

Saltfork Craftsmen

Artist-Blacksmith
Association

March 2007

Happy Saint Patrick's Day



Poz tongs made by Bill and Diana Davis

Saltfork Craftsmen
Artist-Blacksmith Association
Officers and Directors

President: Jim Carothers 580-336-9213
9501 Frontier, Perry Ok. 73077
frontiershop@wildblue.net

Vice-President: Gerald Franklin 580-467-8667
Rt. 3 Box 239J, Duncan, Ok 73533
franklin@gci-wireless.net

Sec-Treas. Mike George 580-327-5235
1227 4th St. Alva, Ok. 73717
mike-marideth@sbcglobal.net

Director: JC Banks 580-482-3209
16007 S. CR 206 Altus, Ok. 73521
jc.banks@okstate.edu

Director: Curtis Allen 918-786-7537
34400 S. 610 Rd. Grove, Ok. 74344
prairieiron@gcinet.net

Director: Bill Kendall 918-742-7836
1756 E. 59th St Tulsa Ok. 74105
wwkendall@aol.com

Director: Richard Dyer 918-582-5065
1119 S Birmingham Pl. Tulsa, Ok. 74104
irondyer@aol.com

Assignments:

Editor: Diana Davis 580-549-6824
23966 NE Wolf Rd Fletcher, Ok 73541
Lazyassforge@tds.net

Librarian/Education: Gerald Franklin 580-252-6002
Rt 3 Box 239J Duncan, Ok 73533
franklin@gci-wireless.net
cell phone 580-467-8667

Events coordinator: Bill Davis 580-549-6824
Lazyassforge@tds.net

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.

Material from this newsletter may be freely copied without permission for non-profit purposes. Please credit the author and this publication.

Visit our Saltfork Craftsmen Website:
www.saltforkcraftsmen.org

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 broomcorn brooms on your handle or mine. \$15.00 plus shipping. Contact Diana Davis, lazyassforge@tds.net or 1-580-549-6824

Hand Pump Rivet Forge all there but needs work \$300.00, Contact Bill Kendall 918-691-2173 or Jeff Kendall 918-607-8495

bill@ttownmetalmen.com
jeff@ttownmetalmen.com

More information and pictures are posted on the Saltfork Website "Tailgate" Section

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

Hossfeld Universal Bender Model #2, with Precision Hydraulic Power Attachment. All instruction manuals & Catalogs. Numerous dies \$1300.00 Contact Mike Boos, mlpbboos@cox.net or 918-357-1043

Wanted:

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

Send your ads to Diana Davis, 23966 NE Wolf Rd. Fletcher, Okla. 73541 or email them to lazyassforge@tds.net

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

<p>Name: _____</p> <p>Address: _____</p> <p>City: _____</p> <p>State: _____ ZIP/PO: _____</p> <p>Country: _____</p>	<p>Cell: _____</p> <p>Work cell: _____</p> <p>Phone: _____</p> <p>Fax: _____</p>
---	--

<p>Type of Membership <input type="checkbox"/> New Member <input type="checkbox"/> Renewal</p> <p><input type="checkbox"/> Regular - \$45.00 <input type="checkbox"/> Contributing - \$100</p> <p><input type="checkbox"/> Student - \$20.00 <input type="checkbox"/> Library - \$20.00</p> <p><input type="checkbox"/> Junior 18-21 - \$20.00</p> <p><input type="checkbox"/> Young - \$20.00</p> <p>Student member: _____</p>	<p>Credit Card Information</p> <p><input type="checkbox"/> Visa <input type="checkbox"/> Mastercard Expiration Date: _____</p> <p>Card # _____</p> <p>Security code (last 3 digits) _____</p> <p>Cardholder Name _____</p> <p>CV # _____</p> <p>Expiry date _____</p>
---	---

Application may also be made at any ABANA club site at www.abana.org

Phone: 505.278.2728
Fax: 505.278.2728

MEMBERSHIP APPLICATION

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.

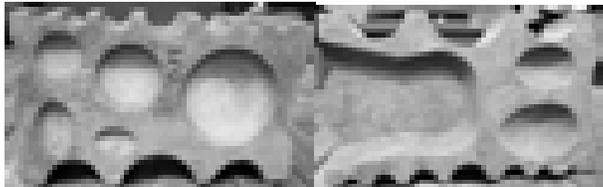
S/C Region coal location: Coal is in 1-2" size pieces. Bring your own container. The coal is at Max Scrudder's place in Mountain View. Contact Max for load out instructions.

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

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 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.

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

Meeting schedule

March

NE Regional meeting (March 10, 2007) meeting will be hosted by Dan Cowart. As for the trade item, I would rather make something at the meeting for the toolbox. Bring forges or share with those that do bring them. I have 2 and one can be worked from either side. Food and drinks will be provided; donuts in the morning and Pat will cook up something for lunch. Everyone is welcome so bring a friend. Map in back of newsletter.

South/Central meeting (March 17, 2007) hosted by Gerald Franklin. Gerald's trade item is a wall hook. Lunch will be provided. A map is in the back of this newsletter

NW regional meeting (March 24, 2007) meeting will be hosted by Ron Lehenbauer at his shop is Waukomis. Ron has chosen a candleholder at the trade item. Lunch will be provided but help out with a side dish of some kind. At this meeting they will also be working to finish up some storage issues with the teaching trailer. If you want to help do any welding please bring your own helmet. The only one that Ron has is equipped with special magnifying lenses that may make it hard to see if not needed by the user. Map provided in this newsletter

April

South/Central meeting (April 21)

JC Banks will host this meeting at the OSU facility south of Altus on highway 283. It will be a repeat of the Poz Workshop that was to be held in January and rescheduled because of the bad weather. Lunch will be provided.

NE Regional meeting (open)

NW Regional meeting (April 28) The meeting will be hosted by Richard Hart, Enid, Ok. The Trade item is anything with a horseshoe. Directions in next month's newsletter.

May

NE Regional meeting (open)

South/Central meeting (May 19th) This meeting is hosted by Terry Jenkins and held in conjunction with the Tuttle Tractor show. There is no trade item and meals are on your own. This is an opportunity to sell some of your ironwork and demonstrate for the public.

NW Regional meeting (May 26th) Hosted by Mike George, Alva Ok. The trade item is any flower other than a rose. Directions in May's newsletter.

⇒**Don't forget to pay your dues**←

2007 Demo request

➤ **Norman Medieval Faire**

Mark your calendars now for the Medieval Faire. Steven Knisely has been demonstrating at this event for several years and is again the one to contact if you would like to help. Last year Donovan's Keep came and helped out and they kept forges going throughout the day for the many visitors to observe the type of blacksmithing that would have taken place during that time period. If you have never been, it is an experience. There is something going on all around you as well as an open market area to browse through.

The dates for the Medieval Faire are March 30-April 1 2007.

➤ **Rural Heritage Festival (Cherokee Strip Museum)** Date is April 28 from 9-3

For more information contact Jim Carothers.

➤ **Tuttle tractor show**

This is a centennial event so this will be a good opportunity for members to show others what blacksmithing is about a to possibly sell some of your work. Terry Jenkins is also hosting the May meeting for the S/C region at this event. When it gets closer to time, get with Terry for any information you need.

The date for this event is May 19, 2007.

➤ **Comanche Old West Fest.** (June 9th) 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. They would like as many blacksmiths to come and set up as possible. Good opportunity to sell your iron work and demonstrate to the public.

➤ **Pawnee Bill Ranch Museum events:**

The Wild West Show dates are June 16, 23, and 30th. 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.

“Watch for more events to come.”

If you know of any events in your community let me know ASAP so they can be published in the newsletter and put on the website

North West Regional Meeting

The meeting was held at the shop of Lynn and Eileen Clowdus in Meno, Ok. It was a miserable windy day outside but just fine in the shop. Lynn and Eileen have a great shop with about every metal working tool a blacksmith would ever need. Lynn is really creative about getting his tools convenient and easy to use. All of his stuff works smooth and quiet, except for one really noisy roof turbine.



The turnout was disappointing; we only had about 12 people show up. However, all who were there, had a pretty good time. Lynn has lots of nice toys to try out. Everyone took advantage of that. As always, the food was really good and there was lots of it. If you didn’t get foundered, it was your own fault.

The trade item was “Anything with a Heart”. There were six very nice items made. Ron Lehenbauer, Lynn Clowdus, Richard Hart, John Burns, Leroy Haight and Mike George all made an item to trade.



It needs some material racks
And equipment hold downs

devised on the inside. We may also look at ways to attach blowers directly to the forges rather than mounted on separate stands, as they are now. We need some sort of containers that will hold tongs and tools for each forge

Next months meeting is at
Ron
Lehenbauers
shop in
Waukomis, Ok.
We are planning
to work on the
Teaching trailer.

station. We can color code the containers, as we have the forges. I think it will be easier to keep track of the tooling for each forge if every forge has it's own box. There may be a medium size army surplus box that will work well. Let Ron Lehenbauer or Mike George know if you think of something that might work and we'll try to have it on hand.

Please mark your calendars and come help out. That's Saturday March 24th. Anyone who can bring a 110-volt wire welder and/or a small angle grinder, please do so. We will need to weld some brackets to the inside of the trailer. Thanks.....Mike George

NorthEast regional meeting at Gary Glodens Scenes from the meeting



There is no meeting scheduled for the NE region. If you would like to host a meeting please let me know so I can get the word out. We need to know at least 30 days in advance to get the information in the newsletter.

A word from the President

Saltfork members:

2007, Oklahoma's Centennial Year, is starting off great for us. We've already had several good well-attended, regional meetings.

I am encouraged that at each meeting I attend I find a few new faces and more interest in smithing and other crafts. There are a lot of talented folks in the Saltfork organization. Our website is now operational again; J.C. Banks has gotten this major task under control. The Bill Epps' workshop has full registration; plans for the Annual Conference are coming along nicely. I think we can look forward to a full plate of regional meetings, public demonstrations, and fun all year.

Since we are pretty busy and some new folks are on hand at our meetings, I encourage you to bring a nametag to the Saltfork meetings. The meeting host could provide nametags, but the host really has enough to do just having the meeting. Name tags will help us get to know one another better and help to make the new people feel more at ease.

March is dues month. Don't just assume that we are going to see your new address, phone number, etc. on your check. Please make sure you fill out a new Membership Application form and send it in with your dues payment to Mike in Alva. If you have a new e-mail address or want to be on the Saltfork E-List let us know. Out of 120 or so names on our present E-List; about 20-30 are not current.

Safety Glasses –bring them to the meetings and demonstrations; wear them. We have been pretty lucky lately in protecting our eyes and possibly those of an on-looker.

And finally to all of you that are new to smithing;

There are only 3 things that you will need to know to be a blacksmith 1) Get it HOT, 2) Hit it Hard, 3) Quit when it's done (Per Vance Baker instructor at the John C. Campbell Folk school).

Jim Carothers

For Sale:

USA Dealer for Refflinghaus Anvils, 77 to 1250 Lb. European 2 horns with or without upsetting block & side shelf. Over 100 sizes and styles available.

Guaranteed face @ HRC59

See @ Shady Grove Blacksmith Shop,

www.blksmith.com

Phone 308-384-1088

Dick Nietfeld, member SCABA

Press Release

Forging on the river, the annual conference put on by the River Bluff Forge Council, is happening on the grounds of the National Ornamental Metal Museum March 23, 24, & 25, 2007. The forge council is proud to announce Mark Aspery, Jeffrey Funk and Daniel Miller as its demonstrators for 2007. Tickets for this event are \$70.00 if purchased by 3/12/07 and \$80.00 if purchased after 3/12/07, and include lunch on Saturday and Sunday. As usually, the organization will offer one free admission to every ABANA affiliate chapter. For more information please see www.rbfcmempis.com, or contact Steven Cuzzilla

(President) at 901-774-6380 Tuesday; through Saturday 9-5 or Bob Rogers (Treasurer) 901-278-7826

Day light saving time

Daylight Saving Time (DST) will be changing this year. Congress as part of the Energy Policy Act of 2005 approved this change. This means we spring forward an hour on March 11 this year, three weeks earlier than in the past and 10 days before the official start of spring. As the other end, clocks will fall back an hour the first Sunday in November, a week later than usual.

Because of this change, there may be certain electronic and computer systems affected. If you would like to see what you need to do for your home pc, Microsoft has set up a Daylight Saving Time Help and Support Center website.

Don't forget to pay your dues.

Don't forget to pay your dues.

Don't forget to pay your dues.

South/Central regional meeting

The day started out on the cool side but warmed up to about 70 degrees. We had 26 folks show up for the meeting with 3 forges going all day. Charlie Groom was making a stylized dragonhead. Bill Davis and Jim Carothers helped a new member with some salt spoons and horse heads. J.C.Banks brought the tools needed to make POZ tongs and explained how they worked and will be making them at the next meeting at his place. Some nice tongs! After a chili and fixings dinner more forging and visiting with friends took place until time to leave that evening. I thank everyone that came and made it a Good Day!

Terry Jenkins

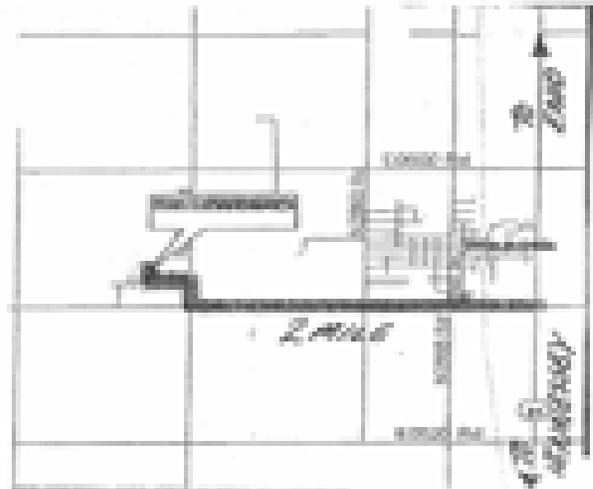
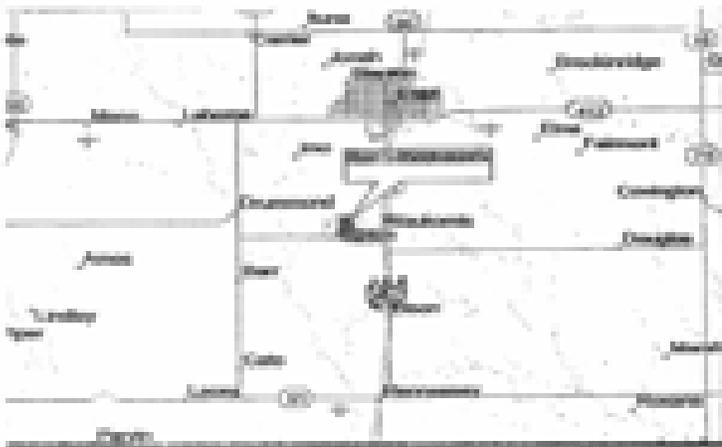


The trade item was a book scraper and you can see there was several different styles brought to the meeting.



Next South/Central meeting will be at Gerald Franklins place. See you there.

Here is a Map to Ron Lehenbauers place. See you at the NW Regional meeting on March 24th.





the news

February 17, 2007

Updated President's Message - 2008 Conference

Whoever said "the more things change ... the more they stay the same" doesn't know the plights of non-profit organizations. Because what I want to talk about is this - ABANA must change its focus to be relevant for another 34 years. ABANA has come to that fork in the road - where do we go from here? Or as Yogi Berra would say - "When you come to a fork in the road, take it." We are taking it, grasping it and coming up with some difficult decisions.

ABANA has been producing conferences every other year for decades now. Well the time has come to reevaluate how we do these events. We, the ABANA Board, have decided not to have a conference for 2008. This decision did not come overnight. After months of discussions and negotiating a formal motion was made on February 9 "that ABANA not have its biennial conference in 2008." On February 13, the motion passed by a vote of 15-0.

As painful as this decision was I know it cannot compare to the disappointment of individuals of the Northeast Blacksmith Association (NBA). Since the Fall of 2004 the NBA put a great deal of time and energy into the possibility of having the conference at the State University of New York at New Paltz. Jonathan Nedbor and the Steering Committee of NBA are to be commended for all the work they have done.

So why aren't we having a Conference? What's the deal? Is ABANA going bankrupt? Let me start by answering the last question first - NO. Though I wish the financial situation were stronger, we are not going bankrupt. To put things in a simple nutshell here is a quick summary of the conferences. They have become too expensive. They cost hundreds of thousands of dollars, which is too much! That doesn't even include the thousands of hours from all of the volunteers. For many years ABANA has supplemented its budget by living off the profit from previous Conferences. We can no longer do that. The Seattle Conference was not the financial success of previous Conferences. It probably lost money. We still do not know the final tally, because there is an outstanding invoice from the

University of Washington. When we do know the accounting figures, they will be posted on the ABANA website.

So why no Conference.

First there is the **Money** –

The costs to put on a Conference have skyrocketed to somewhere in the vicinity of \$400,000. With those figures the average conference expense including transportation would be in the \$1,000 per person range. The majority of our members cannot afford to pay that. Of course we all agree that costs must be trimmed. We need to look at other locations such as fairgrounds. The college campus environment has gotten too expensive. The number of demonstrators has gone through the roof.

Second there is the **Conference Chair** –

Every Conference needs to have someone in charge to do the negotiations, troubleshoot, make decisions, etc. This is a full-time job! Past Chairs who have held this position have burned out – just ask Dave Koenig and Bill Callaway. And did I mention that this job pays nothing?! No one wanted to step up and be Chairman for the 2008 Conference.

Third there is the **Membership** –

The membership has declined in recent months. A year ago the number totaled 4815. Today it is 4468. Our budget figures are based on a membership of approximately 5000. Without that number there would be practically no funds to pay for seed money or pre-conference expenses. Another factor to consider regarding membership is the number of attendees to our biennial Conferences. Seattle had 575 paid attendees, which equates to less than 14% of our membership. This has been a consistent percentage over the last several Conferences. That low figure is another indication that we are definitely not meeting the needs of our members.

Fourth there is the **Central Office** –

LeeAnn Mitchell performed many duties on the three previous conferences – La Crosse, Richmond, and Seattle. She worked tirelessly at each of these events putting in many hours of “volunteer” work. Much was asked of her and she did it – beautifully. There is now a Central Office Administrator, Heather Hutton of Knoxville, Tennessee. She has many strengths and will be a valuable asset to ABANA, but her experience in working with large conferences has not been tested. Without a Conference Chair this would be an impossible task for the new Central Office.

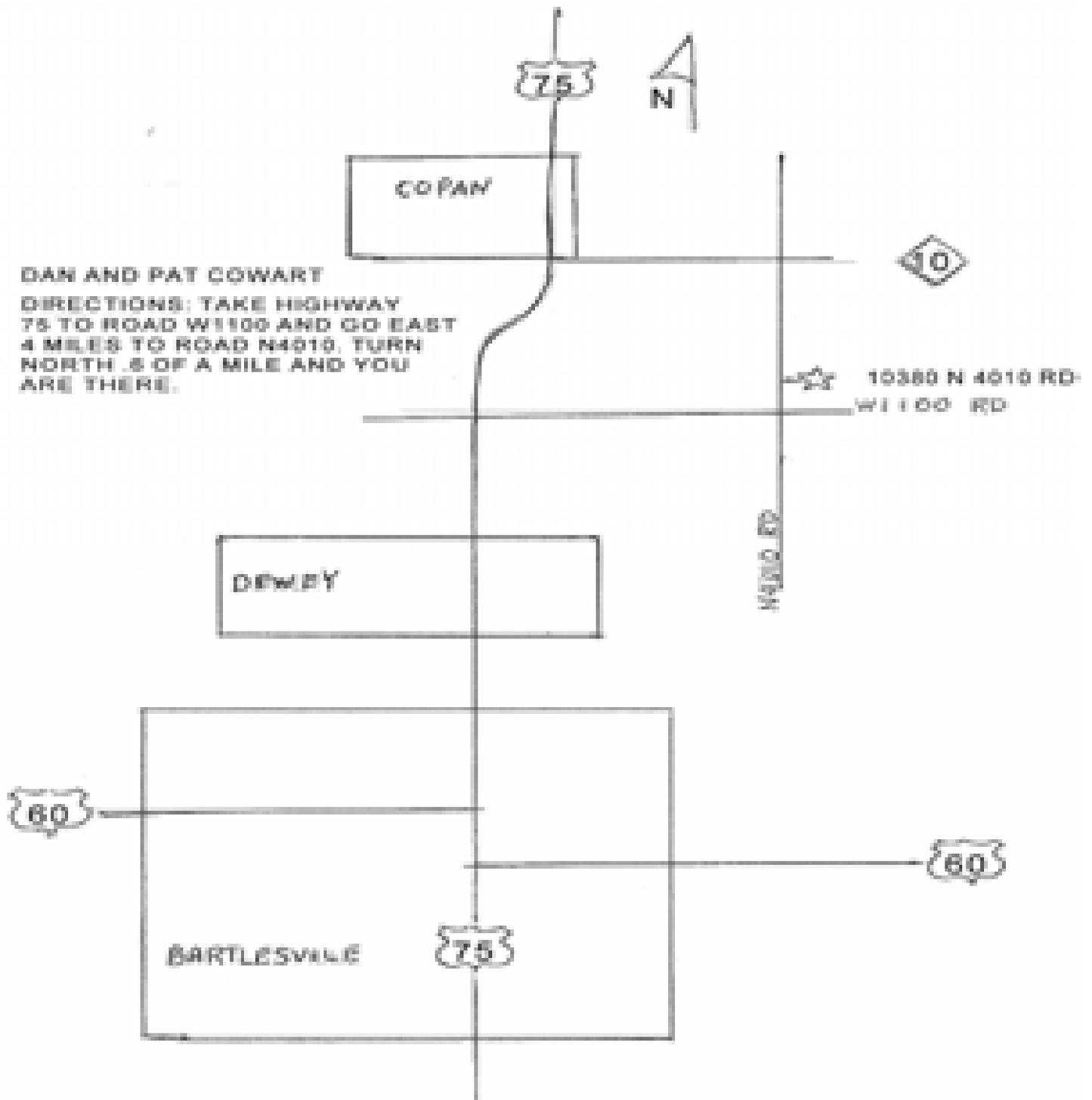
So where do we go from here? This is a question that I asked in my message to the affiliates. I know that many of you like me look forward to getting together with old friends. For that reason alone the idea of not having the Conference will be a great disappointment. The first ABANA Conference I attended was Birmingham in 1988 – Sloss Furnace. The sharing and

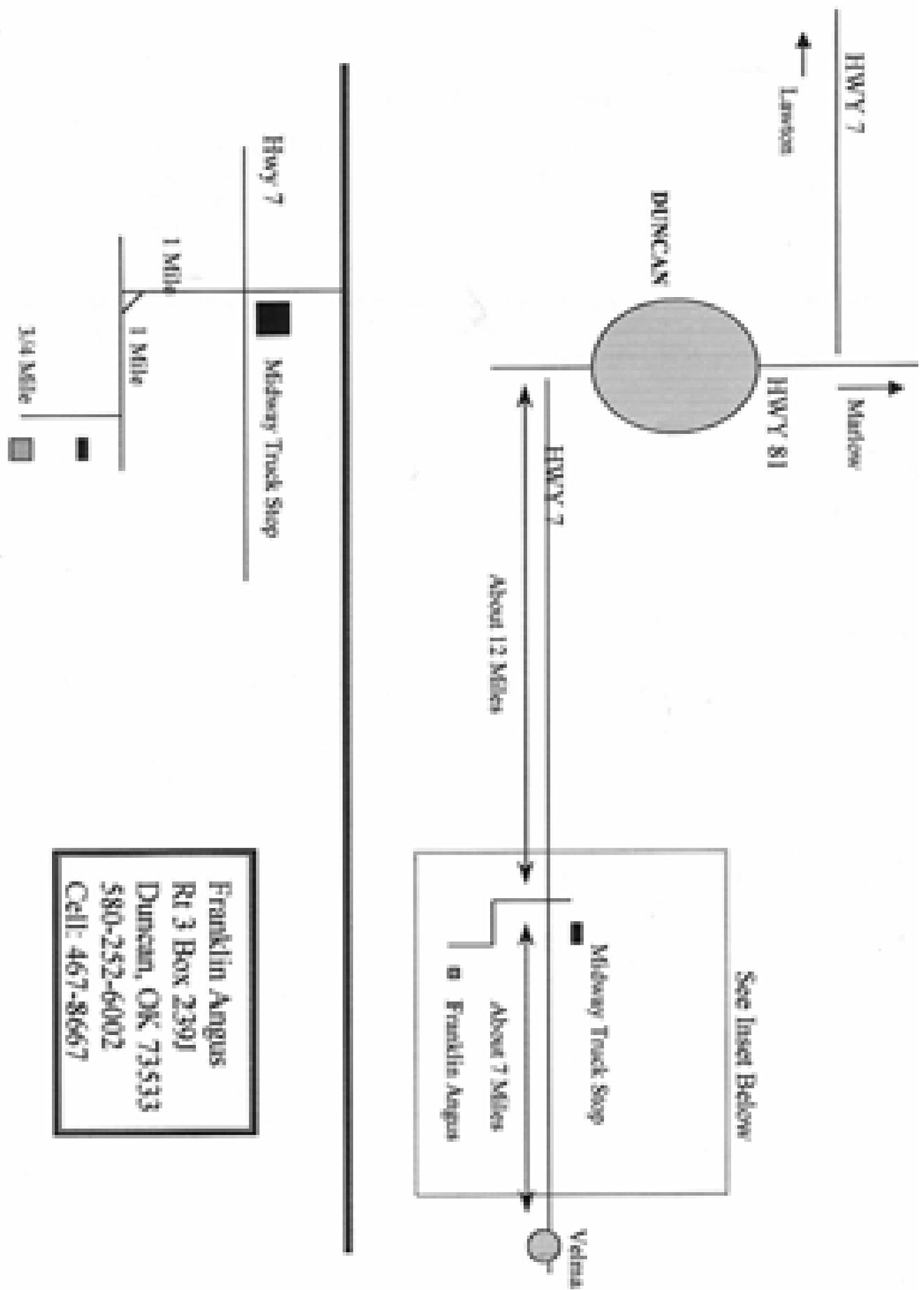
camaraderie alone won me over. There will be other Conferences, but we need a new model. I want to continue this dialog in future letters. Please let me know your thoughts. ALL suggestions are germane. There are no stupid ideas.

The more things change ... the more we need to change ...

Clare Yellin, ABANA President
clayellin@mac.com

Map to Dan Cowart's place.





Franklin Angus
 Rt 3 Box 239J
 Duncan, OK 73533
 580-252-6002
 Cell: 467-8667

David Seigrist attends John C. Campbell Folk School

Recently I was fortunate enough to attend the John C. Campbell Folk School in Brasstown, NC. The Saltfork Craftsmen, you guys, helped with a scholarship for which I am grateful. The class was Traditional Joinery and held from January 7th – 13th. Tal Harris, our 2006 Conference Demonstrator, was the Instructor and Judy Berger assisted.

Before going to school you need to call or email your instructor to discuss the grille you're making, special tools required, scope of project, level of difficulty, etc. To save time in class, Tal said to go ahead and texture the surface and break the corners on all metal before coming. If you're going to make more than one grille of the same pattern get a sheet of steel and scribe the lines on it so you can lay your hot metal on the pattern and your lines will not smudge or disappear. This pattern can be kept for later use. Soapstone and silver pencil are too wide for precision work. You can chalk or silver the rough but for repeated or precise work use a scribe. It really depends on how detailed and exact it has to be. I drew my lines with a silver pencil at home so Tal could verify before they were scribed.

This was my first trip to the School and for those who haven't been it's nestled away in the mountains of North Carolina just on the other side of the Nantahala National Forest. From Hollis, OK to Brasstown is about a 19 hour drive. I stayed with some friends in Nashville Saturday evening and drove to Brasstown on Sunday. There are several buildings that comprise the school campus, many workshop areas, lodging, dining facility, craft shop with a bookstore, and a community center.

After checking in and throwing my bags on the bed I went down stairs to the Community Center for the welcome to JCCF School orientation. It was also the last time I saw the lights on in the room until Friday. It's well known at the school that blacksmiths come in late and leave early, my average time getting back to the room was 10:30 PM. As a matter of fact, I didn't even know whom the guy sleeping across from me was until Friday evening when I walked in and the light was on. "Oh so you sleep there, I've seen you around but didn't know you stayed here." Lodging for me was in the Keith House, the same building as the admin offices and community center. Since it's an older building the floors squeak and whoever comes and goes can't help but make noise. Between the early risers and those who come in late it's a pretty mutual understanding everyone is trying to be quiet but it just can't be helped. We all got along just fine.

Following orientation was a family style dinner and then it was down to the Francis Whitaker Blacksmith Shop about a ½ mile down the road.



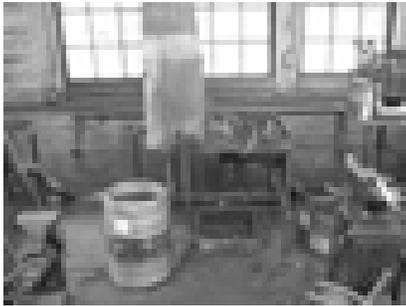
When you go into the blacksmith shop, find a forge station, set your anvil direction and height, and write your name on the side draft hood.

The height is made adjustable by 2"x8" blocks under the big block of wood the anvil sits on. You can add or take away to get the correct height.

Each station consisted of a forge with a side draft hood and lever controlled air supply, fire tools, anvil, post vice with a small shelf attached, coal and water buckets, and an ash dump pan. We went over introductions and some of the students were Mark and Mindy Gardner www.floodplainforge.com who are also instructors, Rick Trahan— The only John Deere Blacksmith www.deere.com/en_US/attractions/historicsite/blacksmith.html, Doug from



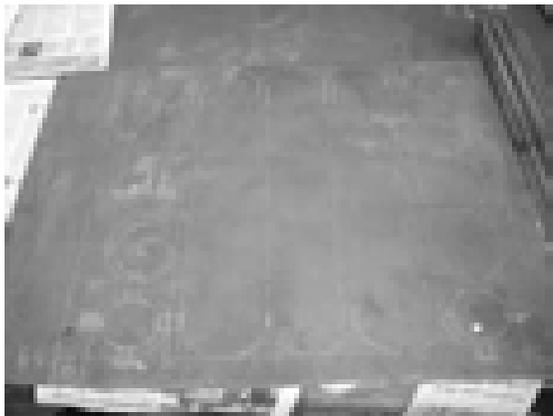
Canada, many from Illinois, one from California, and of course one from the cultural center of the universe, the great state of Oklahoma. There were some who had many years experience and just two with less than two years experience. After the intros we discussed shop safety, eye protection at all times, hearing protection while hammering, etc If iron is in the vice, on the anvil, or on the floor it's considered hot. If it's on the table it's not. If it's on the table and hot write, "HOT" on it. The shop only has to operate until suppertime but most instructors keep it open until 9 or later depending on the work in progress and seriousness of the students.



The shop is equipped with a very nice tool room, trip hammers, treadle hammer, belt sander, band saw, torch, wall full of examples, steel supply barn with a large selection of mild steel sizes you pay for by the foot, with a chop saw and grinder, and in a separate building a welder, wire wheel buffer, and a grinder.

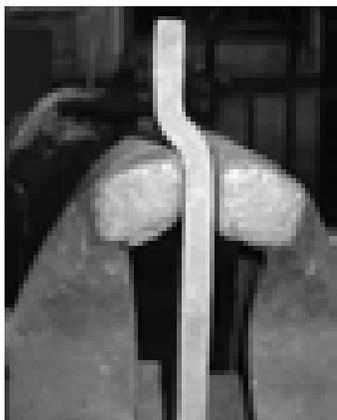


Tal then looked at everyone's drawings, gave advice, and encouraged those who didn't have an idea to think of one by tomorrow. Settling in at the shop I set out to scribe my pattern but didn't know exactly where to start. What part of the square grille should be scribed first? Judy said to start at the far left inside of the frame and make all measurements from that scribed line.



Every morning at 7:45 JCCF has "Morning Song" for anyone who would like to listen in. Monday they tell about the history of the school and it's progression to where it is today. On Tuesday J.D. Robinson sang a few folk songs and told a funny story. His final song was "Momma's not dead she's just playing possum." Wednesday a violinist played a nice medley of tunes. Thursday and Friday I have no idea, I was in the shop.

In the shop Tal demonstrated making a punch for those who used rivets. During the week he not only demonstrated the joinery technique but also tool making for the joinery preparation. Some of the smiths from Illinois brought in their own tools, which took up several trunks. Tal and Judy both encouraged note taking to document your process and what works and what doesn't work. That way, later you can review your notes when making the grille again or a similar process instead of reinventing the wheel. The demos were conducted depending on the needs of the students, not a demo and then you repeat. I believe that was because there were mostly experienced blacksmiths in the class. Later he and Judy also demonstrated or coached forge welding, forge welding a ring, forge welding a frame, drop tongs forge weld, making drifts, offsetting, scrolls, scroll jig, collars, collar tooling, and math formulas for collaring of standard and odd shapes. During the class Tal commented he prepared for several months making all the tooling needed for Francis' last 2-week class at JCCF.



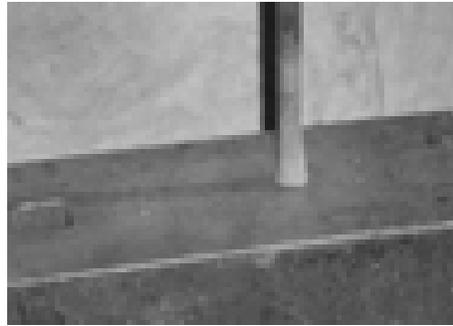
After Tal's punch making demo my first order of business was to burn 3 out of 4 of my 1 1/2" x 1/2" flat bars and spend extra time texturing and breaking the corners on 3 new ones. The bars were pitted in a small area that I didn't catch. Once the bars were ready they were offset, and punched. Now the frame was ready so I made 7 rivets for the four corners. Rivet prep,





upsetting, forming the head, and

cutting it off.



Only one 1/2" rivet was needed for each corner but I made 3 that had off center heads. As I was getting ready to throw them away Tal said to keep them in case I ever had a hole slightly off center. I could put those rivets in and just turn them until it appeared the hole was centered on the joint.

Next phase of the grille was to slit and drift all 16 holes for the 4 vertical bars.

In many of Tal's European pictures of ironwork the pass through weren't square but square with small tears at the ends. He believed it was from wrought iron tearing as the drift was passed through. Since my grille is a copy of one

Schraum I split end pass slit chisels and through, 1/2" hole oversized 1/2" process Tal square pass square, hammer making a square **steps total.** square drifts.



made by decided to do throughs. After experimenting with different sized drifts I finally figured out to make that kind of pass in a 1/2" bar, you needed a 3/4" hot slit chisel and an square drift. The drift is oversized by 1/16". The demonstrated at the state conference, which made a through was: slit, upset, drift round, upset, drift on the side to square up the outside of the hole - pass thru that is square shaped on the outside, **6 Tools used were 7/8" slit, 1/2" oversized round and**



To get the split end pass through effect you: slit and drift square, **2 steps.** I told Tal "Hey we found a new way of making pass throughs." He said "Probably not. Anything we discover is just something that was done by the old Master Smiths and forgotten in history. So we are really discovering how they did it long ago." While doing the pass throughs I didn't stop to take pictures because we were all hurrying up to get as much done as possible. I'll go to my shop and take some photos to be included in a future newsletter.

Since 16 pass throughs are needed I asked Judy what kind of tolerance did I have from pass thru to pass thru. Each interior square is 4" x 4". She allowed a variance of 1/64th of an inch; Tal was a little more generous with 1/16th of an inch. That's good because 1/64" is pretty hard to get. Also found out there's not a measurement of "one tick mark on the ruler" it's either 1/8", 1/16", 1/32", or 1/64". If you say it's just a tick mark, Tal will look at you with an mmmmmmmmm no shake of his head and say, "How wide exactly is it?" You can make adjustments if your pass throughs don't line up by drawing or upsetting the bar between the holes. Unless you have a torch this can be a lengthy process. Not only do your pass throughs have to line up but also your bar cannot be twisted, another problem, or bent. Since this was a school I decided to not be narrow minded and give all of my bars multiple



problems by combining pass throughs not lined up with twisted, and bent bars to get the full benefit of the instructors guidance. Sounds easy huh?

Tal told us **“When Francis heard a hammer hit cold metal, without ever looking up he would yell “GET IT HOT!” and everyone would wonder “Is he yelling at me?” and all irons go back into the fire.”** To Francis metal was hot when it sweats.

Thursday and Friday I learned the importance of a story bar. A story bar/stick is a bar with measurements marked so when you move metal you don't have to measure with your ruler to see if it's right, you're losing heat, instead you hold it up against your story bar to see if it's been drawn out, bent, upset, etc enough. This way you can quickly go back to moving metal if needed. It's very helpful for drawing out the ends of scrolls. After making a scroll jig and getting a few practice scrolls made it was time to start cleaning up the shop. Yes, I'd been there a week already. The scrolls, collars, and rings would have to be done at home. I had only swung a hammer for five days, in the end my hands hurt with every swing of the hammer and my feet hurt with every step..... but man WHAT A TIME!!! Friday afternoon everyone takes their work to the community center to show what they've been doing. Since there are many different classes you get to see quite a few nice projects. There was everything from blacksmithing, painting, marbling, weaving, jewelry making, music, glazing, wood carving, twig furniture, doll making, etc. Take a look at their website www.folkschool.org and see the myriad of classes offered and their schedule.

Looking back what would I do different: 1) Make a smaller grille with fewer pass throughs 2) Practice daily on joinery techniques until perfected under watchful eye of instructor. For instance make various size rivets in the AM, square corners in the afternoon, collars in the evening, and forge welding all day. 4) Use trip and treadle hammer to see how they work and which one would be my next investment 5) Make working copies of many different jigs available at the school, scroll, quatrefoil, stakes, etc. 6) When doing multiple pass throughs have extra bar on each end so instead of spending extra time being exact you can just cut off the extra when done. 7) Save the surface prep for home.

Finally, I'm grateful to all the Saltfork Craftsmen for the scholarship and look forward to sharing my knowledge with you in the future. The grille when completed will be put in the 2007 Saltfork Conference Auction. If you have any questions please email or talk to me at the next meeting. Dseigrist2004@yahoo.com Take care and I'll meet you at the forge.

David Seigrist

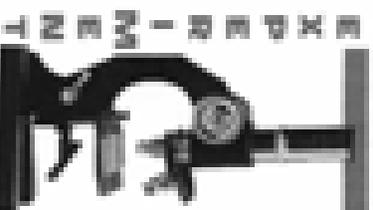
\$189	gas	\$2.15/gal	25mpg	2,200 miles
\$485	tuition			
\$343	room and board			
\$50	on the road meals			
\$30	metal at school			
\$1097	total			

\$800 Saltfork Scholarship

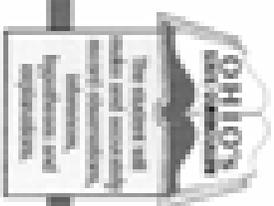
No hotel expense for 2 nights, stayed with friends

If you're thinking about going, be sure to add additional cost for hotel (x 2 nights) and coffee (???)

Steel Elements



Spark Testing for Mystery Metals



Materials required:

- Grinding Wheel
 - Scrap Metal
 - Handpiece Bar (page 21)
- Don't forget to get the iron you need!

Background:

Spark testing is an old method of identifying the chemistry of metals (powdered materials). It uses steel with, then it will a spark tester or two instead. They are used to determine the composition of a sample to determine, they may be used for various, to find the best match of steel using it a group of generally good steel using today's high-tech instruments can provide correct the conditions of metals.

Steps to follow:

1. Before mystery metals, they will need them or they pieces of known metal that you or the teacher, can probably identify. Here are a few suggestions:
 - (1) wrought iron (from iron, stainless steel wire), (2) stainless steel (brush, wire wheels), (3) high-speed steel (cut tool), (4) carbon steel (hammer, chisel), (5) cast iron (not cast iron steel) for additional sources, add a hard copy part, just part or manufacturing facility, for a copy just use you, set the location of Scrap Recycling Materials at 760.307.3692.
2. Use a hand-held or stationary the grinder (not a bench) that is not used over a cast of about 200, they will probably need to buy a grinding wheel (for attachment) at a cost of about \$2. Buy a wheel that weighs to produce at least 1000 surface feet per minute. Consider when that per minute to the way.
$$\frac{\text{rpm}}{\text{ft}} = \frac{\text{Revolutions of Wheel in Time}}{\text{ft}}$$

- before that the RPM

(Caution: Do not exceed maximum recommended RPM rating for grinding wheel selected.)

3. Show the students the steel pieces of them to the students.
4. Hold out the spark identification table on the following page. Discuss the elements to students. The elements contain spark properties for Ti steel materials. Explain to students how the sparks are identified. Make sure they understand each of the six properties to be observed and recorded.
5. Explain that all students have different eye, hair and hand protection than their hand tool for safety and as all present can use the parts.
6. Show each of the mystery metals in a clear and fairly open the grinder. Place business card application to show each student group that to record the spark properties. (the right number recording the samples to each a way that students will not be able to identify them by sight.)
7. Show the groups how recorded the properties of each piece of metal. They should attempt to identify the four mystery metals, using the chart.
8. After all groups have completed their identification of the mystery metals, discuss the spark properties of each metal one by one. Have a spokesperson from each group explain the group's observations, discuss process and conclusions.
9. After each group has concluded to an identification, record the actual identity of the steel sample.
10. Record each discussion on the steel steel sample.

Analysis:

For each of the samples that is the process of observation, students learn to compare with differences in spark stream, to record properties of spark stream and to use their words to draw conclusions. Each time a student concludes a spark stream, be it the a looking at its different properties, that decision to draw a necessary for accurate results.

Spark Identification Illustrations

Material	Spark Illustration
Wrought Iron	
Carbon Tool Steel	
Gray Cast Iron	
White Cast Iron	
Annealed Malleable Iron	
High-Speed Steel	
Austenitic Manganese Steel	

Material	Spark Illustration
Stainless Steel	
Tungsten-Chromium Die Steel	
Stellite	
Coated Tungsten Carbide	
Nickel	
Copper, Brass, Aluminum	

Spark Testing Identification Table

Material Type	Volume of Material	Relative Length of Material in Inches	Color of Material (How it Shows)	Color of Sparks After End of Material	Quantity of Sparks	Volume of Sparks	Test For --
Wrought Iron	Large	50	Blue	White	Very few	Small	Supporting, flame apparatus and structural work
Carbon Steel	Moderately large	25	White	White	Very many	Fine, spreading	Reamers, chucks, dies, mills, cutters, taps and wood-working tools
Cast Iron	Small	25	Red	Blue	Many	Fine, spreading	Auto-cylinders, blocks and heads, pistons, crank shafts, valves, boiler fittings, rivets, pipes, iron and locomotive castings
White Cast Iron	Very small	20	Red	Blue	Few	Fine, spreading	Tools used for cutting steel
Assorted Steels and Iron	Moderate	20	Red	Blue	Many	Fine, spreading	Chains, railroad joints, connecting rods, railroad cars, steering gear, bearings, hinges, pipe, fittings and other parts
High-Speed Steel	Small	40	Red	Blue	Extremely few	Small	Cutting tools
Assorted Magnesium Steel	Moderately large	40	White	White	Many	Fine, spreading	Railroad wheels, auto engines, grinding wheels
Moderate Steel	Moderate	50	Blue	White	Moderate	Small	Cutting spindles and bearings, bearings, structural, shafts, axles and power-driven equipment
Tool Steels (Various) and Steel	Small	20	Red	Blue	Many	Fine, spreading	Drills, reamers, pipe, hand files and files, dies and punches for steel materials
Cast Iron	Very small	10	Orange	Orange	Few	Few	Cast pipe, valves and pumps for water, maintenance in chemical plants
Cast and Wrought Cast Irons	Extremely small	2	Light orange	Light orange	Few	-	Milling, work holding and sand casting
Cast Iron	Very small	10	Orange	Orange	Few	Few	Milling
Cast Iron, Brass, Aluminum	Small	Small	Blue	Blue	Few	Few	Hydro, grinding, reamers, dies, taps

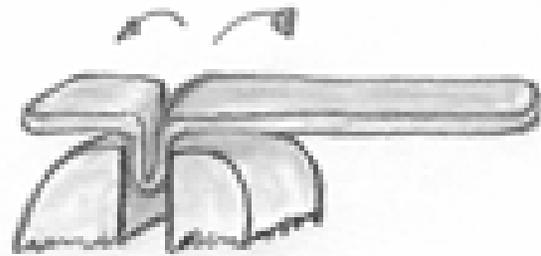
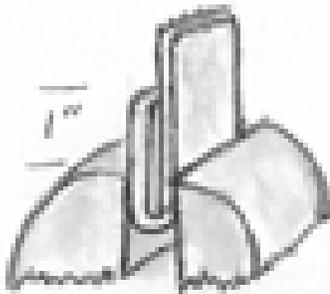
Clay Pot Hook

By Bill Epps 2-10-97

MATERIAL: $\frac{1}{2}$ " x $\frac{3}{4}$ " x 7" Flat strap



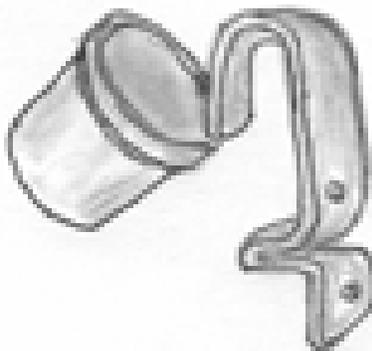
- Mark w/center punch 2" from end. Heat and round corners.
- Fold at your 2" mark.



- Place in vise w/1" of fold out then flatten to 130°.



- Bend long end to form hook. Leave $\frac{1}{2}$ " clearance for pot.



- Mount w/2 screws and tip pot to seat in hook.

Gerald Franklin



Artist-Blacksmith Association

<http://www.saltforkcraftsmen.org>

Special Blacksmithing Meeting Notice May 5th South East Oklahoma Area

The Saltfork Craftsmen ABA will hold a special one-day meeting on Saturday, May 5th in Paris, TX at the shop of James Allcorn -- Bois D'Arc Forge Blacksmith Shop is located at 33 1st Street NE. Look for the red and white brick building. Note that 1st Street NE is a **one-way** street running South.

The main purpose for this meeting is to see if there are enough S.E. Oklahoma / N.E. Texas people and interest in the Saltfork organization and blacksmithing to create a "Southeast Region" with regularly scheduled meetings on the first Saturday of the month.

Plan to arrive around 9 AM; a catered barbeque lunch will be served. Bring your portable gas or coal forge, tools, and scrap steel for a day of fun, hospitality, and fellowship. Tailgate sales of tools and equipment are encouraged.

The trade item is anything made from a horseshoe or part of a horseshoe.

If you are interested in blacksmithing but do not have smithing tools, join us anyway. We'll find a forge and a mentor for you to connect with.

Let us know if you are planning to come to this meeting so that we can make the appropriate plans – such as enough lunch for all...

For more information contact:

James Allcorn 903-517-1667 cell

jallcorn@suddenlink.net

Jim Carothers 580-336-9213

frontiershop@wildblue.net

Saltfork Pres. (2007)

Google or other on-line map: [33 1st St NE, Paris, TX 75460](#)

North Texas meeting

Some of us hold double memberships, meaning we are also members of other blacksmithing groups. Bill and Gerald Franklin as well as I are members of the North Texas Blacksmith Association. We attended one of their meetings. To say the least, their meetings are different from ours. Where ours are more of a get-to-gather with lots of food and forging, there are usually held for business purposes. It is a rare occasion if you see anyone doing any forging. I'm not saying that they don't have forgings at their meetings its just that its not a every meeting occurrence like at ours. At some of their meeting they have someone come in to teach the groups something. It might be about welders or other equipment used by metal workers.

At this meeting they were welding in the frame for a new door in a new shop. It was too cold for me to stand around watching them weld when I could go inside, drink coffee and watch Jim White and Bill Epps forge. Bill Epps showed me how to make a flowerpot holder. Gerald took notes and drew up the instructions that are provided in this newsletter. This is a quick and useful piece for public demonstrations.

Jim White was also doing some forging for the watchers but I didn't get a chance to see what he was working on.



Terry Farquhar was getting advise on how to making dinner bells. He does some public demonstrations in Texas and they are good

sellers.

Attention: Open meeting dates

South/Central Region
North East Region

October 2th
April 14th
May 12th
June 9th
July 14th
Aug 11th
Oct. (Conference)
Nov 10th
Dec 8th
July 28th
Aug 25th
Sept. 22nd
Oct. 27th
Nov 24th
Dec 22nd

North West Region

Help us fill these meeting dates. For the Northwest region please contact Mike George if you wish to host a meeting. South/Central or North East region please contact Diana Davis. Contact information can be found in the list of officers/assignments section of this newsletter.

Editor

FOR SALE

- GAS FURNACE (factory model for use 7" x 22 1/2" x 27 1/2" w natural gas w/ regulator and gas hookup and thermostat control. \$2,500.
- Champion (Brazos) hand chisel w/ steel, with 4" blades. \$150.
- Champion large blower. Hand crank on factory cast iron stand. Heavy spiral gear drive. \$200.
- Laramie Western Chief (hand pump) on factory stand. New belts. \$200.
- Best power brooder/broiler. Year 1/2" sq. coil. Makes 1/2" rod to 3/4" rod. Heavy mild. Spines: 1, 2, 4, 7, 9, 10, 12, 20. \$2,250.

**EQUIPMENT IS ALL IN EXCELLENT RUNNING-CONDITION,
PAINTED AND READY TO USE!**

- Complete line shaft with equipment. 40-hp. Perfect power hammer.
- Champion pulleys/grooves on pedestal stand.
- 3/4" table w/ 10" wire stand and grinding stone.
- Champion No. 201 post drill. Two speed and automatic feed. Quick adjustable table with original work. No. 24 double quick adjustable chuck 1" - 1 1/2" capacity.
- 1 1/2" line shaft is 18" long with 3 factory made forged brackets, all hooked up to above equipment. All new in 1922 and used in home blacksmith and welding shop until 1992. Used in craft and living history shop to present. All hooked up and running, in excellent condition. Extra flat belts, boxes of new Allstate belt splitters, extra new line shaft, wood pulleys, and cast iron pulleys. Set of dark polishing wheels and box of grit.
- New cycle 2 hp 220v 1/2 motor with overhauled switch, wires, and connections. Lots of other items that go with line shaft, too many to list. All for \$24,500.

Can deliver and help set up

Jim White, PO Box 1249, Mansfield, TX 76063 • Ph: 817/229-5297