Saltfork Craftsmen
Artist-Blacksmith Association

May 2008

Balcony railing recently completed for a new home in Paris Texas. It has a brownish-blackish matte finish with a lacquer topcoat. It is approximately 4 feet on each side and the curved front is about 10 feet long by 52 inches high. The fleur d' leis on the bottom are the main supports and are made from 3/8" flat bar held in place by 3 stainless lag bolts on each support. The railing does not touch the top of the balcony, as specified by the client. The railing was designed by Cindy Allcorn.

Saltfork Craftsmen Artist-Blacksmith Association Officers and Directors

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The Saltfork Craftsmen Artist-Blacksmith Association, a non-profit organization of amateur and professional artist and craftsmen, publishes this newsletter monthly. Our purposes are the sharing of knowledge, education and to promote a more general appreciation of the fine craftsmanship everywhere. We are a chapter of the Artist-Blacksmith Association of North America.

Visit our Saltfork Craftsmen Website:

Trading Post

For Sale:
¾" round bar of 5160 ($3.30 per foot plus shipping)
¾" and 1" round bar of 52100 ($6.00 and $9.45 per foot plus shipping) Contact Ray Kirk, ray@rakerknives.com or 1-918-456-1519

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. 2008 SCABA calendars featuring SCABA members, $10.00 Contact Diana Davis, lazyass-forge@tds.net or 1-580-549-6824

One Champion, one Tiger, freestanding hand crank blowers, good condition, $125. for choice. Contact Mark Carter 405-964-5754

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 good condition used #50 hammer ($3,500), two rebuildable 50# hammers (one at $1750 and one at$2,000), I have some miscellaneous parts, dies, babbit 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 -327-5235or o Mike-Marideth@sbcglobal.net

Club Coal

Saltfork Craftsmen has Arkansas coal for sale. The coal is $95/ton to members and $145/33non-members. 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. The coal is in large chunks; bring something to break up the coal into manageable size pieces.

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.

Cost for this coal is .06/pound or $120.00/ton. NO SALES to non-members.

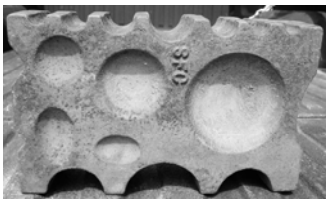
Max Scrudder can be contacted at (405) 226-9951

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

Saltfork Craftsmen Swage Blocks $105.00 each plus shipping. SCABA members can purchase **one** block for a special members price of $85.00

Contact Mike George at 1-580-327-5235 or mikemarideth@sbcglobal.net or Bill Kendall at 1-918-742-7836 or wwkendall@aol.com

Bill and Diana Davis have a few blocks available for those in the S/C region.



Mail your ads to the editor or email them to lazyassforge@tds.net

MEETING SCHEDULE

May

There are NO official regional meeting scheduled for May due to the Club Picnic.

Meetings will resume in June.

South/Central region—June 21st. Hosted by Larry Morefield at his shop in Medicine Park. Lunch is provided. The trade items is a punch or chisel.

Northeast regional meeting. June 14th hosted by Charlie McGee at his home near Sand Sprints. Trade item is a hat/coat rack.

Northwest regional meeting. June 28th. Hosted by Charlie Todd.

Southeast regional meeting. June 7th. Hosted by Gerald Franklin in conjunction with the Annual Frontier Days Celebration in Marietta, Okla.

May 10th Club picnic

Where: Fair Grounds at Norman Okla.

When: May 10th

What: SCABA club picnic.

- Food
- Forging
- Family classes
- Fellowship
- Door prizes
- Contest

Why: The Board or Directors decided that this would be a good opportunity for members to get together and enjoy the day.

Bring your lawn chairs, forges, items for door prizes(at least one item per person attending) and appetite and join in the fun.

There are two family activities planned.

1. hand made paper

If you have an old bed sheet that you can spare, please bring it. We will be cutting it up..

2. bulletin board (bring with you)
   - 1 fat quarter of fabric
   - 12 buttons
   - 6 yards of ribbon

. The address for the fair grounds is 615 E. Robinson St. in Norman Oklahoma. When you get to Norman take exit 110 for Robinson St toward Research Park/Univ. Airpark. Turn left at W Robinson St. go 2.6 miles. At Finley Ave. turn left into Fairground. We have the N. building reserved for SCABA. You can also contact Byron or Carol Donor for directions. Byron's phone number is (405)650-7520

Putting on a event like this is a big undertaking. If you would like to help with any of the activities contact the member in charge of that activity.

Gerald Franklin or Byron Donor

David Seigrist for forging contest or demonstrations (580)688-3555

Diana Davis for family activities or door prizes. (580)549-6824

PUBLIC DEMO'S AND REQUEST

May 2nd Geronimo Road School annual Encampment at Ft. Sill
Demonstrator needed.
May 7th NRCS Demo Duncan Public Schools
Demonstrator: Gerald Franklin
May 17th Healdton "Taste of the West"
Demonstrator: Gerald Franklin
May 17th David King's shop in Guthrie for the Oklahoma Tool Collectors gathering and swap meet.
Demonstrator: Steven Knisely
June 7th Women in the Outdoors
Instructor needed. Contact Beth An Amico at (405)769-4108
June 14th Frontier Days Celebration in Marietta

Boy Scouts, Adult Leaders, & Saltfork

Levy Rutledge & Jim Carothers represented the Saltfork Craftsmen at the Boy Scouts Southern Plains Rendezvous held the weekend of April 3-5 at the William Scout Reservation west of Enid. Levi brought an extra tent for me so that we could both set up on Friday night and be ready early on Saturday morning. The scouts and Jeff Wilber (an adult leader) made sure we had plenty to eat Friday evening and had breakfast ready so that we had the forges going by about 7AM. In all, there were probably over 500 people in attendance, most all of them at one time or another during the day came by to see what all that hammering was about.

One of our projects was a coffee pot tipper for Jeff (master Dutch oven chef). Levi made the long horn critter on the handle end and I made the other parts. Levi also made several other campfire cooking tools like the hook and chain next to the coffee pot.

We finally put the fires out just before the Saturday evening meal at 6:30. We had a great time and are promised an invitation to next year's event. I hope many more of our members can attend this event in 2009.

Jim Carother and Levi.Rutledge

Saltfork Members:

If you are coming to the scaba picnic/ hammer in on May 10th and you are in need of bolts, nuts, pop rivets, washers—about any kind of fastener, bring a bucket or two. Saltfork has been given 2 tons (4 000 Pounds) of hardware by SBS Industries. These are floor sweepings, excess inventory, old stock, etc. that they were going to scrap. Being the good stewards that we smithing types are, I told SBS that we would gladly recycle this iron at no cost to them.

Jim C.

Norman Medieval Fair

On April 4th, 5th and 6th, the 32nd annual Norman Medieval Fair was again held in Reeves Park in Norman. As in past years, Saltfork Craftsmen were invited to participate and we had an excellent showing. Combined with the crew from Dawnavans' Keep, we had six forges and over a dozen blacksmith busy through out the three days of the fair. As one of the top 10 fairs in the nation and one of the largest events in Oklahoma, and with an estimated attendance of about 400,000 visitors, it was great opportunity to let the public see some of our members at work and show that blacksmithing is alive and thriving in Oklahoma.

The weather was warm and sunny, there was a lot of good things to eat and drink, and we got to visit with a lot of old friends and make some new ones while doing a craft that we all enjoy. It doesn't get much better than that. As the year goes on check out the events that members will be at and come out to visit with or help them and enjoy the companionship of friends who share a common interest.

Steven Knisely

The following is a letter sent by the fair showing their appreciation:

April 14, 2008

Dear Saltfork Craftsmen Artist Blacksmith Assoc.

I would like to thank you for your participation in this year's Medieval Fair. Your outstanding blacksmithing demonstrations added an important education component to the fair. Every time I passed your area there were large groups of people watching and listening to your blacksmiths.

We appreciate your contribution in making this year's record setting fair such a success. Out estimated record attendance was 400,000. We look forward to having you participate in next year's fair.

Sincerely
Linda Linn
Coordinator, Medieval Fair

Cover Story>>>>

James and Cindy Allcorn live and work in Paris Texas. James and Cindy hosted quite a few of the organizational meeting for the SE Region. James is a very talented blacksmith and Cindy does a very nice job of designing many of his projects. On the cover is a balcony railing produced by James and designed by Cindy.

They have made several pieces for the same house. This is a wine cellar door that is vines and grape leaves. The vines are made from combination of 3/4, 5/8, 1/2, 3/8 and 1/4 round bar all worked in free-form. Leaves are 14 ga. plate. Grape clusters individually assembled from different sizes of "grapes". Color achieved with various chemical treatments and lacquered. They are normally displayed in the open position.

This is a bed that was also designed by Cindy Allcorn.. It is approximately 540 pounds and 8 feet tall. It has a chemical finish with matte lacquer topcoat. The finish work took 3 weeks.

Like to thanks Cindy and James for all the pictures and info they have sent to the newsletter.

Diana

Knife Group Association

This is a link to some photos that were taken at the Knife Group Association shop tour that was held at the home of Rick Menefee in Blanchard, Oklahoma. We had a great time and enjoyed visiting and doing a little knife making. I want to thank Less Jones for his contribution of photos. It is hard to be every where.

Our next shop tour is scheduled after our knife show and will be held in October sometime. We have plans to hold it at the home of Ray and Barbara Kirk near Tahlequah, Ok. An itinerary hasn't been set yet.
http://s124.photobucket.com/albums/p29/raykirk/menefee%20shop%20tour/

Sad News

Saltfork has lost one of it's very talented and much loved members. Ruth Burns has succumbed to cancer and the effects of it's treatment. Rush passed away Saturday, April 12th 2008. She was 86 years old. She was cremated at her request. A memorial service was held at Capron, Ok on Wednesday, April 16, 2008. Memorials may be made through Marshalls Funeral Home, 230 W. Flynn, Alva, Ok. 73717 to Flannigan's Boys and Girls home or Kiowa hospital District Manor.

John and Ruth Burns were one of the original thirteen memberships who started Saltfork Craftsmen Artist=Blacksmith Association. Both John and Ruth have been more than generous with their time and money in support of our Club. Ruth will be sorely missed by all of us. If you want to convey condolences, John's address is
John Burns'
50965 McClain Rd.
Alva, Ok. 73717
580-829-4521

Saltfork Craftsmen Continues Support of the Loco VFD

Loco, Oklahoma is a VERY small town southeast of Duncan and west of Ardmore, OK. It just happens to be the closest actual town to my place but many of you who have been here for meetings and visits probably didn't come through Loco. Its major industry is the Volunteer Fire Department. In the past, Saltfork people have been very generous in donating items for the VFD's main fund-raising activity, the Bean Supper and Bake Sale.

Many of you may remember a couple of years ago when we collected items during a S/C meeting here at my place and donated them to the sale. That effort on your part was very well appreciated by the VFD as we were having a rough time with fires and the small departments in the area were flat out of money.

This year, the fire situation was still pretty bad, and money is still tight, so Fire Chief Glen Knutson asked if I'd come down and demo during the Bean Dinner and Bake Sale. I took the standard set-up: forge, anvil, vise, etc. and set it up just outside the front door so people couldn't help pass by and get a whiff of the coal smoke. As I finished forging an item, I'd put it on a display table, which was marked "Auction Items". Since I wasn't able to turn out as much stuff during the demo as I wanted to donate, I brought several items that I had made earlier. These were all simple things like hat hooks, spike men, a flower or two, Fredriech's crosses, etc. I forged stuff for the demo that went quickly (steak turners, hoof picks, etc) so that I could increase the "body count" quickly and have as many items as possible to try to get into the wallets of folks at the auction. Things sold well, accounting for something like $550 for the Department's bank account. No, the forging wasn't all that good. People were bidding to support their VFD. Any time you see one of your steak turners that normally sells for $10 bring over $100, you know that you can't use an event like this to price your work to a regular customer. This was a fun event for me and it was very rewarding to be able to contribute to a community organization.

Gerald Franklin

Saltfork Craftsmen Support the Marshal County Antique Tractor Show

I demonstrated at the 6th Annual Marshall County Antique Iron Show on April 11. The show was again held at their show grounds near Enos, OK. For those of you who may not be familiar with Enos, you go south of Madill, OK until your feet start getting wet in the Red River, and you're in Enos. This year, it was easier to get your feet wet since the majority of the show grounds were under several inches of water from recent rains. When I got there early Friday morning, the tractor club folks were busy with back hoes and oil field salt water trucks trying to pump the bulk of the water off.

hammering a little and visiting with the tractor show folks. The tractor count was down this year, most likely due to high fuel prices. Come to think of it, that may explain why there weren't many school busses. I didn't go back on Saturday, due mainly to low participation and fuel prices.

As with most public demonstrations, the folks expressed genuine interest in our craft and were very willing to share their favorite "Grandpa was a blacksmith" tale. It was a fun event, only marred by the wind, rain, and low turn out. Maybe next year we'll have better weather and more folks.

Gerald Franklin

Minutes

Saltfork Craftsmen Board of Director's Meeting
2:00 PM Apr 20, 2008

- Call to order – The meeting was called to order at 2:01 PM in Perry, OK. Board Members present were J.C. Banks, Jim Carothers, Byron Doner, Gerald Franklin, and Bill Kendall. Also present were Bill and Diana Davis, Tom Nelson and David Seigrist.

- Treasurer's Report – The club is solvent.

- Web site report - J.C. Banks reported that the site is working fine and we continue to receive about the same number of hits each month. We need to remove out-dated tailgate items from site. Bill Kendall and J.C. Banks will continue work on establishing a Pay Pal account for the site.

- Workshops - David Seigrist is doing a great job of organizing these events. Classes currently scheduled are Tooling Workshop on Apr 26, 2008 (full), Touchmark Workshop on May 17, 2008, and a Decorative Punch Workshop on Aug 30, 2008. The Board also approved the concept of bringing in a paid professional teacher for some classes (e.g. forge welding).

- Statewide meeting/picnic - Plans for the Statewide Meeting/Picnic were finalized. Doner and Franklin will coordinate food. The event will be held at the Cleveland County Fairgrounds in Norman from 9AM to 4PM on May 10, 2008. Members are asked to bring a dessert item and items to be used for door prizes. There will be a trailer load of donated bolts to be given away in the Tailgate area. Members should bring a container to carry their bolts home, as containers will not be provided. Tailgaters are welcome; the more, the better. There will be a drawing out contest, demonstrations, and craft classes.

- Arts Council Event – SCABA will not participate in this event this year.

- Conference items – Conference demonstrators for the 2008 conference have been set up (Alison Finn and Bob Alexander). Robb, Chad and Brad Gunter have agreed in principle to demo for us in 2009.

- Cone Mandrel Project - Jim Carothers has completed the drawing and distributed copies to the BOD so that we can begin soliciting foundries to pour them.

- Swage Block Status - Bill Kendall reported that there are 23 swage blocks at his shop in Tulsa. There are approximately a dozen at other locations around the state. Bill Kendall will coordinate with Dan Cowart to determine if he can get a bid on more swage blocks from the Coffeyville foundry.

- Mileage Reimbursement – It was decided to authorize reimbursement (gas money) for those traveling on club business (Board Meeting for example) @ 20 cents per mile if that member chose to ask for it.

- Election of Officers -The officers and Board of Directors remain the same as last year unless Richard Dyer wants out, then Dan Cowart will be asked to fill that spot. We need to create a SE board member position.

- Next BOD meeting – August 16, 2008 at the S/C regional meeting in Blanchard, OK.

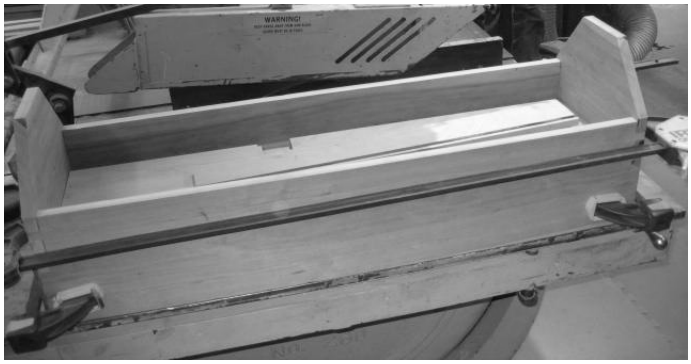
- The meeting was adjourned at 3:50 PM.

S/Central meeting

Saturday the 19th was a beautiful day to do some forging! Although we had only 2 forges going for most of the day they got some pretty good use. We had about 25 folks show up. Several tried out the bellows and forge that Dawnavan Crawford, Cory Charlton and I built over the winter. Gerald was showing a new member some basic skills needed. After a lunch of grilled hamburgers and hotdogs Gerald got this look of fear in his eyes as he scurried around taking pics of everything, muttering something about Diana. The trade item was a feather and we had 4 in the pot up for grabs. All in all a good time was had by those that were there. Terry Jenkins

Thanks to Gerald, Terry Jenkins, Steven Knisely and many others for covering the events for me. As much as I try, I can't attend all the events that take place in a month's time. I really appreciate all the members that send in pictures or articles.

Diana Davis



After the board meeting we had the opportunity to go by and check out the new tool box that is being made by Adam Hall. The box is being constructed from cherry wood that was cut by Jim Carothers father and was stored in a barn.

The box has two drawers. One on each end of the box. The top is about 2 feet long and 3" deep..

Tool/Item	Maker/Buyer
Box	Adam Hall
Hardware for toolbox	Mike George
Cross Pein	
Straight peen	
Rounding hammer	
Tongs:	
¼ v-bit	
3/8 v-bit	
½ v-bit	
¾ v-bit	
¼ flat	
3/8 flat	
½ flat	
¾ flat	
Scrolling	
Side grip	
Pick up tongs	
Fire tools (Shovel, rake, poker)	
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	JC Banks
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	
Scribe	Bill Kendall
Bending forks	JC Banks
Spring swage (necking down)	
Flux spoon	
Metal folding ruler 6'	
Soapstone	
Ball tool	
Hook Ruler	Gerald Franklin
20 Mule Team Borax	
Finishing Wax	
Nail Header	
Dual Caliper	David Seigrist

NORTH EAST REGIONAL MEETING DATES

January 12, 2008
Host: Bill Kendall 918-691-2173

February 9, 2008
Host: Gary Gloden Letter opener 918-321-5015

March 8, 2008
Host: Dan Cowart 918-534-0299
Trade item something for the grill
Lunch:

April 12, 2008
Host: Mark Coatney
Phone #: 918-476-6755

May 10, 2008
Host: *State meeting*
Phone #:

June 14, 2008
Host: Charlie McGee
Phone #:918-643-3299
Trade item: hat rack (wall or floor)

July 12, 2008
Host: Dwayne Moss
Phone #:918-260-3267

August 9, 2008
Host: Omar Reed
Phone# (918)478-4088

Sept. 13, 2008
Host: Dan Cowart
Phone #:918-534-0299
Trade item is a tool to be added to the tool box

October 11, 2008
Host:
Phone #:

November 8, 2008
Host: Mike Sweany
Phone #: 918-245-8460

December 13, 2008
Host:
Phone #:

NORTH WEST REGIONAL MEETING DATES

January 26, 2008
Host: Ron Lehenbauer :(580)758-1126
Trade item: spoon

February 23, 2008
Host: Ron Lehenbauer (580)758-1126
Trade item: fork

March 22, 2008
Host: Bob Kennemer (tool for cooking on a grill)
Phone #: 580-225-3361

April 26, 2008
Host: Mike George (pair of small Shelf brackets)
Phone #: 580-327-5235

May 2008
Host: State meeting –No regional meetings
Phone #:

June 28, 2008
Host: Charlie Todd
Phone #:580-242-0105

July 26, 2008
Host:
Phone #:

August 23, 2008
Host:
Phone #:

Sept. 27, 2008
Host:
Phone #:

October 25, 2008
Host:
November 22, 2008
Host: Tom Nelson
Phone #: 580-862-7691

December 27, 2008
Host:
Phone #:

SOUTH CENTRAL REGIONAL MEETING DATES

January 19, 2008
Host: JC Banks
Phone #(580)482-3209
Scroll jig workshop

February 16, 2008
Host: Gerald Franklin
Phone #: 580-467-8667
Scroll ends workshop

March 15, 2008
Host: Byron Donor
Phone #(405)650-7520

April 19, 2008
Host: Terry Jenkins
Phone #(580)485-2394

May 2008
Host: State meeting no regional meetings
Phone #:

June 21, 2008
Host: Larry Morefield
Phone #: 580-529-3081
Trade item: Punch or Chisel

July 19, 2008
Host: Max Scrudder
Phone #: 580-654-2229

August 16, 2008
Host: Richard Simpson
Phone #:

Sept. 20, 2008
Host: Dawnavan Crawford
Phone #: 405-520-3712

October 18, 2008
Host: : SCABA Conference Perry, Okla.
Phone #:1-405-344-7413

November 15, 2008
Host: Bill and Diana Davis
Phone #: 580-549-6824

December 20, 2008
Host: Aniela Hadich
Phone #:405-869-2043
Trade item: some kind of vessel

SOUTH EAST REGIONAL MEETING DATES

January 5, 2008
Host: Bois D'Arc Forge
Phone #:

February 2, 2008
Host:
Phone #:

March 1, 2008
Host: Gerald Franklin Durant Stockyards
Phone #: 580-467-8667

April 5, 2008
Host:
Phone #:

May 2008
Host: State meeting in Norman Ok
Phone #:May 10 ..Info in newsletter

June 7, 2008
Host:
Phone #:

July 5, 2008
Host:
Phone #:

August 2, 2008
Host:
Phone #:

Sept. 6, 2008
Host:
Phone #:

October 4, 2008
Host:
Phone #:

November 1, 2008
Host:
Phone #:

December 6, 2008
Host:
Phone #:

Touch Mark Workshop

Bill Davis will be conduction our third workshop on the 17th of May as his place near Fletcher Oklahoma. A touch mark is the blacksmiths' way of signing their work. In learning our craft one of things we tend to leave out, at least in the beginning, is the signing of our work. Bill will show us and then guide us in making our own "John Hancock" so when we spend all that time and energy into making something we are proud of we can put our stamp on it.

Bill tells me all the tools and materials will be supplied, no forging required, just bring a Dremel Tool and a side dish. Draw up a simple design that fits inside a 3/8" diameter circle. If you want your initials or just letters, limit it to no more than 3 letters. If we have time and you want to, you can make a second touch mark. Perhaps one for regular size stamping areas and then another for smaller work. We will start at 9:00 AM on Saturday the 17th and finish the same day.

Cost for the workshop is $20 and we are limited to 10 students and no observers. If you would like to attend please give me a call or send an email and I'll add your name to the list. I'm also making an alternate list in case we have dropouts.

It's never too late to turn in a survey, and those who return a survey requesting that class has first dibs.

Davis Seigrist
P.O. Box 163
Hollis, Ok 73550
580-381-0085
dseigrist2004@yahoo.com

Decorative Punch Workshop

Gerald Franklin will be conducting a decorative punch workshop on the 30th of August at his place in Duncan, OK.

Often times we would like to add that little something special to our work to really highlight our piece and make it stand out from the crowd but just can't think of what it would be. A decorative punch with a few hammer blows can really make your work stand out and provide that extra detail so prospective clients will stand up and take notice. Usually some of us realize how much a decorative mark would add to the piece when we see it on someone else's work and say "Wow! Why didn't I think of that?" usually followed by "How did you do that?"

Gerald will put on a cold forge workshop, since it's in August, to teach us how to make our own decorative punches. We'll be able to make a punch or two and before it's over, take with us the knowledge to make a wide variety of punches in our own shop. It's a one-day workshop to help folks who are traveling. Gerald tells me it's not that hard we just sometimes need a boost on the basics to upgrade our skills at the forge, increase confidence in our ability to make tooling, and potentially the price of our product.

All that's required is a Dremel tool and if you don't have one, Harbor Freight (I know that's taboo to some folks) has one for about $8. If you have a small belt sander, perhaps a 1" or 2" and can bring it that would be good.

We will start at 9:00 am on Saturday the 30th and finish the same day. Cost for the workshop is $20 and limited to 8 students and no observers. If you would like to attend please give me a call or send an email and I'll add your name to the list. I'm also making an alternate list in case we have dropouts.

It's never too late to turn in a survey, and those who return a survey requesting that class has first dibs.

David Seigrist
P.O. Box 163
Hollis, OK 73550

(580) 381-0085
dseigrist2004@yahoo.com

Election results

There are nearly 275 members in the SCABA organization. In last months newsletter there was a ballot with the names of the board members that were up for reelection. Only 8 members voted in the election. That leaves about 267 that either couldn't find a stamp to mail in their ballot or just didn't care.

If you don't exercise your right to vote then you can't complain if things aren't run they way you want them to be. This goes for any situation where you put your trust in someone else to do what is best or right. Vote what you believe not what is popular.

Editor

SCABA WORKSHOP SURVEY

Name: _____

Address: _____

Ph: _____

List in order your choices for workshops you would like to attend. The above list is not your only choices; please include any others you would like.

Workshop Title:	How long: Saturday only, weekend, one week	Instructor: Any ideas for an excellent instructor?	Travel: How far can you travel? North East OK, South East OK, North West OK, South West OK, Paris Texas, Statewide to include Paris TX	Tools: Can you bring your own tools? Forge, anvil, vice, hand tools? Yes or No

Comments:

Mail to: David Seigrist
PO Box 163
Hollis, OK 73550

Picnic/Hammer-In Schedule

Time: 9:00 AM-4:00 P.M.

Admission: (1)one door prize item per person (suggestion only)

Food: The club is providing the meat, buns, chips, beans, potato salad and drinks. If you can, please bring a desert. We could probably also use some sliced tomatoes, pickles, onions etc. We are planning for about 60 people.

Events:

Open forging and tailgating all day.

Paper making class starts at 9:00AM (Teacher-Diana)

Jim White blacksmithing demo @ 10:00 AM

Eat 11:30-1:00PM

Door Prize drawing during noon break

Forging Contest 1:00-2:00 PM (David Seigrist in charge)

Gerald Franklin blacksmithing demo 2:00 PM

Decorative Bulletin Board Class 2:00 PM (Diana)

4:00 PM clean up and head home

PLEASE contact Diana Davis to let her know how many to plan for if you wish to take one or both of the classes. There is a list of materials listed elsewhere in this newsletter that she would like for

The following 8 pages are reprinted with permission. From the Hammers Blow.

Twisting

By Bob Fredell
Illustrations by Tom Latané

1. The completed twist

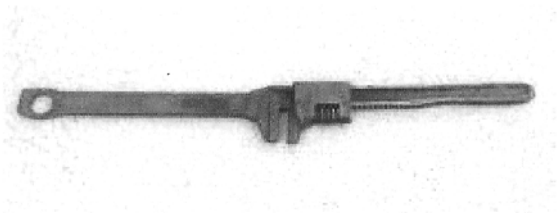
Lesson Number Five--Twisting

Definition:

Twisting rotates the bar around its axis.

Intent:

The student will twist a 1/2"square bar one and one-half turns.



2. A Twisting Wrench.

The twist is 3" long and starts 2" from the end of the bar. The finished twist is to be straight and along the same axis as the untwisted portions of the bar. The entire length of the twist is even so that it does not easily show variations in the spaces between the turns. The twist is to be made to dimensions and in one heat.

Tools Needed:

You will need basic tools plus a twisting wrench, divider, container to direct water to parts of the twist and two lightweight bars 6" to 10" long.

3. An alternative type of twisting wrench.

Different types of twisting wrenches may be used. By welding a handle on to a smooth jaw plumbers' wrench an adjustable twisting wrench is made. The traditional "S" shaped twisting wrench may also be used. Experienced blacksmiths are able to use flat-lipped blacksmith tongs. However, beginners using this method run a higher risk of making a crooked twist because when applying the rotational force from only one side of the bar there is a tendency to bend the bar up, down or sideways.

Two light bars to test completeness of the twist.

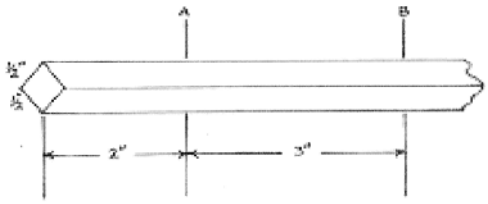
The exact size of these bars is not critical. Bars in the area of 1/4"x 1/2"x10", or slightly shorter, work well. The idea is to use straight, lightweight bars.

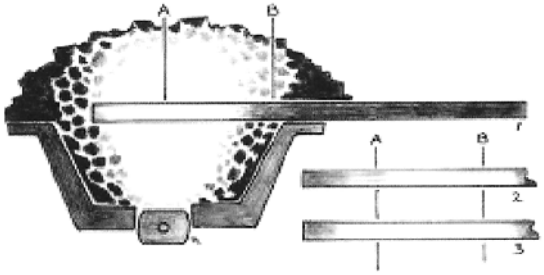
Water container

Use a container of your choice. You may use an old soap squeeze bottle, a tin can with a pinched top or anything else that produces a small, well-controlled stream of water.

Materials:

24" of 1/2" square mild steel





4. Measuring and heating the bar.

Step One:

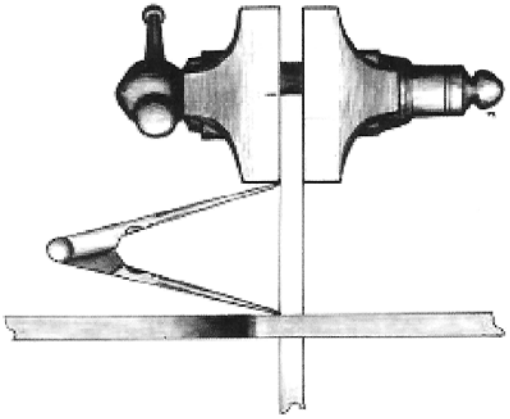
Place the bar in the fire so that 2" from the end of the bar is in the center of the fire and heat to a medium orange heat. Push the bar so that 5" from the end is over the center of the fire and heat to a medium orange heat. This is done to insure that the heat is well beyond the area to be twisted. Withdraw the bar and inspect the temperature. The color of the bar must be exactly the same for at least one inch beyond both directions of the area to

be twisted. Reheat as necessary to achieve a perfectly even heat that is three inches long. The length of this heat will ensure an even twist.

Hints:

An even heat makes for an even twist; an uneven heat makes for an uneven twist... *close* to even doesn't do it!

Do not heat the bar hotter than the recommended temperature because too high of a heat may cause the edges to crack when twisting.



4. Setup for twisting.

Step Two

Place 2" of the bar horizontally in the vise. This may be achieved in several ways. (a) Before heating the bar, center punch 2" from the end. However, this will leave a mark that you may or may not consider unsightly. (b) Place a chalk mark on the vise 2" from the end. This will work only if the twist is to be close to the end of the bar. (c) For twists in the center of a long bar, place a blacksmith's stand or other obstacle on the opposite side of the vise to act as a stop. *Note*—for some applications other than this lesson, the smith may find it useful to place the bar vertically in the vise.

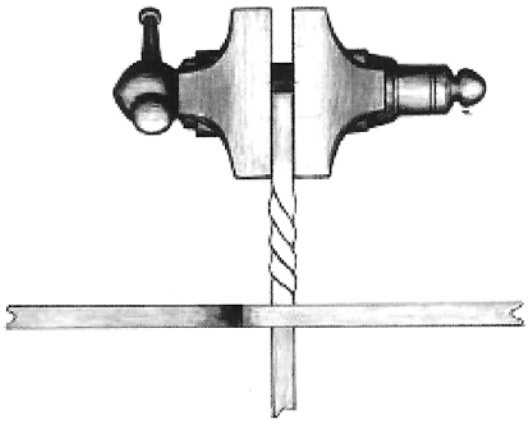
Use the dividers pre-set at 3" to determine the location of the twisting wrench and place the twisting wrench on the bar.

Hints:

When setting down the dividers do not allow the weight of the twisting wrench to rest on the bar as the bar may bend downward.

Step Three:

Twist one turn using even pressure with both hands. The twisting will take place only between the vise and the twisting wrench. Be sure to use gloves to protect your hands from falling scale.



5. Twisting in the vise.

Hints:

Be consciously aware of not bending the bar up, down or sideways, as this will put a bend in the bar.

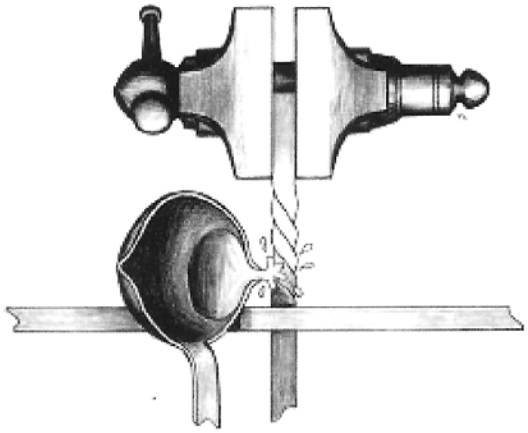
Some twists call for multiple twists in the opposite direction. Always make the first twist in the same direction to avoid forgetting which way to twist. (This may be either clockwise or counter clockwise.) It is well to develop the habit of always twisting in the same direction, except when the design calls for doing otherwise.

Step Four:

Quickly brush off the scale and inspect the twist. If part of the twist is tighter that the rest, cool it with water. Continue twisting to finish with exactly one and one-half turns.

Hints:

You will need some practice to learn how much water to use.



6. Cool tight sections with water.

7. Check the twist to make sure it's straight.

Step Five:

Sight lengthways down the bar; rotate 90 degrees and sight again. The bar, including the twisted and untwisted portions, is to be straight. The bar needs correction if you can detect a bend. Learn to train your eye to see deviations.

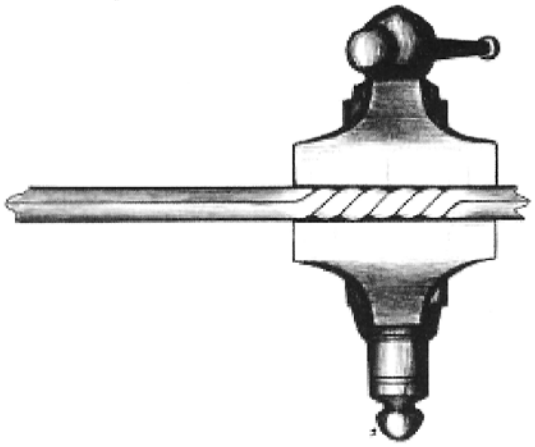
Beginners may need to use the following procedure to check for straightness: Place a straightedge lengthwise along the bar on a corner covering the twist and both untwisted parts. Do this on all four corners. The straightedge is to make contact with the untwisted corners and the corners of the twist.

If the bar is not straight and requires correction, proceed to step #6. If it is straight go to step #7.

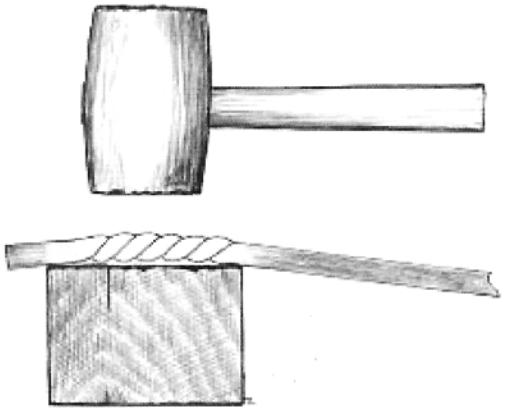
Step Six:

If the bar is simply bent, this may be quickly corrected by placing the twist in the vise on the diamond and gently tighten, rotate to the other diamond and tighten, then repeat this procedure on the flat of the bar. A second method is to place the bar on a block of wood and strike it with a wooden or rawhide mallet. Be sure to use wood to avoid deforming the edges of the twist. Wet the wood to reduce the amount of smoke in your eyes.

Correction may be more difficult if the bar is offset at the junction of the twist and untwisted portion. The block of wood method described above may correct the offset. Or, reheat to an orange heat, quench the twist to protect it and place the twist in the vise at the point of the offset. Strike the bar to move it back into alignment. At the same time apply pressure in the opposite direction at the end of the bar to avoid bending the bar.



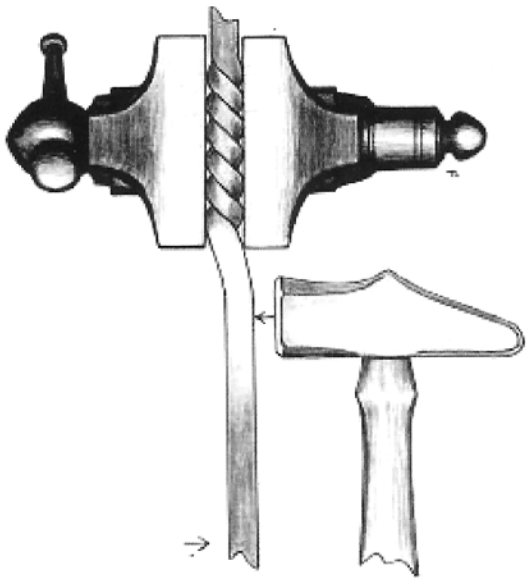
8. Correcting a simple bend.



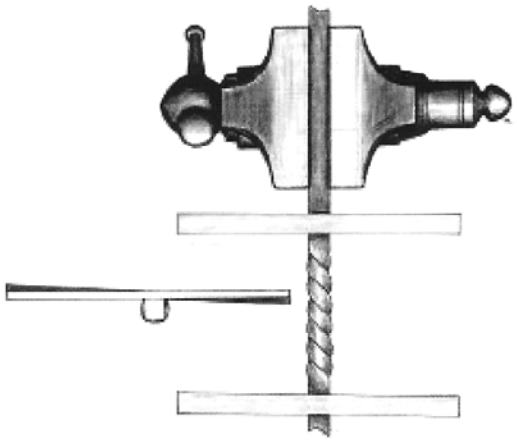
9. Another method for correcting a simple bend.

Hints:

Bends and offsets are most often caused by moving the twisting wrench up, down or sideways or allowing gravity to sag the bar downward when twisting. Be consciously aware of applying even pressure on both handles of the twisting wrench.



10. Correcting an offset bend.



10. Another way to straighten an overbent end.

Step Seven:

To check for exactly one and one half turns, place the twisted bar horizontally in the vise. Lay one of the light bars on the flat, untwisted portion at one end of the twist and at a right angle to the twisted bar. Likewise, lay the other light bar on the other side of the twist. Sight lengthwise down the twisted bar. If the light bars are exactly parallel you have completed this lesson. If they are not exactly parallel the bar is either twisted too much or not enough. Place the twisted bar back in the original position in the vise and adjust. This process may require the twist to be heated.

Targets:

The twist is to be:

1. 3" long and 2" from the end with a deviation no more than 1/16 of an inch.

2. 1 1/2 turns with the leveling bars as described in step #7.

3. No cracked edges.

4. Equal size increments of the turns. The spaces between each corner of the twist are to vary no more than 1/16" as measured lengthwise along the bar. *Note*—the vise and the twisting wrench are heat sinks causing slightly wider turns at the ends.

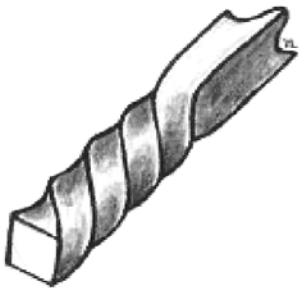
5. The entire bar is straight. A good test for straightness of the twist is to place a straightedge along the twist and check for contact with each of the corners of the twist. Also, sight lengthwise along the bar—there is to be no detectable crookedness for the entire length of the bar.

6. Complete the twist in one heat.

Forging Dynamics:

The length of the bar remains the same because the axis of the bar does not change. Twisting makes the edges stretch; the flat surfaces remain straight, although they have the appearance of being concave. A cross section of the twist will show the flat surfaces as straight.

The corner-to-corner diameter of a square is greater than the face-to-face diameter. Before twisting the bar, the corners and the faces are parallel to the axis. When twisted, the corners and faces revolve around the axis at an angle to the axis. The corners, having a greater radius than the faces, will protrude farther out from the axis of the twist than will the faces. The radii of the face gradually becomes less moving from the corner to the center of the face; a concave shape is then created between the corners while the faces remain straight.

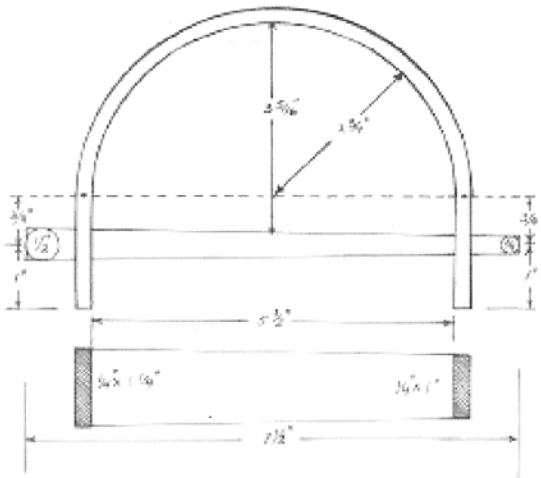


11. Forging dynamics of twisting.

Drawing, Punching, and Bending

By Peter Ross
Illustrations by Tom Latané

Lesson Number Six- Drawing Punching, and Bending



1. The final forged shape.

Definition: This lesson uses skills developed by previously published lessons.

Intent.

The student will learn to incorporate several basic skills into a single project while maintaining dimensional control.

Tools needed:

Basic tools plus tongs to hold 1/4" thick flat bar, tongs to hold 5/8" or 3/4" diameter on end, and punching tongs to hold punch (if using a short punch), center punch, rule, compasses.

Materials:

24" (or as convenient) of 1/4" x 1 1/4"

24" (or as convenient) of 1/2" square mild steel

5/8" or 3/4" tool steel to make two punches

Method.

It will take planning to achieve target dimensions. Let's start by thinking of the bent rectangular bar.

First, the bar must be the right length and the two holes correctly placed. If the bar is forged to proper length, the bending will be simple. We can accurately compute the overall length and the distance between holes from the plan (see lesson Four, Bending, *Hammer's Blow*, Volume 11, #2, Spring 2003). This will give us the "straightened" layout of the bar. With this layout established, the choice of steps can begin.

In planning a project, it is wise to do the less-predictable operations early and do the more predictable ones later. By "predictable" I mean in the dimensional sense- not the skills of the workman.

For example, forging a taper of precise length can be done with certainty (using the method learned in lesson one, *Hammer's Blow*, Volume 11, #1, Winter 2003), but it is difficult to predict how much stretching will occur while punching holes. If we punch early in the sequence, the uncertain effects on dimensions are resolved before drawing to final length. Maintaining correct dimensions will be simpler and more direct. Making the round tapered pin will not affect the dimensions or fit of the flat bar, and can be done independently.

Step One:

Make two punches, each with a 4"-long round taper. One should end in 3/16" diameter and the other end in 3/8" diameter. Be certain that the entire taper is carefully forged and truly round. Any irregularities in the tool will transfer to the work.

Review Lesson #3 (drawing a round taper) if necessary.

Previous lessons have involved only mild steel, but for this exercise, we will need something tougher for the punch. If the punch is made of mild steel it will likely bend in use. Using a harder steel, even if it is not hardened and tempered, will make a more durable tool. At this beginning stage, I recommend avoiding more exotic and expensive tool steels. A very serviceable punch can be made from the simplest tools steels (such as W-1) and they will be much more forgiving for the beginner to use. The drawback of simple steels is that they are softer and will deform more easily during use, especially if they get hot. Good technique will enable you to use them with very little problem.

If you would rather not buy new steel, you may use a piece of scrap (such as a piece of coil spring) of appropriate thickness.

2. Flat bar in its unbent layout.

Step Two:

We will start with the flat bar.

Refer to the drawing of this project for dimensions and calculate the length of the flat bar before bending. Also determine the distance between holes. Review this procedure in Lesson Four (Bending) if necessary.

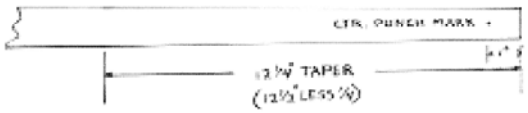
It is often a good idea to make a simple sketch of the piece as it should look before bending with these dimensions noted. At this stage, it is nothing more than a tapered flat bar with two holes.

Begin by forging a taper on the end of the flat bar. This taper does not end in a point, so draw the end of the bar only until

you reach the target dimension- in this case, 1/4" x 1". Square the end by upsetting if necessary. Once you have forged the end to dimension, work your way back up the bar until you have a straight, even taper 1/4" shorter than the desired length. This will allow for some stretching during punching and final corrections.

Hints:

Do not draw the bar too thin, as this is the hardest fault to correct. Any areas that are too thin must be upset to proper thickness. Refer to the lesson on upsetting if necessary.



3. The marked bar.

Targets:

Make sure the bar is an even 1/4 " thick the entire length of the taper. Variation should be 1/64" or less.

Hold length tolerance within 1/16"

Make the taper as smooth and straight as if it were the end of the project.

Step Three:

Measure from the small end to find the location of the small hole. Using the center punch, mark the location. Make a deep mark so that it will be clearly visible when the bar is hot.

Take a heat and punch the small hole.

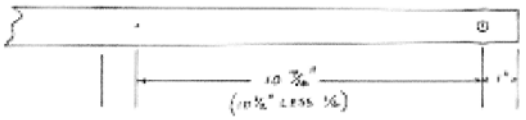
Drift the hole to 9/32" diameter using the punch.

Refer to lesson 2 (Hot Punching) if necessary.

Hints:

It is a good idea to mark the bar when cold (or mostly). This will avoid errors caused by measuring a hot, expanded bar: after the bar cools and shrinks, the marks can be off by as much as 1/8". Also, using the center punch on hot material may draw the temper from the small tip.

Targets:



4. The layout of the second hole.

Punch and drift the hole in the same heat. Since the punch is close to the final hole size, this should not be difficult. After drifting, the bar should be at a low heat and ready for smoothing. For this project, it will be acceptable to leave the bulge around the hole.

With practice you should be able to punch, drift, and smooth the bar in one heat.

Step Four:

Using the center of the first hole as the starting point, measure for the location of the second. Punch and drift the second hole to 1/2" diameter.

Hints:

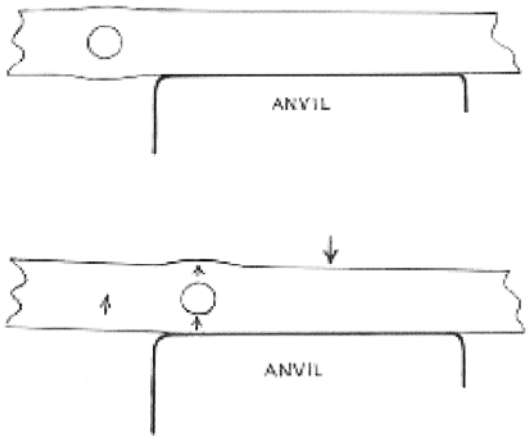
Rather than center punching the exact location, make the mark approximately 1/16" too close to the first hole. This will allow for inevitable stretching, and decrease the chance of the holes being too far apart. If there is any error to correct, it will be much easier to stretch the bar a little than to shorten it.

A more accurate measurement can be made when the bar is cool.

With the second hole finished, measure between the holes and correct the taper length to match the dimensions on your sketch. Final measurement is best done with the bar below a red heat, to minimize errors. This is also the time to make sure the taper is straight and even and the surfaces smooth.

For this project, the bulging of the bar edges around the punched holes may be left as is.

Once the holes have been punched and the bulges created, it is very important not to let the bulge rest on the anvil even when working in the middle of the taper. With a bulge on the anvil, the taper will not rest squarely on the anvil face. A hammer blow



5. Proper placement of the bar.

in this condition will bend the bar and squash the hole. This is an example of an idea presented in lesson one: the bar is squeezed by the hammer and the anvil simultaneously. You must think of what the anvil will do whenever positioning the bar.

Targets:

Hold length tolerances of each section to plus or minus 1/32", and overall length to within 1/16".

Step Five:

Now that final length is established, the piece can be cut from the bar. Make a mark on the face of the bar with the center punch, or on the edge with the hardie. Take a heat, and using the hardie, cut the piece from the bar.

Hints:

It is helpful to cut before bending for two reasons: first, if we are going to dress the end of the bar with the hammer, this is the last convenient time. Once the bar is bent, it will be impossible.

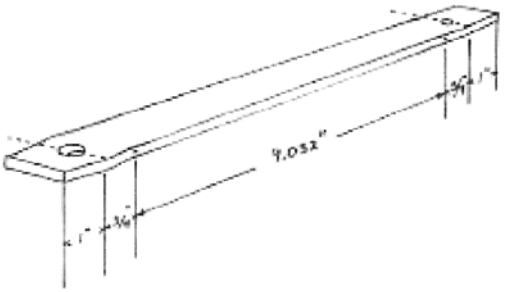
Second, cutting would deform the bend if it were already done. We would have to do the work all over again.

Careful cutting will keep the end of the bar as square as possible and make upsetting easier. Since this is a rectangular bar, it will help to cut part way through from all four sides. The intent is to keep the resulting burr as small as possible and centered on the end. If you cut equally from opposite sides rather than mostly from one side this will happen.

From this point onwards, it will be necessary to hold the piece with tongs. Simple flat jaw tongs will work well for this project. Most tongs are made to fit one size bar, though they sometimes will hold several additional sizes adequately. To check to see if tongs fit properly, the jaws should be parallel at the thickness of the bar. Thus, the jaws will contact the bar for the entire length of the jaw. Conveniently, one pair of tongs sized to hold 1/4" thick flat bar will hold the piece at either end, or anywhere in between.

Hints:

It may be necessary to square the end after cutting. If so, make sure to quench everything except the end itself to prevent undoing the accurate dimensions already achieved.



7. The bar with punch marks on edge.

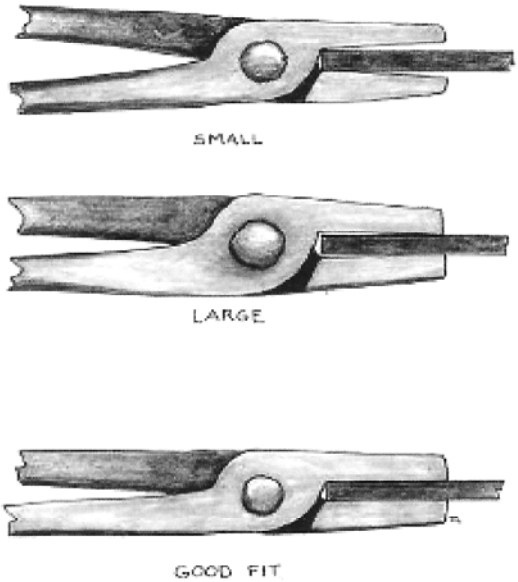
In preparation for the final step, it may be helpful to mark the limits of the bend (see Lesson 4, Bending) on the edge of the bar.

Step Six:

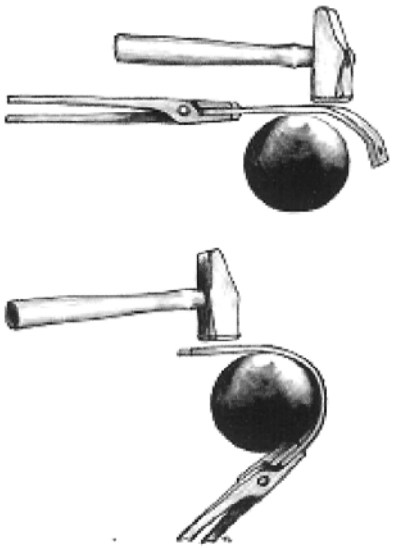
Bend the piece to match the given dimensions. Heat approximately one half the length of the bar and bend while holding the cold end in the tongs. Once done, switch grip to the bent end, heat the second half, and finish the bending. Switch grip as often as necessary to make corrections and adjustments.

Hints:

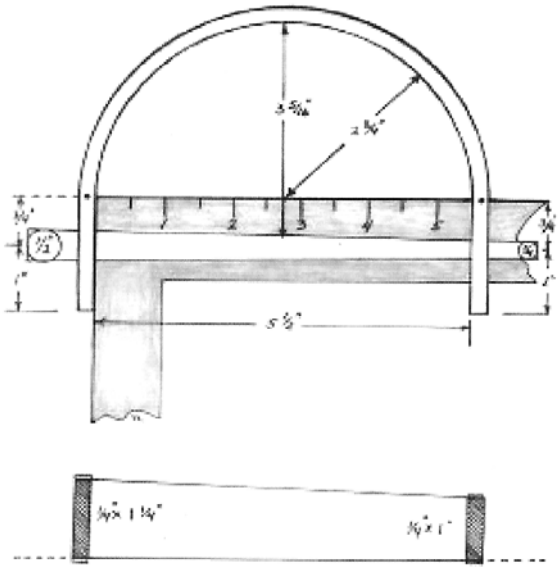
Since the bar is tapered, care must be used to get an even bend (it will bend more easily where it is smaller). If you have chosen to center punch the edges of the bar for reference it should be easy to determine if the bends start and stop at the correct places.



6. Proper and improper tong fit.



8. Manipulation of stock for bending on the horn.



9. A square can be used to assure that the curve begins and ends properly, to locate a center to check the curve, and to check that the straight ends are parallel. The sides of the curved bar should lie evenly on a flat surface except for the swelling around the punched holes.

Refer to Lesson Four (Bending) if necessary.

Remember, the two ends including the holes are not bent, but straight.

Targets:

The two straight sections at either end should be parallel in side and end views, and the correct distance apart. They should also be perpendicular to the imaginary "horizon" created by connecting the two dots.

With a straightedge connecting the two reference dots, check the radius of the bend and whether the ends are square.

Match the given dimensions within 1/16" or less.

Step Seven:

With the flat bar completed, it is time to make the tapered round pin.

Starting with 1/2" square bar, draw a round taper to match the given dimensions.

With the proper taper made, cut the piece from the bar and square the cut end if necessary.

Straighten and check for accuracy.

Hints:

Refer to Lesson Three (Drawing a Round Taper, *Hammer's Blow*, Volume 11, #2, Spring 2003) if necessary.

When cutting a round bar that is to have the end squared, cut evenly all the way around the bar. This will leave the resulting burr small and centered on the end.

Since you are using 1/2" square bar as a starting material, it is possible to make a pin which is larger than 1/2 " diameter. Therefore, use care in checking your progress.

Step Eight:

With both parts cool, slide the pin through the holes in the bent bar. The pin should stop close to the desired location, with close to correct amounts projecting from both holes. If the pin is round and straight, the distance between it and the top of the arc will remain constant even if the pin is rotated.

Check all given dimensions.

Hold tolerances to 1/16" or less

If you have made a full-size drawing, you can place the finished piece directly over it to check your results.

If the piece does not match the sketch, you can also figure out where the errors occurred; whether holes are in the right place, bending was accurate enough, or overall length was estimated correctly.

Work shop report

The hinge and handle workshop was held at the shop of Mike George in Alva, Okla. Mike made the hinges and handles for our 07' conference tool box and will be making the hardware for the 08' tool box.

The workshop participants was limited to 10 and it was full. Mike has a small shop, and it was close but we all managed to share the equipments and finish up a set of small hinges on Sat. The workshop was scheduled to continue on Sunday but most had to go home at the end of Saturday.

Mike started some of us out by having us clean and texture out metal. We were using metal about 22 gauge. To get a antique texture, we heated the metal in a forge fire until you have a nice layer of scale developed. If you hammer on it without removing the scale you can achieve a interesting texture effect. This is what we were wanting. This step was repeated across the surface of the metal. Next, after it cooled, we sanded the surface to remove the remaining scale and reveal the mottled look of the metal.

We also had to cut out the pattern. Then when the metal was ready, glue the pattern down to it. We could then cut it out using a band saw or metal shears. While some were working with the sheet metal, others were making the fixture for turning the eye of the hinge. This is a block of metal that has a hole drilled in it that is large enough for the pin and 2x the thickness of the metal.

When the metal is all cut out you then need to do a lot of filing or grinding to get the edges smooth and refine any curves.

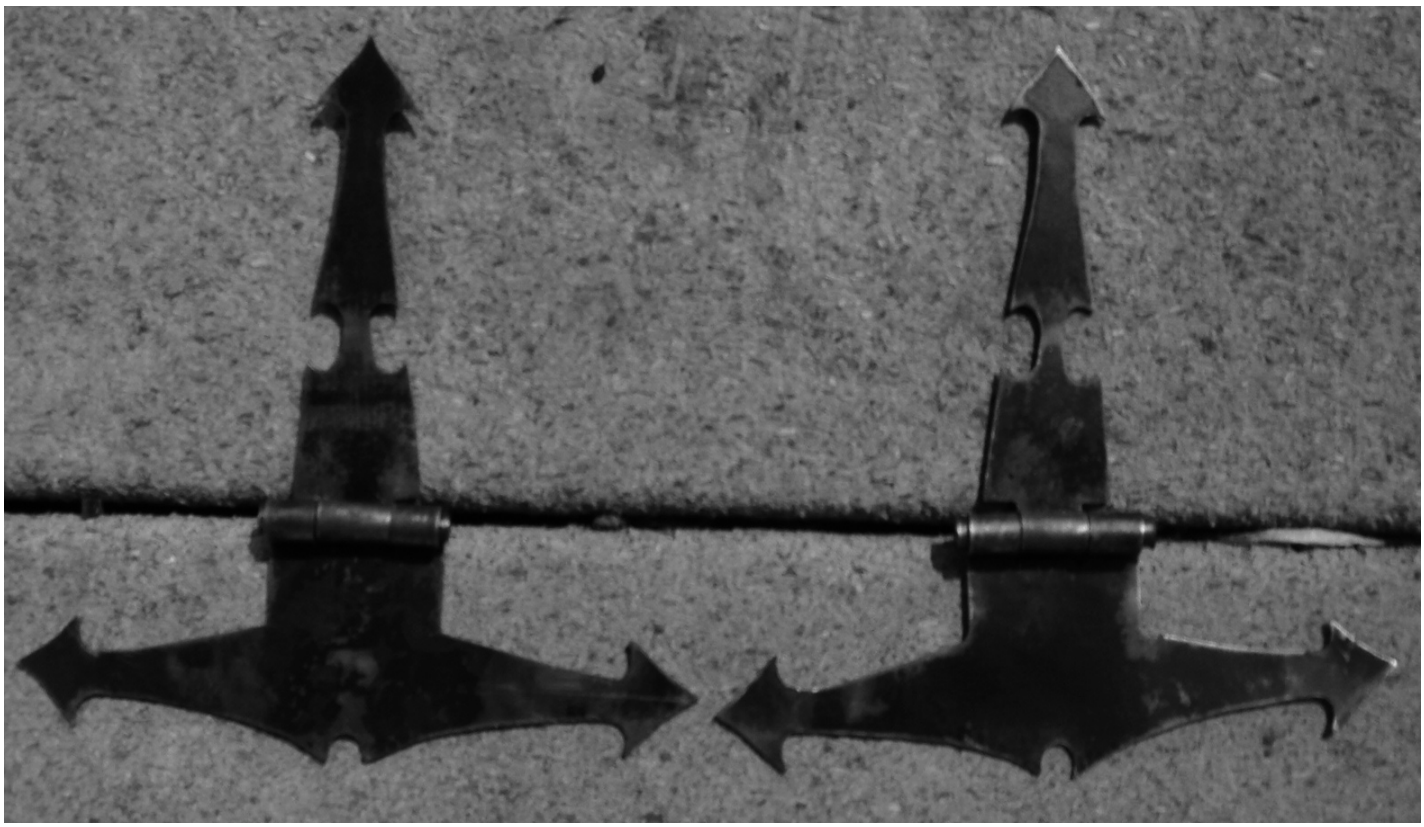
.

For lunch we all loaded up and went to the local Dairy Queen for a burger and fries. Maredeth provided coffee and desert during the day so all we had to do was go inside and help ourselves.

Those that had one brought a old saw vice. These worked perfect for hold the metal for filing. We also used an assortment of round and flat files.

Getting it all together….

Once we had all the parts ready, it was time to start the assembly process. Using the block that you made to fit your pin and thickness of metal you clamped the hinge in a vice and used the block to form the round eye of the hinge. This was repeated for each section. You then had to do some trimming to finish up the eyes so they would fit together. The final part was to put the pin in place and upset the ends so that it wouldn't fall back out.



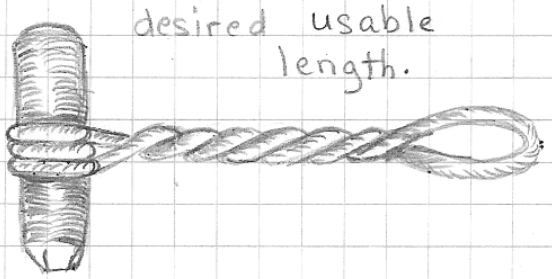
Sketchbook

dld

Hot Stamp
As done By Bill Davis

Start with a piece of medium or high carbon steel with a diameter large enough for your design.

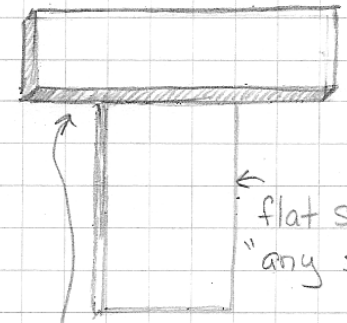
Customize with a handle or cut to a desired usable length.



Suggestions: 

 if you can draw it, it can be made into a stamp.

flat stock welded together to form guide



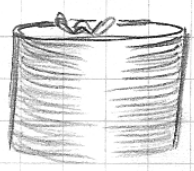
this piece needs to be the right thickness to align stamp up with center of rod. different size letter stamps will require different thickness of guide.

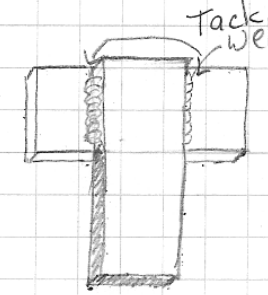
Material needs to be annealed to prevent damage to lettering stamps. Some letters are the same forward and reversed. otherwise you need a set of reverse stamps.

A guide will help you center your stamps and keep multiple letters in a straight line.

Remember to think backwards. If you want MW you need to stamp it  .

When stamping your letters into the rod, metal is displaced out where the stamp enters. This metal must be filed off. Keep stamping and filing until stamp is as deep as you want it. The deeper the letters are the clearer they will be when stamped into HOT metal.



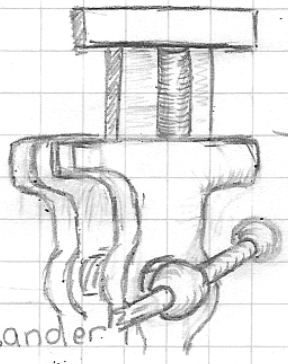


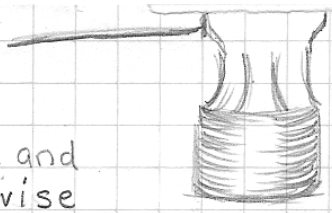
5/8" x 8" Long annealed med. to High carbon steel

grind or file end Flat

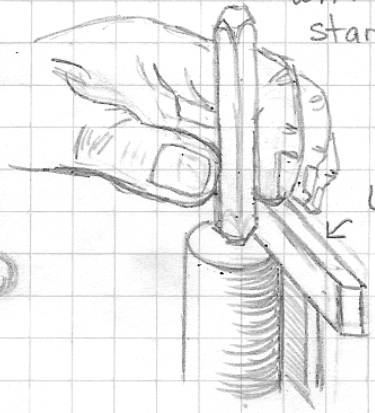
Belt sander

Place rod and guide in vise

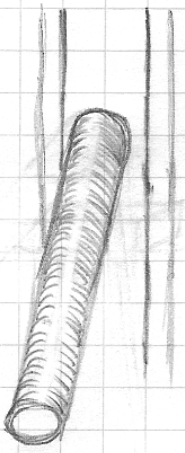




lettering is done with reverse stamps.

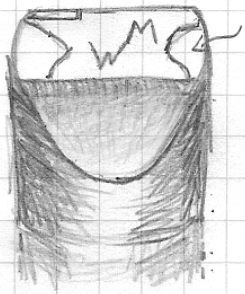


Use a guide to help center stamps on Rod.

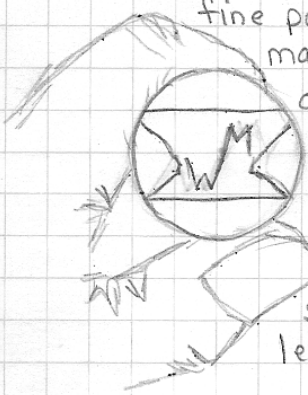


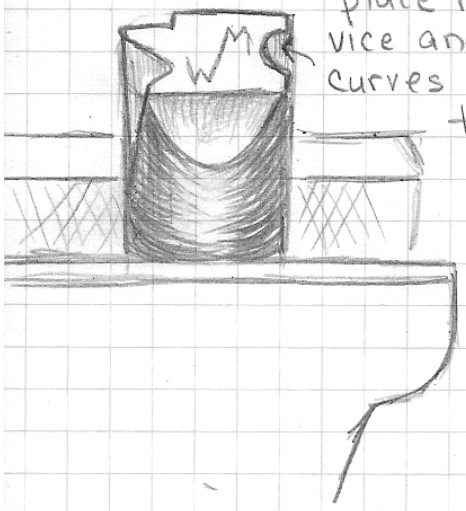
Start by grinding or filing flat areas.

then use a file or dremel to start to rough in other parts of design

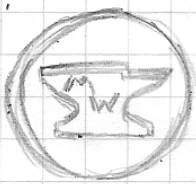


after stamping, use fine point marker to draw shape to be ground around stamped letters.





place rod in vice and smooth edges of curves and flat areas of the design to finish.



to test stamp during filing, stamp into lead.

when stamp is finished Rod can be cut to desired length. Heat treat the stamp end according to the requirements for the steel used. DO NOT treat the end of the rod that will be struck with hammer.

Saltfork Craftsmen

Artist-Blacksmith Association
Membership Application
April 2008 thru March 2009

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, 2009

*Signed*_____

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

ABANA

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