

# Saltfork Craftsmen Artist-Blacksmith Association

June 2007

Happy Father's Day



Little Men from RR Spikes by Bill Davis

Saltfork Craftsmen  
Artist-Blacksmith Association  
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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](http://www.saltforkcraftsmen.org)

Trading Post

**For Sale:**

3/4" round bar of 5160 (\$3.30 per foot plus shipping)  
3/4" and 1" round bar of 52100 (\$6.00 and \$9.45 per foot plus shipping) Contact Ray Kirk,  
[ray@rakerknives.com](mailto:ray@rakerknives.com) or 1-918-456-1519

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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 broomcorn brooms on your handle or mine. \$20.00 plus shipping. Contact Diana Davis, [lazyassforge@tds.net](mailto:lazyassforge@tds.net) or 1-580-549-6824

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NEW 50# air hammer. \$1600.00 the air hammer is home made. The air system is set up similar to a Big Blu hammer. The rest of the hammer is my own design. It has two sets of dies, one set of flat and one set of draw. For information contact Anthony Niernberger at 918-527-8074 or [antsct@netzero.com](mailto:antsct@netzero.com)

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Rebuilt Little Giant Trip Hammers! Better than New! 25#-\$3495; 50#-\$4595; Misc. leg vices and hand cranked and electric blowers. Contact Mike George at 1-580-327-5235 or [Mike-marideth@sbcglobal.net](mailto:Mike-marideth@sbcglobal.net)

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For Sale, like new JHM Manufacturing "Certifier" 100 pound anvil. New these are about \$500; this one is \$375 Photos and more information; Jim Carothers 580-336-9213 or [frontiershop@wildblue.net](mailto:frontiershop@wildblue.net)

**Wanted:**

Advertising Coal Hammers, Contact Mike George at 1-580-327-5235 or [Mike-Marideth@sbcglobal.net](mailto:Mike-Marideth@sbcglobal.net)

**Send your ads to Diana Davis, 23966 NE Wolf Rd. Fletcher, Okla. 73541 or email them to [lazyassforge@tds.net](mailto:lazyassforge@tds.net)**

## Club Coal

Saltfork Craftsmen have Arkansas coal for sale. The coal is \$95/ton to members and \$145/ton to non-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.

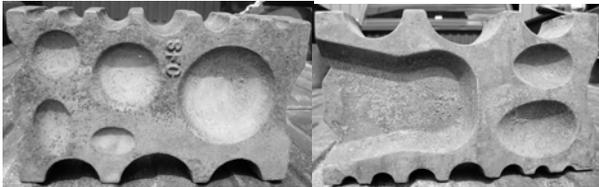
**S/C Region coal location:** Coal is in 1-2" size pieces. Bring your own container. The coal is at Max Scrudder's place in Mountain View. Contact Max for load out instructions.

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

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Saltfork Craftsmen Swage Blocks \$95.00 each plus shipping. SCABA members can purchase one block for a special members price of \$75.00

Contact Mike George at 1-580-327-5235 or [mike-marideth@sbcglobal.net](mailto:mike-marideth@sbcglobal.net) or Bill Kendall at 1-918-742-7836 or [wwkendall@aol.com](mailto:wwkendall@aol.com)



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

## Library List

Title
SCABA Conf - 2002 - Bill Bastas
A Traditional Suite: Sword Making, Set Hammer
A Water Powered Smithy
ABANA Comes of Age - 1994 NOMM Exhibit
ABANA Comes of Age - 1994 NOMM Exhibit
Basic Blacksmithing - Hershel House (Part 1)
Basic Blacksmithing - Hershel House (Part 2)
Basic Blacksmithing - Hershel House (Part 3)
Forge Welding - Bob Patrick
SCABA Conf - 1997 - Frank Turley (Tools)
Hammerman in Williamsburg
Jerry Darnell - 18th Century Lighting (Part 1)
Jerry Darnell - 18th Century Lighting (Part 2)
Jerry Darnell - 18th Century Lighting (Part 3)
Jerry Darnell - 18th Century Hdw - Latches
Jerry Darnell - 18th Century Hdw - Hinges
Jerry Darnell - 18th Century Hdw - Pintles

SCABA Conf - 2001 - Jim & Kathleen Poor
Jim Hrisoulas - Damascus Pt 1
Jim Hrisoulas - Damascus Pt 2
Omey's 2002 - Kendall & Dyer - Table
SCABA Conf - 1998 - D. Steigler - Baskets
SCABA Conf - 1998 - R. Gunter - Hammers
SCABA Conf - 1998 - D. Steigler - Iris & Finishes
SCABA Conf - 1998 - R. Gunter - Hollow Forging
SCABA Conf - 1998 - D. Steigler - Repousse'
SCABA Conf - 1998 - R. Gunter - Scrolls
Samuel Yellin's Legacy
Omey's - 1997 - Ted Sawyer
Omey's - 1997
The Loveless Legend
Tom Smith at Hartdner, KS
Yellin Foundation & Manfred Bredohl
Allen Rogers - Projects
Forge & Anvil - Various Episodes
Unknown Conference - Unknown Smiths
Broom Making for the Blacksmith
Elmer Roush: Colonial American Hdw & Fixtures
European Masters & The Woodwright's Shop
ABANA Gallery Exhibit - 1992
Doug Merkel: Misc Projects
Doug Merkel: Nail Header
Doug Merkel: Sawtooth Trammel
Doug Merkel: Tomahawk & Misc
Doug Merkel: Hammers
Blacksmith's Journal Techniques - 1
Blacksmith's Journal Techniques - 2
Bill Epps - Tongs
Bill Epps - Animal Heads
Bill Epps - Animal Heads
Bill Epps - Birds & Bugs
Bill Epps - Leaves & Flowers
(RD1) 1990 Metal Madness
(RD2) Ivan Bailey & Paul Hubler
(RD9) 1992 BAM Ozark Conference
(RD69) 2002 UMBA Conference
(RD79) 2003 UMBA Conference
Knifemaking With William White
(RD 82) Wagon Wheel, Marble Inlay, Strikers
National Museum of Horse Shoeing Tools
SCABA Conf - 2004 - Don MacKay
SCABA Conf - 2004 - Bob Patrick
SCABA Conf - 2005 - Peter Happny
SCABA Conf - 2005 - Brian Gilbert
SCABA Conf - 2006 - Tal Harris
SCABA Conf - 2006 - Ed & Brian Brazeal
SCABA South Central Meetings - 2004

**Saltfork Craftsmen**  
Artist-Blacksmith Association  
Membership Application  
April 2007 thru March 2008

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, 2008

Signed \_\_\_\_\_

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



**ABANA**

Name: \_\_\_\_\_

e-mail: \_\_\_\_\_

Address: \_\_\_\_\_

www url: \_\_\_\_\_

City: \_\_\_\_\_

Phone: \_\_\_\_\_

State: \_\_\_\_\_ Zip/PC: \_\_\_\_\_

Fax: \_\_\_\_\_

Country : \_\_\_\_\_

Type of Membership  New Member  Renewal

Credit Card Information \_\_\_\_\_

Regular - \$45.00  Contributing - \$100

Visa  Mastercard Expiration Date: \_\_\_\_\_

Student - \$35.00  Library - \$35.00

Card # \_\_\_\_\_

Senior (65+) - \$40.00

Submit check, money order (U.S. banks only), or by credit card: \_\_\_\_\_

Foreign - \$65.00

ABANA affiliate: \_\_\_\_\_

LeeAnn Mitchell

P.O. Box 816  
Farmington, GA 30638

Phone: 706.310.1030

Fax: 706.769.7147

Application may also be made at the ABANA  
web site: [www.abana.org](http://www.abana.org)

**M E M B E R S H I P   A P P L I C A T I O N**

## Meeting schedule

### June

**SE Regional meeting (June 2<sup>nd</sup>)** The meeting will be hosted by Duane Goodin at 140 Pecan Street, Blossom, Texas. Bring your forges, anvils and a sack lunch and plan to enjoy the day. For more information you can call Duane at 903-491-1177

**NE Regional meeting (open)**

**South/Central meeting (June 16<sup>th</sup>)** Larry Morefield is hosting the meeting at his shop in Medicine Park. He has chosen "something with a leaf" as the trade item. Lunch will be beans and cornbread cooked by the Marauders. Bring a side dish if you like.

**NW Regional meeting (June 23<sup>rd</sup>)** The meeting is hosted by John Burns. Trade item is a letter opener. Lunch will be provided but please bring a side dish to help out.

### July

**NE Regional meeting (open)**

**South/Central meeting (July 21<sup>st</sup>)** Hosted by Max Scrudder. Trade item is wall hanger

**NW Regional meeting (open)**

### August

**NE Regional meeting (open)**

**South/Central meeting (Aug 18<sup>th</sup>)** Hosted by Gregory George.

**NW Regional meeting (open)**

### Sept.

**NE Regional meeting (open)**

**South/Central meeting (Sept. 15<sup>th</sup>)** Hosted by Terry Jenkins/Sulphur tractor show

**NW Regional meeting (Sept. 22<sup>nd</sup>)** Hosted by Dorvan Ivey, Hammon, Okla.

### Oct.

**NE Regional meeting (open)**

**South/Central meeting (Oct. 20<sup>th</sup>)** Hosted by Aniela Hadick, trade item is a doorknocker

**NW Regional meeting (open)**

### 2007 Demo request

- **Oklahoma Pioneer Exposition** (June 1-2) Cleveland County Fairgrounds, Norman Oklahoma

- **Comanche Old West Fest.** (June 9<sup>th</sup>) The festival will be held at Field of Dreams Park, which is located on the west side of town south of the public school buildings. The city of Comanche is also hosting the Oklahoma Freewheel bicycle rally. Anticipated crowd size is 1500. Good opportunity to sell you iron work and demonstrate to the public.

- **Pawnee Bill Ranch Museum events:**

The Wild West Show dates are June 16, 23, and 30<sup>th</sup>. We have set the date for Heritage Skills on October 13. We also have a blacksmithing workshop tentatively planned for May 12. I think that Brandon can teach this class on May 12, but we would love to have an additional person as well depending on the class size. The Centennial Wild West Show is anticipated to be a pretty big event –your group's involvement with our demonstrations on the hill is so important to us! We couldn't do it without you guys.

- **Sulphur tractor show**

Sept. 15, 2007. Terry Jenkins is hosting a S/C regional meeting at this event. Here again is another opportunity to show the public what blacksmithing is and to sell some of your work.

- **Okla. Antique Tractor Assoc & Classic Stock Tractor Assoc. joint show.** Sept 28-30 In Broken Arrow. At 121<sup>st</sup> & Garnett. More info at [www.oata116.com](http://www.oata116.com)



Saltfork Craftsmen members Jim Carothers, Adam Hall, Tom Nelson and others helped Boy Scout Troop 850 of Guthrie during a Metalwork merit badge campout at the Ricking HF Ranch in Guthrie.

## HEAT TREATING STEEL - QUICK GUIDE

Temperatures in degrees Fahrenheit

Type of Steel	1045	1095	4140	5160	52100	L6	O1	A2	H13	S1	S7
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Quenching Medium	Water	Water	W&Oil	Oil	Oil	Oil	Oil	Air	Air	Air/Oil	Air/Oil
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<b>Forging:</b>											
Preheat	None	None	1250	None	None	None	None	1250	1400	None	None
Not Over	2275	2100	2250	2200	2100	2000	1950	2000	2100	2050	2050
Not Under	1600	1500	1600	1600	1700	1550	1550	1700	1650	1600	1700

<b>Normalizing (Air)</b>	1650	1575	1600	1600	1625	1600	1600	Do Not	Do Not	Do Not	Do Not
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<b>Annealing:</b>	1550	1475	1550	1450	1450	1400	1400	1800	1600	1475	1500
Down To	1200	1200	1200	1200	1275	1000	1275	1000	1000	1000	950
Max. Drop/Hour	50	50	25	Air Cool	10	40	40	20	50	40	25

<b>Preheat soak - Hardening Temp.</b>	None 1550	None 1475	None 1575	None 1525	None 1550	None 1550	1200 1475	1200 1750	1175 1700	1200 1700	1250 1725
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<b>Low temperature required before tempering:</b>	100	150	150	150	125	125	175	150	125	150	150
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<b>Tempering: after quenching, temper all to at least 300 degrees F</b>											
45RC	600	800	750	425	800	1000	Not Rec	1200	1100	1100	1150
50RC	400	700	600	350	650	900	Not Rec	900	1050	800	875
55RC	as quenched	600	as quenched	300	500	700	600	550	as quenched	450	600
60RC		400		as quenched	350	400	475	400		as quenched	300
62RC or higher		as quenched			as quenched	as quenched	as quenched	as quenched		as quenched	as quenched

Industrial heat treating practices such as soak times, variations for steel thickness, alternate hardening temperatures, alternate quenching mediums and temperatures, various annealing practices, and more accurate tempering temperatures will be found in each companies Data Sheets. This quick guide is developed with the blacksmith and his typical equipment in mind.

Don't forget about our toolbox for this year's conference. Pictured is last years box. It was a great success and we plan to repeat it again this year. Adam has agreed to make us another box and we need everyone to try to make something to help fill it up. Any tool that you can think of is needed for the box. All donations are appreciated. .

Diana Davis  
Tool Box Raffle Chairperson

**Tool Box list:**

Hacksaw  
Rounding  
Hammer  
Tongs  
Punches  
Slitting Chisel  
Cross Peen  
Hammer  
Straight Peen  
Hammer  
Scrolling Tongs  
Cold chisel  
Twisting Wrench  
Bending forks  
Wire Brushes  
Files with handles

And anything else you can think of.

We need tools ready by the last meeting date in Sept. so that they can be collected and put with the box by the SCABA Conference that is Oct 13 and 14. For more information contact Diana Davis at 580-549-6824 or email at [Lazyassforge@tds.net](mailto:Lazyassforge@tds.net)



## Elementary School Demo at Fort Sill

By Gerald Franklin

On Thursday, April 26<sup>th</sup>, I responded to an invitation to demonstrate at the Geronimo Road

Elementary School's Western Encampment Day. A Geronimo Road teacher, Mr. Dan Wilmore, really went all out to put together a great program for the students and teachers. There were gunfighters, stagecoaches, storytellers, chuck wagons, and of course, a blacksmith.

I was asked to set up whenever I wanted on the school grounds. After a quick survey, I decided to stake myself out within a few feet of Walker and Linda Ryan's chuck wagon. Walker and Linda have been feeding me at these events for a few years and I have never left hungry. They really put on a good feed and I wanted to stay close to the chow.

After I got set up, I stole some fire from one of Linda's cooking fires to get the forge going. Then the press showed up. After a little mugging for the newspaper guys and the TV reporters, it was down to work for the first of ten separate demos for the day. As with most school demos, the item of choice was an S-Hook. I varied it a little as the groups cycled through, though, and forged some drive hooks and a couple of leaves to break up the routine. It was my intent to give each teacher a hook or a leaf for their classroom until I found out that there are close to fifty teachers at the school. I settled on forging a large "G" (Geronimo, get it?) out of 3/8" round to give to Mr. Wilmore to hang on the wall in the entry of the school. All in all it was a good demo with lots of interested students and teachers and lots of good chuck wagon food. By the way, SCABA was invited back for next year's event, so I may be hitting some of you up to go with me so that we can lay out an even larger smithing array.

## Sad news

Doug Hendrickson lost his battle with ALS (Lou Gehrig's Disease) at 7:30 am on 5/5/07. His friends and the ABANA community will miss him.

Dorothy Stiegler

*Doug demonstrated at the SCABA 2000 conference at Guthrie, Oklahoma*

There is a memorial service for Doug at the funeral home in Lesterville Sat. May 12 at 11 a.m. For more information go to

<http://www.peolavalley.com/>

Ed & Mara Harper

# Horseshoe Nail Cross



**Horseshoe Nail Cross by Bill Clemens** – Made from 4 size 16 Nails the finished cross is approximately 2 1/2 “ long

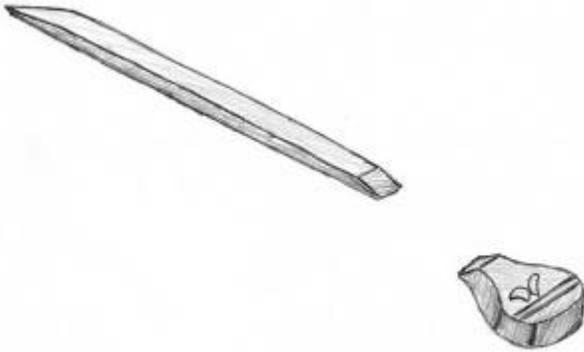
**By Bill Clemens**

I was ask by our minister to repair a cross pendant that he always wears. He has had it for over 10 years and it was a gift from his wife. It appeared to be made from horseshoe nails but close examination revealed that it was cast of some soft but unknown alloy. He had tried to super glue it back together but it didn't hold. It was while trying to remove the super glue residue in preparation to solder the cross back together that I determined just how soft the metal was and that's when I decided that I would first try to make a replacement cross from actual horse shoe nails just in case I couldn't repair his cast cross.

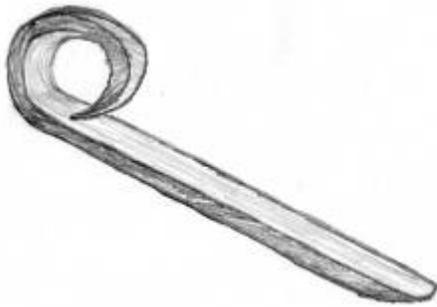
**What** follows are the steps I took to make a cross pendant by forge welding 4 horseshoe nails together. So far I've only made three crosses and I've learned something with each one I've made. If you make one I'd love to hear about it and if you come up with any refinements to these instructions let me know that too.

I started with 4 number 16 Mustad horseshoe nails. I determined the size by comparing the cast cross to a size chart on the Internet. Three nails make up the cross and a fourth one with the head removed is used to make the loop for hanging it.

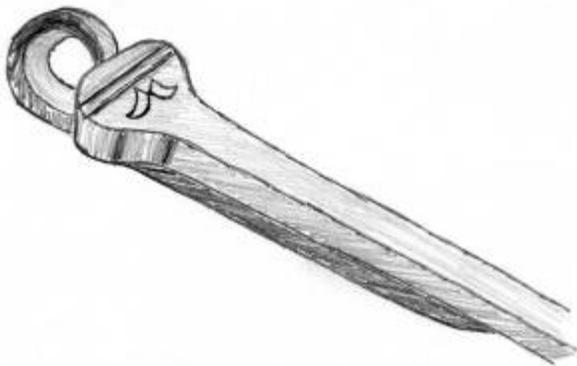
**Begin** by cutting the head off one of the nails and forming a scarf by forging a short taper on the end. Also the nails are tapered along its length and since you'll be placing the nail upside down behind the central nail of the cross, you'll need to taper it to match and thin it at the head end.



**Turn** the nail over and form the loop. Forming the loop before forge welding it to the back of the central nail gives you a means of positioning the two nails for welding and protects the tapered point while in the forge.



**Place** the loop tight against and behind the head of a second nail. After the cross is completed you can reposition the loop slightly so it is not tight against the head.

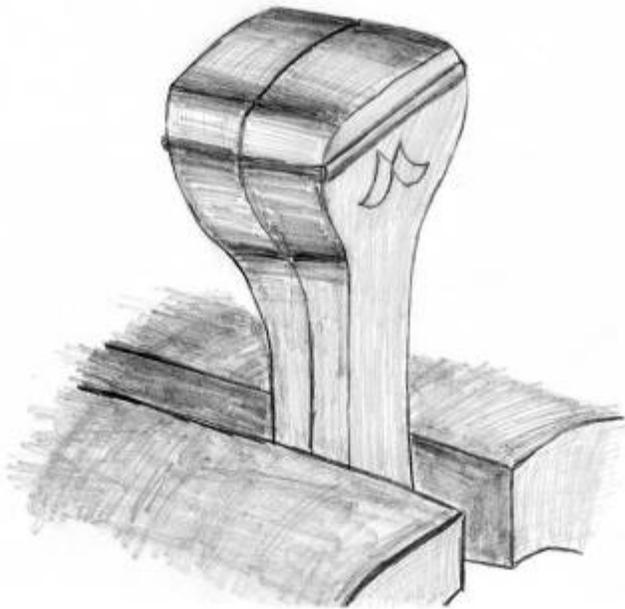


**Hold** the nails by the head and loop. I used a pair of Round bit Farrier's Fire Tongs that have domed bits that will accommodate the head and loop while holding the two nails firmly just below the head and used a tong clip to hold them secure.

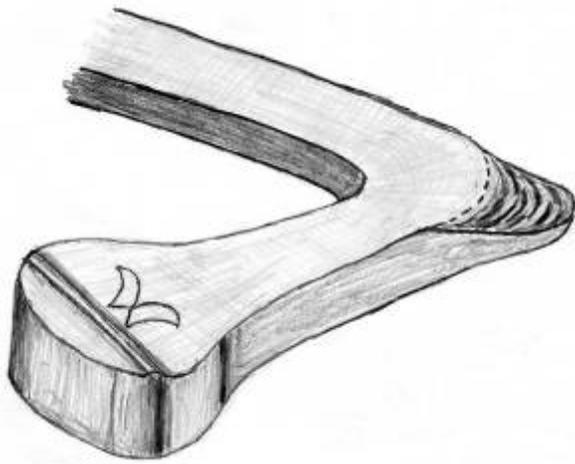


**You** need a small clean fire and a slow airflow. Place the nails in the forge and heat to orange, brush and flux. After fluxing insure the nails are in contact along their length. Return to the fire and heat slowly rotating them to insure uniform heat. At welding heat remove from fire and tap gently. If done right, the pieces have actually welded in the fire and your gentle taps are just to make sure the weld is complete, any small gaps are closed, and any remaining flux is expelled from the weld joint. This is fire welding as opposed to hammer welding where the two pieces to be joined are heated separately in the forge fire and joined at the anvil with hammer blows. Once welded you may remove the tongs and place the head and loop end in the fire to complete the weld on the remainder of the shank and at the head. Take care not to burn the thin loop or to distort it with a misplaced hammer blow. These welds are an exercise in both fire management and hammer control.

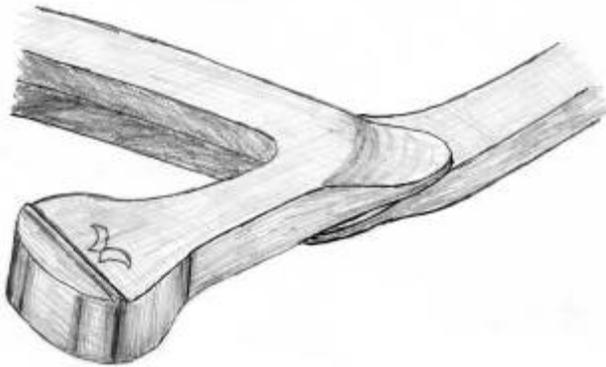
**Lay** this piece aside and take the remaining two nails and place them back-to-back. You might want to practice placing them in a vise like this while still cold. You want about one inch protruding above the vise. With a hammer form a 90-degree bend in both nails. By placing them back-to-back in the vise you are ensuring that both arms of the cross will be the same length.



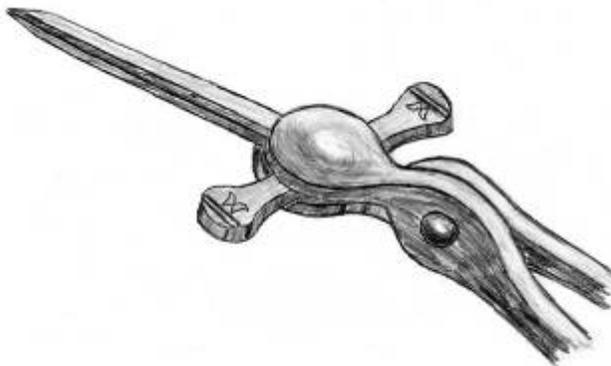
**Square** up the bend on each nail independently making the inside corner as tight as possible but be careful that the lengths of both arm remains the same. Forge a scarf on each nail as shown here.



**Forge** the scarf on one nail face up and the other face down, so that when the two nails are placed together (both face up with their shanks on top of each other) their scarfs will over lap as shown here.



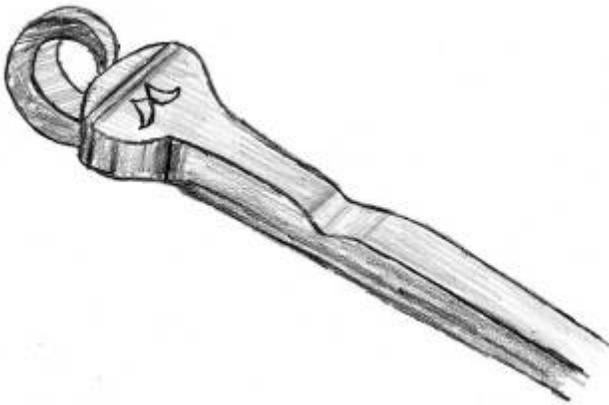
**Place** the nails in tongs and weld the points first following the same procedures as for the central nail and loop.



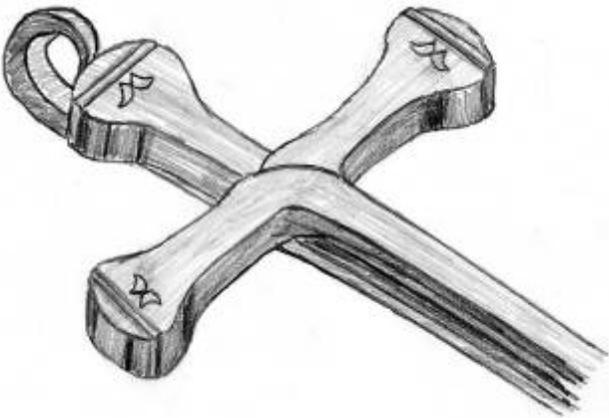
**While** completing the weld on the top of these nails forge a scarf from the backside as shown. First make sure the thin tops of the arms are flush on the front and then thin the shaft below the arms leaving a “bulge” on the lower half of the arms.



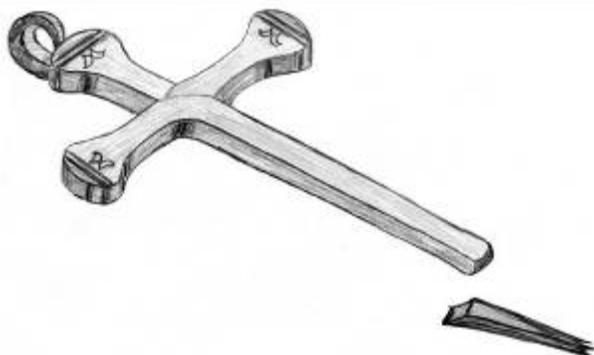
**Align** the arms on the central nail and forge a slight indentation to accept the bulge on the arms.



**With** the arms and central shaft positioned repeat the forge welding process one last time to join the two parts of the cross together. Again after welding, thin the central shaft of the cross below the arms while maintaining the proper width and cleaning up the sides.



**Trim** the bottom of the cross to 2 and 3/4 inches and then upset the bottom end leaving only a slight taper (if any) in the width and thickness of the bottom of the cross with a slight swelling at the very bottom.



**Oh**, and remember that cast cross I set out to repair? Well I did finally get the two broken pieces back together but not without making three pieces out of two first. With persistence I finally coaxed the three pieces back together with solder and after some grinding with a Dremmel tool, filing and sanding, it looks almost like brand new:



Broken

Repaired



### **Horseshoe Nail Heart Pendant**



## Western Spirit Celebration – 2007

By Gerald Franklin

On April 28th and 29th, Jerry Cathey and I demonstrated as part of the two week long Chisholm Trail Stampede at the Chisholm Trail Heritage Center in Duncan, OK. We were set up near the chuck wagons at the south side of the facility. Weather clear and sunny and turnout was good on both days. There were 20 to 30 onlookers at our forges for most of the day. Larry Morefield and a member of the “Marauders” came by for a while to help wave the Saltfork flag.



There was a lot going on at this event. Chuck Wagons, a herd of Longhorn cattle, Kowboy Kal and a horse-breaking demo were set up near us. Also Tim Poteete from the Museum of the Great Plains was there with a really good display of pelts and primitive “mountain man” firearms.

Several folks expressed an interest in Salt Fork Craftsmen so we may pick up a few new members from the effort. We set up display and sales tables and sales were good on both days. There were many other vendors there that were set up behind us that helped funnel the crowd past our forges.

One of the best things about the event is that I was approached by a chuck wagon cook to make a very simple but tough and useful Dutch Oven lid lifter. He had an example that he'd had for many years and wanted a new one. I copied the design, made some suggestions to improve it (of course), and made him one. He liked it and bought it. Some of the other cooks saw it and ordered four more for their wagons. I'll put an article together on the design and fabrication for a future newsletter.



## Tractor shows and School kids

Those two things don't seem to go together in this day and time but on Friday, April 27<sup>th</sup>, Max Scrudder, Gregory George and myself (Diana Davis) spent the day showing the students of the local schools around Mountain View the art of Blacksmithing. We had all the usual questions. Have you ever burnt yourself or what is that you are burning and why are you turning that crank. Also I think everyone of their fathers or grandfathers were blacksmiths.



Max Scrudder with Gregory in the background. It was a beautiful day. We did have to keep on constant watch for grass fires. Several times we would look down to see a growing area of flames erupting from below our forges. We kept the older boys that were hanging around busy helping us watch for fires.



Next to us was a display of farm tools. The kids were having fun trying to sharpen an ax on a large hand crank grinder. I am surprised someone didn't come up missing a few fingers, but they did all right.

Friday was school day so we didn't have very many adults come by but Max and Gregory George were going to return on Saturday to demonstrate for the rest of the Tractor Show attendees.



## And then....

Friday May 4<sup>th</sup> I helped Terry Jenkins, Larry Mills, Byron Doner and Ricky Nusbaum demonstrate for the students of NewCastle School. Larry Mills and myself were the first to arrive and we got started setting up. We were both hoping that the rest of the group hurried up and got there because we were expecting our first classes to arrive around 9:00 and it was getting close to that time. Everyone showed up and had their fires going pretty good when the kids started walking in. I think that every class came by at some time during the day. Some were interested in what we were doing and others were just glad to be out of class. The older ones kept me busy making the cowboy hats out of copper pennies. I think I made about 60 before the pennies ran out. Even had some of the kids digging in their pockets looking for pre-1981 pennies for me to use to make more.

Several newspapers came by and took pictures and interviewed us. I hope we made a favorable impression on them. You never know with those newspaper types.



# Perry, OK Rural Heritage Festival April 28, 2007

Saturday, April 28th was Rural Heritage Festival day in Perry. Saltfork members Adam Hall, Tom Nelson, Ralph Speece, and Jim Carothers provided smithing demonstrations and hands on tutoring at the Cherokee Strip Museum on Fir Avenue.



In addition to the outdoor smithies, there were a number of children's events



(including a May Pole), a rope maker, a sign maker that used branding iron letters, several cow trail camp sites, and a chuck wagon cooking demos.

Even though the week had been wet, the weather was really nice all day. We got the first forge going around 8 AM or so. The Museum grounds were a busy place all day long with lots of adults and children watching the blacksmiths; we did not tear down until well after 4 PM.



We had a good crowd all day, including two who wanted some hands on experience. As we had extra safety glasses, gloves, and aprons, their request was honored by time at the forge. I taught our "students" to make a simple drive

hook as in the <http://www.anvilfire.com> iForge Demo No. 20 – a favorite beginner's project. Our students were Shawn Henderson and Susan Nash. Shawn is from Morrison, OK; Susan is from West Warren, Massachusetts.

As well as the class project drive hook, Adam also made tiebacks for the curtains in his house. Seems like he is already getting started on the "domestication" road. Tom and Ralph made many other small items from old horseshoes and other scraps of steel. Ralph's hand forged knives were a very popular item. The Chris Fredrick crosses were very popular also. See <http://www.anvilfire.com> iForge Demo No. 79 for details of the cross.



For our demo work / participation in the Rural Heritage Festival, the Museum staff donated \$25 to the Saltfork Scholarship fund and offered the museum facilities for Saltfork use at any time.



Jim C.

## SE Regional meeting

Saltfork roared into Paris on May 8, 2007 and left a huge cloud of coal smoke and smiles in its wake! This was my first Saltfork meeting and I had only a few meetings from another blacksmithing group for comparison and, well, there is NO comparison! Led by Jim Carothers, Mike George, Tommy Dean, Byron Doner, David Seigriest, Gerald Franklin, Chip Barkman and others (I promise I'll learn everyone's name sooner or later), Saltfork put on truly historic blacksmithing demonstrations.



I was a bit apprehensive not knowing what kind of attendance we would have. This was an organizational meeting and even though

we had radio spots, great coverage from the Dollarsaver Shopper, The Paris News, Saltfork's web site and a host of other ads up in Oklahoma, you just never know who or how many will show up. In addition, this was my first time to host something like this so I didn't know what to expect.



All fears were soon put to rest as the coal smoke from the four forges began drifting upward among the downtown buildings and the crowd started to gather. A total of 50 raised their hands for the lunch count and brief, but informative, speeches by Jim

Carothers and Mike George about Saltfork's history and their vision for blacksmithing in the Red River Valley of NE Texas and SE Oklahoma.

The thing that impressed me the most was the reception from those attending who were not Saltfork (or other blacksmith group) members. By "reception," I mean their attention, interest and participation in the day's activities. Folks from all ages participated in one way or another and a

number of young men and women from Paris Junior College's art and jewelry schools took hammer in hand for a real "hot" learning experience. (PJC has



the foremost jewelry and horology school in the world.) However, for me, the hit of the day was 12 year-old Brazos White from Roxton, Texas. Mike George (and I think Chip Barkman) was giving him hands-on-

how-to instruction while his dad watched. He said that Brazos had agreed to sell his 4-wheeler in order to buy an anvil, forge and some other tools! Three cheers for Brazos!

After the smoke cleared, I looked around and you could see the satisfaction on the faces of the smiths who manned the forges - Jim, Mike, Chip, Tommy,

Byron, David and Tommy. They were the teachers, the heroes of the day. It is always a good feeling



when you can look back on a day's work and know you have been able to impart knowledge and create a spark of interest where it did not exist before. After all, blacksmithing is one

of those crafts that simply cannot be explained, it has to be experienced.

By James Allcorn

Bois D'arc Forge Blacksmith Shop



## Saltfork Members:

For quite sometime several of us on the Board of Directors have been thinking of other fund raising projects for Saltfork. As most of you know, our annual dues do not even begin to cover the cost of the Saltfork newsletter much less all the other services the club provides. We are looking for something like the swage blocks. On several occasions a floor cone mandrel has been suggested.

On a CAD system, I have one designed that will be about the size of a highway department construction cone. This cone mandrel is hollow, sits on three feet (pads) at the base, and the upper tip (3 to 4") is solid. The finished cone would weigh right at 70 pounds; the UPS shipping limit is 75 pounds. We could have heavy duty shipping boxes made for this item as we did for the swage blocks.

OK so far so good. The problem is the foundry pattern cost for the cone mandrel. The overall pattern system would have to include a core as well as the pattern for the outside shell. Professional foundry pattern work is very expensive. We are likely looking at a cost of \$1800 to \$2600 for the patterns to make a simple cone mandrel; we would need to sell about 500 to break even on this high pattern cost. To further complicate matters, some foundries are very choosy about who makes their patterns and want to work very closely with the professional pattern maker himself (read this as the foundry does not want one of us inexperienced people making the pattern).

Do any of you know a professional foundry pattern maker that would be willing to donate his time and materials to Saltfork? Or a foundry pattern maker that would be willing to work with us to help us get patterns that we can actually afford? Let me hear from you; my contact information is on the front of this newsletter.

Jim Carothers  
President (2007) Saltfork Craftsmen ABA

## NW Regional meeting

The NW regional meeting was at Mike & Marideth George's shop in Alva, Ok. Being Memorial Day weekend,

attendance was a little low at eighteen. We had a good time, good fellowship and good food. Ron Lehenbauer

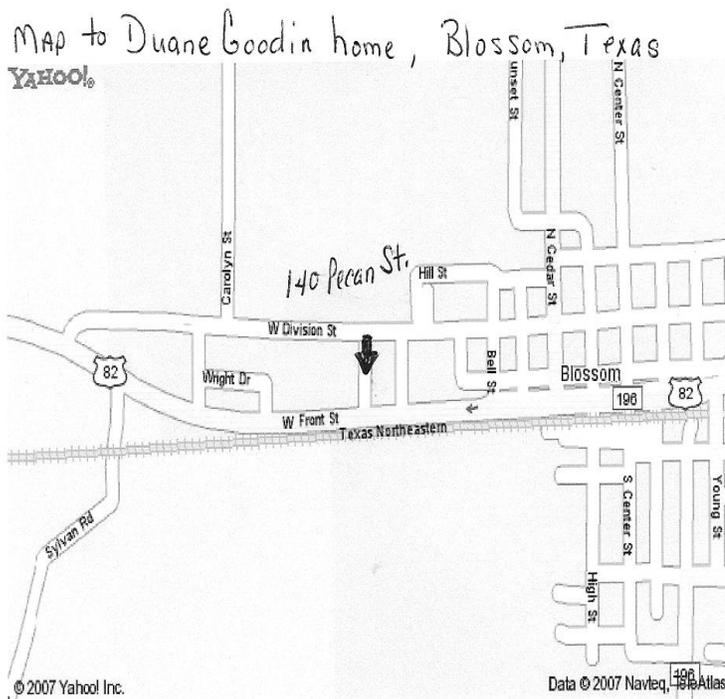


gave an impromptu demo on making a flower from square tubing with a forge-welded leaf.

Mike George gave a little class on making leaves on the end of small bar stock. Several people tried out Mike's power hammers. Jim Omev and Wayne Smith really smashed up a bar with the 100 lb Little Giant. It was a fun day and the weather was absolutely Georgeous (pun intended).



## BOD Minutes May 20, 2007



- Call to Order – The Saltfork Board of Directors met the home of Byron and Carol Doner in Norman, OK on May 20, 2007. Members present were J.C. Banks, Jim Carothers, Byron Doner, Gerald Franklin, Mike George and Bill Kendall. Bill Davis was also present. The meeting was called to order at 2:50 PM.
- Election of Officers – Motion by Gerald Franklin to re-elect all current officers for another term. Second by Mike George. Motion carried. Officers for the coming year are President – Jim Carothers, Vice-President – Gerald Franklin, Secretary/Treasurer – Mike George.
- Website Report – J.C. Banks reported that the Saltfork website has received over 4900 hits for the first nineteen days of May. This is good news as it is an indication that we are getting interest from the rest of the smithing world. There are more changes in store for our website so be sure to visit it often at [www.saltforkcraftsmen.org](http://www.saltforkcraftsmen.org).
- Scholarship Fund – Motion by Mike George to move \$1500 into the Don Bellah Memorial Scholarship Fund. Seconded by Gerald Franklin. Motion carried.
- 2007 Conference – The demonstrators have been confirmed. Jim Keith of Tucumcari, NM and Maurice Hamburger of Phoenix, AZ will demonstrate. The Conference Duties Worksheet was updated and many more of the duties were filled in. Members will be contacted over the next two months to solicit help in filling conference positions. J.C. Banks showed a draft flyer that he is putting together for nation wide mail out. It should be in final form soon. The BOD agreed that we should invite vendors to the conference and allow them to set up without charge.

### S/C Regional meeting

We had good weather for the Tuttle Tractor Show on Sat. the 19<sup>th</sup>. It was just about right for the 9 forges going most of the day. Max was making humming birds and others were trying their hands at making knives. I even saw a hammerhead being worked on. We had about 15 members show up thru out the day and most took a turn at one of the forges. We had a lot of comments from the various tractor clubs on a good display of forge work. The Tuttle club expressed their appreciation several times on such a good turnout. Thank you to all that came by!

Terry Jenkins

### Fyi

Lonnie Robinson, a Saltfork member from Rowlett TX, has been approached by the folks who run the Canton (TX) flea market wanting a group of smiths to come to Canton for a hammer-in type event on the second weekend of July. The event would be under a pavilion type building so there will be shade for smiths and spectators. Demonstrating smiths would be able to set up their sales tables to sell items to the public.

Point of contact for more information is Lonnie Robinson 972-475-1720

- Toolbox Raffle – Byron Doner is to contact Adam Hall to get dimensions of the box so that we can start building tools to be included in the raffle package. Byron will also get a sketch from Adam to be included in the July newsletter. The sketch is to be delivered to Diana Davis by June 20, 2007. Mike George agreed to make the corner hardware and the handles for the completed box. Tickets need to be printed and ready for sale by the time the July newsletter comes out.
- SE Region Meeting – Jim Carothers mailed out 26 flyers to attendees of the May 5<sup>th</sup> meeting in Paris, TX. The flyers contained the location and directions to the June 2d meeting in Blossom, TX. This is a busy time for many of us, but we should try to get as many of the established members to go to this meeting. Jim Carothers suggested that we should try to set up a workshop in the SE corner of the state sometime in November.
- Support of the Regional Conference in MO – SCABA was asked (informally) about providing equipment and personnel for one of the four forging stations that will be part of the Regional Conference in Sedalia, MO in 2008. The BOD agreed that we could probably support the event. Jim Carothers agreed to contact the Blacksmith Association of Missouri (BAM) to get more information on their needs and expectations.
- Swage Block Sales in Alabama – We were asked to set up a vendor booth at the next Alabama Forge Council conference. Mike George will contact the AFC for more details. Jim Carothers volunteered to take a few swage blocks to Birmingham to leave with an AFC member if needed.
- Francis Whitaker Blacksmith Shop – The John C. Campbell Folk School in Brasstown, NC is planning to renovate and expand the Francis Whitaker Blacksmith Shop beginning in 2009. They are asking for donations from individuals and organizations to help with this project. Donations of \$500 or more will be recognized with a plaque in the new building. Motion by

Mike George to donate \$1000 and a Saltfork swage block to this project. Second by Jim Carothers. Motion carried. Bill Kendall will coordinate this effort.

- Next BOD Meeting – The Board of Directors will meet at the Noble County Fairgrounds in Perry, OK at 2PM on August 26, 2007.
- Adjournment – The meeting was adjourned at 5:45 PM.

## Conference toolbox update

Adam Hall has been working up the plans for the wooden toolbox that will be filled with tools and raffled off at the SCABA Conference in October.

It will be a Tool Chest instead of a box like last years. (Pictures as soon as they come available) The box will be solid oak and stout. It will have a divider down the center and one small lift out tray. The interior dimensions will be  
 Length 21”  
 Width 9.75”  
 Depth 6.5”

The tray will take up space in the main box and will be  
 Length 20”  
 Width 4”  
 Depth 2”

Finished dimensions may be a little different, but that is what I am shooting for. At this point the wood is selected; pieces are blanked out and planed. Once the chest is a little further along I will send out drawings of hinges and handles. Hard corners should not be required for this design.

Adam Hall

## Tools for box

Now that we have the dimensions of the box everyone can get started on tools to fill it up. There was a list in the front portion of this newsletter. The best rule of thumb is “if you use it when you are forging them it is a good bet that it will be a good tool to make and put in the tool box.” Last years winner was new to Blacksmithing and needed every tool that was in the box.