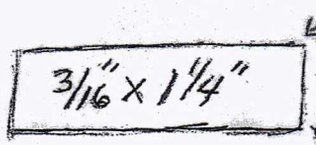
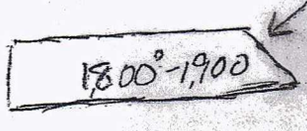
AACB Cannons borough 2016

Making a "High Notch Skinner". Sam Stoner Jr.

Dub off corners on grinder

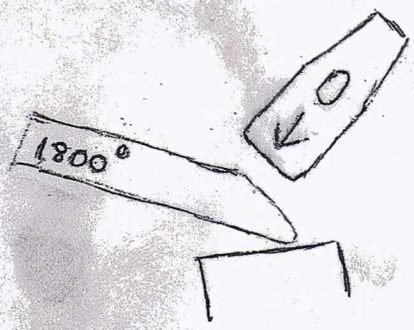


Forge steep angle (approx 45°)

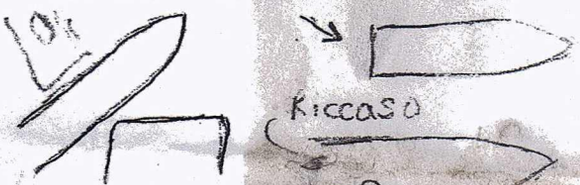


Try to keep uniform thickness

Forge radius on upper corner and at same time bring point to center line of bar



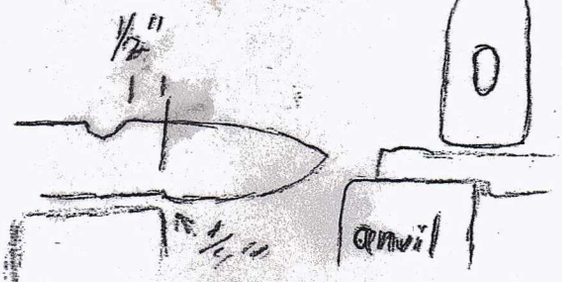
desired result



Next, establish blade length

Forge distal taper at this point
Do not thin riccaso

If desired, High Notch can be made at this point



Start at 1800°
forge to 1,300°
Concentrate Blows here

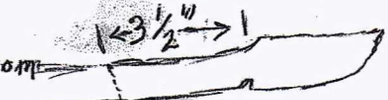
Forge Bevels

← this will raise point

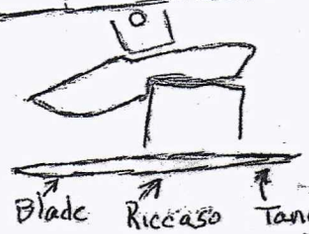
lighten Blows as temp. nears 1,300°

Do not thin below 1/16 in thickness

Hot cut knife from bar 3 1/2" from riccaso notch.



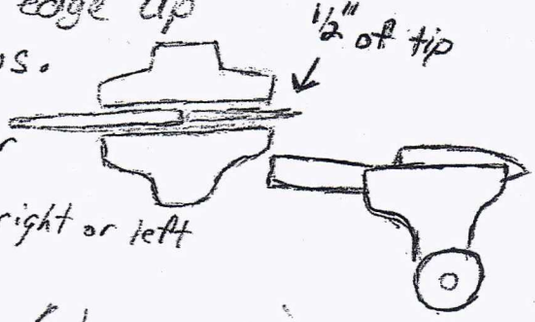
Forge handle taper over anvil edge.
Forge distal taper length of tang



riccaso should be thickest part

2

Bring blank to cherry red and clamp edge up in vise. allow 1/2" of point past jaws.



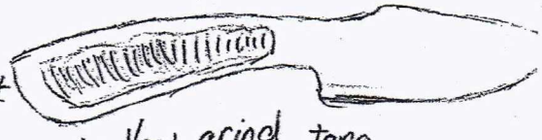
Sight along tang and edge and hammer straight. Tip protrudes enough to tap right or left as needed.

Once straight, Bring to just none magnetic (cherry range), air cool to black heat. (1st normalizing)
Reheat to non magnetic and air cool to room temp. (2nd normalizing)
This refines grain structure and softens for grinding / drilling.

Next is grinder work...

Grind profile to desired shape

Next we must establish flat surfaces...

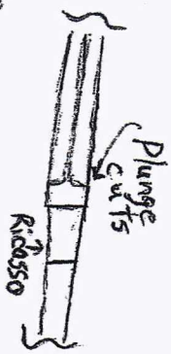


2nd Grind tang flat on grinder platten
Remove all scale / hammer marks from

Grind Bevels next...

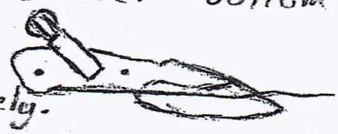
- Important considerations are:
Don't take grind line too high Before heat treat
- Be sure plunge cuts line up and edge is straight & centered

Now drill handle pin holes
I use #30 bit for 1/8" & #41 bit for 3/32" & letter F Bit for 1/4" holes
This give a couple thousanths clearence that is very helpful!



Heat treating: This determines final potential.
Place knife edge down in clean even fire
Only enough air blast to reach proper temp.

We only need to reach Non magnetic over bottom half of blade
Quench bottom half in light oil
when all color is gone, submerge entirely.



Repeat this process for a total of 2 Cycles.

Once cooled to handling temp. we must clean hardened portion and wipe extra oil off knife. Use grinder or sandpaper on hardened area until clean metal surface is bare.

Blade can be placed in oven for 1½ hours at 400° or... use propane torch. Heat spine with tip of flame.

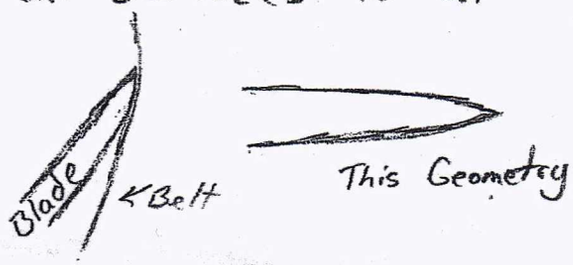
Heat slowly, moving flame along spine only.

Watch for pale yellow color on shiny metal. Color will change fast. When color is dark brown with violet tint quench in water.

Next, finish grinding by taking to final thickness approx. .020 to .025 at egde. Grind all surfaces to at least 220 grit finish.

On slack belt grind convex edge. 220 or 400 grit

Hand pollish or buff blade now.

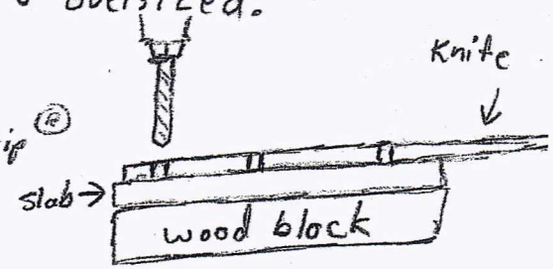


Handles... Trace handle outline on desired material

Cut material being sure to stay approx 1/8" oversized.

Grind both slabs flat.

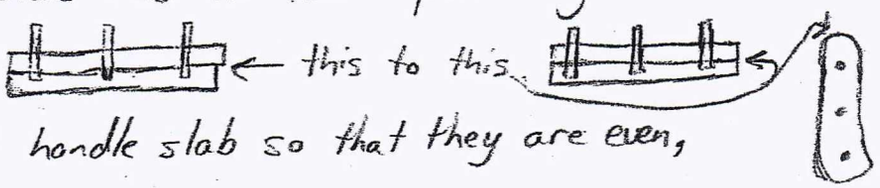
Clamp one slab to the tang with Vise grip® and drill using tang as a template



Repeat with opposite side

Cut pin stock min. 1/8" longer than total handle thickness.

Slide pins through one slab and at least partially into opposite handle slab



Now grind or file top of handle slab so that they are even, finish with 220 or finer

Make a trial fit to be sure every thing fits nicely.

Mix epoxy, dip pins in glue and place in one slab. Coat slabs liberally. Clamp tightly. When dry, grind to shape. Radius done with slack belt. Finish all surfaces to at least 220 grit.

Enjoy your new knife!