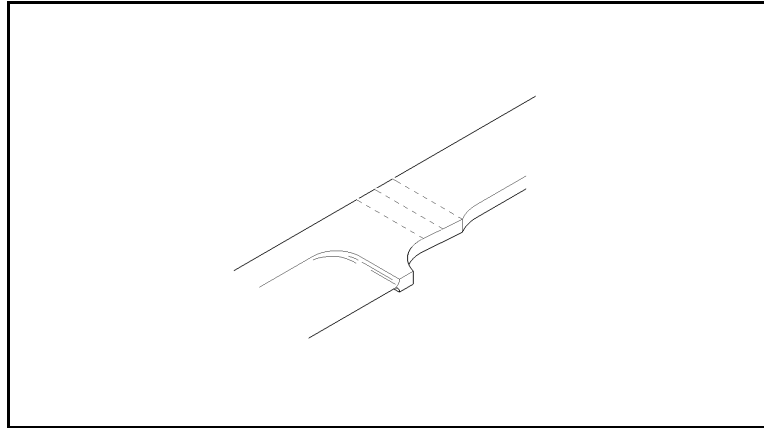


## Making a Loveless style guard

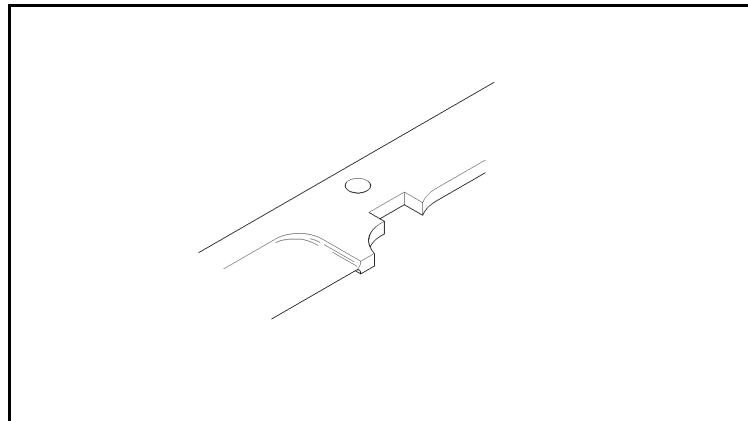
When starting off to fit a guard, three lines need to be scribed on the blade where the guard is going to be fitted in place. This will be a centre line as well as the front and back faces of where the guard will be. These lines will guide where the pin hole is to be drilled as well as the recess for the guard.



Drill an oversize hole on the centre line leaving at least 5mm from the top of the blade to the top of the hole.

This hole will be filled with a brass rod prior to the guard pin being drilled, and after heat treatment.

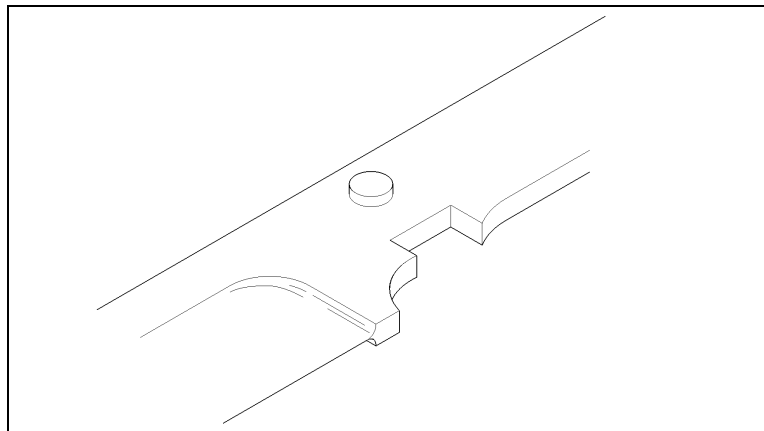
At the lower end of the blade, cut, file or machine a recess into the blank. The guard will fit into this slot and it needs to be slightly smaller than the thickness of the guard material. The depth of the recess is not critical, it is there so that the guard can slot into it for a nice tight fit without any forward or rearward movement of the guard. Lightly countersink the pin hole.



Once these steps have been finalised the blade can be heat treated.

Once the blade has been heat treated, fit a piece of brass rod into the oversize pin hole making sure it is a tight fit.

Grind it flush with the blade and polish the blade.

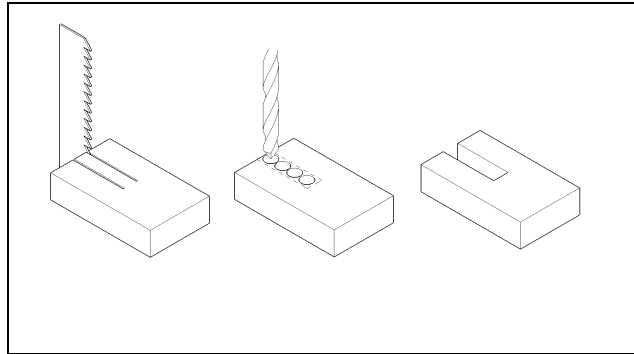


Once the blade is polished the guard can be cut and fitted to the blade.

To achieve this several different methods can be employed, namely:

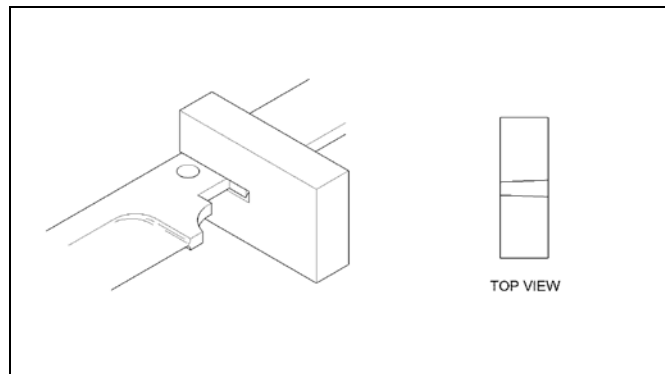
- Filing the slot by hand (this will be very time consuming)
- Using a hack saw to cut out the slot
- Drilling a series of holes and then cutting with a hacksaw or filing the slot
- Milling it out on a milling machine using either a milling cutter or a slitting saw

Depending on your skill levels the slot is normally cut undersize and then filed to get a nice tight fit.



Final fit of the guard can be done using various methods.

- If you have a tapered handle, file the guard till it fits just behind its final resting place making sure the slot is parallel to the blade and that no gaps are present. Using a disc sander with fine paper grind the blade on both sides lightly checking on a regular basis until the guard fits in place.
- Using a fine file, file the guard slot at a slight angle taking more material off the rear of the slot than in the front creating a slight taper in the slot. Take care not to file too much at the rear as this will leave a gap once the guard is fitted.

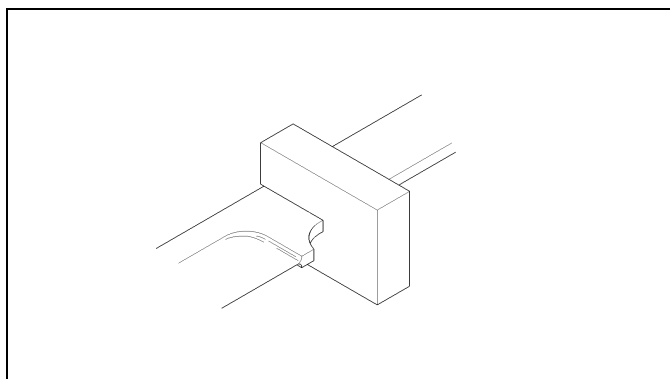


Once the slot is a nice fit on the blade it is time to work on the thickness of the guard.

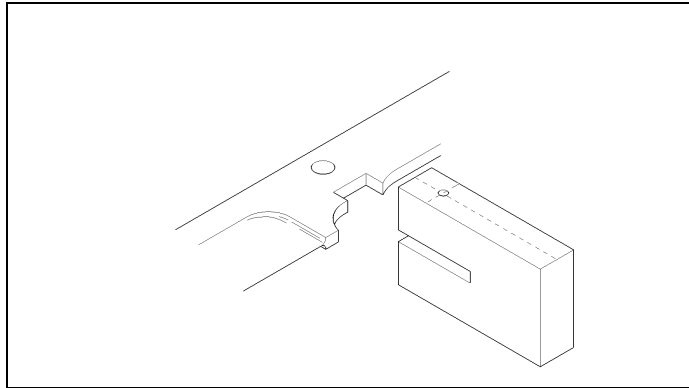
Polish the front face of the guard and then carefully grind the rear of the guard till it fits into the slot of the blade.

The depth of the slot in the guard must be such that it slightly protrudes above the top of the blade once it is fitted to the blade.

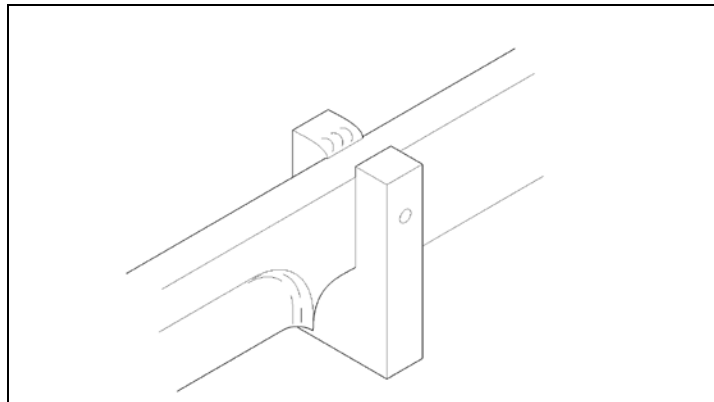
Measure the amount of protrusion.



Mark a centre line down the length of the side of the guard where the pin hole is to be drilled.  
Measure the distance from the top of the blade to the centre of the brass rod in the blade and add the amount of protrusion that was previously measured. Carry this measurement over to the guard and mark where the pin will be.  
Centre punch this mark.



Fit the guard to the blade making sure it fits tightly in place.  
Drill a hole through the guard and blade using an appropriate size drill for the pinning material that is to be used.  
The brass insert should be large enough to allow easy drilling of the blade should there be any slight misalignment.  
Fit a pin into the hole and peen it over on both sides.  
The guard should now be securely in place with no visible gaps showing.  
Place the guard in a vice so that the top of the blade is uppermost.  
Using a ball peen hammer peen the insides of the bolsters towards the blade (a punch can also be used). If done correctly this should fill any gaps that might have been visible.



The top of the guard can now be ground flush with the blade.  
Pre grind guard to size before fitting handle slabs as this will prevent heat build-up when grinding to shape thereby save you from burning the handle material.  
The knife is now ready to have the handle fitted.

