conference had a nice gallery set up. I volunteered to work for a couple of hours and was lucky enough to work in the gallery/auction area for my two hours. I came back with some good ideas that I would like to try in our gallery/auction. They also had some workshops for the editors and photographers. There were also lots of workshops for anyone interested. Carol Doner took several sewing classes which were organized for the family members. They had broom tying and classes on metal finishes also.



Some of the Gallery items...



One of the items at this years conference was a nail stump. Anyone that wanted to could make a nail and drive it in the stump. The stump was to go to the Metal Museum in Memphis for display. I took some pictures of some of the really neat nails.



We enjoyed some really great demonstration.

If you get a chance to attend one of the ABANA conferences it is well worth it. Great demo's, workshops and opportunities to meet others with like interest.

## SOUTH CENTRAL MEETING DATES

January 16, 2010  
Host: JC Banks  
Phone # 580-482-3209  
Trade item:

February 20, 2009  
Host: Gerald Franklin  
Phone #: 580-252-6002  
Trade item: a riveted item

March 20, 2010  
Host: Byron Doner  
Phone #

### **April 17, 2010 STATE PICNIC NORMAN OK**

May 15, 2010  
Host: Gary Seigrist  
Phone #  
Trade item: Hardy tool

June 19, 2010  
Host: Byron Doner  
Trade items is something made from a horseshoe

July 17, 2010  
Host: Alex Scrudder  
Phone #: 580-550-0882

August 21, 2010  
Host: Terry Jenkins  
Phone #:  
Trade item: camping tool

Sept. 18, 2010  
Host: Gerald Franklin at Sulphur tractor show  
Phone #: 580-467-8667

### **October 16-17, 2010 Host: : SCABA Conference Perry, Okla.**

November 20, 2010  
Host: Bill and Diana Davis  
Phone #: 580-549-6824  
Trade item: door knocker

December 18 2010  
Host:  
Phone #:

## SOUTH EAST MEETING DATES

January 2, 2010  
Host:  
Phone #:

February 6 2010  
Host: Eddie Horton  
Phone #: 580-513-8370

March 6, 2010  
Host:  
Phone #:

April 3, 2010  
State Picnic Month

May 1, 2010  
Host:  
Phone #

June 5 2010  
Host: Mark Hamell in Hugo, Ok  
Phone #: 580-317-3700

July 3, 2010  
Host:  
Phone #:

August 7, 2010  
Host:  
Phone #:

Sept. 4, 2010  
Host:  
Phone

October 2, 2010  
Host:  
Phone:

November 6, 2010  
Host: open  
Phone #:

December 4, 2010  
Host:  
Phone #

## NORTH EAST MEETING DATES

January 9, 2010  
Host: Gary Gloden  
Phone #  
Trade item; something made at meeting

February 13, 2010  
Host: Bill Kendall  
Trade item. A heart

March 13, 2010  
Host: Dan Cowart  
Trade items: a 4 leaf clover or something

April 10, 2010  
STATE PICNIC MONTH

May 8 2010  
Host: Gerald Brostek  
Phone #: 918-687-1927 trade item; yard ornament

June 12, 2010  
Host: Bill Phillips  
Phone #:918-823-4224  
Trade item: Animal or Bird

July 10, 2010  
Host: Clayton Hall  
Phone # 918-605-6241 Trade item; spork/eating utensil.

August 14, 2010  
Host: Omar Reed/ Fort Gibson  
Phone# 918-478-4088  
Trade item Hinge

Sept. 11, 2010  
Host: Dan Cowart/ Pawhuska  
Phone #918-440-0653  
Trade item: something with a feather

October 9, 2010  
Host: State conference  
Phone#

November 13, 2010  
Host: Matt Goyer  
Phone # 918-272-8424  
Trade item: cross

December 11, 2010  
Host: Charlie McGee  
Phone #: 918-245-7279  
Trade item: angel

## NORTH WEST MEETING DATES

January 23, 2010  
Host: Charlie Todd  
Phone# 580-242-0105  
Trade item; anything forged

February 27th, 2010  
Host: Mandell Greteman  
Phone # 580-515-1292  
Trade item; tool

March 27, 2010  
Host: Mike George  
Phone #: 580-327-5235  
Trade item; Flower

April 24, 2010  
STATE PICNIC MONTH

May 22, 2010  
Host:  
Phone #  
Trade item:

June 26, 2010  
Host: Ron Lehenbauer at Fairview fair grounds  
Phone #:580-758-1126  
Trade item; something western

July 24, 2010  
Host:  
Phone #:

August 28, 2010  
Host: Ron Lehenbauer, Fairview trade item: campfire tool  
Phone #: 580-758-1126

Sept. 25, 2010  
Host: Gary Seigrist (Elk city)  
Phone #: 580-225-3007  
Trade item; something from a horseshoe

October 23, 2010  
Host:  
Phone #.

November 27, 2010  
Host: Tom Nelson  
Phone #: 580-862-7691

December 25, 2010  
**Merry Christmas**



# Splitting the End of a Bar

Text and photos by Dan Nauman

Drawings by Tom Latané

Lesson #19. Unit: Cutting

*Definition:* Using a sharp edged tool to cut or alter a bar, or to remove material from a bar.

*Intent:* To learn to use a hot-cut chisel to cut down the centerline from the end of a bar.

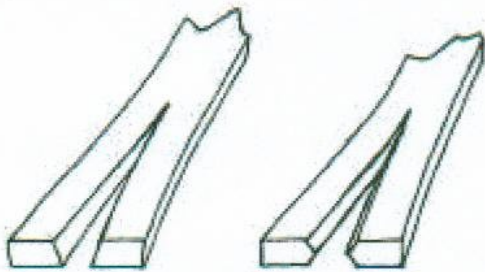
*Tools:* Basic tools, plus a hot-cut chisel, cutting plate or saddle, tool to hold the hot cut, tool to hold the work-piece.

*Material:* 2 pieces of 1/4" x 1" x 24".

*Note:* There are two methods of cutting we will teach in this lesson. Method one(M1) will teach cutting a bar from one side all the way through. Method two(M2) will teach cutting a bar from opposing sides.

Each method leaves a very distinctive kerf. (See Drawings #1 and #2.) Image #1 shows the kerf made by method one. Image #2 shows a kerf made by method two.

It is important to determine which method to use in order to achieve a specific goal. Thinner materials, 1/4" (one quarter inch) or less, are often (but not always) cut using method one. Thicker materials are often (but not always) cut using method two.



1 & 2. Method 1 kerf, left, and method 2 kerf, right

*Forging Dynamics:* On either side of the kerf, the bar-stock will be displaced by the thickness of the chisel. The chisel should be thin so the amount of stock displaced is minimal. As the bar begins to split, the opposing sides of the kerf (legs) will peel away from the line of the cut. This stretching is caused both by the material being pushed apart by the hot-cut chisel.

*Note:* It is important to use the correct chisel. A cold-cut chisel, as the name implies, is used to cut cold stock. This type of chisel needs to be heavier, or backed up by enough material so the chisel does not snap or crack from the shock of cutting the harder cold stock. Because it is cutting softer material, the hot-cut chisel receives less shock, and can have a more acute bevel. (Photo #3 a+ b shows the difference in blade bevels of the hot-cut chisel and the cold-cut chisel.) Note that both chisels have

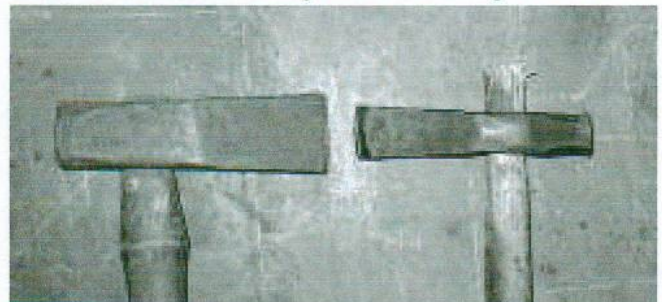


3. Notice the difference in the thickness between the cold cut (left) and the hot cut (right).

rounded, not square edges. This allows the chisels to easily track in the kerf, and in some cases, allows you to make a curved kerf. (Photo #4 a+ b shows the side shape of the two chisels.) A square chisel is harder to control, as the abrupt wall left by its impression makes it necessary to lift the blade out of the kerf track to advance. (See Drawing # 5 of the potentially bad kerfs made by a square chisel) In this lesson, we will be using the hot-cut chisel.

The specific purpose of the cut may determine which method you choose. For example, if the legs formed by the cut are to be drawn out, it would be easier to draw out a M2 kerf, which has a center crown, being beveled from both sides, rather than a section with one tall beveled edge as seen in the M1 kerf. On the other hand, an M1 kerf might be desirable as the naturally beveled edge left from cutting may serve as a decorative accent. Method one could be used for making a split scroll with a beveled edge, while method two could be used for beginning the end of a fork.

Holding the bar steady while cutting must be considered. There are several methods of holding the bar for cutting. One method



4. This photo shows the rounded edges of the hot and cold cut, which allows the tool to slide along the workpiece more easily, than if the edges were square.



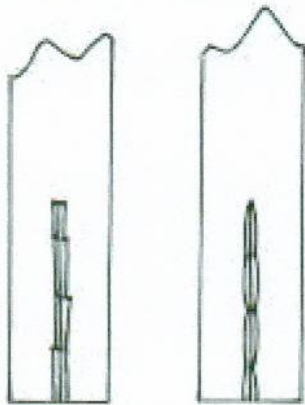
## CONTROLLED HAND FORGING

for cutting short bars is to use a holdfast, as seen in Photo #6. A holdfast can easily be made out of mild steel, of a slightly smaller diameter than your anvil's pritchel hole. To use the holdfast, simply slide the shank into the pritchel hole, and place the flange on top of the work-piece. Lightly tap the top of the holdfast to secure the work-piece onto the anvil.

For longer bars, you could use a "blacksmith's helper" which is an adjustable stand. Some smiths prefer to use a weight to keep the piece steady while cutting. One way to apply the weight is to attach a chain to an "S" hook, and attach the weight at the end of the chain. (See Photo 7.) When using the blacksmith's helper, adjust the stand so the bar rests flat on the face of the anvil.

The important thing is to keep the piece flat and stationary on the anvil while cutting. If the bar is not resting flat on the anvil face, the bar will bend more dramatically, and the impact of the chisel will be lessened as well.

Holding the chisel is also a consideration. If you have a chisel with a long enough shank, you may be able to hold it while cutting without burning your hand. It might be easier for some to use a pair of chisel tongs to hold the chisel. Many smiths prefer



5. Scars potentially produced by a square-edged chisel and a wavy cut potentially produced by an overly rounded chisel.

to use a chisel with a solid handle of either a bar wound around the chisel, or a wood handle that pierces the chisel. (See Photo #8 showing the tongs, and two types of handles) For this lesson, we will use a chisel with a wooden handle.

### Cutting Method #1

#### Step One

Measure 2" from the end of the bar, and with a centerpunch, mark the exact center of the bar. Make the punch mark large enough to see when the bar is hot, but not too large, as a large punch mark might remain visible after cutting.

#### Step 2

Heat 3" of the end of the bar to yellow. Place the end of the bar flat on the anvil. Place the center of the chisel on the end of the bar at the bar's center. Lightly tap the chisel to create a light

impression, about 1/32" or less deep.

*Note:* In this step, you do not wish to drive the chisel through the bar, nor create a bold kerf as you need to first establish the proper kerf track. If your judgement is off, the light impression will not usually be deep enough to ruin the project, and can be corrected by simply adjusting the chisel to create a new kerf. The new kerf will push material towards the old kerf, closing it up. Unless you are dramatically off in your initial judgement, this correction will likely be undetected in the finished piece.

In the same heat, move the chisel by sliding, not lifting it, one half the width of the chisel, and take another light tap. You should always slide the chisel towards you, as you can see where the chisel is in relation to the bar. When moving the chisel, always leave a portion of the cutting edge in the track of the kerf



6. The holdfast slides into the pritchel hole, and holds the workpiece firmly with a light tap of the hammer above the holdfast's vertical shank. To remove the holdfast, lightly tap the side of tool's vertical shank with the hammer.

from the previous blow. Some smiths prefer to linearly rock and then slide to advance the chisel. These procedures insure that a double kerf line isn't accidentally formed.

Continue the light kerf all the way down to within 1/16" of the center-punch mark, making sure you remain in the middle of the bar. If you make an errant blow along the way, make the correction immediately before continuing down the bar. Make sure the chisel remains perpendicular to the workpiece at all times.

*Forging Dynamics:* The bar will begin to curl upward as the force of the chisel makes impact. To cut properly, the bar must be tapped down flat on the anvil every time you retrace the kerf to deepen the cut.

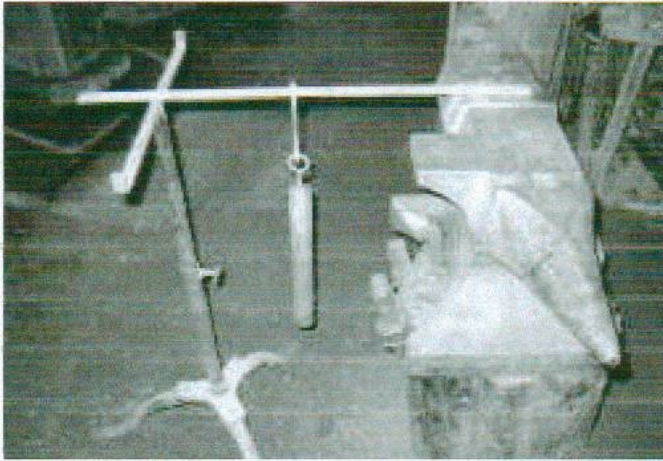
*Note:* When cutting heavy stock, some smiths prefer to quench the chisel after four or five blows to keep the chisel blade cool. This is more important when using a chisel of simple carbon steel.

#### Step 3

Take another yellow heat 3" long. Place the bar on the cutting surface.



## CONTROLLED HAND FORGING



7. A blacksmith's helper stand helps to hold longer bars. The attached weight helps keep the workpiece steady. Adjust the blacksmith's helper so the workpiece lies flat on the anvil or cutting saddle.

*Note:* STOP! Do not even think about cutting through the bar on an unprotected anvil. It is believed by some that the table of the anvil, sometimes referred to as the step of the anvil, is to be used for cutting. Doing so will only scar the surface to the point where it is no longer useful. The bottom of the hot bar will sink into the scars left by the chisel from past cuttings, leaving unsightly marks on the work piece.

A piece of 1/8" to 3/16" thick (or thicker) plate of copper, brass, or a piece of low carbon steel can easily be used as a base beneath the bar being cut. Make sure it is large enough to effectively support the workpiece. Some smiths prefer a more stable cutting surface, and may shape the cutting plate to fit snugly over the edges of the anvil. This tool is called a cutting saddle. (See image 9 of a cutting saddle.) This not only protects the anvil, but also protects the chisel edge. When the surface of the plate or saddle becomes scarred, simply throw it away and make a new one, or if it is thick enough, you may remove the scars by grinding or forging.



8. A wooden-handled chisel, left, dedicated chisel-holding tongs, center, and a wrapped handle (on a punch), right.

As you did in step two, place the chisel at the end of the bar and this time strike the chisel with a medium to heavy blow as now your aim is to drive the chisel through the bar.

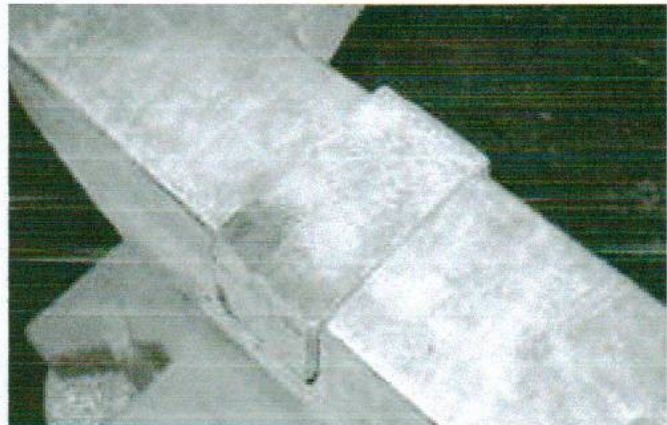
Move the chisel down the bar as you did in step two, creating a deeper kerf. Again, stop short of the center-punch mark. If you have not split the bar at this point, repeat the process until the bar is split through, hitting with less force to save the cutting plate from getting deep scars.

### Step 4

You now want to finish the cut with a nice square edge at the bottom of the cut. The reason the initial cut is not cut right down to the center-punch mark is that since the chisel is curved, you will not have a clean square kerf at the end of the cut.

*Note:* In some cases, a tapered kerf at the end of the cut may be desired as a design element. For the purpose of this lesson, we are explaining how to finish the cut with a squared termination. (See image 10 showing the two types of terminations.)

To finish the cut, place the bar tightly in a vise with the center-punch mark 1/4" above the vise jaws with the legs in the vertical position. Place the chisel between the legs of the cut and carefully drive the chisel straight down until the chisel just pierces the center-punch mark. This last step can be done at a low orange to orange heat. A lower heat may be easier to control, as the chisel will meet more resistance, and you are less likely to cut too deep. Properly executed, the bar should now look like image 10.



9. This cutting saddle was made from 1/2" x 3", lies flat on the anvil face and fits snugly over the edges. The thickness has been reduced by re-dressing the surface to eliminate surface scars made from cutting through the workpiece. "blacksmith's helper" so the workpiece lies flat on the anvil or cutting saddle.

### Targets

- The kerf must be through the middle of the bar within 1/32" per side.
- The kerf must have a clean appearance, with no ragged edges.
- There must be no double kerf lines.
- The kerf must be 2" long within 1/64" (one sixty fourth inch).



- The face of the bar must be flat.
- The inside end of the kerf must be square to the face of the bar.
- You should be able to split the bar in three heats. With practice, you could split it in one heat.

## Cutting Method #2

(Review method one for forging dynamics, and notes to the cutting procedure.)

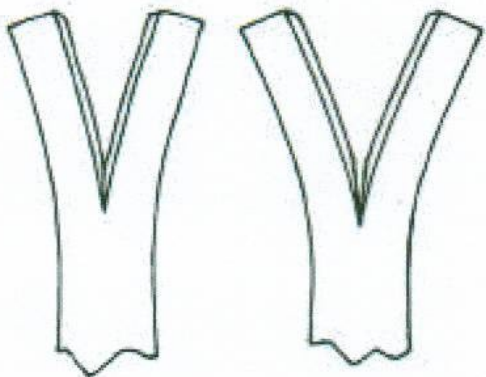
### Step 1

Measure 2" from the end of the bar, and with a center punch, mark the exact center of both sides.

### Step 2

Heat 3" of the end of the bar to yellow. Place the end of the bar flat on the face of the anvil. Place the center of the chisel on the end of the bar at the bar's center. Lightly tap the chisel to create a light impression, about 1/32" or less deep. Move the chisel by sliding, not lifting it, one half the width of the chisel and take another light tap. Continue the light kerf down to within 1/16" of the center punch mark.

In the same heat, tap down the end of the bar to regain a flat



10. A tapered kerf end, left, and a straight kerf end, right.

bar. Retrace the kerf with the chisel, taking a heavy enough blow to cut half-way through the bar.

### Step 3

Heat 3" of the end of the bar to yellow. Rotate the axis of the bar 180 degrees. As you did in step two, cut a light kerf to within 1/16" of the center punch mark, then tap the end of the bar to regain a flat bar.

Note: Accuracy is important! If you do not cut a line down the middle of the bar, you will get a kerf offset from the kerf on the other side. (See Drawing #11 of offset kerfs vs. two opposing kerfs.) To make sure you begin the second kerf in exact opposition to the kerf on the other side, look at the end of the bar to view both kerfs simultaneously. If they are offset, make the correction immediately.

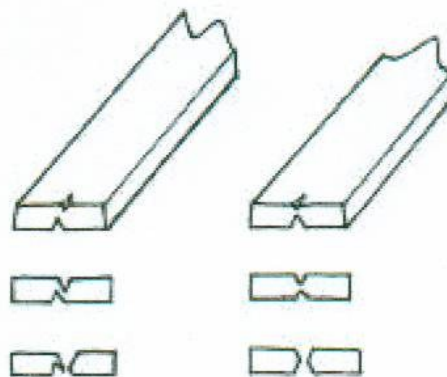
Next, with heavier blows, retrace the shallower kerf with the chisel, and drive the chisel through the bar. Remember to use a cutting plate or saddle!

### Step 4

To finish the cut, at a low orange to orange heat, place the bar tightly in a vise with the center punch mark  $\frac{1}{4}$ " (one quarter inch) above the vise jaws, with the legs in the vertical position. Place the chisel between the legs of the cut and carefully drive the chisel straight down until the chisel just pierces the center punch mark.

### Targets

- The kerf must be through the middle of the bar within 1/32" (one thirty second inch) per side.
- The kerf must have a clean appearance, with no ragged edges.
- There must be no double kerfs.
- The opposing kerfs must meet cleanly; no heavy burr from offset kerfs.
- The kerf must be 2" long within 1/64" (one sixty fourth inch.)
- The face of the bar must be flat.
- The inside end of the kerf must be square to the face of the bar.
- You should be able to split the bar in three heats. With practice



11. The result of offset kerfs (right) compared to opposing kerfs (left).

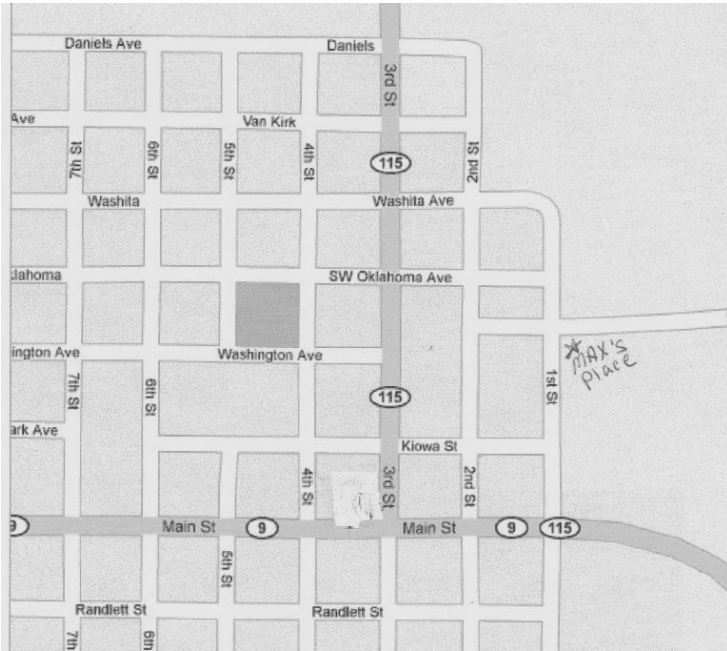
you could split in two heats.

*Notes about dressing the edge of the kerf:*

- 1.) The kerf can be filed to suit the job.
- 2.) The legs can be bent away in a "Y" shape to 90 degrees, or one leg may be gently folded over the bar. The kerf can then be lightly forged with the face of the hammer, retaining the beveled edge. Afterward, the legs may be bent back.
- 3.) The legs can be bent or folded as above, then the kerfs can be forged so the cut edge is square to the face of the bar.



Map to the meeting hosted by Alex Scrudder for the S/C region in July.



This is a starter list for the tool box that SCABA will be raffling off this year at the Conference in October. Get started making a tool or two today. I don't know who will be in charge of the tool box this year but watch future newsletters for a contact person.

### State fair project.

Last year the club forged during the State Fair. This year we have been asked to come back and forge again. Byron Doner is the coordinator for the event. If you are interested in getting into the fair free with having convenient parking passes, contact Byron and sign up for a shift.

The fair runs from Sept. 16-26th. We need two to four smiths to man the forges each day. Some have already started picking the day/days they want. Byron has a list started so call him and get your name down. You can work as many or as few days as you choose.

- Thur. 16— Gerald F.
- Fri. 17—
- Sat. 18th—Ron L.
- Sun. 19th — Ron L.
- Mon. 20th — Mandell G.
- Tue. 21st —
- Wed. 22nd —
- Thurs. 23rd —
- Fri. 24th —
- Sat. 25th —Terry J.
- Sun. 26th.— Gerald F.  
Terry J.

Set up needs to be done on Wed. 15th and tear down will be late Sunday the 26th or early the 27th. That will be coordinated by Byron Doner.

<b>Tool/Item</b>
Box
Hardware for toolbox
Cross peen hammer
Straight peen hammer
Rounding hammer
Tongs:
1/4 v-bit
3/8 v-bit
1/2 v-bit
3/4 v-bit
1/4 flat
3/8 flat
1/2 flat
3/4 flat
Scrolling
Side grip
Pick up tongs
Fire tools (Shovel, rake, poker)
Hot cut hardie
Cold cut hardie
Twisting wrench
Treadle/Hand Hammer Tooling
Set of punches and holder
Center punch
Chisel, large
Chisel, small
Chisel, hot slit
Slitting chisel
Hold Down
Flat wire brush w/handle
File, flat bastard cut w/handle
File, half round w/handle
Set of monkey tools
Rivet backing tool
Rivet setting tool
Hacksaw
Bolster plate
Square
Dividers/Compass
Scribe
Bending forks
Spring swage (necking down)
Flux spoon
Metal folding ruler 24" or 72"
Soapstone
Ball tool (round blunt nose punch)
Hook Ruler
Iron Mountain Flux
Finishing Wax
Nail Header
Dual Caliper
Total value to date:



***Need someplace to go to get away from the Oklahoma heat and enjoy you favorite hobby?***

The Colorado Metalsmithing Association (CoMA) has put together a conference spotlighting a line up of internationally known artists and metalsmiths. It will be July 16-18 in Salida Colorado. For more information you can go to their website..www.coloradometalsmiths.org

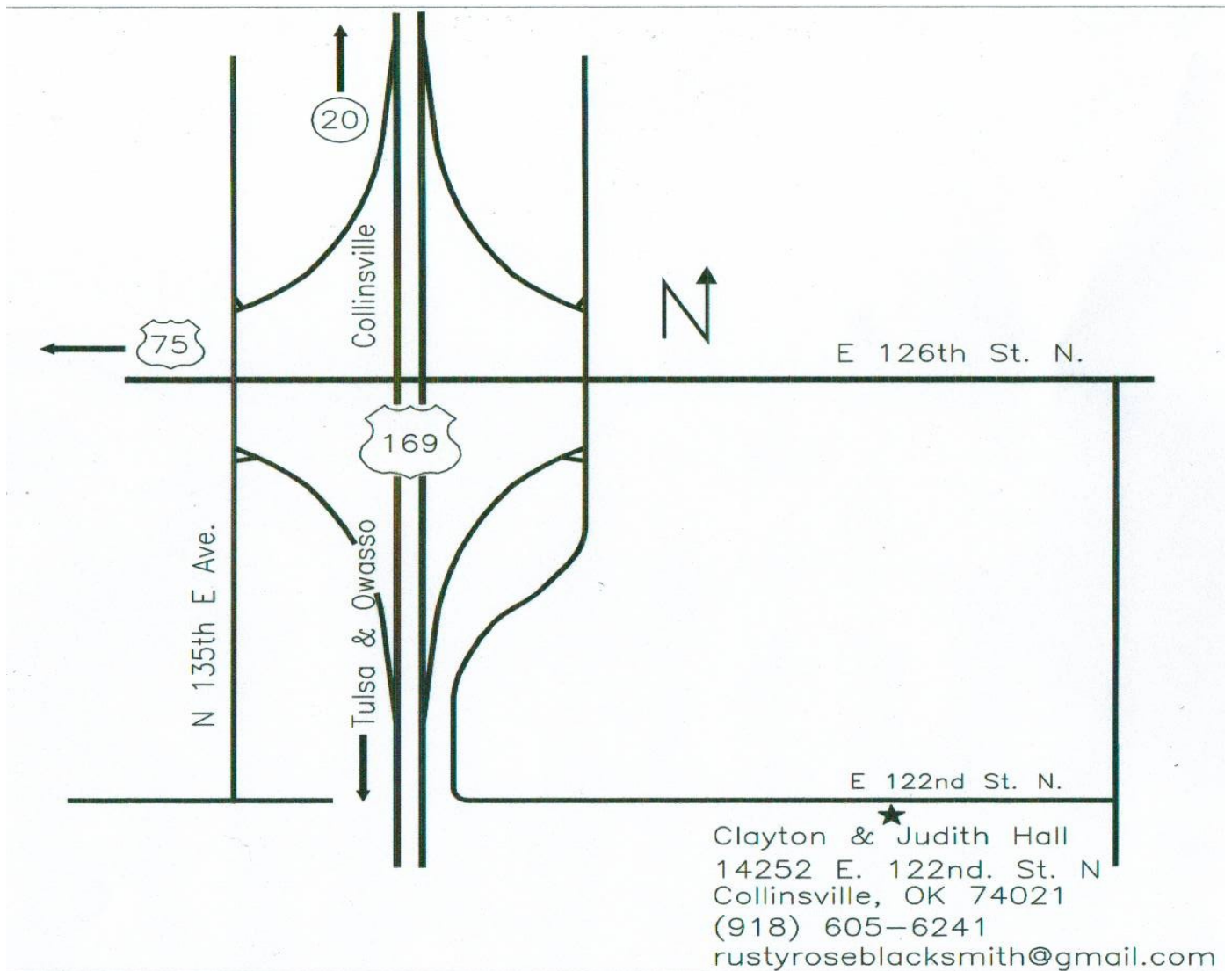
***Pawnee Bill Wild West Show (6/19/2010)***

The second weekend of the Wild West show and other festivities at the Pawnee Bill Ranch went well this year. Adam Hall tended the blacksmith shop all day and demonstrated a variety of items for the guests. Gates opened around 10:00am. The crowd picked up after the 2:00 parade and was steady until the Wild West Show began around 7:00 pm.

The entire ranch, including the mansion was open for the event. The festivities also included gunfighters, belly dancers, magicians, musicians, leather workers and other craftsmen.

Adam Hall

**Words from the Editor:** I would like to let everyone know that I appreciate all the write-ups that are submitted each month by the members. I can't make it to every event around the state so need others that do attend to let me know how it went and who else was there to enjoy it. Again thanks... Editor



## SCABA Shop and Swap

### For Sale:

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

2 forges: Champion forge, some damage, \$20.00  
Champion forge, good, \$40.00

Bridge anvil, good conditions, \$150.00

Contact Dustin Sypher for more info.  
tallgrassforge@yahoo.com

### Wanted:

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

## Club Coal

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

### NW Region coal location:

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

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

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

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



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Nathan L. Robertson

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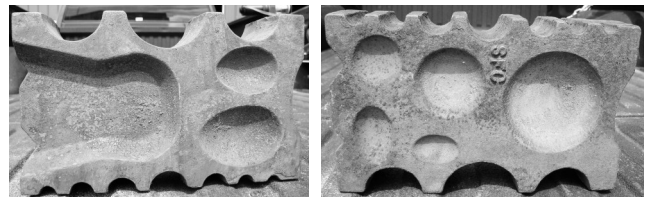
Nathan will be at our conference in October with his selection of forged hammers.

### SCABA swage blocks

\$80. plus shipping to members. (1st block)

\$100.00 plus shipping to non-members

Contact Bill Kendall for more information



## LITTLE GIANT

PARTS—REPAIRS—INFORMATION

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# SCABA membership application

April 1 2010—March 31– 2011

Please accept my application

Date: \_\_\_\_\_

First Name \_\_\_\_\_ Last Name \_\_\_\_\_

Married?  Yes  No Spouses Name \_\_\_\_\_

Address \_\_\_\_\_

City \_\_\_\_\_ State \_\_\_\_\_ ZIP \_\_\_\_\_

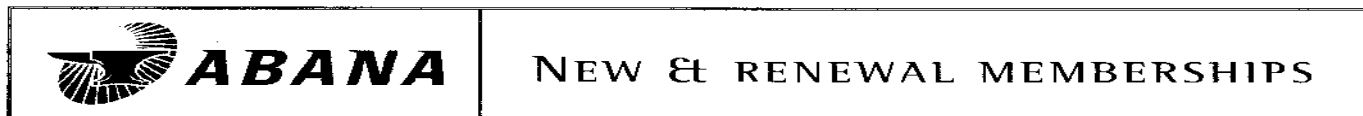
Home Phone (\_\_\_\_) \_\_\_\_\_ Work Phone (\_\_\_\_) \_\_\_\_\_

E-Mail \_\_\_\_\_ ABANA Member?  Yes  No

I have enclosed \$20.00 for dues to March 30, 2011

Signed \_\_\_\_\_

Return to: Saltfork Craftsmen, 1227 Fourth St. Alva, Ok 73717



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	

Mail to: ABANA, 15754 Widewater Drive, Dumfries, VA 22025-1212 USA

Please pay by Check, U.S. Money Order or Credit Card.

You can also join on-line at

or by calling 703-680-1632.

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