

Saltfork Craftsmen Artist-Blacksmith Association

July 2009



Heart and Rose wall hanging forged by David Seigris. It won First Place during the Wild West Days Art Show at Mangum Ok. June 2009

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

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Rt. 3 Box 239J, Duncan, Ok 73533
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23966 NE Wolf Rd
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1227 4th St. Alva, Ok. 73717
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byrondoner@earthlink.net

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1756 E. 59th St Tulsa Ok. 74105
wwkendall@aol.com

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irondyer@aol.com

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23966 NE Wolf Rd Fletcher, Ok 73541
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918-440-4318

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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

Trading Post

For Sale:

ANVILS: **400#** Arm & Hammer serial # 34008. Face has some torch mark damage on the heel, but is repairable. \$2000. **100#** Kohlswa Excellent condition. \$500. **100#** Cast anvil with a tool steel face. (I think it's a Vulcan, but there are no marks on it.) \$200 LEG VICES; Good screws and good condition overall. \$75 and up. HAND CRANK GRINDERS; Several different sizes. Most have stones. Great for demos. \$25 and up. Buffalo rivet forge; Sheet metal pan and blower. Good demo size Ready to go \$225. Two ;hand crank Champion blowers-one with stand. \$100 and \$125.
Call 580-862-7691 (before 9:00 P.M. Please)



Army surplus round nosed pliers that 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. \$20.00 plus shipping. Diana Davis 580-549-6824 or lazyassforge@tds.net



Due to health problems, I have decided not to rebuild any more Little Giant hammers. I have for sale: One decent used 100# hammer (\$3,500), one completely rebuilt 50# hammer (\$4,500). One early style rebuildable 50# hammer (\$1750), and one transition style rebuildable 50# hammer (\$2,250). I have some miscellaneous parts, dies, babbitt mandrels, and etc. for sale. Contact Mike George at 580-327-5235 (home), 580-829-1968 (cell) or Mike-marideth@sbcglobal.net



Wanted:

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

Club Coal

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

NW Region coal location:

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

S/C Region coal location: Coal is in 1-2" size pieces. Bring your own container. The coal is at Max Scrudder's place in Mountain View. Contact Max for load out instructions.

Max Scrudder can be contacted at (405) 226-9951

NE Region coal location: Dan Cowart also has coal to sell. He can be contacted at dacowart@dishmail.net or Cowart-Pat@gmail.com

New shipment of swage blocks now in.
\$80. plus shipping to members.
\$100.00 plus shipping to non-members
Contact Bill Kendall for more information

Send your ads to the Editor by the 20th of each month. Ads will run for 60 days unless requested.

MEETING SCHEDULE

July

S/C Regional meeting (July 20) Hosted by Max Scrudder at his shop in Mountain View, Ok. The trade item is a flower. Meal will be provided but bring a side dish to help out. Max's shop is located just south of the auction barn.

SE Regional meeting (July 4th) Hosted by Gerald Franklin conjunction with The Calvin Old Time Swap Meet in Calvin, OK. Lunch opportunities will be on site, so bring your lunch money. This is set up to be an old time type swap meet with campfire cooking and entertainment. It should be a good opportunity for us to generate some more interest in the SE corner of the state.

NE Regional meeting (July 11th) Hosted by Mike Sweany. Meal provided. Trade item is a arrowhead.

We need members to step forward and agree to host meeting in the SE and NW regions.

Directions to Mike Sweany's place: (918) 245-8460
634 S. 193rd W. Ave Sand Springs Ok. From hwy 64/US-412, take the 177th West Ave Exit going South, 177th West Ave becomes w. Wekiwa Rd. Follow W. Wekiwa Rd. West to S. 193rd West Ave and turn North. Follow your nose until you arrive at the above address (about 0.6 mi).

Muskogee Renn Faire

The Muskogee Renn Faire was held every weekend in the month of May. Dawnavan Crawford, Cory Charlton, Richard Simpson, Steve Knisely, Micheal and Melissa Lusk and I (Terry Jenkins) were there for the 5 weekends. We made just about everything you can think of as demos and for the spectators, knives, forks, spoons, roses, bottle openers, key fobs and crosses. We even did some work for the Castle (fair grounds). We straightened some forklift forks and made clevises for them to hang highs with. There was lots of good music, food and lots of fun to be enjoyed. Jerry pace and his wife was helping a friend in a food booth serving some of the best blackberry cobbler and ice cream that I have had in a long time and hit the spot after a busy turn at the forge, if you got there before they ran out.

This year the paid gate was over 100,00 people for the 5 weekends and we got a lot of interest from folks wanting to know about the Saltfork Craftsmen and how to get started blacksmithing and if we had any groups in the eastern and south east part of the state. Friday of the 3rd weekend was school day and we had Schools from as far away as Conrad, Arkansas and South Mo. Show up. Somewhere around 30 schools came that day and kept us very busy.

Every weekend all 150 vendors are judged by a panel of 6 judges for King and Queens choice. Judging is on your booth, display, workmanship (if any craft) interaction with the crowd and several other things. On the 4th weekend we were awarded Kings choice (best of show) so we were invited back for next year! So if you would like to demo at a Renaissance Faire and join the fun let me know. We would love to have the help.

Terry Jenkins

President's Notes

Gerald Franklin

Well, we are certainly neck deep into another typically hot Oklahoma Summer. With temperatures well into the 100-degree range we all need to be aware of the potential for heat injury. It's easy to put off drinking while you are involved in a demo or just forging at home. Drinking plenty of liquids is a must. Take breaks and step away from the fire as often as you can. Don't wait until you get dehydrated to drink, by then you could be in for a real heat injury situation.

We were treated to a great animal heads workshop in Elk City conducted by Bill Davis and David Seigrist. (*Gerald did his fare share of teaching. Editor*) There were Twelve students signed up and David did a good job of setting things up for the group. Since it was only a one-day workshop, Bill decided to teach a few 2-D heads only. Maybe we'll have time later in the year to get Bill to hold a 3-D workshop. This was one of several smithing workshops that David has coordinated for the membership and there are a few more scheduled before the end of the year. Check the schedule elsewhere in the newsletter to see if there is something that you might be interested in. These are excellent opportunities to learn new skills or brush up on things that you may be a little rusty on. We are fortunate to be able to offer these types of learning opportunities to our members at reasonable cost. If you have any suggestions for future workshops, please let David Seigrist know so he can put it on the list of possible classes in the future.

Speaking of David, the next time you see him, congratulate him on winning some major awards a recent art show in Mangum. There is a picture of his artwork on the cover of this newsletter.

Our next really big event is the Saltfork support of the Oklahoma State Fair in Oklahoma City. There are still plenty of demo spaces available, so take your pick of a time to come demonstrate for the public and possibly sell some of your work as well.

In closing, I'd like to encourage you to come to the July SE meeting at the Calvin Old Time Swap Meet in Calvin, OK on July 4th. Since we're still trying to generate more membership and interest in the Southeast corner of the state, this will be a good opportunity to talk to new smiths and hopefully establish more meeting sites in the SE. The people who are hosting this event expect to have entertainment, cooking contests, and several old time vendors and "swappers".

S/C Regional meeting

Kent and Anelia Hadick hosted the meeting for the S/C region at their home in Midwest City. It is really hard to get most folks to even think about forging when the temperatures are hovering around the century mark. Only one or two even got close to the forge that day. He worked just long enough to finish up his trade item. The trade item was a bird feeder. We had four really nice one brought for the trade. One humming bird feeder and four grain feeders. All had nice examples of forging or other type of metal work.

We had about 18 members show up to enjoy the day. Steven Knisely even brought his grandson.



We enjoyed a lunch of pork loin and chilli. We also had blackberry cobbler and ice cream for desert. Because of the heat, many of us started back home shortly after lunch.



Animal Head Workshop

The animal head workshop got started promptly at 9:00am at the Route 66 Museum Blacksmith shop in Elk City. Bob Kennemar and Gary Seigrist hosted the workshop. The museum has plenty of anvils and equipment for this type of event. The instructors were Gerald Franklin, David Seigrist and Bill Davis. All three of these members had attended a animal heads workshop that was presented by Darryl Nelson at Gerald Franklins shop.

There were 12 signed up for the class. One didn't show and we had one come in at the last minute. Bill took the first session and taught how to make a horse head. Gerald Franklin and David each taught one of the other heads and also gave one-on-one help to the students. These are 2-d heads so they were using 1/4 x 1 or 1/4 x 1 1/2 for their stock.



and David each taught one of the other heads and also gave one-on-one help to the students. These are 2-d heads so they were using 1/4 x 1 or 1/4 x 1 1/2 for their stock.



The animal heads that they are going to make are the horse/mule, bear and bird.

Check out the list below and sign up to make a tool for the tool box. We have a very nice box made by JC Banks from oak. As many of these tools as we can get made will be added to the box and raffled off at the 2009 SCABA conference in October.

SCABA TOOL BOX AND TOOLS for 2009

Tool/Item	Maker/Buyer	Cost/Value
Box	JC Banks	
Hardware for toolbox	Mike George	
Cross peen hammer	Clay Reamy	
Straight peen hammer	Clay Reamy	
Rounding hammer	Clay Reamy	
Tongs:		
1/4 v-bit	Clay Reamy	
3/8 v-bit	Clay Reamy	
1/2 v-bit	Clay Reamy	
3/4 v-bit		
1/4 flat	Clay Reamy	
3/8 flat	Clay Reamy	
1/2 flat	Clay Reamy	
3/4 flat		
Scrolling		
Side grip	Reamy	
Pick up tongs	Reamy	
Fire tools (Shovel, rake, poker)	Reamy shovel and poker	
Hot cut hardie		
Cold cut hardie		
Twisting wrench		
Treadle/Hand Hammer Tooling	JC Banks	
Set of punches and holder		
Center punch		
Chisel, large		
Chisel, small		
Chisel, hot slit		
Slitting chisel		
Hold Down		
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	Reamy	
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:		

Oklahoma State Fair Demo Schedule

Thur. Sept. 17	1:00-6:30	Mark Carter (405)964-5754 Gerald Franklin (580)467-8667 Jim Carothers (580)336-9213
Fri. Sept. 18	1:00-6:30	Brahk Hadick (405)406-3705 Tony Cable (405)793-9626 Terry Jenkins (405)485-2394
Sat. Sept. 19	11:30-6:30	Brahk Hadick Kent Hadick Tony Cable
Sun. Sept. 20	11:30-6:30	Brahk Hadick Tony Cable Jim Carothers
Mon. Sept. 21(School tour)	9:00-6:30	Kent Hadick Mandell Greteman (580)515-1292 ????????
Tue. Sept. 22 (School tour)	9:00-6:30	Mark Carter Gerald Franklin ????????
Wed. Sept. 23	1:00-6:30	David Seigrist (580)688-3555 Doug Bliss (405)997-5436 Linda Bliss
Thur. Sept. 24 (School tour)	9:00-6:30	David Seigrist Gary Martin (405)359-8342 Terry Jenkins
Fri. Sept. 25 (School tour)	9:00-6:30	Brahk Hadick David Seigrist Terry Jenkins
Sat. Sept. 26	11:30-6:30	Brahk Hadick Kent Hadick Mark Carter
Sun. Sept. 27	11:30-6:30	Brahk Hadick Kent Hadick ????????????

If you have questions about this event or wish to help out contact Diana Davis or Anelia Hadick. We could use all the help we can get for this. This is our first year to attempt a public demo of this length.(10 days in a row)

SCABA Workshops

Title:	Date:	Instructor:	Location:	Status:	Cost:
Project Design	29 Aug 09	Max Scrudder	Mt View, OK	7 open seats	\$25
Repousse	6 – 9 Nov 4 day workshop	Mark and Mindy Gardner	Altus, OK	6 open seats	The more stu- dents the lower the cost.
Power Hammer Use and Tooling	14 Nov 09	Richard Dyer	Tulsa, OK	5 open seats	\$ To be deter- mined

Project Design:

Max Scrudder will show us how as a professional blacksmith he does project design and various factors he must take into consideration when putting together a project. He said we'd even have enough time to put together a small project at the end of his lecture. It's mostly paperwork with a little bit of forge work, which sounds just about right for August.

Power Hammer Use and Tooling:

Richard Dyer from his many years of experience as a professional blacksmith will show us some of the tooling and techniques he uses in commercial production of forged items with the use of a Little Giant power hammer.

Repousse/Chasing Workshop – We have a class locked on.

We have 6 folks interested so far. The class will be held in Altus, OK from 6 – 9 November, that's a Friday thru Monday. JC has offered to put Mark and Mindy up at his place so that cuts out quite a bit of their hotel expense. With 6 people signed up the cost is about \$290 per person plus your meals and lodging, if 12 signup, the cost would be about \$145 per person, plus your meals and lodging. That's a very good price! Compare this to what you would pay to attend John C. Campbell Folk School.

The first day will be tool making and the next three are repousse work. Mark will be bringing special treadle hammers that are very helpful with this kind of work; he can bring enough for 12 students. The treadle hammers would be for sale at \$1,350 each after the workshop. Buying a treadle hammer isn't required, he brings them for the students and if you want to purchase one he'll sell it.

Their fee is \$250/day plus travel and eats. Their website is www.floodplainforge.com. Let me know if you would like to attend.

If we have	6 students it only costs about	\$ 290	9	\$ 195	12	\$ 145
	7	\$ 250	10	\$ 175		
	8	\$ 217	11	\$ 160		
	Plus your meals and lodging					

To sign up for any of these workshops call or email and then send a check to me.

David Seigrist
P.O. Box 163
Hollis, OK 73550
(580) 381-0085 dseigrist2004@yahoo.com

Tractor Show **Demonstration.**

The morning of June 6th 2009 The Saltfork Craftsmen were represented at the Cleveland County fair grounds for a tractor show & pull sponsored by the Canadian Rivers Old Iron Club by Byron Doner, Tony cable and Allen Heinrichs. We set up at the east end of the tractor pull tract with the wind to our backs and the sun on our heads. The first order of business was to set up the shade. With that accomplished we moved in and set up blacksmithing shop. We demonstrated to a sparse crowd but did manage to visit with several people whose parent/grandparent/uncle etc were blacksmiths and explained it was not a lost art yet and that the Saltfork organization was keeping it alive and well. We did give out a few newsletters and little BS. After the tractor pull started at 1:00 the spectators opted to sit in the stands and watch the pulls so we took the opportunity to browse the flea market that was going on inside the barn. We were able to resist almost all of the bargains but did manage to find a few precious treasures to take home to round out our day. It was my understanding that because we demonstrated at their event the fee for our using the fairgrounds for our statewide picnic a week or two before would be waived. We have worked this event several times before and probably will again since it was an enjoyable day.

Tony Cable



SCABA membership as of June 30 2009

Last name	First name	City	State	Zip	Phone	date
Underwood	Richard	Fairbanks	AK	99709	907-458-9320	3/10
Wolfe	James	Parrish	Al	35580	205-717-8913	3/10
Black	James	Arkadelphia	AR	71923	870-245-8785	3/10
Egan	David	Harrison	Ar	72601	870-741-9895	M-10
Truoiolo	Joe &	Harrison	Ar	72601	870-420-3913	3/10
Taylor	Terry	Centerton	Ar	72719	479-795-2521	3/10
Todd	Hardy	Huntsville	AR	72740	479-665-2249	3/10
Latham	Jerry	Scottsdale	AZ	85251	480-874-1569	M-10
Hamburger	Maurice	Phoenix	AZ	85029	602-938-7905	M-10
MeGee	George	Placerville	CA	95667	530-622-3919	3/10
Schumann	Charles	Alto Pass	IL	62905	618-893-2090	3/10
Stafford	Don	Pennville	IN	47369-0246	260-729-7579	M-10
Olsom	Floyd	Tonganoxie	KS	66086	913-724-3020	M-10
Edwards	David	Emporia	KS	66801	620-343-1947	M-10
Roy	Jon	Douglas	KS	67039	316-746-2213	3/10
Vossberg	Lynn	Douglas	Ks	67039	316-200-8608	3/10
Moffet	William	Rosehill	KS	67133	316-992-3362	3/10
Gries	John	Wichita	KS	67220	316-683-5595	M-10
Base	Buster	Salina	Ks	67401	785-827-5557	3/10
Ralzlaff	Ronald	Hutchinson	Ks	67501	620-663-2578	3/10
Spotts	Douglas	Hutchingson	KS	67502	620-662-7135	3/10
Bill Epps	No.36428-177	Oakdale	LA	71463		3/10
Robertson	Nathan	Max	MN	56659	218-659-4590	m-10
Kamp	Richard	St.charles	MO	63304	636-926-0600	M-10
Collins	Earl	Forsyth	Mo	65653	417-546-2852	3/10
Junker	Bruce	Fairbury	NE	68352	402-230-9008	3/10
Thumma	John B.	Vanderwagon	NM	87326	505-778-5932	3/10
Hines	Mike	Jones	Ok	73049	405-413-1623	M-10
Smith	Bill	Lawton	Ok	73507	580-355-5618	M-10
Taylor	Deedie	Duncan	Ok	73533	580-656-3355	M-10
Newell	Carolyn	Elk City	Ok	73644	580-225-2544	M-10
Christensen	Gordon	Thomas	Ok	73669	580-661-2854	M-10
Briggs	Cody	Alva	Ok	73717	580-748-0209	M-10
Ent	Keith	Alva	Ok	73717	580-227-5221	M-10
Koch	Terry	Glenpool	Ok	74033	918-322-3996	M-10
Stevens	Glenn	Keifer	Ok	74041		M-10
Pastore	Joe	Owasso	Ok	74055	918-639-0130	M-10
Dickey	Jim	Tulsa	Ok	74107		Lt
Tedlock	Christopher	Henryetta	Ok	74437	918-652-8260	M-10
Smith	David	Tahlequah	Ok	74464	918-431-1691	M-10
Hall	Calias	Blanchard	Ok	73010	405-485-2690	m-10
Jenkins	Terry	Blanchard	Ok	73010	405-485-2394	m-10
Peters	Eulan E.	Blanchard	Ok	73010	405-485-3940	3/10
Simpson	Richard	Blanchard	Ok	73010	405-344-7413	3/10
Stevens	Charles	Bradley	Ok	73011	405-320-1255	3/10
Scott	Brain	Carnegie	Ok	73015	580-774-8317	M-10

SCABA membership as of June 30 2009

Meador	Joe	Chickasha	Ok	73018		3/10
Doner	Byron	Norman	Ok	73026	405-329-5635	3/14
Gough	Mark	Norman	Ok	73026	405-364-0244	M-10
Wahington	Aubrey	Norman	Ok	73026	405-329-9755	3/10
King	David	Edmond	Ok	73034	405-348-0476	3/10
Martin	Gary	Edmond	Ok	73034	405-359-8342	3/10
Repp	Mary Jane	Ft. Cobb	Ok	73038	405-643-5012	3/10
Hoag	Bill	Jones	Ok	73049	405-399-2316	3/10
Scott	Jeff	Lexington	Ok	73051	405-527-2970	3/10
Hines	Lyndel	Marlow	Ok	73055	580-658-5690	M-10
Charlton	Cory	Minco	Ok	73059	405-352-4878	3/10
George	Gregory	Mountain View	Ok	73062	580-347-2570	3/10
Scudder	Max	Mountain View	Ok	73062	405-226-9951	m-10
Porter	Mike	Mustang	Ok	73064	405-376-9837	3/10
Nusbaum	Rickey	Newcastle	Ok	73065	405-387-2853	3/10
Stone	Elmer C.	Noble	Ok	73068	405-872-3989	3/10
Tucker	Loncie	Noble	Ok	73068	405-366-1411	3/10
Heinrichs	Allen	Norman	Ok	73071	405-364-8157	3/10
Carothers	Jim	Perry	Ok	73077	580-336-9213	3/10
Guy	Craig	Piedmont	Ok	73078	405-373-3222	3/10
Blasius	Richard	Yukon	Ok	73099	405-324-2017	3/10
Hunholz	Fred	Midwest City	Ok	73110	405-737-3627	m-11
Knisely	Steven	Midwest City	Ok	73110	405-737-6994	M-10
Persons	Lou	Oklahoma city	Ok	73112	405-947-4564	M-10
Vaughan	Mark	Okla, City	Ok	73118	405-528-5237	3/10
Kroier	David	Midwest City	Ok	73130	405-769-4787	M-10
Hadick	Aniela	Oklahoma City	Ok	73150	405-869-2043	3/10
Perry	Michelle	Moore	Ok	73153		M-10
Oldham	George	Oklahoma City	Ok	73159	405-681-9325	3/10
Cable	Tony	Moore	Ok	73160	405-793-9626	3/10
Gabrish	Teresa	Oklahoma City	Ok	73162	580-458-7180	M-10
Dyer	Jim	Ardmore	Ok	73401	580-653-2243	3/10
Powell	CJ	Foster	Ok	73434	580-658-5849	M-10
Powell	John	Foster	Ok	73434	580-641-1882	M-10
Harrelson	Jeff	Lawton	Ok	73507	281-795-0169	m-10
Moms	Lindsey	Lawton	Ok	73507	580-514-9683	3/10
Banks	JC	Altus	Ok	73521	580-482-3209	m-11
Cathy	Jerry	Duncan	Ok	73533	580-255-6625	M-10
Franklin	Gerald	Duncan	Ok	73533	580-252-6002	3/10
Galloway	Mark	Duncan	Ok	73533	580-252-5559	3/10
Whatley	J.T.	Duncan	Ok	73533	580-255-4383	M-10
Davis	Bill	Fletcher	Ok	73541	580-549-6824	3/10
Robbins	Larry	Headrick	Ok	73549	580-482-5700	M-10
Seigris	David	Hollis	Ok	73550	580-688-3555	3/10
Morefield	Larry	Medicine Park	Ok	73557	580-529-3081	3/13
Courtright	Dorothy	Temple	Ok	73568	580-342-6915	3/10
Vardell	Ricky	Temple	Ok	73568	580-342-5191	3/10

SCABA membership as of June 30 2009

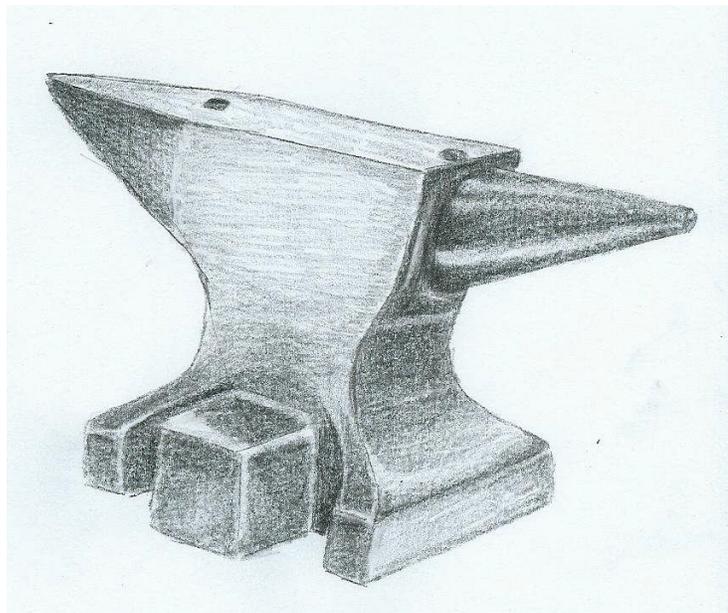
Bell	Roy	Clinton	Ok	73601	580-789-0673	3/10
Rhoads	Rusty	Clinton	Ok	73601	580-323-3005	m-10
Kennemar	Bob	Elk City	Ok	73644	580-225-3361	m-10
Nidey	Chris	Elk City	Ok	73644	580-225-5696	3/10
Seigrist	Gary	Elk City	Ok	73644	580-225-3007	m-10
Word	Billy	Elk City	Ok	73644	580-225-2194	3/10
Greteman Sr.	Mandell E.	Foss	Ok	73647	580-515-1292	m-10
Ivey	Dorvan	Hammon	Ok	73650	580-473-2761	m-10
Smith	Joe	Leedy	Ok	73654	580-488-3869	3/11
Garner	Don	Thomas	Ok	73669	580-661-2607	M-11
Hart	Richard	Enid	Ok	73701	580-541-8236	3/10
Todd	Charlie	Enid	Ok	73701	580-242-0105	m-11
Frazee	James	Enid	Ok	73703	580-237-6087	3/10
McMullen	Butch	Enid	Ok	73703	580-233-1107	3/10
Brooks	Terry	Alva	Ok	73717	580-327-2295	Lt
Burns	John	Alva	Ok	73717	580-829-4521	Lt
Geroge	Mike	Alva	Ok	73717	580-327-5235	Lt
Haight	Leroy	Alva	Ok	73717	580-327-2511	Lt
Maddox	Mickey	Alva	Ok	73717	580-327-3020	3/10
Omey	Jim	Alva	Ok	73717	580-621-3311	Lt
Schupbach	Louis	Alva	Ok	73717	580-327-2542	Lt
Smith	Wayne	Alva	Ok	73717	580-327-1453	3/10
Thomas JR	Brian	Alva	Ok	73717	580-327-8089	3/10
Nelson	Tom	Douglas	Ok	73733	580-862-7691	M-10
Dale	Kim	Jet	Ok	73749	580-626-4754	Lt
Winn	Richard	Jet	Ok	73749	580-626-4592	3/10
Paterson	Dean	Manchester	Ok	73758	580-654-2316	3/10
Clowdus	Lynn	Meno	Ok	73760	580-776-2225	3/10
Voss	Fred	Okarche	Ok	73762	405-263-4637	m-11
Greb	Ray	Okeene	Ok	73763	580-822-4813	M-10
Lehenbauer	Ron	Waukomis	Ok	73773	580-758-1126	3/11
Rutledge	Levi	Woodward	Ok	73801	580-256-8512	Lt
Fugate	Tim	Bartlesville	Ok	74003	918-336-4717	3/11
Swenke	Gundar	Bartlesville	Ok	74003	918-338-2217	3/10
Malsom	Bill	Bartlesville	Ok	74006	918-333-4398	m-12
Tate	Roy	Bartlesville	Ok	74006	918-331-9387	3/10
Helton	Billy	Claremore	Ok	74019	918-341-0263	3/10
Hall	Clayton	Collinsville	Ok	74021	918-605-6241	3/10
Moss	Dwayne	Mannford	Ok	74044	918-865-2030	3/10
Turnipseed	Lonnie	Mannford	Ok	74044	918-865-4449	M-10
Bartlett	Lynn	Owasso	Ok	74055	918-272-3500	M-10
Cowart	Tracy	Owasso	Ok	74055	918-376-2382	3/10
Groom	Charlie	Tulsa	Ok	74055	918-272-2200	3/10
Pace	Jerry	Owassa	Ok	74055	918-272-3063	3/10
Winston	Matthew	Perkins	Ok	74059	405-372-6707	3/10
Sweany	Mike	Sand Springs	Ok	74063	918-245-8460	3/10
Gloden	Gary	Sapulpa	Ok	74066	918-321-5015	3/14

SCABA membership as of June 30 2009

Lewis	Ken	Sapulpa	Ok	74066	918-224-9021	3/10
McGee	Charlie	Skiatook	OK	74070	918-245-7279	M-10
Williamson	Virgil	Skiatook	Ok	74070	918-288-7645	3/10
Schroeder	Mike	Stillwater	Ok	74074	405-372-8908	3/10
Gordon	Jack	Stillwater	Ok	74075	405-372-0452	3/10
Martin	Andy	Terlton	Ok	74081	918-757-4141	M-10
Orrell	Bob	Terlton	Ok	74081	918-865-8286	M-10
Cowart	Danny	Wann	Ok	74083	918-440-0653	3/11
Dyer	Richard	Tulsa	Ok	74104	918-582-5065	3/10
Dyer	Steven	Tulsa	Ok	74104	918-584-3664	3/10
Kendall	Bill	Tulsa	Ok	74105	918-742-7836	M-10
Ward	C.J.	Tulsa	Ok	74105	918-742-6194	3/10
Walker	John	Tulsa	Ok	74114	918-747-8464	3/10
Axtell	Jason	Tulsa	Ok	74120	918-857-6132	M-10
McCallum	Mike	Tulsa	Ok	74128	918-437-4342	3/10
Krohn	Chris	Tulsa	Ok	74147	918-695-6720	3/10
Coatney	Mark	Chouteau	Ok	74337	918-476-6755	M-10
Barnhart	Roy	Colcord	Ok	74338	918-326-4322	3/10
Brostek	Gerald	Muskogee	Ok	74403	918-687-1927	M-10
Alford	Vic	Coweta	Ok	74429	918-486-3460	m-10
Chartier	Jack	Coweta	Ok	74429	918-486-2347	3/10
Robbins	John	Eufaula	Ok	74432	918-618-4800	3/10
Tedlock	Jeff	Henryetta	Ok	74437	918-650-5668	3/10
McCormack	Ed	Okmulgee	Ok	74447	918-733-9844	3/10
Eaton	Joe	Stigler	Ok	74462	918-967-8912	3/10
Meyers, CJF	Joepaul	McAlester	Ok	74502	918-424-5545	3/10
Hamill	Mark	Hugo	Ok	74743	580-317-3700	3/10
Bliss	Doug	Shawnee	Ok	74801	405-997-5436	3/10
Carter	Mark	McCloud	Ok	74851	405-964-5754	3/10
Doner	Ken	Newalla	Ok	74857	405-321-2038	M-10
Klutts	Jack	Okemah	Ok	74859	918-623-1626	M-10
Cranford	Justin	Stonewall	Ok	74871	405-922-6866	m-10
Terry	Art	Stonewall	Ok	74871	580-520-1937	M-10
Milligan	Raymond	Stratford	Ok	74872	580-759-2586	3/10
Turnbull	John	Wellston	Ok	74881	405-356-2980	M-10
Curnell	Bob	Walland	TN	37886	865-983-2404	M-10
Lancaster	Mike	Amarillo	Tx	79114	806-282-8053	M-10
Zickrick	Fred	Denison	Tx	75020	903-465-5937	3/10
Thomas	Page	Fairview	Tx	75069	972-562-2017	3/10
Lowry	David	Kemp	Tx	75143	903-498-7245	3/10
Powers	Lanny	Mesquite	Tx	75149	972-284-3113	3/10
Watson	Ferris	Royse City	TX	75189	972-636-9283	3/10
Urban	Larry	Dallas	Tx	75218	214-328-3083	3/10
Sheldon	Frank	Princeton	Tx	75407	972-658-3251	m-10
Hamm	Allen	Blue Ridge	Tx	75424	972-752-5737	3/10
Cope	Cedric	Paris	Tx	75460	903-784-5351	3/10
Cox	Doug	Paris	Tx	75460	903-669-9949	3/10

SCABA membership as of June 30 2009

Puroy	Ray	Paris	Tx	75460	903-739-9027	3/10
Allcorn	James	Paris	Tx	75462	903-785-2608	m-10
Butler	Gary	Paris	Tx	75462	903-785-9545	3/10
Strohm	Larry	Quinlan	Tx	75474	903-356-2453	3/10
White	Brazos	Roxton	TX	75477	903-346-3204	M-10
White	Melvin	Roxton	TX	75477	903-346-3204	M-10
Bost	Howard	Sumner	Tx	75486	903-785-0864	3/10
Barkman	Chip	Texarkana	Tx	75503	903-832-6227	3/10
Dean	Thomas	Hallsville	Tx	75650	903-736-8990	3/10
Piccola	Paul	Huges Springs	Tx	75656	903-639-3349	3/10
Campbell	Glenn	Arlington	Tx	76016	817-457-3146	3/10
White	Jim	Mansfield	TX	76063	817-329-5297	3/10
Stokes	Robert	Newark	Tx	76071	817-988-5001	m-10
WTF Gunwork		Fort Worth	Tx	76111	940-206-6824	M-10
Hines	Tee	Magnolia	TX	77355	281-356-1340	M-10
Shelton	Phil	Borger	Tx	79007	806-273-9792	m-10
Klapper	Billy	Pampa	Tx	79065	806-665-2740	3/10
Latham	Keith	Amarillo	Tx	79106	806-355-5511	M-10
Allen	Richard	Abilene	Tx	79601	325-677-7105	m-10
Tolbert	John	Midland	Tx	79707	432-695-4544	M-10
Tanneberg	William	North Freedom	WI	53957	608-370-2211	3/10



NORTH EAST REGIONAL MEETING DATES

January 10, 2009
Host: Gary Gloden

February 14, 2009
Host: Bill Kendall

March 14, 2009
Host: Dan Cowart

April 11, 2009
Host: Open Easter Weekend
Phone #:

May 16, 2009
Host: *State meeting*
Phone #:

June 13, 2009
Host:
Phone #:
Trade item:

July 11, 2009
Host: Mike Sweany
Phone #:

August 8, 2009
Host: Omar Reed
Phone#

Sept. 12, 2009
Host: Dan Cowart (Pawhuska Blacksmith shop)
Phone #:
Trade item something Indian, (feather, leaf, etc.)

October 17-18, 2009
SCABA Conference

November 7, 2009
Host: Dwayne Moss
Phone #:
Trade item

December 12, 2009
Host: Charlie McGee
Phone #:

NORTH WEST REGIONAL MEETING DATES

January 24, 2009
Host:

February 28, 2009
Host: Ron Lehenbauer

March 28, 2009
Host: Bob Kennemar
Phone #:

April 25, 2009
Host: Mike George
Phone #:

May 16, 2009
Host: State meeting –No regional meetings
Phone #:

June 27, 2009
Host:
Phone #:

July 25, 2009
Host:
Phone #:

August 22, 2009
Host:
Phone #:

Sept. 26, 2009
Host: Gary Seigrist (Elk city)
Phone #:

October 17-18, 2009
SCABA Conference

November 28, 2009
Host: Mandell Greteman
Phone #: 580-515-1292

December 26, 2009
Host:
Phone #:

SOUTH CENTRAL REGIONAL MEETING DATES

January 17, 2009

Host: JC Banks

Phone #

February 21, 2009

Host: Gerald Franklin

Phone #:

March 21, 2009

Host: Terry Jenkins

Phone #

April 18, 2009

Host: Bob Kennemar

Phone #

May 16, 2009

Host: State picnic at Norman

No regional meetings

June 20, 2009

Host: Anelia Hadick

Phone #: 1-405-406-3705

July 18, 2009

Host: Max Scrudder

Phone #: 1-405-226-9951

August 15, 2009

Host: Richard Simpson

Phone #: 1-405-344-7413

Sept. 19, 2009

Host: Dorvan Ivy (Elk City Museum)

Phone #: 1-580-473-2761

October 17-18, 2009

Host: : SCABA Conference Perry, Okla.

November 21, 2009

Host: Bill and Diana Davis

Phone #: 580-549-6824

December 19, 2009

Host: Anelia Hadick

Phone #: 1-405-406-3705

SOUTH EAST REGIONAL MEETING DATES

January 3, 2009

Host: Howard Bost

Phone #:1-903-785-0864

February 7, 2009

Host: Howard Bost

Phone #: 1-903-785-0864

March 7, 2009

Host: James Allcorn

Phone #:

April 4, 2009

Host: Howard Bost

Phone #: 1-903-785-0864

May 16, 2009

Host: State meeting in Norman Ok

June 6, 2009

Host: Mark Hammell

Phone #:

July 4, 2009

Host:

Phone #:

August 1, 2009

Host:

Phone #:

Sept. 5, 2009

Host:

Phone

October 3 2009

Host:

Phone #:

November 7, 2009

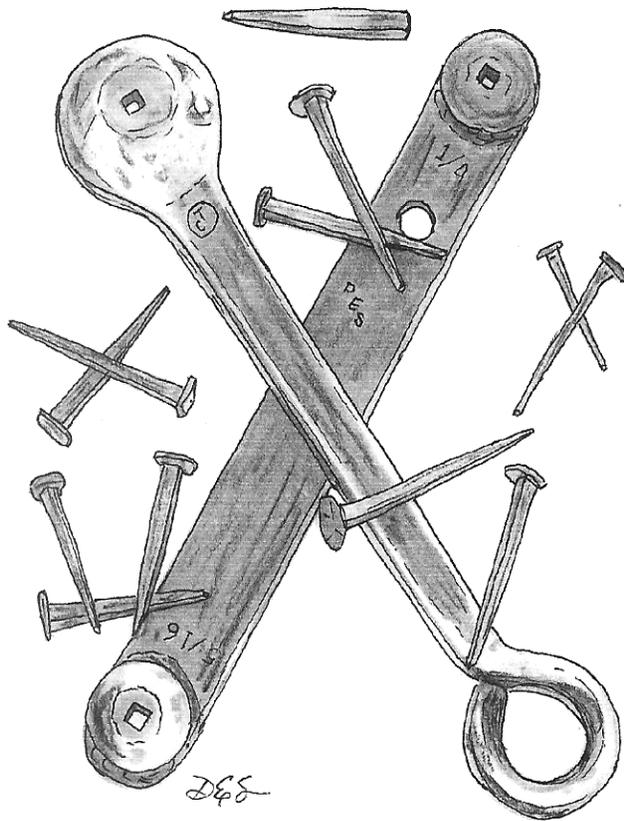
Host:

Phone #:

December 5, 2009

Host:

Phone #



Making Nails

by Dave Smucker

with illustrations by the author

Making Nails? Why an article on nail making? After all, nail making is easy or at least looks easy when you see someone else make nails. Many books on blacksmithing show a nail header and devote only a page or so to nail making.

Well here are some of my reasons you should try it and I hope to show you some things that are not in all of those books.

- Nail making is one of the very oldest forms of forging.
- Square hand made nails have 4 times the holding power as a round wire nail.
- It is a great way to learn better hammer control.

- If you want to change the "style" with which you hold your hammer and use it then nail making is a great item to practice on.
- It is a great way to warm up when starting out forging for the day.
- Even though factory nails are cheap, there is a market for hand made nails.
- It is a great demo item, and something that you can make and give away to kids. (Adults should pay for them.)
- Making a good nail header is not hard, unless you follow the information in all of those books.
- It is a fun contest item to test you skills against other blacksmith at local forge meetings.

The Basics

To make nails we start with a round or square rod usually in a size from 3/16 up to say 5/16 in either diameter or square. The ideal material would be very low carbon steel but we can make good nails from either hot or cold rolled mild steel.

We first heat our steel and then draw out the shank of the nail, working on two sides at right angles to each other.

Then using our hot cut hardie we cut most of the way through the stock rod leaving just enough material for the head.

Now, placing the shank of the nail into our nail header we break off the stock rod with a twist and then follow by forging the head on the nail.

Sounds quick and easy - and if you are really really good you can do this in one heat. Most good nail makers will do it in two heats. One to form the shank of the nail and cut almost through on the hardie and then a second heat to heat the now cool head area and forge the head.

Starting out making nails you will need 3 or 4 heats and should not feel bad about more until you get the speed and rhythm down.

There are several variations on this basic method and we will discuss what I will call the "Peter Ross", "Jerry Darnell" and "Tom Clark" approaches later in this article.

A Short History of Nails

Man has been making and using nails for a long time, at least 5000 years and maybe longer. Along with forging of weapons and knives, nails were one of the first metal items made in volume from copper and then iron. Copper and bronze nails continued to be used in shipbuilding as iron came into wide use in other construction. Iron nails from the Romans have been found in Britain.

All of these nails were hand forged one at a time. For centuries, the stock for nails would be hand slit into square cross section from iron that had been pounded out. The "sheet" was most likely made with waterpower heavy hammers. Then in 1606, a major improvement was made with the invention of the slitting mill by Englishman Bevis Bulmer. This slitting mill could cold shear a series of square sections from a thin bar of wrought iron. Bundles of these nail rods were "loaned" to local folks who would convert them to nails often using the home hearth as their forge. They would then be paid by weight of good nails returned less some allowance for waste. Most of this work took place on British farms and everyone made nails from kids to grandparents. The pay was very low.

Nail making in America followed a similar pattern with most of the nail stock coming from England. Nail stock has been found at Jamestown so local forging of nails took place from the very start in the USA.

In 1775, Jeremiah Wilkinson, a Rhode Island inventor devised the first machine to make cut nails from iron sheet. By 1795 there were machines that could cut and head nails in one operation.

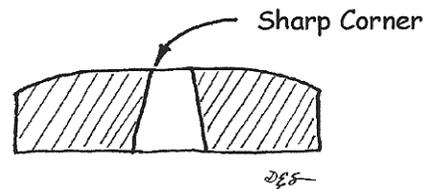
Nail making didn't really change again until after the large volume production of mild steel by the Bessemer Converter process. By 1880, mild steel wire was being produced and the wire nail became king because of its lower material / high volume production. Most nails today are wire based with some cut nails still being produced. Increasingly, nails being driven by pneumatic nail guns to the point where some construction workers today don't seem to know how to hand drive a nail.

Making a Nail Header

First, we need a nail header and you can easily make your own. Or you can purchase a very good nail header from Tom Clark for about \$ 35.00. Tom makes these himself and they are not something that he imports.

If you want to make your own, there is one very important thing to keep in mind "DON'T MAKE IT LIKE WHAT IS SHOWN IN THE BOOK." Now what do I mean by that strong statement? Well, I have looked in 7 different books I have on blacksmithing and all 7 show a form to the nail header that will not work without modification - and none of these books tell you what to do.

They all show a form like the following for the opening in the header. A square tapered hole in a domed forged with the taper larger at the bottom and a sharp top edge. In other words a square hole, punched from the bottom of the tool.



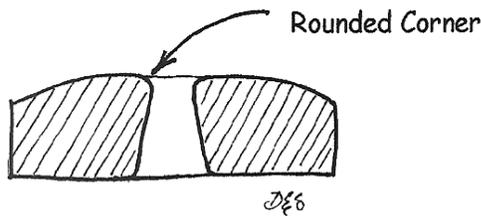
DO NOT make a nail header like this

If you make a nail header like this with that sharp top edge what happens? When you go to head the nail a small amount of metal is forged downward into the hole in the header. Because of the mass of the metal in the shank of the nail and because the metal right at the head is usually hotter you will get a small amount of upsetting just below the sharp edge of the nail header. This upset is now larger than the opening at the top of the nail head and locks the nail into the header. "Game Over".

However, if we look at all of the old historical nail headers, they were made this way - how did they get them to work?

One of two ways, and swearing wasn't one of them. One of the ways was to very carefully file or dress that sharp edge to remove it and give some top relief to the header.

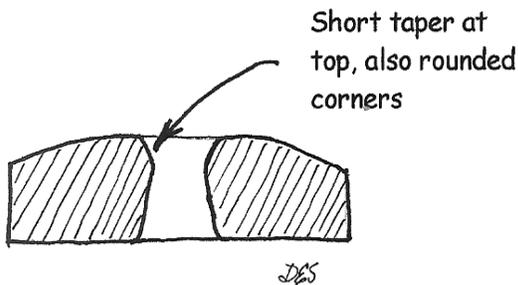
It looked something like this.



This will work.

The second method was to first punch through or nearly through from the bottom side. Then reverse the punch and punch gently through from the top forming a somewhat hourglass form. I say somewhat because the waist of the hourglass is close to the top of the tool. This form may also have been dressed with a file. I think that this is the most common form on historical headers.

It looks something like this in section.

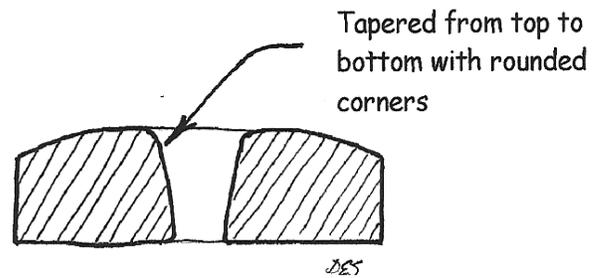


I have had good luck with this form.

I find that in making nail headers rather than using a very small needle file required to fit the hole that I can dress the hole using a small strip of emery cloth.

Now Tom Clark has done just the opposite. He puts the taper hole in the nail header with the large side at the top and small side at the bottom. He is also very careful to make sure that the header has no sharp edges. Looking carefully at the Top Clark Header my guess is that he dresses the hole with emery cloth as I do.

Here is the way the section looks through a Tom Clark Nail Header.



This form also works very well

What steel should you use for a Nail Header? I have seen workable nail headers made from mild steel. Not my choice because when I take the time to make a tool, I want it to last a long time. Tom Clark makes his nail header from 5160 - a good choice. The nail header that Jerry Darnell has with which he has made 1000's of nails is made from the end of automotive steering or suspension rod. I also like W1, O1, 4140 or 4340. S7 or H13 would also be good choices. The problem with the last two steels, since they are air hardening, once you get them hot, you can't drill or file them, any finishing work is going to be by grinding or polishing them with emery cloth. Historically, W1 or similar high carbon plain steel would have been used. The W1 tool steel "bit" would have been welded to a wrought iron backer bar as a handle.

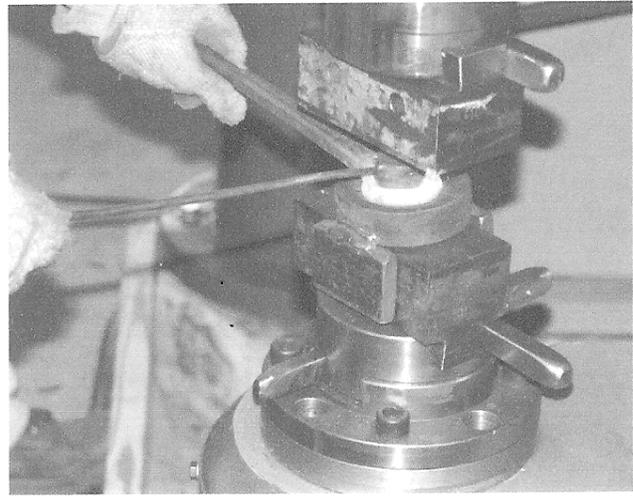
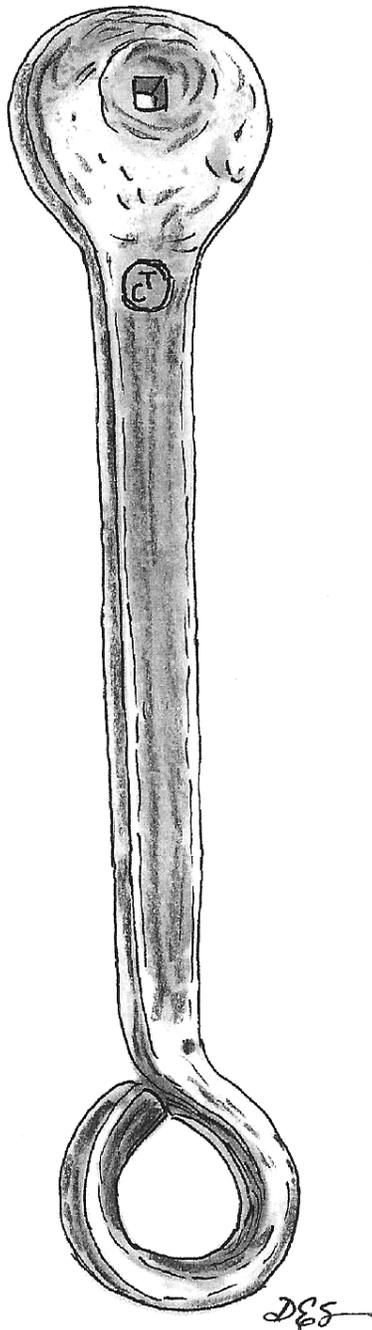
5160 is a good place to start because most of us can put our hands on a used leaf spring - which is most likely 5160. Tom Clark, since he is selling his nail headers only uses new 5160 material, but for most of us, a leaf spring will do.

How Tom Clark makes a Nail Header.

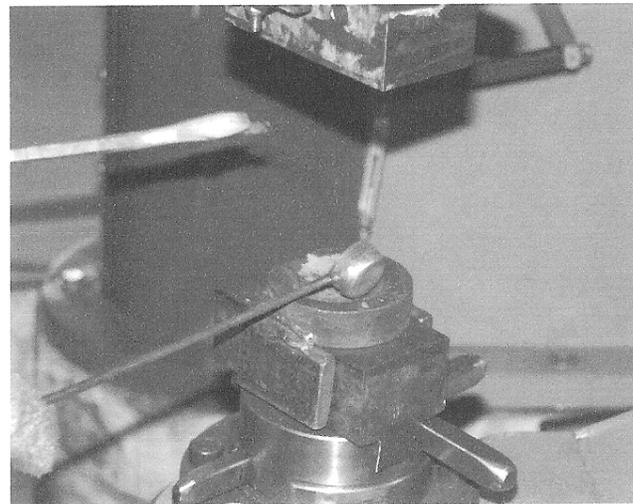
Tom makes the Header shown here by first drawing out the handle on the power hammer and then forming the head. He rounds that on the power hammer and then takes another heat and dishes the head using a fixed female bottom tool and a hand held male top tool.

He then puts in the taper hole and dresses the tool. Before he sells it, he makes a nail to make sure there are no problems.

It will be some work, but you can do all of these steps without a power hammer. Or you can weld a handle onto a smaller piece of leaf spring and then dish the tool in a swage block, especially if you have the help of a striker.



In this photo Tom is putting the dome in his nail header under the power hammer.



In this photo are both the bottom tool and the top tool used to form the dome on the working end of the nail header.

To purchase nail headers from Tom. Contact him at:

Tom Clark, Ozark School of Blacksmithing, Inc
20183 West State Hwy. 8

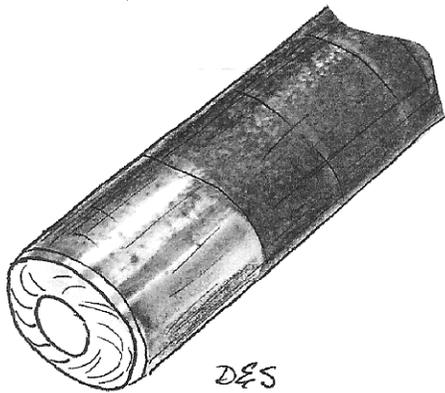
Potosi, Missouri 63664

phone 573 438 4725 fax 573 438 8483

email ozarksch@therural.net

My method is a little different and you might say it is a machinist or welder's approach.

I first grind a domed surface on the end of a round piece of tool steel.



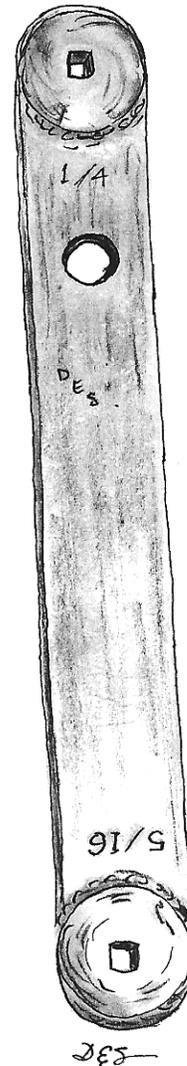
I just do this free hand on a 2 X 48 inch belt sander but you could also do this with a 4 & 1/2 inch angle grinder. Or, being a blacksmith, you could forge it on.

Then I cut off a small slice of the tool steel about 1/4 inch thick. The reason to dome the end before cutting it is that is much easier to hold and grind a piece that is a foot or so long. You can try making this cut in a horizontal band saw if your tool steel is annealed, but a chop saw will work with hard material and save your saw blade for mild steel.

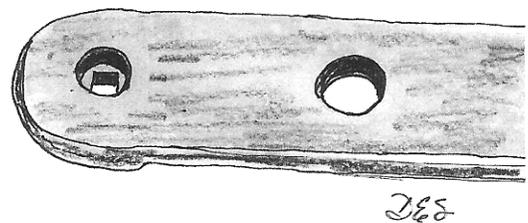
Now, weld your disk of domed tool steel to a mild steel bar which will become both the backing material and handle. I do this with a disk on each end so that I can have two nail header sizes in one tool.

Then anneal your welded up tool. To do this, heat the whole tool to above critical temperature and then place in vermiculite. If you don't have vermiculite, wood ashes or lime will work. By heating the whole tool - the tool steel part will anneal better because the overall tool will cool slower. You will not be able to anneal S7 or H13 using just a forge, you just can't cool it slow enough.

If using S7 or H13, drill your hole in the disk before welding to the back bar. It should be "soft" as it comes from the supplier.



Now drill a hole in the center of your domed areas. This hole wants to be about 2/3 of your finished nail square dimension. (You could also punch this hole but you will get less distortion by drilling.) I also add a hole so that it can hang on the wall.



Backside of Header, note the relief drill in the backer bar. The other hole is for hanging.

Now heat your tool up and drift your hole to a tapered square form. Like Tom Clark, I drift this one from one side so that the hole is bigger at the top. I have also made nail headers with taper in both directions, just make sure you have that top taper that goes about 1/3 of the way through your tool steel.

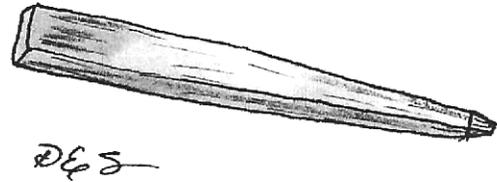
Last step is to dress your tool. To do this I use 120 or 180 emery cloth. Tear some very narrow strips (1/8 to 3/16 inch wide) and work them back and forth through the hole to polish all surfaces and especially the edges. This is the most important step in making a nail head - so that the nail doesn't stick.

You can also make a Nail Header similar to mine using the head of a Grade 8 bolt.

Because Grade 8 bolts are made from a high strength alloy steel, they will make a good nail header. A 3/4 inch bolt makes a nice size. You first dome the head of the bolt by grinding and then drill your starting hole that will be drifted square in the center of the bolt head. Next cut off the bolt head leaving a few threads. These threads can then be used to attach the bolt head to your backing bar / handle by tapping a hole. Alternately, you can cut the head off flush and weld it to the backing bar / handle. If you go the threaded route, you will want to drill from the underside with a larger hole so that you will be drifting only a depth of 1/4 to 3/8 of an inch.

Making your square tapered DRIFT.

In all of the methods for making a nail header that we have shown here you will need a square tapered drift for completing the hole in the Header. This drift should have a taper of 10 to 12 percent over its working area. In other words, taper of about 1/8 inch per inch of length. A very shallow taper such as 5 percent or less will not work for a header because such a taper is self-locking and the last thing you want is a self-locking taper. What is a self-locking taper? Think of the Morse Taper you will find on some drill bits and in the spindle of your drill press. Once set you have to drive out a Morse Taper. A Morse Taper is approximately 5 percent.



To make my square drift shown here I start with a square lathe tool bit. I dress one end flat with rounded corners and then grind the taper onto the lathe tool bit. To do this grinding I hold the tool bit in the jaws of a vise set at the approximant angle I want for the taper. I then use a 4 and 1/2 inch angle grinder to grind the taper on one side at a time. If you work slowly and carefully, you can produce a very good drift this way. Because a lathe tool bit is made from high-speed tool steel, you will have a drift that will handle hot temperatures and never wear out. You can buy lathe tool bits from MSC or Enco or find a machinist friend to give you a few. For these nail headers I used a 1/4 square bit. You can also use a 5/16 or 3/8 square bit. One major caution - **DON'T DRIVE THIS DRIFT WITH YOUR GOOD FORGING HAMMER.** The tool bit is very very hard and you will damage the face of your hammer. That is why you need a "junk face" hammer at your forge. I use an old stonemason's hammer for that function.

You can make your drift from other steels besides a lathe tool bit. W1, O1, S7, H13, 5160, 4140 or 4340 will all make good tapered drifts. You can forge the taper of such a drift and finish it by grinding. I would not use mild steel (A36) You can drift a few holes with a mild steel drift - but if you are going to make a tool and put time into it why not make one that will last. Round drifts can be made from mild steel. They are easy and quick to make and they are uniformly loaded in use. Square drifts take more time to make and the corners of a square drift are highly loaded when drifting. Make them from a tool steel.

Making Nails

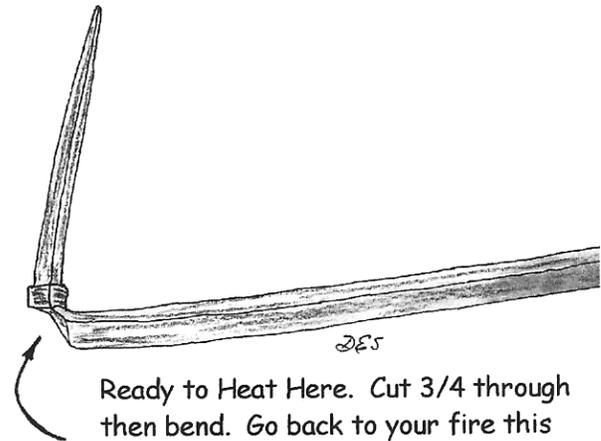
We now have a nail header - So let's get on with making nails. As noted before, you can use either square or round stock. Depending on the size of your header, a stock size from 3/16 to 5/16 of an inch is common. Historically, nail stock was square in cross section. It was first cut by hand from flat forged bar stock of wrought iron and later cut on a slitting mill into nail stock.

In the "Tom Clark" method of nail making, we heat our stock and then extend a short portion on the anvil and draw out a taper working back and forth between two faces. Typically, we will get a nail length that is about 3 times the length that we lay onto the anvil. So for a 2-inch nail we would start with about 3/4 of an inch on the anvil. By not laying more material than this on the anvil we retain heat in the stock we are going to use for the head. We don't worry about and don't really want a sharp point.

Once we have our taper we now use a hot cut hardie to cut most of the way through our stock just back from the taper leaving enough material for the head. We don't want any more material here than about the diameter or width of the stock. Too much material for the head and it will fold rather than upset when we forge the head.

If your vise is at hand consider putting your hardie in the vise rather than into the anvil. This way you can leave it in place as you make nails. Please don't leave your hardie in the anvil while doing other operations at your anvil - it is very easy to cut off a finger or seriously hurt yourself with that hardie sticking up in your anvil. (Watch for it in the vise too, but here at least it is usually out of the way.)

Tom Clark now does a neat little thing just before he takes a second heat to make the nail head. He taps the partly cut through nail and stock so that he gets a form that looks like this.

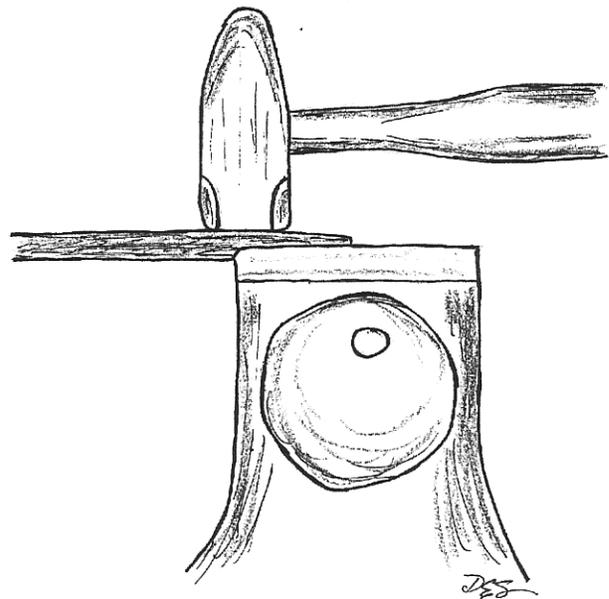


This allows him to go back into the fire with the nail tip up and out of the hot part of the forge.

Now he goes to the header, twists off the stock rod and forges the head using a central upsetting blow followed by four quick blows to forge the facets of the nail head.

The Peter Ross Method. I haven't seen Peter make nails so I am basing this method on what Ron Howard has told me and the way he learned to make nails from Peter. In many ways, this is similar to Tom's method except that Peter makes a point of setting off the head area at the start of nail making. He uses a half-on-half-off blow to set down the stock from two sides of the nail stock. The nail is then drawn out.

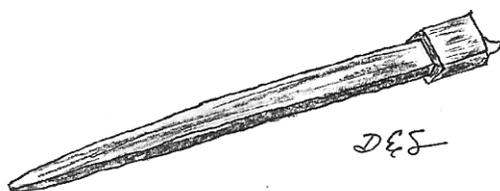
The half-on-half-off blow looks like this.



After the shank of the nail is drawn out the unfinished nail look like this.



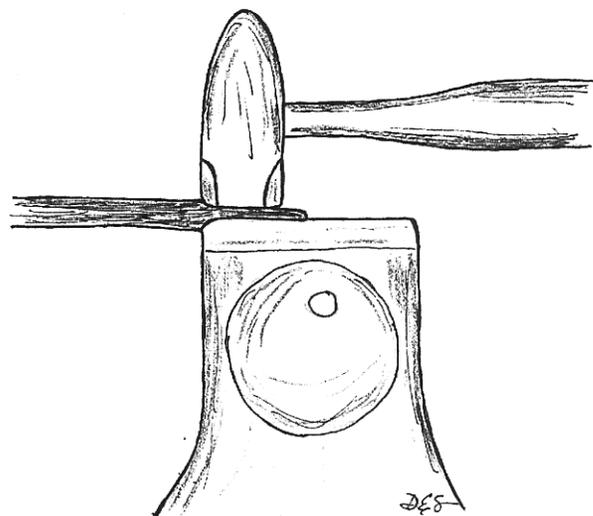
Two quick half-on-half-off blows can then move the shank to the center when used on the other side of the shank.



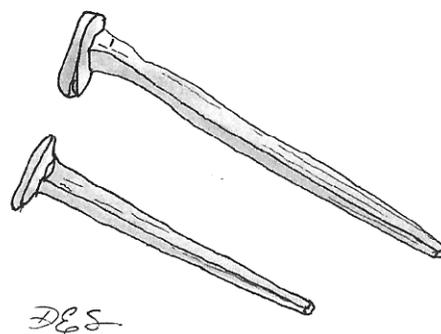
Now cut nearly through with the hardie, place in header, break off and forge the head. Historically a good nail maker could do this in one heat. A good smith could make 100 nails an hour and do it for 10 hours a day. If you have to take another heat, it is not a sin.

One important result of the Peter Ross method is that the shank of the nail is nearly straight with not as much taper as in Tom's method. This means that for the same given amount of metal, Peter's nail is longer. Not a big difference, but in the days of very high price metal vs. labor cost, getting the most nails per pound was important.

The Jerry Darnell Method. Jerry's method is similar to Peter's but with an important difference. Rather than use the half-on-half-off method of shouldering that Peter teaches, Jerry uses the hammer to shoulder from the top and the anvil edge to shoulder the bottom.



This means that when the nail shank is forged only the final steps of cutting off and forging the head are left. Also, because there is no contact with the rest of the stock it retains most of its heat. While it may be hard to believe, I have seen Jerry make two nails in one heat. Each nail was about 1 inch in length. Historically, really good nail makers would have used this high hammer control method. (I suspect that Peter would use the same method as Jerry when making nails himself but teaches the half-on-half-off method of shouldering because it is much easier to learn.)



Here is a sketch of two Jerry Darnell nails I have from one of his classes at the Folk School.

Light that forge and go make some nails. Have a nail-making contest at your local forge group. It's fun. If you can advance to the Jerry Darnell method of nail making, then your hammer control will have advanced to the point that you will be a much better smith.

The Great Myth about burning houses for the nails. In many books on blacksmithing and all kinds of articles on the internet you will see repeated the story that during colonial times nails had such high value that if some family was going to move west to a new area that they would burn down their house and collect the nails before leaving.

I think that this is pure Myth. Just repeated and repeated - yet no one gives any original source or even a reference to an original source for this story. No one who has built a house and could sell it would burn it just for the nails. It just does not make sense.

Where does this Myth come from? Most likely, it is the fact that nails did have high value and when a building or house did burn, the owner would always take the time to sift through the ashes and recover the nails. Fires were not uncommon and destruction was often rather complete so this could have happened many times.

A few buildings that had not been used and had failed roofs might well have been burned for the nails but I think this would have been rare. Log cabins and out buildings of a simple nature were built mostly using wood pegs etc. so they didn't have many nails to go after.

Think I am wrong about this? Well I'm always open to new information. Why don't you send me an original reference where some record of the time says that "Thomas Jones burned the house on his farm so he could take the nails with him as he headed to Ohio territory." *Dave*

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Dating Antique Items Made by Blacksmiths

by Gary Scasbrick

Close dating of blacksmith made items, especially some hand tools is impossible without makers marks or documentation. Some styles of tools have been made the same for 200 years. Some styles or types came into use and went out of use in certain periods. Here are some clues to come up the approximate date of some hand forge items.

- 1.) Dome Head factory made rivets were common after 1845. Items with factory rivets should date later than 1845.
- 2.) Tools from England were Stamped "Made in England" after 1891
- 3.) Tools stamped with "Cast Steel" were made after 1760
- 4.) Pritchel Holes in anvils appeared about 1830 in English Anvils.
- 5.) Earliest Factory made hatchet approx. 1845
- 6.) Double bit axes first became popular around 1850
- 7.) On any edged tool, steel bit forge welded to iron body, look for a line where the steel was forge welded to the iron body. These steel bits were generally added after approx 1744 and quit approx. 1870
- 8.) Pre Civil War handles for axes were straight not curved.
- 9.) No Poll on Axes in the 1600's, First hint of a poll about 1715, Fully developed polls by 1750, Round polls continued to be made until about 1800 and square polls are still made.
- 10.) Threads on bolts were hand filed and rounded before 1830 - where sharp and crisp later. (*I have English threads lathe cut and rounded, American a sharp V thread after 1830 - Dave.*)
- 11.) First practical steel production furnace in America was 1730. Edged tools were scarce before this time.
- 12.) 1840 First adze eye hammer (long or deep eye) same as on modern hammers
- 13.) Nail pulling slots in bottom edge of blade in shingling hatchets became popular in early 1800's.
- 14.) 1815 First cut nails with a square head were made by a machine, these had flat sides a had forge nail had four tapered sides. (*I have this date about 25 years earlier Dave*)

Patina, items stamped with a date, item with a makers mark, items with original wood handles mean "everything" when trying to put a value on any antique hand forged item!

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April 2009 thru March 2010

Please accept my application

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Married? Yes No Spouses Name _____

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I have enclosed \$20.00 for dues to March 30, 2010

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