

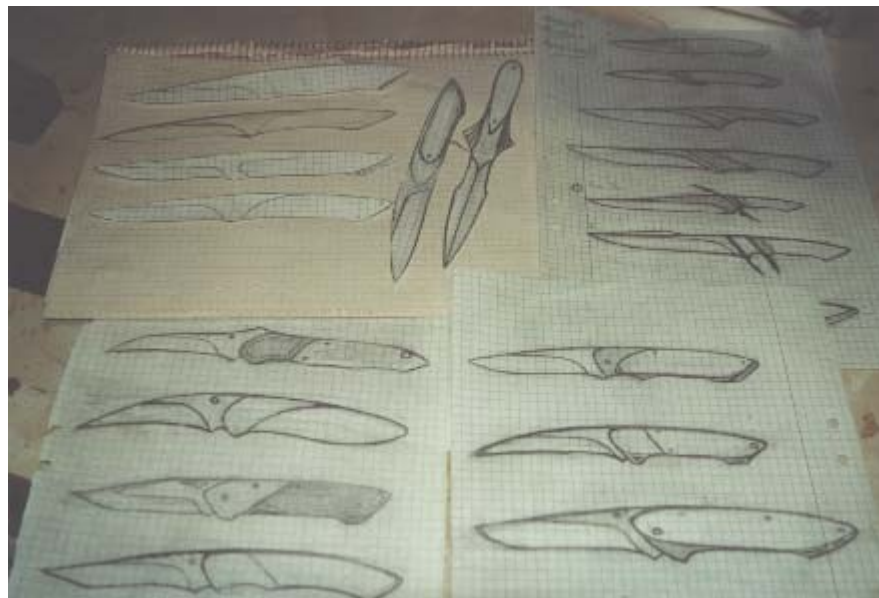
# The making of a knife ! Our way !

On this page will I try to tell you how I make my kind of knife , from the beginning , with a bar of steel , until a finished knife , embellished with scrimshaw from Viveca Sahlin .

She will also tell you how she makes her wonderful scrimshaw . I do not have a digital camera so you have to be patient while I am developing the photos and also having the time to publish them on our site .

This is Part 1 . [Click here for Part 2](#) . [Click here for Scrimshaw](#) .

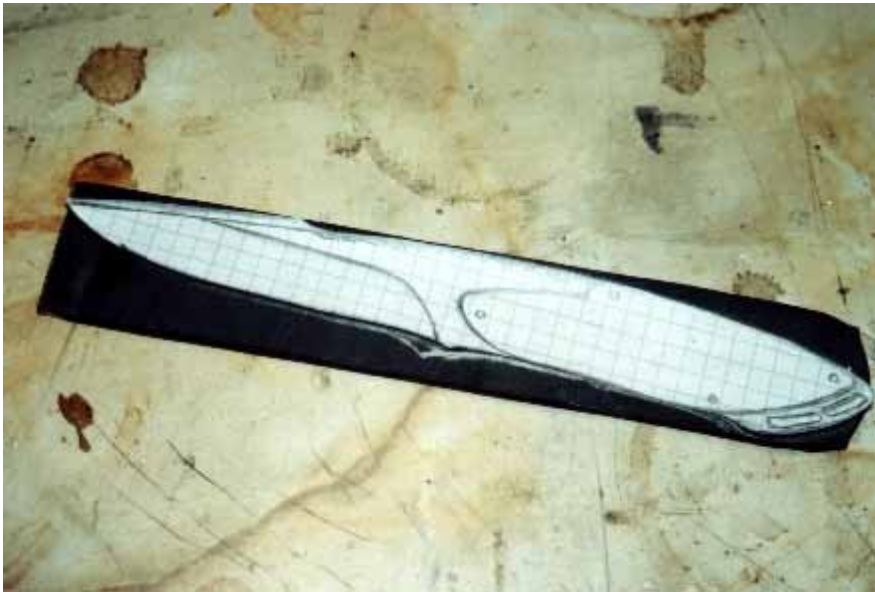
When I try to find out what kind of knife I would like to make , I always use my "sketch-book" . If I don't find anything interesting at the moment , then I make some new sketches .



Then I look at my different sorts of stainless steels , ATS-34 , RWL-34 , Damasteel , 440C etc , and decide what sort I would like to use .



Then I place the cut-out from paper on the steel and trace the lines with a marking pen . The steel of this knife will be the "twist-pattern" from Damasteel .



If the steel , for some reason , isn't the same size as the sketch . I have to make it fit , and for that purpose am I using a hack-saw .



Then I begin to grind the steel following the lines that I made on the steel .



When the profiling is done , I drill holes in the knife blank . Bigger holes for making the knife easier to taper and smaller holes for the rivets to the scales .



I am using a marker pen to color the back-end of the knifetang , then I take a scribe and mark the final size of the tang . I usually spare 1 m/m of the steel .



The first thing I grind of , is a 45 degree angle , so that I will see how close I will come when doing the tapering .



Then am I flatgrinding the sides of the tang , from the front-end of the bolsters to the end of the tang . That means that the tang will narrow from the bolster to the end of the tang ( a tapered tang .).



I start the same way when I do the grinding of the blade , but this will be a hollow ground blade , not a flat ground .



This is how it looks when I have made the blade grinding using grit 120 sanding belt .



[Continue with part 2](#)

If you have any questions , please contact Anders Johansson at [anders@scrimart.u.se](mailto:anders@scrimart.u.se)

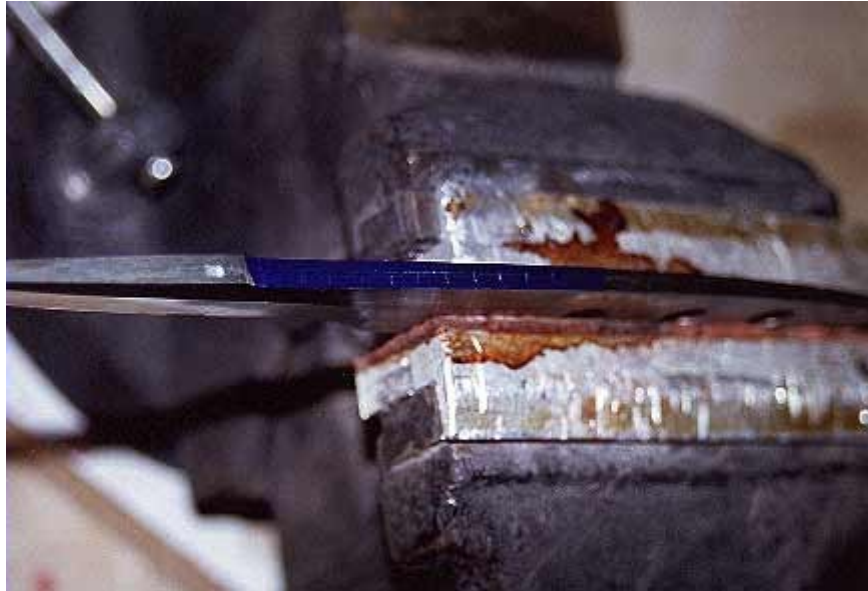
## The making of a knife , part 2 .

[Click here for Part 1](#) . [Click here for Scrimshaw](#).

After grinding the blade with grit 120 , I continue to 180 . Then I change to the Trizact-belt A 65 and A 45 .

Now it is time to make some decorations , i.e. filework .

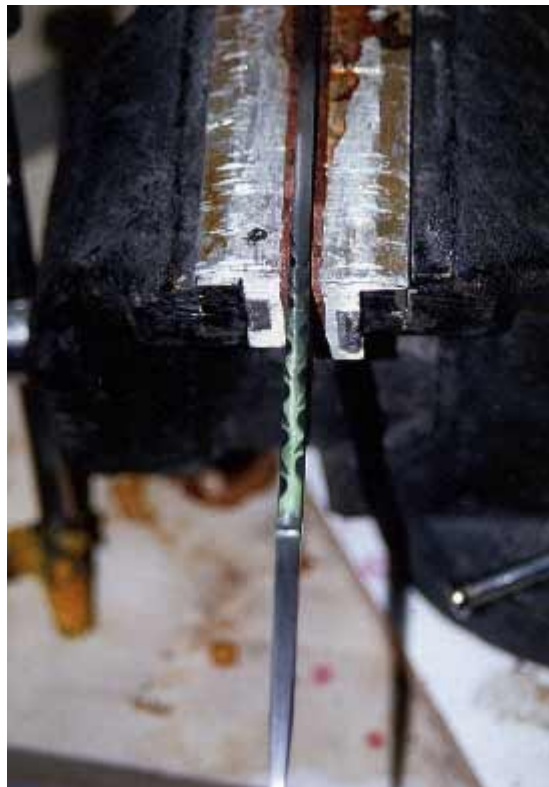
The first thing that I do is using a marker pen and dye the area that will be fileworked . Then I mark the centerline with a scribe and also marks the places where I will do my working .



When this is done do I take a small square file and marks the places better .  
The next thing is to use different files to different fileworking patterns .



Experiment a lot to find out some special patterns that you like .



When all this is done do I send the blade for professional heat treatment .  
When it comes back I start to do the hand sanding , using a flat piece of soft  
wood or plexiglass to the flat parts and a piece of hard rubber hose or a ice



hockey puck, ground to the same radius as the contact wheel, for the edge .



Because this is Damasteel and I have to etch the blade , I stop hand sanding at grit 800 . Otherwise , I go to 2000 or 1200 depending on what type of finish I want on the blade , polished or satin finish . Now it is time to profile the handle slabs , I will have a "frame" of damasteel around the mammoth ivory and mark the handle profile on to the ivory . After that I move the markings appr. 5 mm inwards and cut it out with a bandsaw . Take it very easy , mammoth ivory is very sensitive to heat .



I clamp one of the ivory slabs to the handle , in desired position and drill the pin holes .



After that I clamp the two slabs together and drill the holes using the first slab's holes as markers .



Using two old drills as "pins" , I start to grind the two slabs together , making them a pair , same size and form .



When I have the size I want , I mark the form of the slabs on a piece of spacer material and cutting and filing it out exactly .



When the handle slabs are finished it is time to etch the Damasteel . I use a 1 liter plastic bottle , cut off at the top , filled with hydrochloric acid . Let the blade be in the acid 25-35 minutes , a little bit depending of what koncentration and what temperatur the acid has .

Be sure to use gloves , eye and inhalation protection , work in a well ventilated area because the vapour is toxic !

( I sometimes use acetic acid , but it takes a couple of days for the acid to work properly , but it is much healthier ! )

Sorry , no photo from the acid process , I didn't want to destroy my camera .

I have used 1,5 mm goldthread for the pins , be sure to have flattened or doomed ends of the pins to get them properly peened . Use 24 hour epoxy-glue , to be sure that you don't run out of time when gluing the handle slabs .

The finished work before scrimshaw looks like this :



Now it's time for [SCRIMSHAW !](#)

If you have any questions , please contact Anders Johansson at [anders@scrimart.u.se](mailto:anders@scrimart.u.se)