


Peachsmith Designs


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"At face value, the knife is a simple tool - a sharp-edged blade attached to a handle- that dates back millions of years. Yet, it looms large not only in human history but in literature and legend as a utilitarian device and weapon... But as conceived and created by metalsmiths, this ancient instrument becomes an astounding work of [art](#)"

- 500 Knives - Lark Books

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By listening to many great thinkers, I have learned the best way to learn something is to jump right in.

This document is a combination of learning by looking at as many facts as possible while training the body and hands to do the work. While making this, I created around 50 knives, which 10 were folders. I learned alot, failed alot, but most important if you are reading this I am still fighting, grinding, and repeating every day.

- Ted

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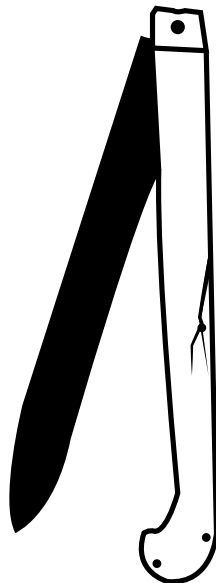
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## History of the Pocket Knife



600 B.C.

- Single blade with bone handles

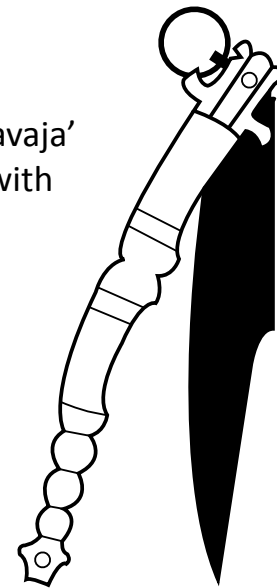


1600

- Gully Knife
- Common among sailors & pirates

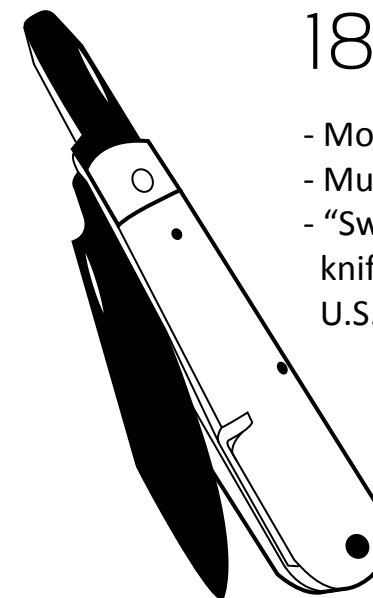
1660

- Spanish 'Navaja'
- First knife with lockback
- Slipjoint developed



1890

- Modell 1890
- Multi-tool
- "Swiss Army" knife coined by U.S. soldiers



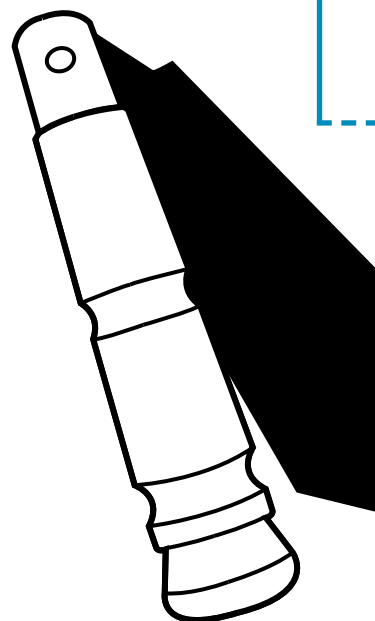
200

- Roman 'Swiss Army' Knife
- Rare among Traders



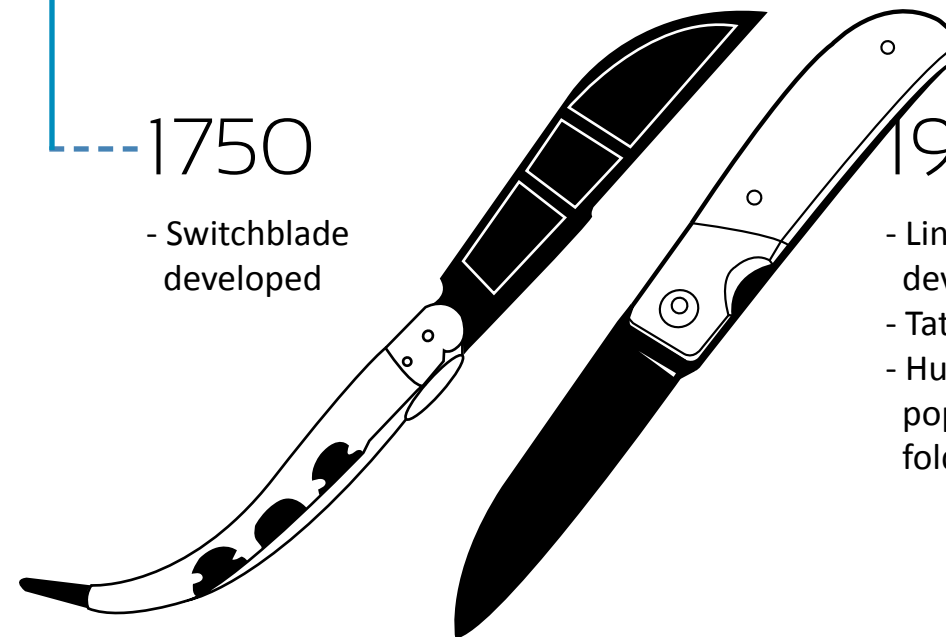
1650

- Penny Knife
- Production run in Sheffield, England
- Common among farmers & workers



1750

- Switchblade developed



1980

- Linear lock developed
- Tactical Folders
- Huge spike in popularity in folders

# Overview of Knives

## Pocket Knives



## Fixed Blades



## Art Knives



## Culinary





## Production Market

- High volume production
- Cost Range:
  - Low cost from outside countries
  - Higher cost from specific brands
- Patented locks and style markers
- Custom maker production replications



### Spyderco

- Golden, Colorado
- Known for 'abnormal' style
- Spends a lot on research
- Over 86 Patents and trademarks
- First company to use a clothing clip in 1981
- Round hole makes for easy one hand opening



Trademark Round Hole

Bi-Directional Texturing

### Microtech

- Bradford, Pennsylvania
- Established in 1994
- Known for out the front (OTF) knives
- Produces fixed blades, OTFs, Butterfly, Assisted-opening knives
- Also produces one-off customs



OTF deployment







# Custom Market

- Makers range in original fields before knives
- Styles differ largely between makers
- Higher prices
  - Sold on secondary market for even more
- Higher tolerance and hand fit
- Each piece is unique/individualized
- Series continually evolving in some form



## Tuff Knives



- 28 year old
- Penndel, Pennsylvania
- Current Models:
  - Tanics \$800+
  - War Toad \$300+
- Sold War Toad to Boker



## Serge Knives



- 32 year old
- Originally from Ukraine
- Current Models:
  - Bean Folders \$550+
  - Coin Claws \$250
- Sold Dog Tag to Spyderco





# Artisan



Wilburn Forge



Moing \$175



Leeman \$550



Serge \$\$\$



Walker \$\$\$\$



Patt \$\$\$



Chimeras ~\$400



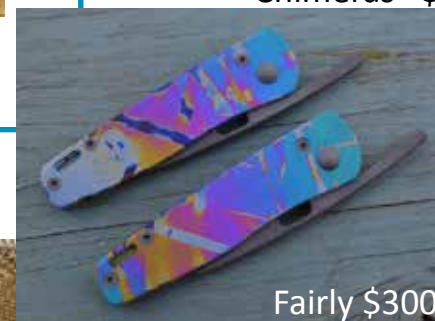
Tuff knives \$800+

\$50

\$1500+



Fairly \$150



Fairly \$300



Atwood \$90



Delorme \$100



Fellhoelter \$200



R. G. Epting



Wilburn Forge \$1400



Morris \$70+



Delorme \$180



Serge \$250



Runals \$450



Serge \$5



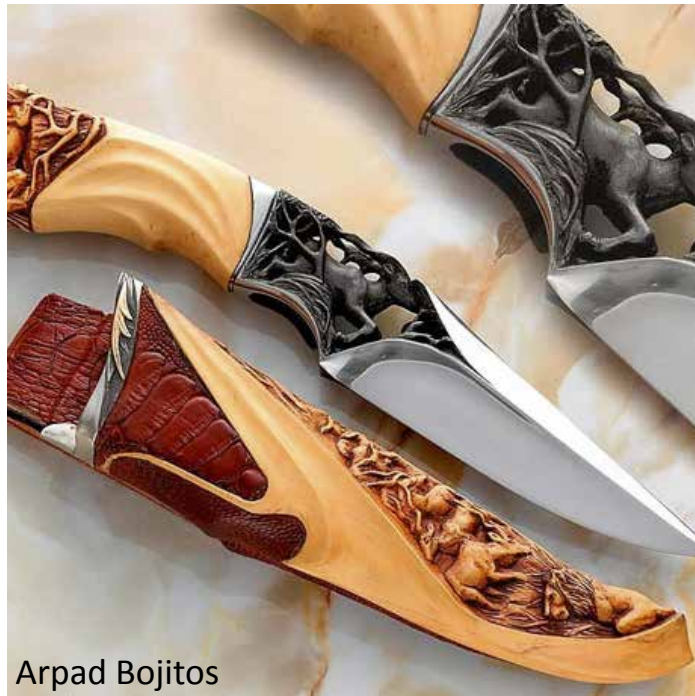
Woods \$1000

# Tactical



# Art Knife Market

- Full custom knives
- Cost easily moves up to \$10,000
- Decoration goes well beyond normal
- Use of exotic/rare materials
  - Mosaic Damascus
  - Precious metals (Gold)
  - Precious stones (diamond)
- Incorporates jewelry-like skills
  - Engraving
  - Setting pieces/stones



Arpad Bojitos



Dr. Fred Carter



Jurgen Steinau



Johan Gustafsson "Golden"



Steve J. Lindsay



# Multi-tool Market

- Multi-tools
- With or without blade
- Key chain tools
- Often sold beside pocket knives by same or similar companies/makers
- Common Features:
  - Prybar
  - Driver bits
  - Bottle Opener

## Leatherman

- Portland, Oregon
- Established in 1983
- Known for multi-tools
- Also produces knives and pocket tools
- Over 50 patents
- Patented bit holder and thin driver bits



Driver Bit & Holder      Locking Blade



BOKER

\$10



Victorinox \$15



Gerber \$6



Swiss Tech \$20



Curtis \$35

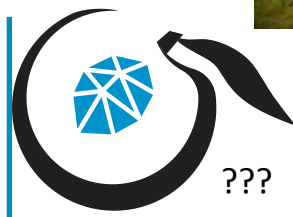


Uzi \$30



Leatherman \$25

Artisan



???



Timberghost \$350+



Timberghost \$140+

\$100+



Tuff \$75



Leatherman \$160



Swiss Army \$65



Gerber \$60



Amsler \$75



Leatherman \$80

Tactical

## Europe

### Anti-locking Countries



#### Denmark

- All locking and fixed knives illegal
- Single-handed opening illegal
- Non-locking knives legal under 3"
- Knife will be confiscate if illegal



#### France

- Non-locking knives legal with no limit
- "Category 6"
  - Any weapon that can constitute a danger to public
- Low knife crime rate



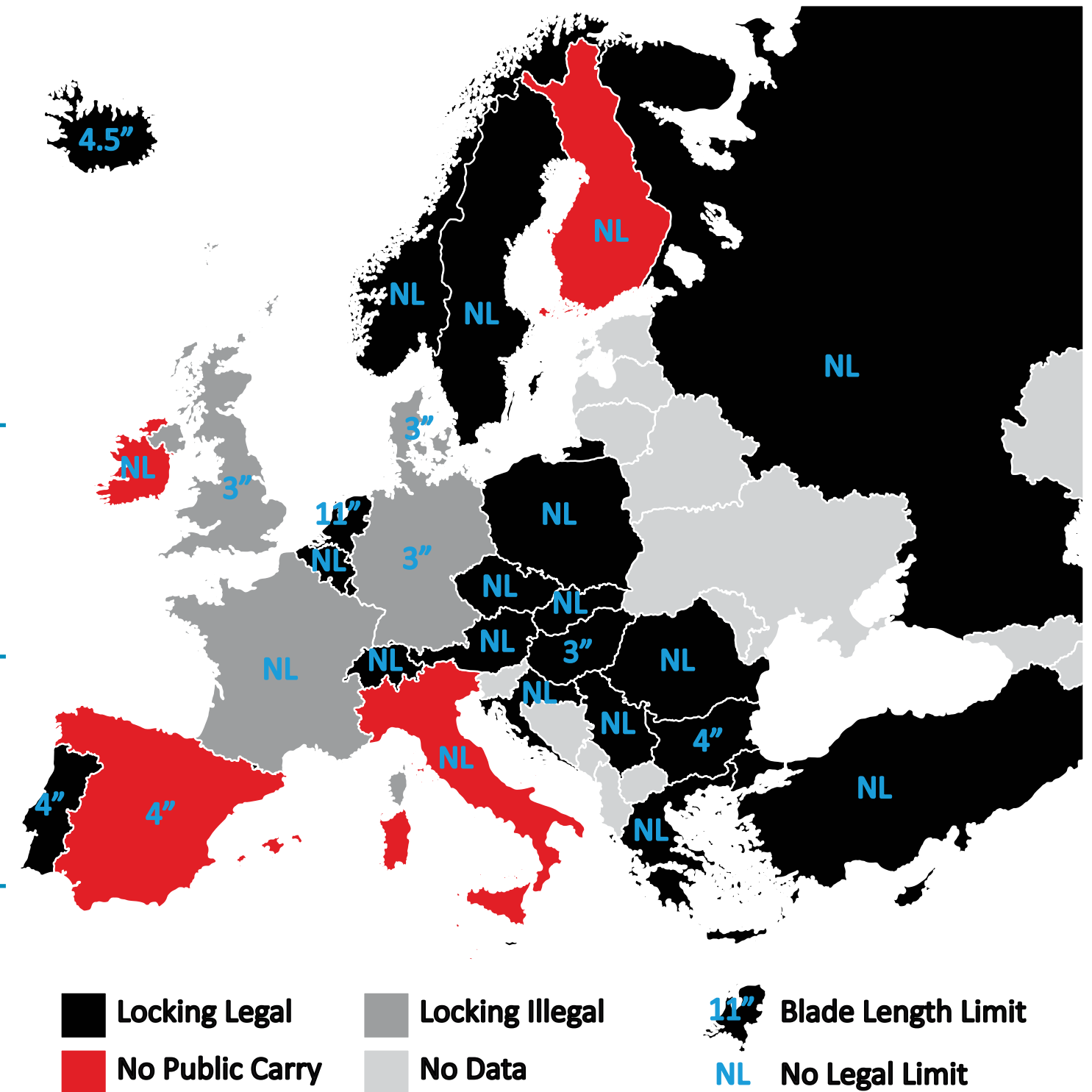
#### Germany

- Non-locking knives legal under 3"
- Single-handed opening illegal
- Exception for hunting or profession related knives



#### U.K.

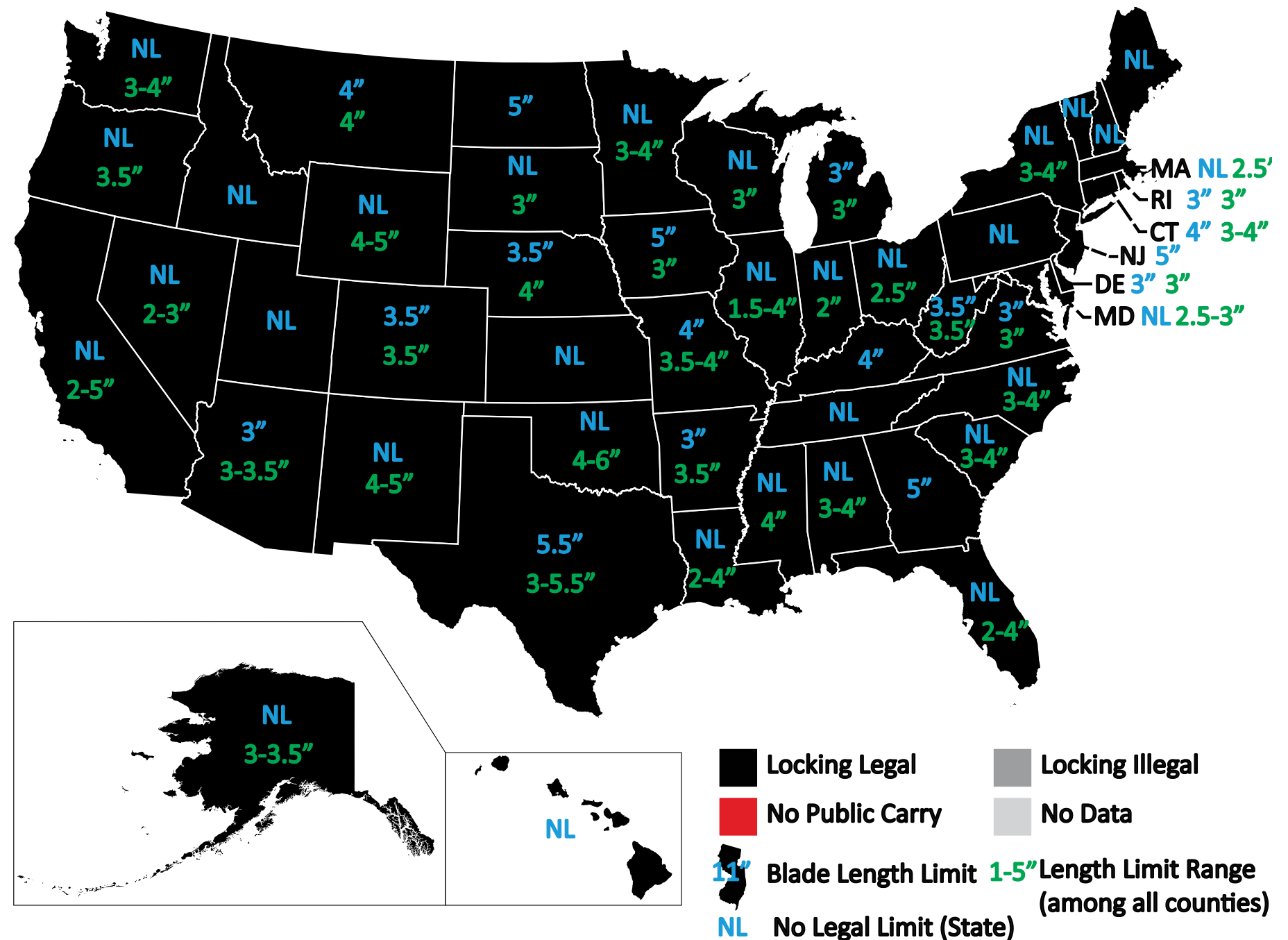
- Non-locking knives legal under 3"
- Must have justified reason for carry
- Swiss Army knives very popular
- Higher knife crime than USA



# U.S.A.

## Federal Laws

- Switchblade and ballistic knives are illegal to carry
- Any knife with <2.5" blade is not considered "dangerous"





# Terminology

What makes a pocket knife?





# Parts of a Knife

- Parts differ depending on:

- Lock
- Blade Profile
- Grind

- Terms:

- **Belly**

- curved part of the blade, width affects point sharpness

- **Bolster**

- metal ends that support pivot

- **Choil**

- where blade meets handle, can be sculpted with finger groove

- **Jimping**

- notches designed into blade for better thumb control

- **Ricasso**

- flat section between guard and bevel/grind

- **Serration**

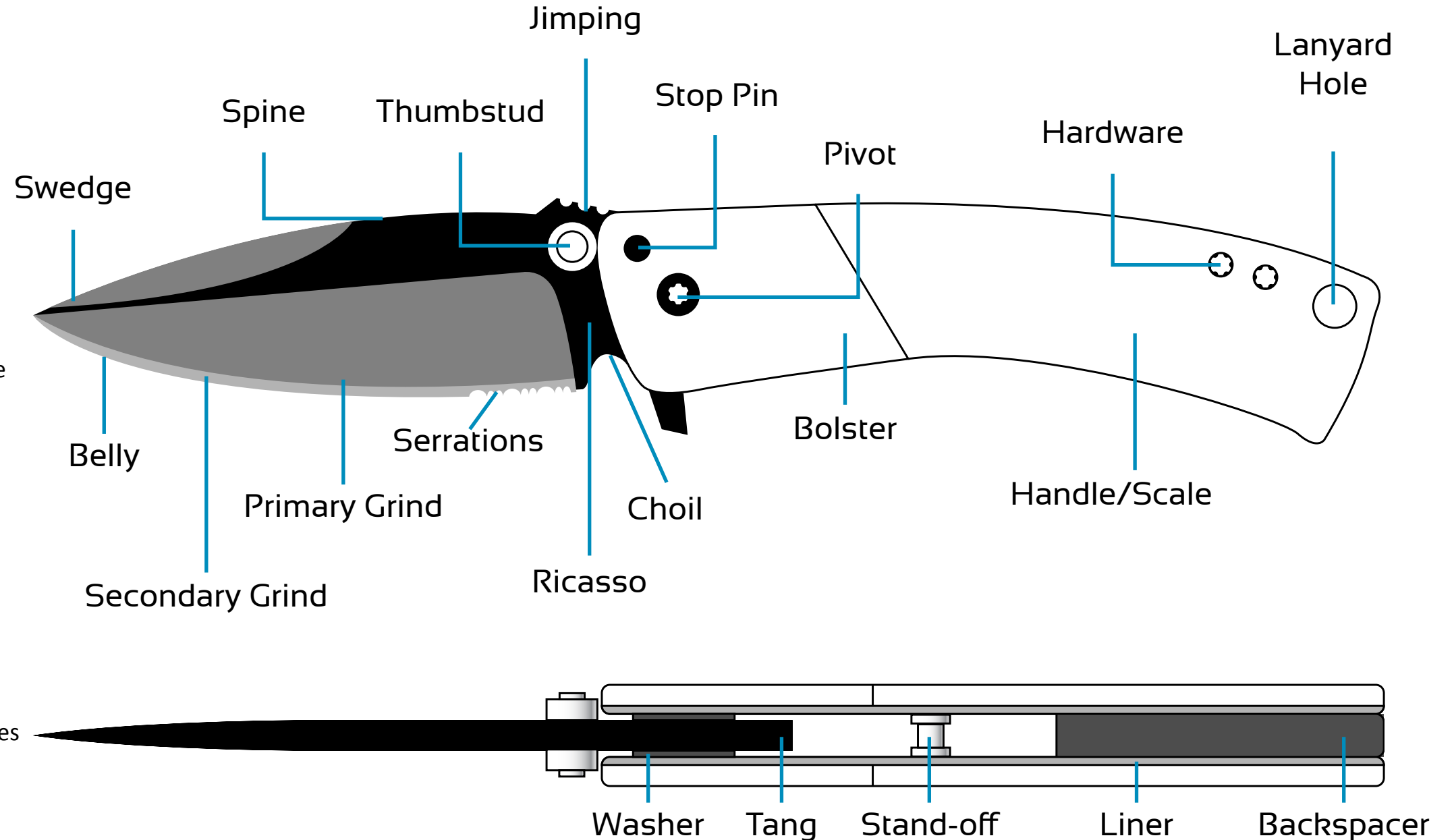
- set of "teeth" to aid in cutting

- **Spine**

- thickest part of blade, found in the middle on double edged blades

- **Swedge**

- bevel on back of blade, known as false edge and can be sharpened



# Blade Profiles

## Normal

- Flat back allows user to apply finger pressure
- Good at chopping, picking, and slicing



## Spey

- Lacking a point
- Suitable for skinning
- Not meant for piercing



## Tanto

- Kamasu Kissaki (Japanese)
- Point aligned with spine
- Strong, thick tip
- Good for piercing



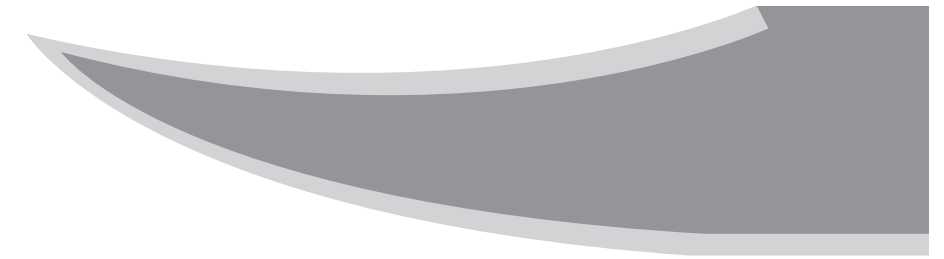
## Warnccliffe

- Straight edge
- Dull back curves down
- Usually very thick and heavy



## Clip-point

- Ground sides start low on blade
- No secondary bevel/edge
- Thin but sharp edge



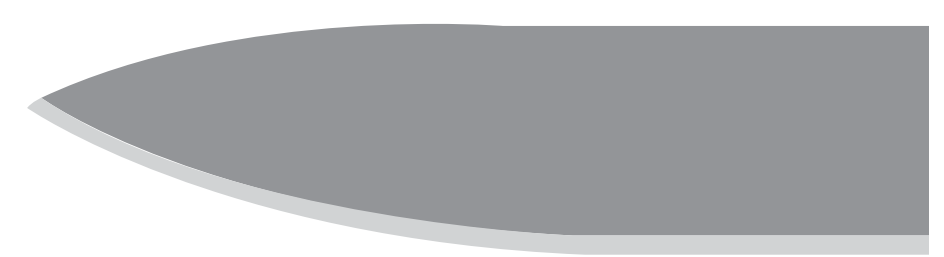
## Trailing-point

- Large cutting area/belly
- Allows for larger edge
- Optimized for slicing or slashing



## Drop-Point

- Convex back towards point
- Stronger tip than Clip-point



## Sheepsfoot

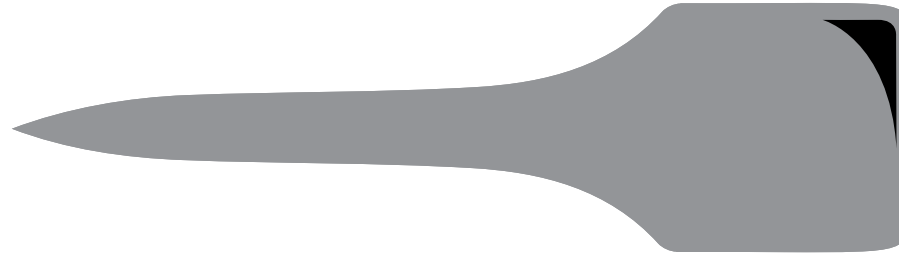
- Back curves down near tip
- Prevents accidental cuts from tip during carry



# Blades Grinds

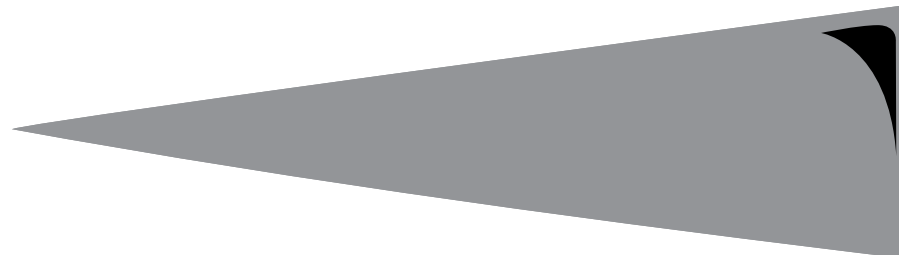
## Hollow

- Concaved ground sides
- Thin edge = Sharp
- Low durability



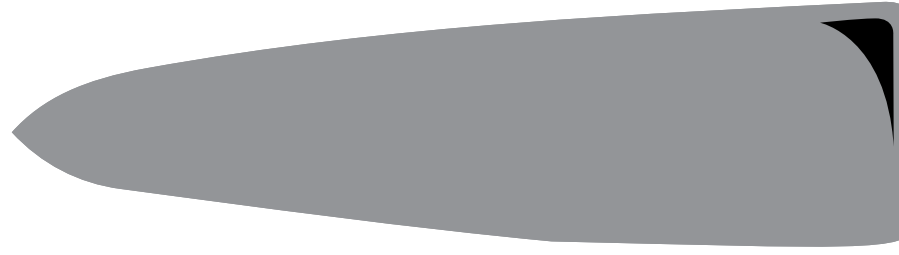
## Flat

- Straight ground sides
- Easy to sharpen
- Moderate durability
- Can have second bevel edge



## Convex

- Sides taper but slight curved outwardly
- Very strong edge



## Chisel

- Only one side is ground
- Sharpest edge
- Japanese put a small hollow on back to reduce drag



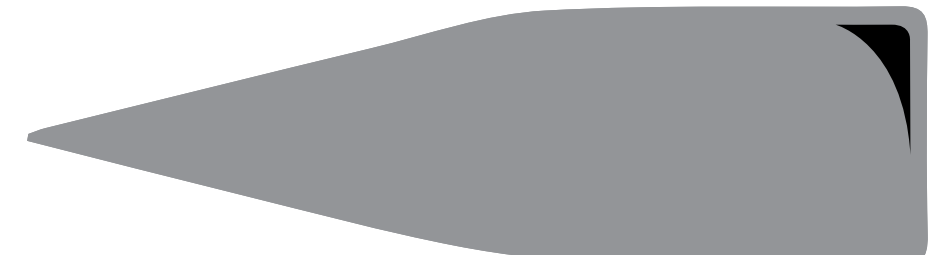
## Scandi

- Ground sides start low on blade
- No secondary bevel/edge
- Thin but sharp edge



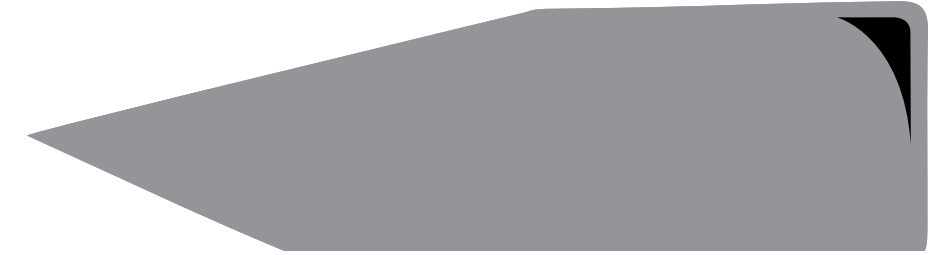
## Saber

- Ground sides begin half way down blade
- Good for tougher jobs
- Best with second edge



## Assymetric

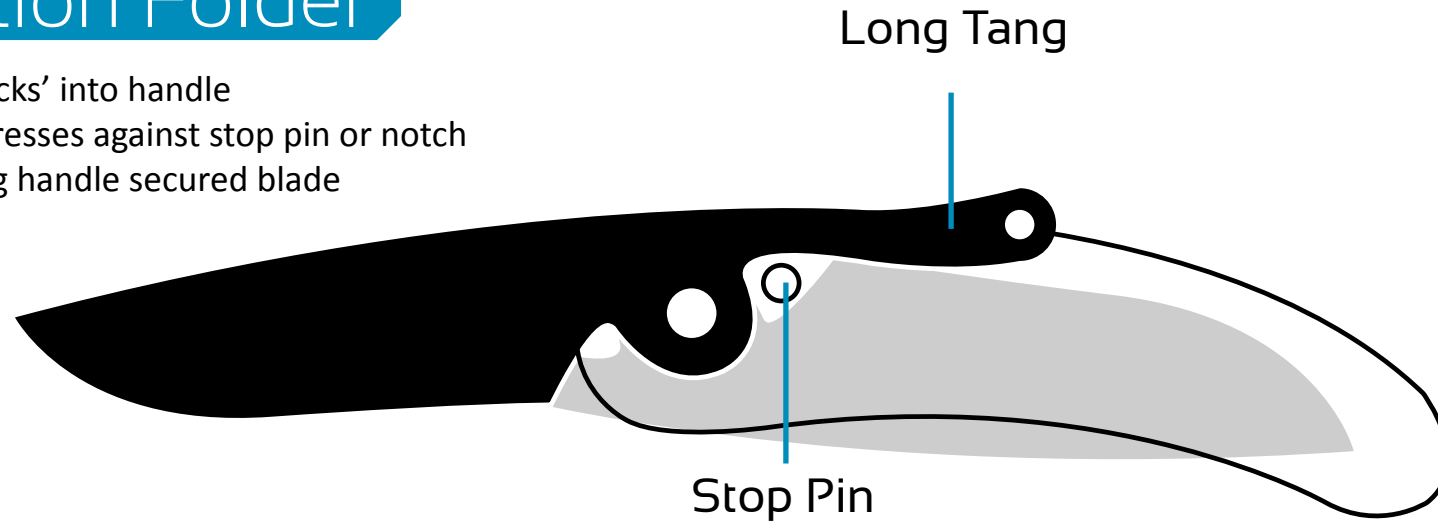
- Combines grinds on each side individually depending on use
  - assymetric flat
  - semi-convex
  - chisel with back bevel
- Adds durability
- Weakens sharpness



# Non-locking Styles

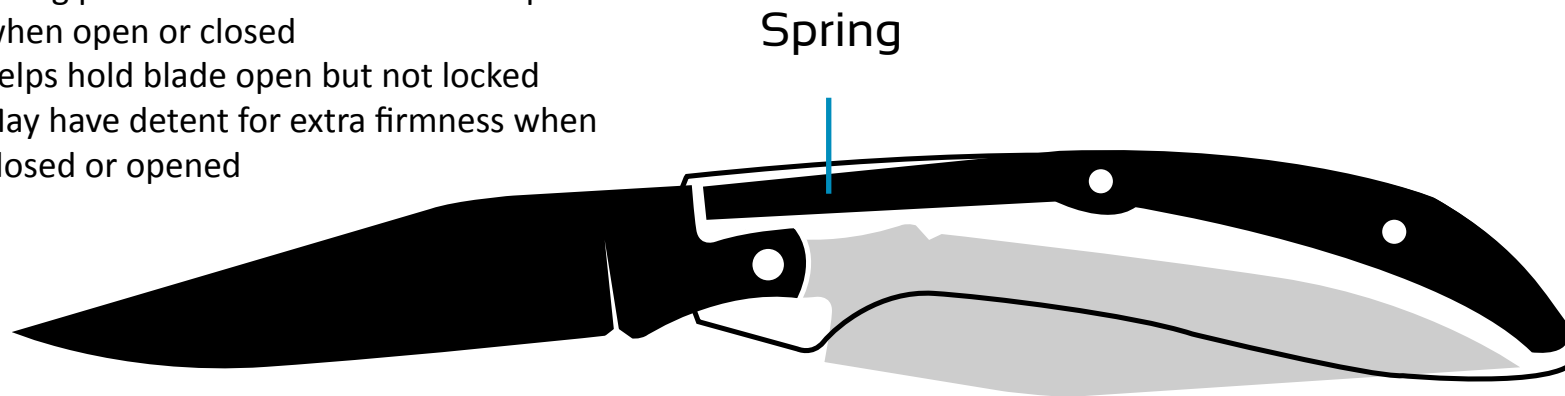
## Friction Folder

- Tang 'locks' into handle
- Blade presses against stop pin or notch
- Gripping handle secured blade

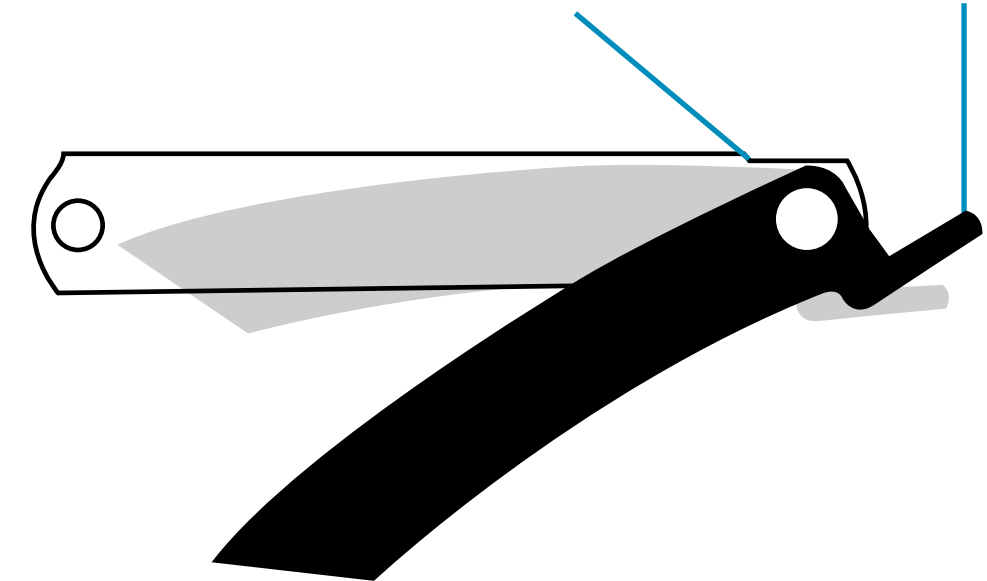


## Slip Joint

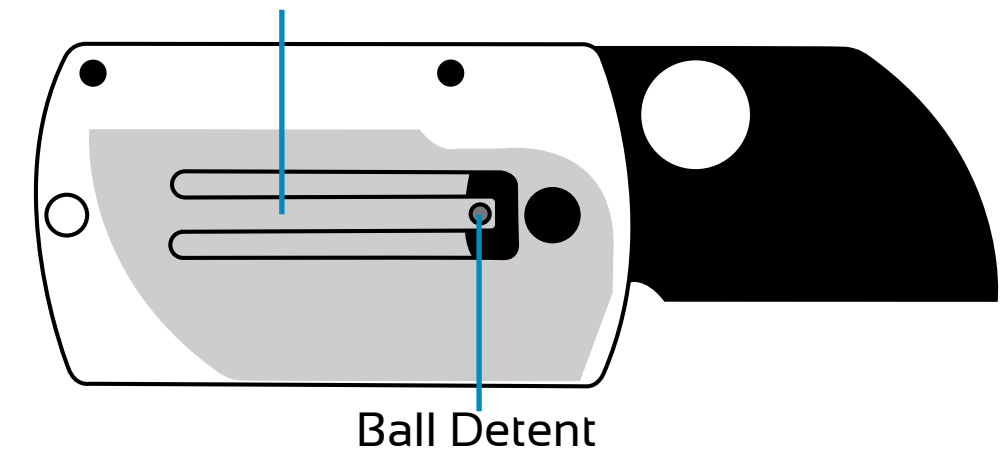
- Spring presses on back of blade except when open or closed
- Helps hold blade open but not locked
- May have detent for extra firmness when closed or opened



Stepped Tang  
Notch for tang



Integral Spring

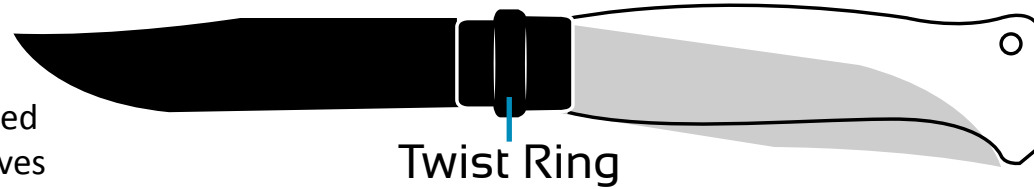




# Locking Styles

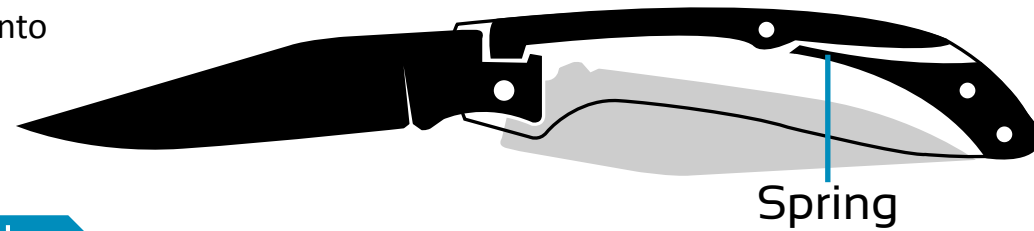
## Collar Lock

- Ring around bolster turns to lock blade when open and closed
- Found on Opinel knives



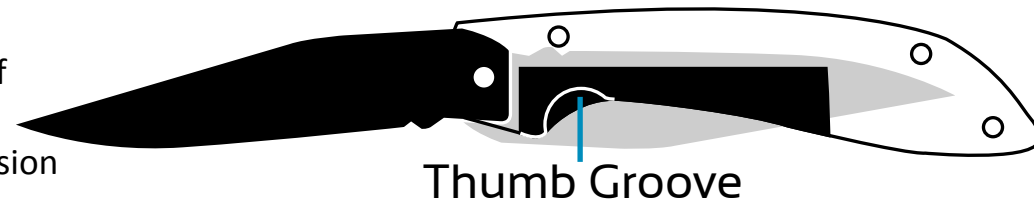
## Lock Back

- Pivoted spine locks into blade when open
- Variations: Mid lock



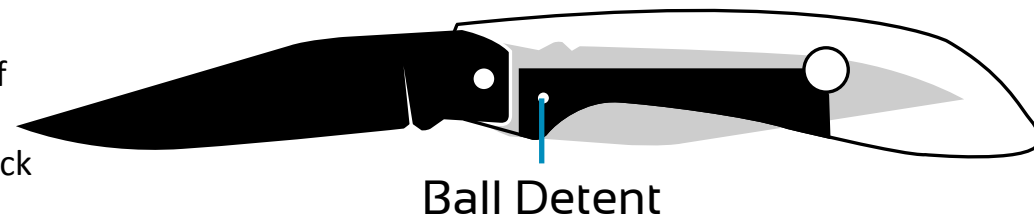
## Liner Lock

- Tensed part of liner locks against back of blade
- Variations: Compression



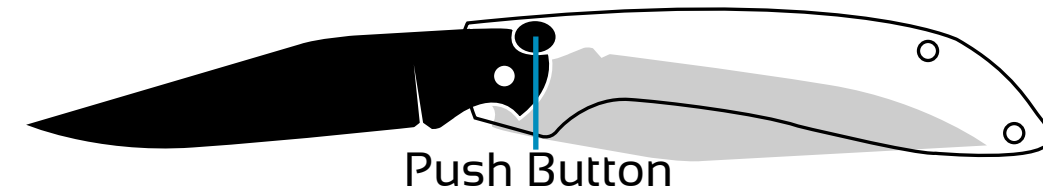
## Frame Lock

- Tensed part of scale locks against back of blade
- Heavier than liner lock



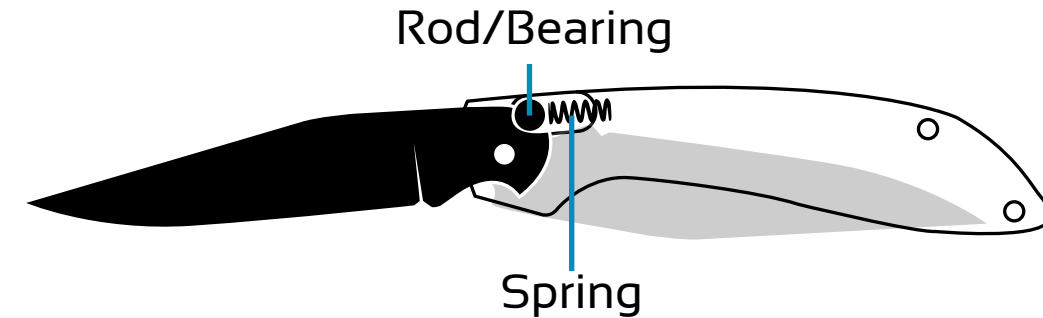
## Button Lock

- Push button locks into notch in blade
- Similar to lever lock



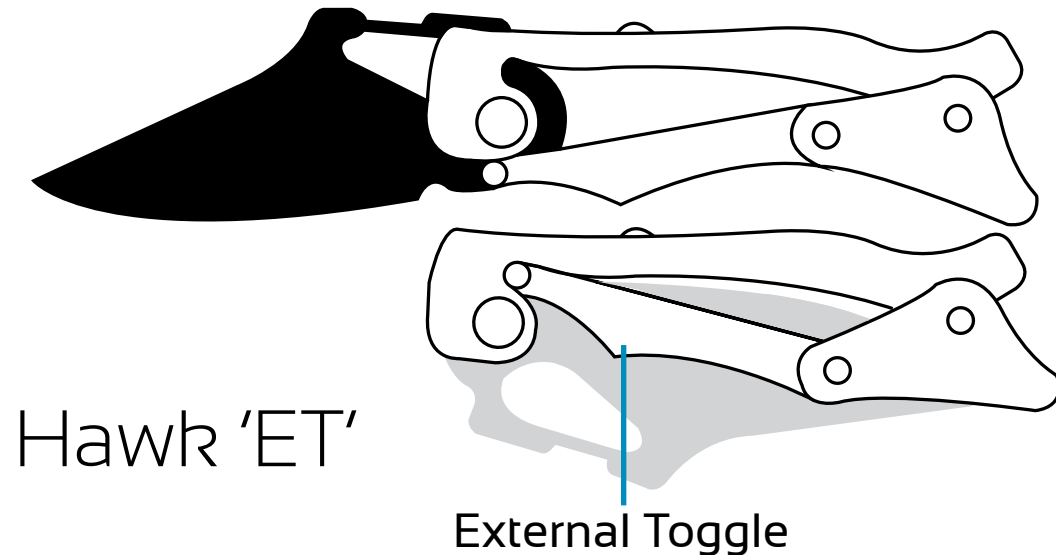
## Bolt Lock

- Rod is pressed against notch in blade
- Many versions exist as company patents



## Other...

- New versions are being created daily with some better than others
- Makers such as Hawk Knives focus on locking systems



# Choosing Materials

## How to Choose

- Performance is affected by many factors including but not limited to:
  - Geometry of blade
  - Type of Grind
  - Hardware
  - Material Choose
  - Intended Use
- Thus choosing the right material depends on many factors such as skill level and tools available to maker since new tools are required for different material sometimes

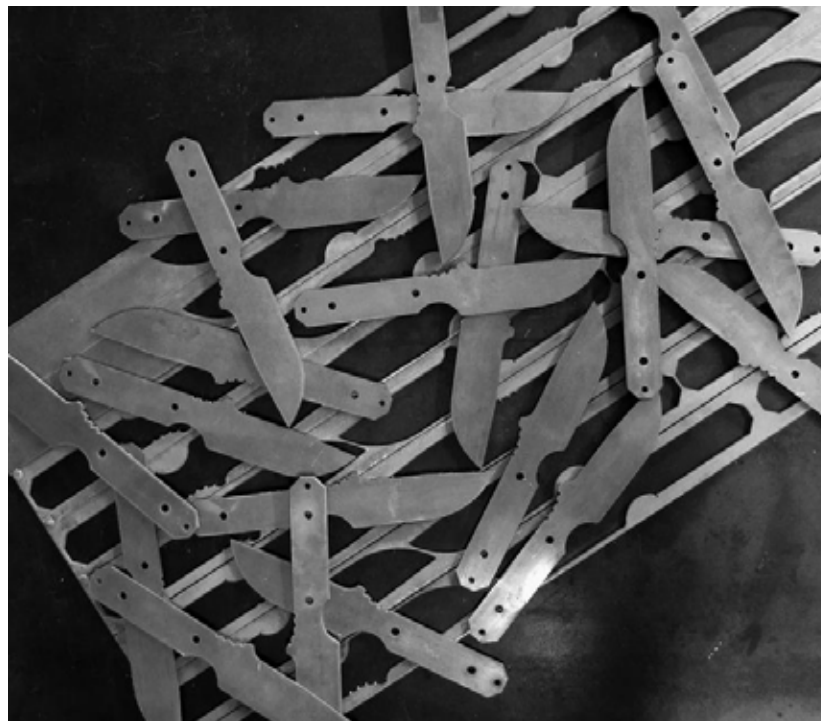






## Blade

- Choice of Carbon or Stainless
- Performance of edge relies on:
  - Type of steel
  - Blade geometry
  - Heat treatment
- Material choice depends on:
  - Performance
  - Environment
  - Durability
- Intended Use and skill level often decides material



## Handle

- Often decorated or textured
- Wide range of material combinations
- Material choice depends on:
  - Aesthetics
  - Environment
  - Durability
  - Lock style





# Metallurgy

## Terminology

- **Metallurgy**
  - Branch of science focus on metal properties, production, and purification
- **Alloy**
  - Metal made by combining metallic elements
  - Choose of alloy is a balance between:
    - **Corrosion Resistance**
      - Ability to stand up to environment conditions before rusting
    - **Strength**
      - Ability to withstand applied pressure
    - **Toughness**
      - Ability to absorb energy and plastically deform without fracturing
      - Tougher = worse at edge retention
    - **Wear Resistance**
      - Resistance to abrasion during use
- **Particle Metallurgy (PM)**
  - Steel is formed into powder
  - Powder is then bonded and compacted
  - Results in uniform composition of alloy

## Ingredients

- Strength vs Toughness

- Alloy Ingredients

- Increasing Strength

<sup>6</sup> <b>C</b> Carbon	<sup>14</sup> <b>Si</b> Silicon	<sup>24</sup> <b>Cr</b> Chromium
<sup>27</sup> <b>Co</b> Cobalt	<sup>25</sup> <b>Mn</b> Manganese	<sup>23</sup> <b>V</b> Vanadium

- Increasing Toughness

<sup>28</sup> <b>Ni</b> Nickel	<sup>42</sup> <b>Mo</b> Molybdenum	<sup>74</sup> <b>W</b> Tungsten
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- Others

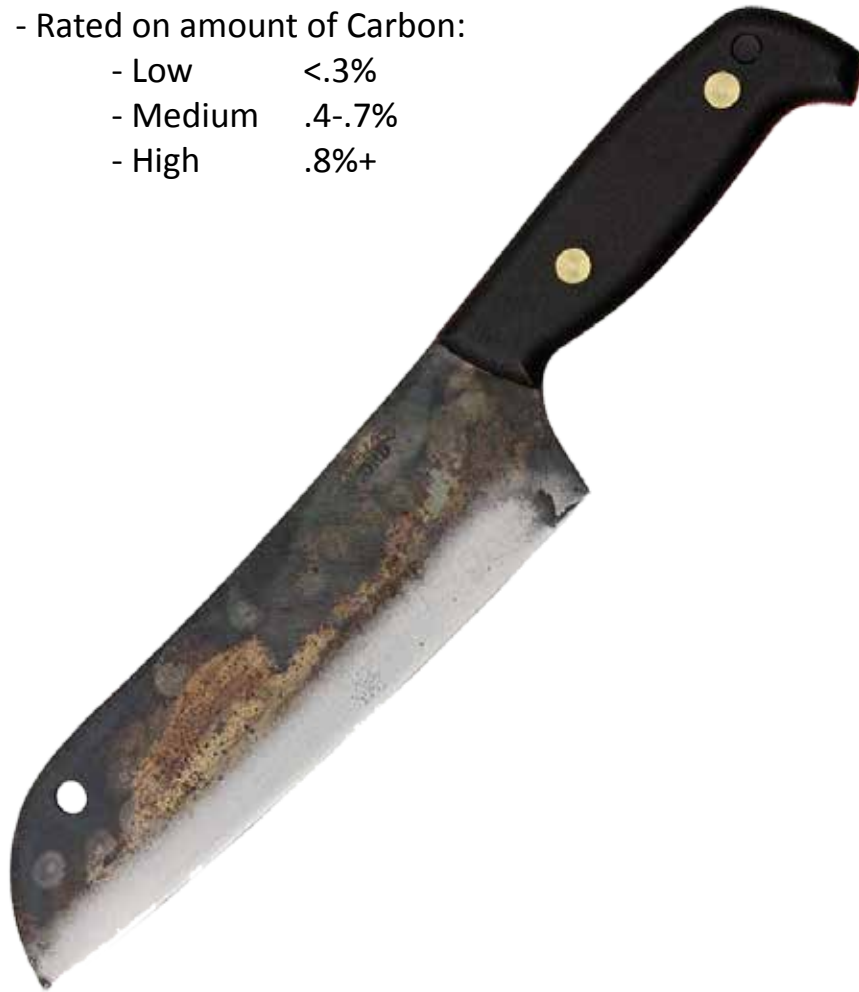
<sup>7</sup> <b>N</b> Nitrogen	<sup>15</sup> <b>P</b> Phosphorus	<sup>16</sup> <b>S</b> Sulfur
<sup>29</sup> <b>Cu</b> Copper	<sup>22</sup> <b>Ti</b> Titanium	



# Blade Steel Types

## Carbon

- Quickest to rust
- Require maintenance by oiling
- Rated on amount of Carbon:
  - Low <.3%
  - Medium .4-.7%
  - High .8%+



## Stainless

- Will still rust if left unattended
- Stain resistant
- Must have at least 13% Cr
- Addition of Chromium
- Raises corrosion resistant
- Lowers edge retention



## Damascus

- Made by folding alloys into single billet
- Can be either carbon or stainless
- Alloys create the pattern within
- Complexity depends on amount of alloys and skill of blacksmith during forging
- Still hand forged resulting in highest cost among steels
- Includes Mosaic Damascus patterning





# Handle Materials

## Metal

- Common among custom and higher end production pieces
- Provides a solid response to user's grip
- Locking mechanism options differ by metal
  - Zirconium
  - Titanium



## Synthetic

- Man-made resin/plastic parts
- Often seen as having plastic/soft feel to user
- Composites
  - Use of resin to bond to fibers or structure
  - Issue with voids/air pockets
  - Requires shaping/texturing
- Plastics
  - Can be used to mimic natural materials
  - Fully molded plastic parts
  - Possible injection molding



## Natural

- Very traditional style
- Range of prices due to large variety in materials
  - Bone/horns variety
  - Wood variety
- Further shaping and carving possible
  - Raises price of piece





# Metal Handles

## Stainless

- Pros: Durable, corrosion resistant
- Cons: Heavy, slippery
- Textures needed to help grip



## Aluminum

- Pros: Light, color options
- Cons: Cold grip, slippery, cheap
- T6-6061 is most common



Anodized

## Titanium

- Pros: Strong, light, colorful
- Cons: Relatively expensive
- Grade 5 common for knives
- Often seen as liner locks



Natural finish

## Precious

- Usually only used as accents
- Can be used as plating



## Damascus

- Mosaic Damascus
- Most often seen on art knives
- Wide range of patterns
- Not corrosion resistant if carbon



## Zirconium

- Pros: color options
- Cons: Expensive, flammable
- Not springy enough for use as frame or liner locks



Polished finish

## Timascus

- Similar to Damascus in process
- Alloys react differently to heat allowing for crazy color
- VERY expensive



Flame Anodized

## Mokume

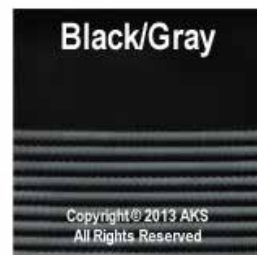
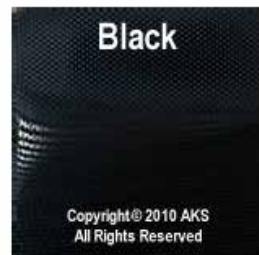
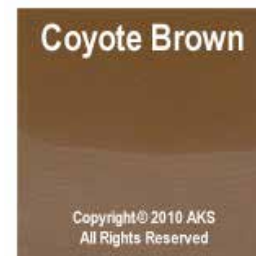
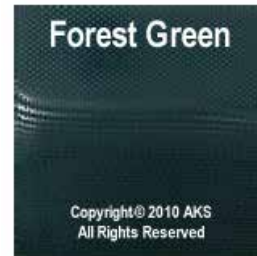
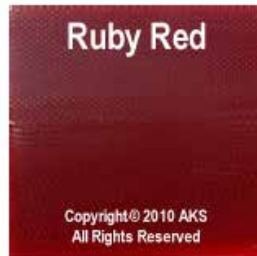
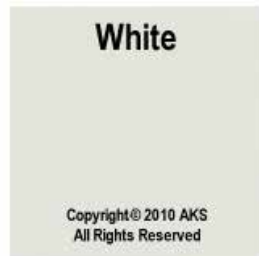
- Similar to Damascus in process
- Different types/mixes
- Used as accents/inlays usually
- Very expensive



# Synthetic Handles

## G10

- Pros: Tough, light-weight
- Cons: Brittle
- Laminated colored fiberglass
- Many options for coloring



## Micarta

- Pros: Durable, light
- Cons: Brittle
- Laminated linen/cloth
- Lots of pattern/color options



## Carbon Fiber

- Pros: Strong, light, eye-catching
- Cons: Expensive, brittle
- Laminated carbon
- Reflects light within pattern



## C-tek

- Pros: Strong, color options
- Cons: Expensive
- Resin filled Aluminum honeycomb



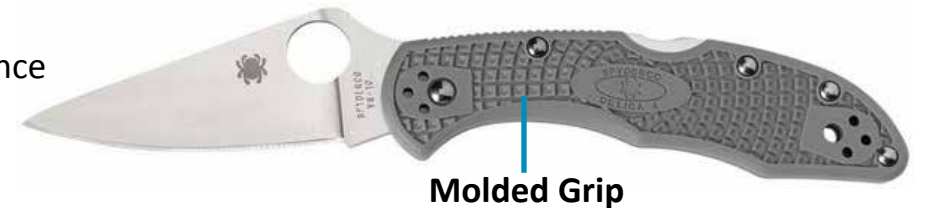
## Acrylic

- Pros: Moldability, Cheap
- Cons: 'Plastic' feel, slippery
- One of many thermoplastics
- Can be dyed in wide range



## FRN/Zytel

- Pros: Moldability, zero maintenance
- Cons: 'Plastic' feel
- Needs grip molded in
- Practically indestructible

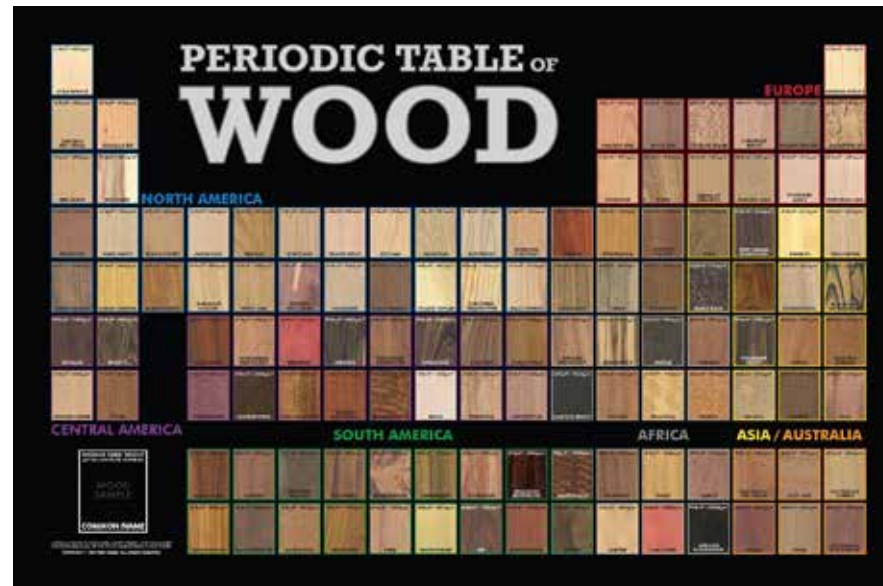




# Natural Handles

## Wood

- Pros: Durable, comfortable
- Cons: Porous, Instable
- Wide variety of species
  - Unique colors and grains
  - Wide range of price
- Can be stablized with resin to create new patterns
- Dyable for range of colors



## Dymondwood

- Lamination of wood veneers and resin
- Stable and colorful



## Mother-of-Pearl

- Comes from mollusks
- Expensive
- Most seen on 'art' knives
- Albalone alternative



## Bone/Horn

- Comes from wide range of animals such as elk and cow
- Dyable in range of colors



## Stone

- Usually used as accents
- Must be set into handle
- Seen ground into resin for details



## Leather

- Commonly only seen on hunting knives and such



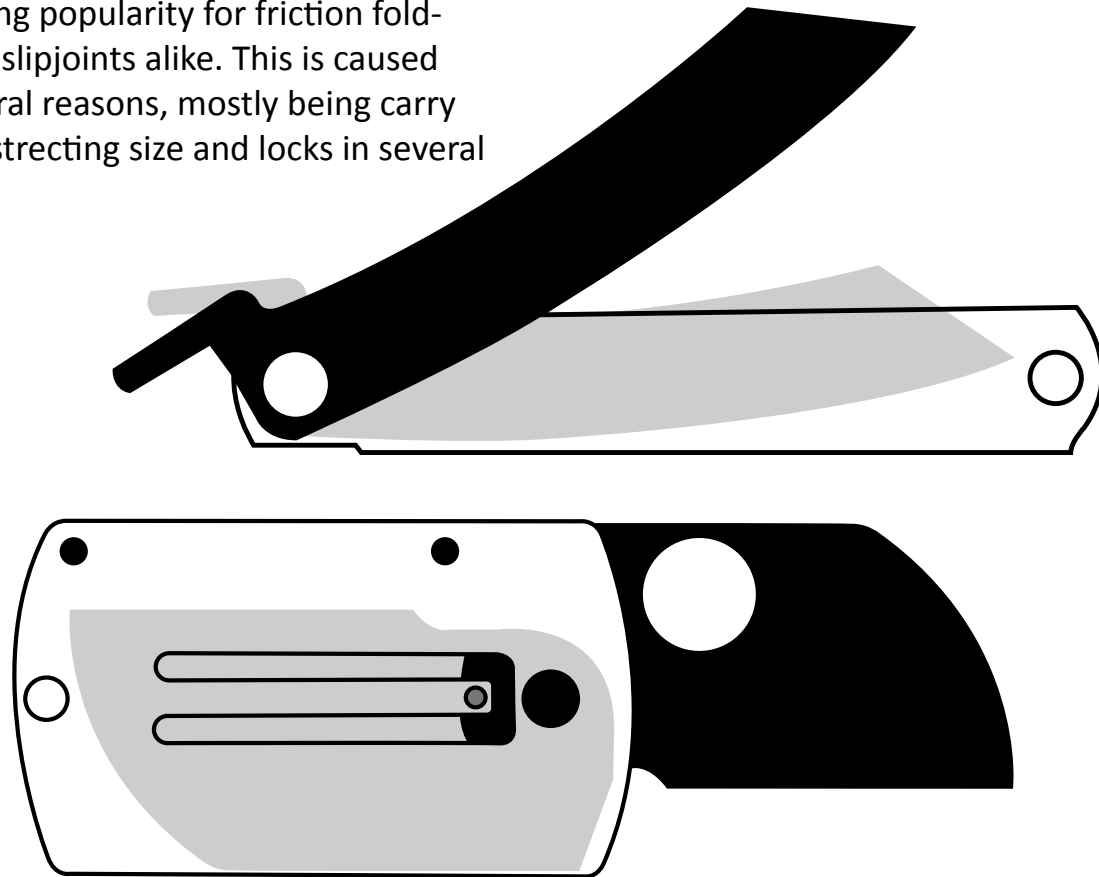


# A Direction

10 weeks into my research and about 40 fix blades later.  
I was ready to design my first folder.

## Non-Locking

The simplicity of a non-locking knife seemed a good choose as a first run into the world of knifemaking. There is a growing popularity for friction folders and slipjoints alike. This is caused by several reasons, mostly being carry laws restricting size and locks in several areas.



## Small Market

The market for custom EDC knives is still growing with the use of social medias and forums.



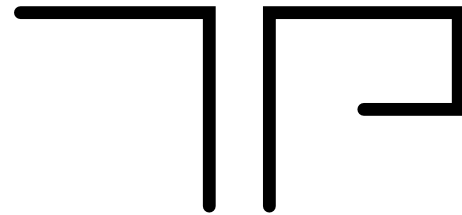
## EDC-Proof

Since EDC stands for every day carry, the knife must be able to stand up to the abuse of the user as well as the elements from the environment. Thus tough materials must be chosen such as stainless and titanium.



## Branding

Looking at the layout of the market, branding of oneself is the most important part as a knife designer and maker. This meant that all older logos and brands must be re-worked. The key being that the logo could be easily scaled and placed within the design.



## Detail-Oriented

Often higher end custom knives would feature details such as file work or texturing to add value to the piece. This would also add value to the design. Also looking to jewelry, the addition of negative space would add an uncommon feature that would help separate the design from others in the market.





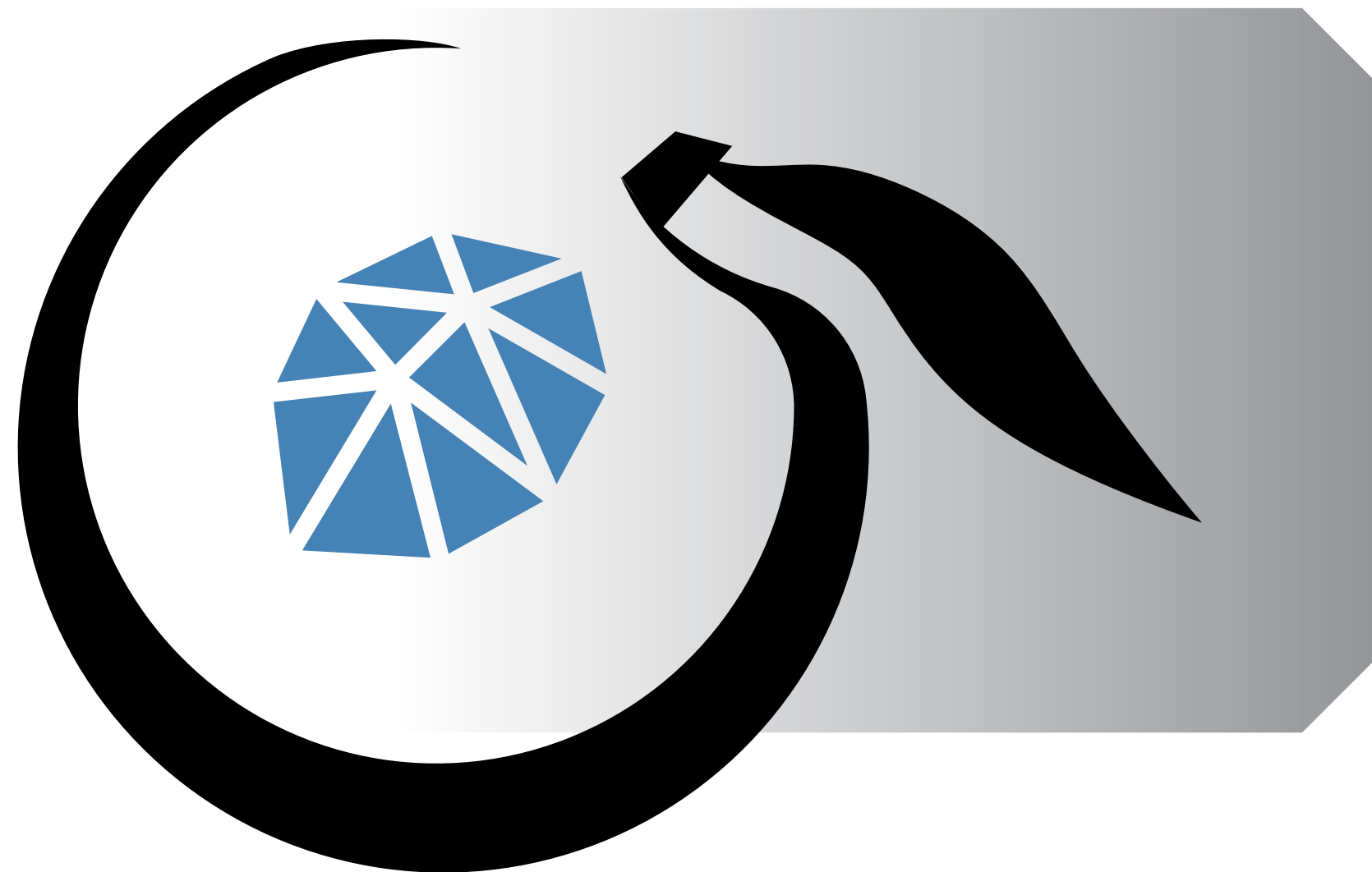
# Rebranding Oneself

## Peacher?

After looking over market I wanted to find a way to incorporate my last name into the brand as honor of tradition among fellow knifemakers.

## Peachsmith?

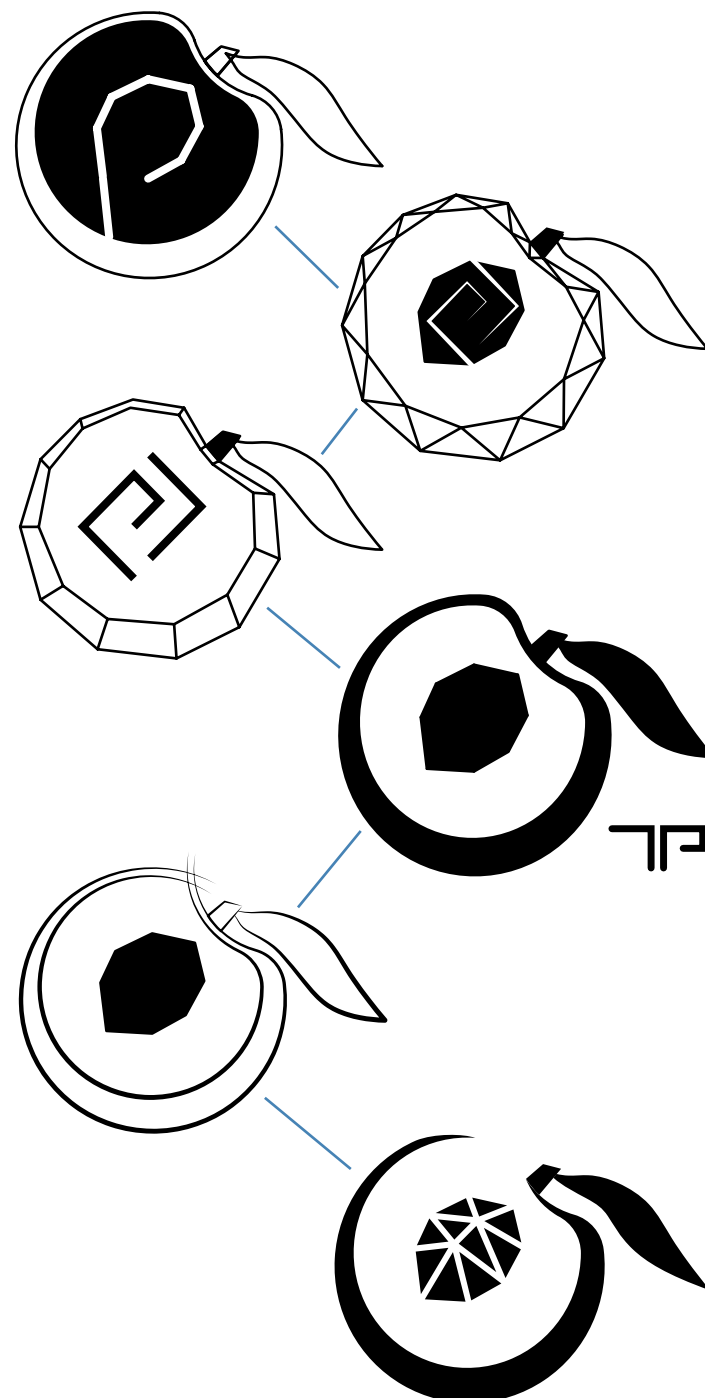
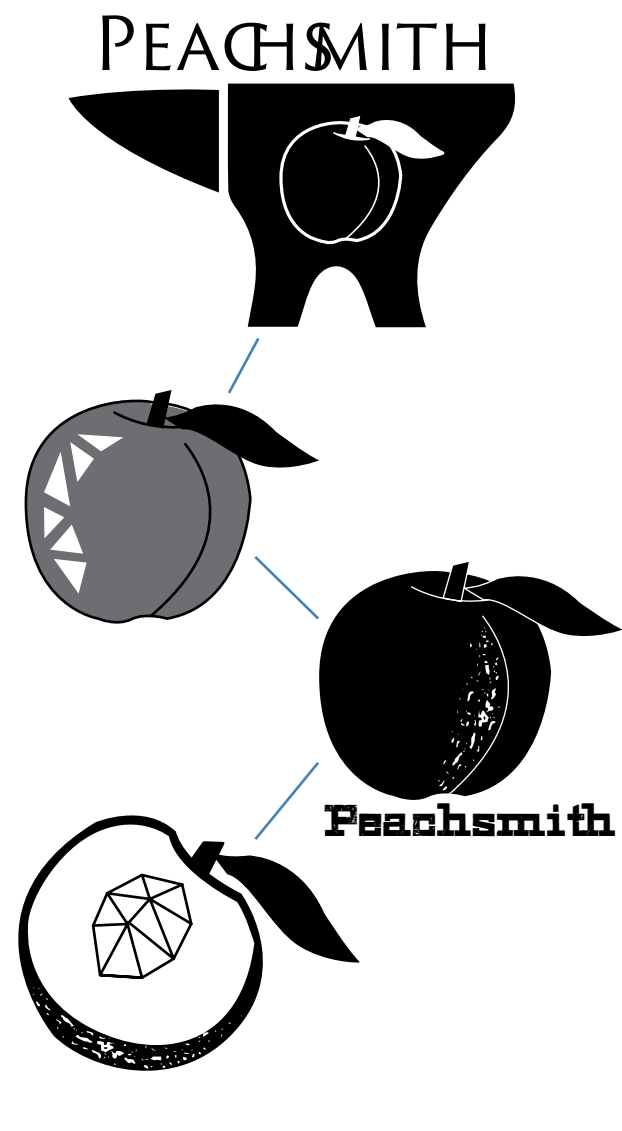
Peacher is often misread as peaches when people first learn my full name and while it use to both me I have come to embrace the fact after living in Georgia for a while. I add smith to my peach as I became a metalsmith in college.



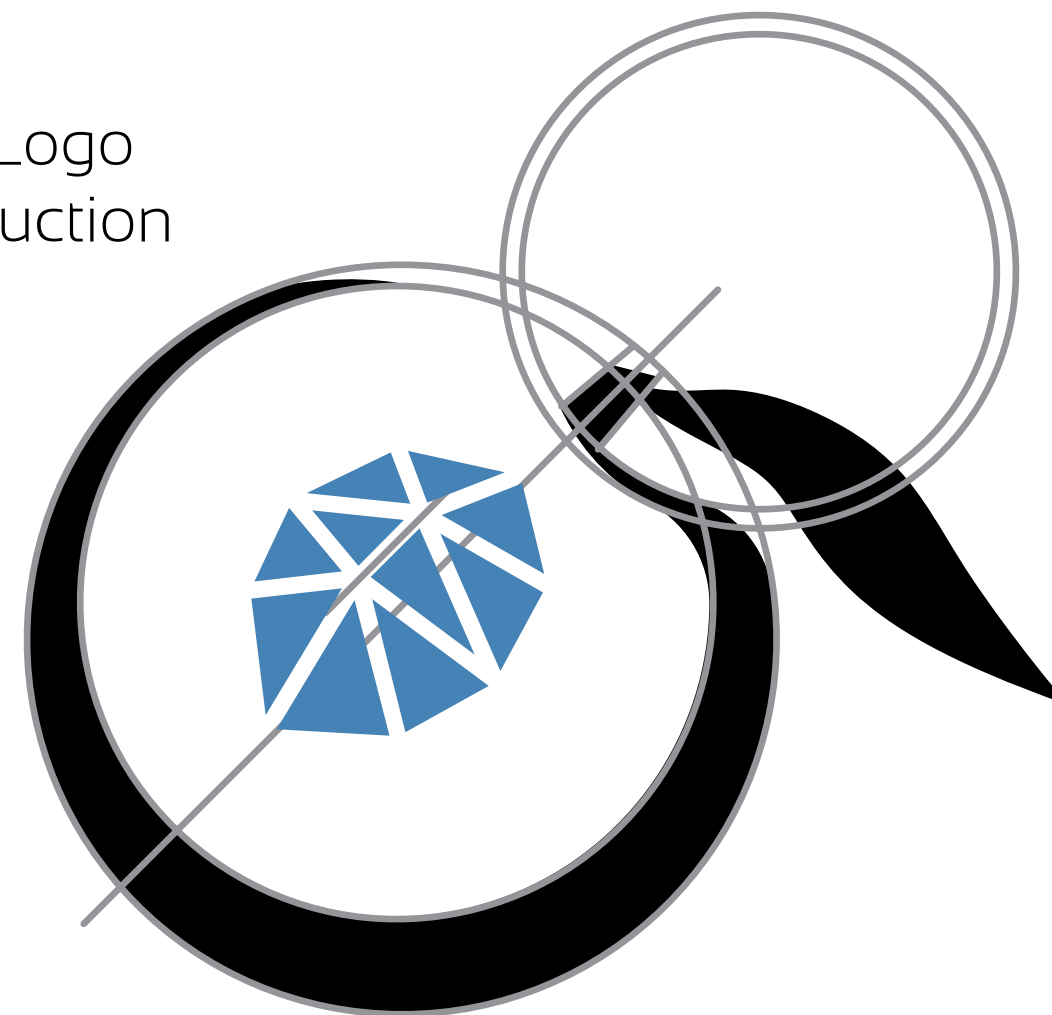
# Peachsmith

# Logo Development

Upon deciding on a name, I quickly began developing a simple logo that could be easily read in a range of scaled sizes and over several different mediums.



## Rhino Logo Construction



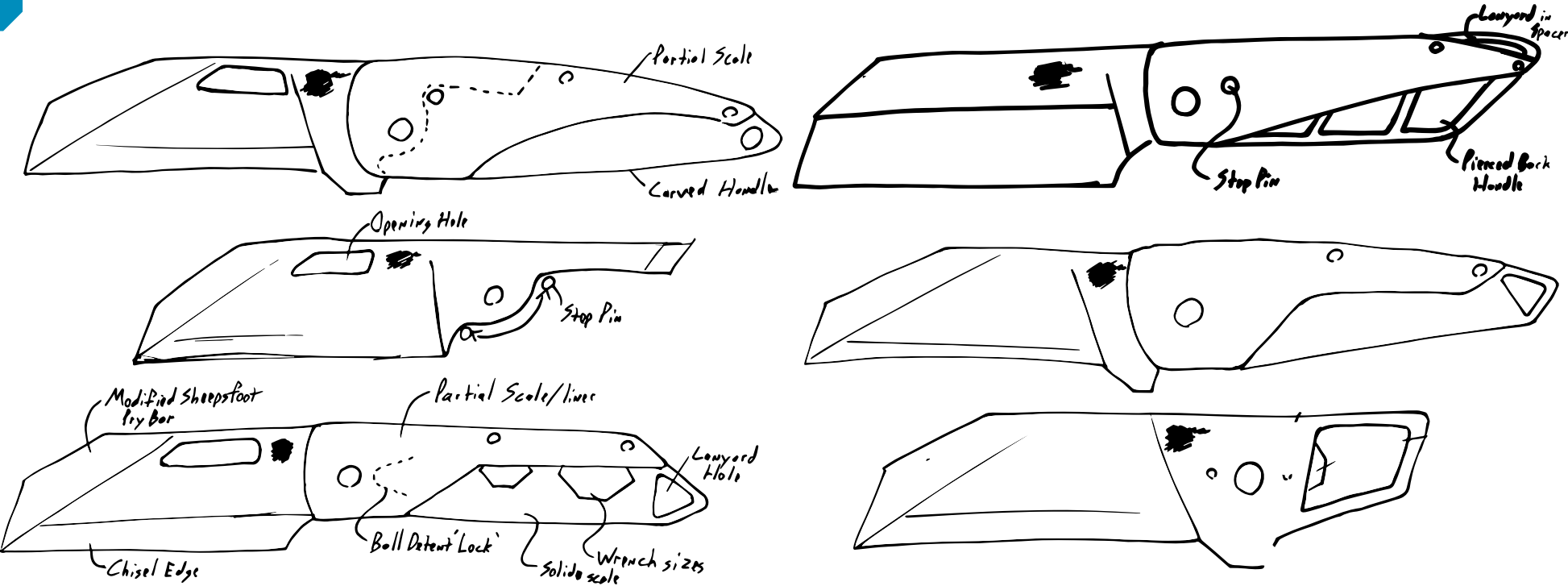
Steel Blue  
#4086AA

Black  
#000000



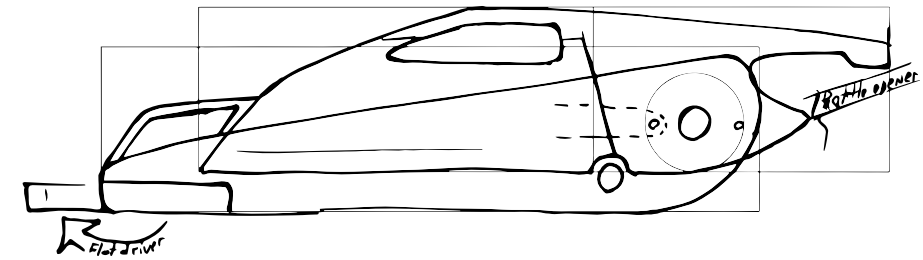
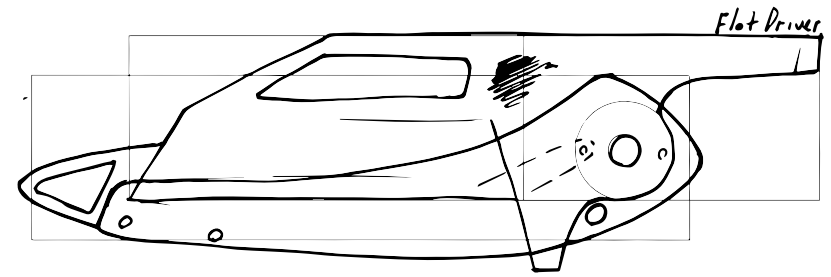
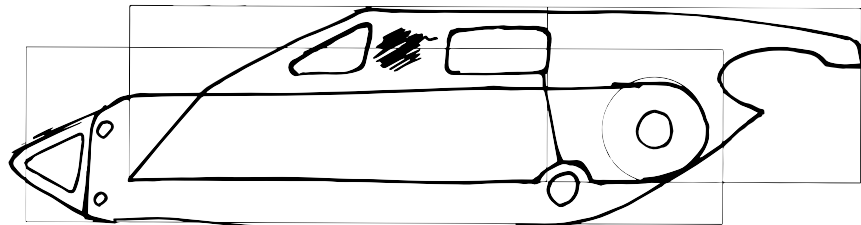
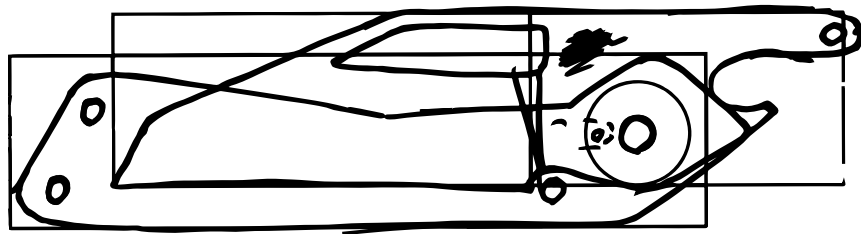
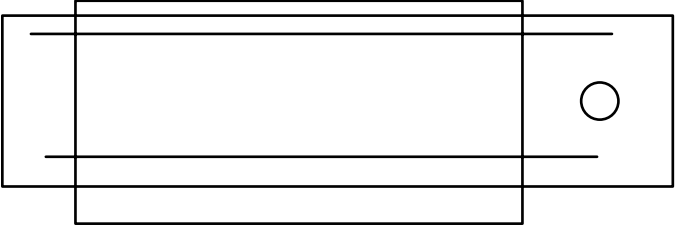
# Round 0

Having never sketched a knife before I worked mostly from memory to just play around but quickly moved toward using templates to help with basic hardware.



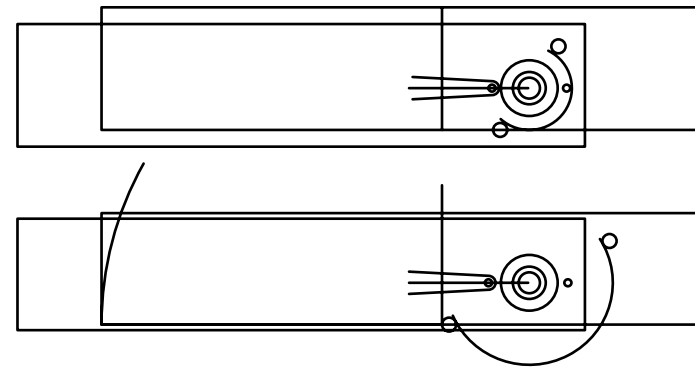
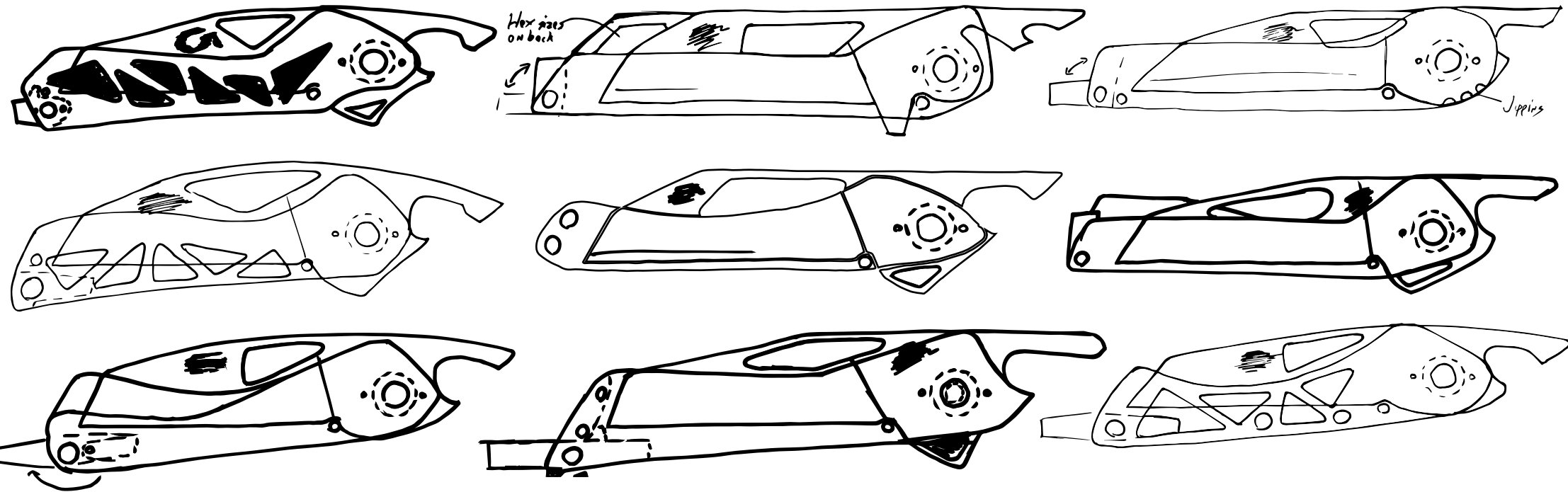
# Round 1

The first template was very simple with only reference lines for dimension.



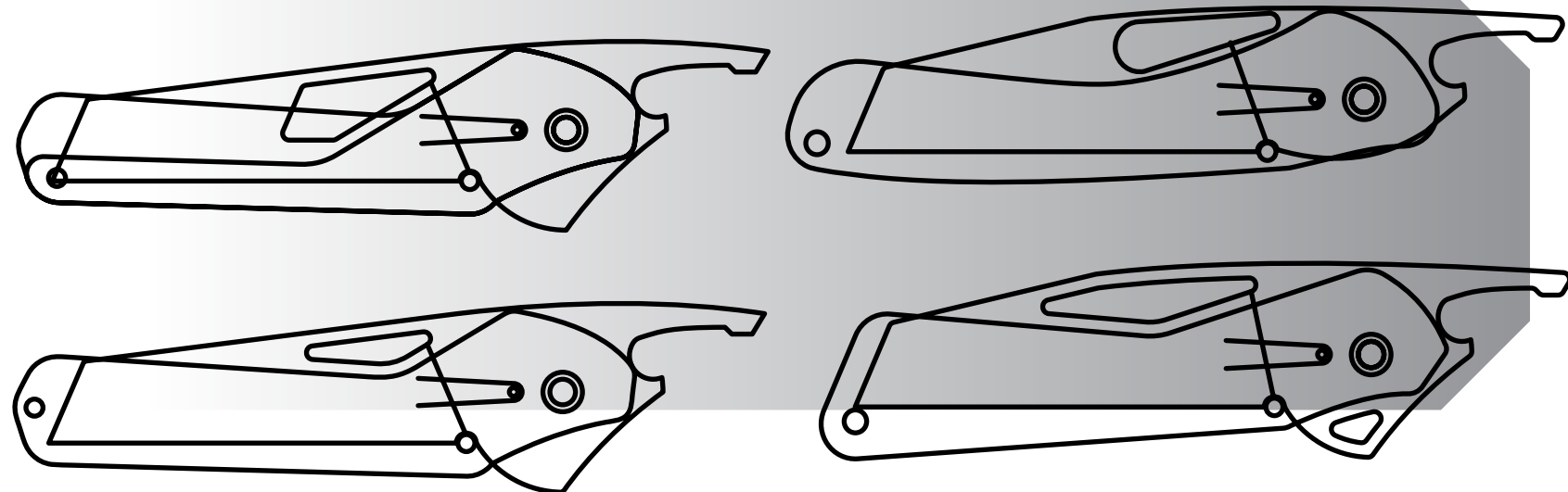
## Round 2

Adding stop pin locations and changing reference lines allowed for quick development of form and also the addition of more function in the form of a secondary pivoting arm.



## Mock-ups 1

Made from laser cut cardboard profiles, these rough mock ups were to better understand the human factors of possible forms.

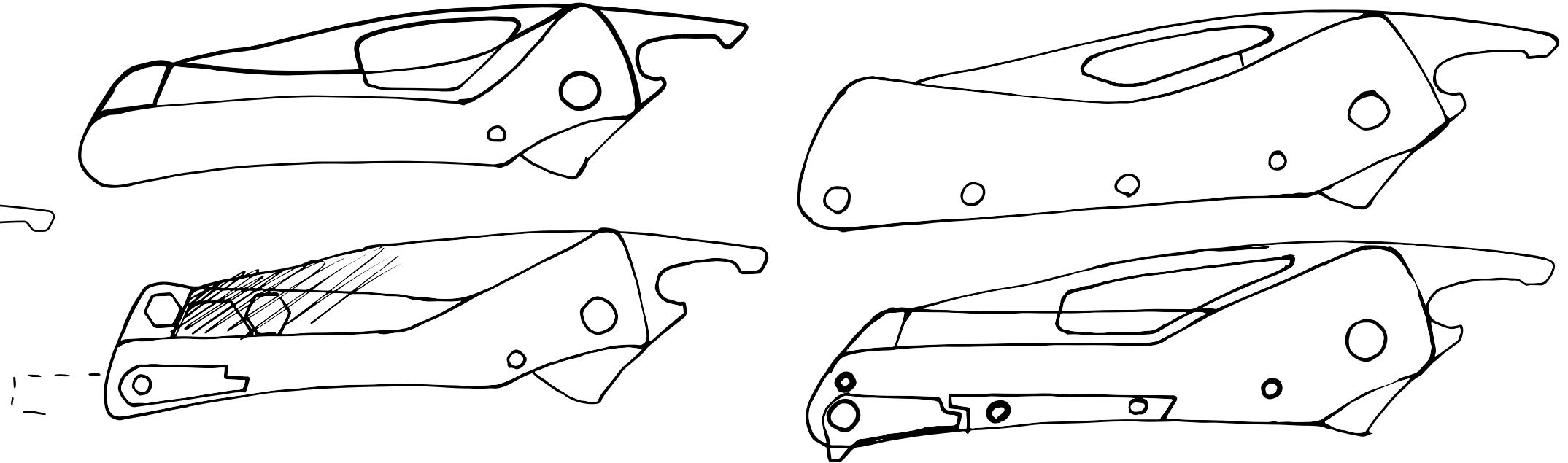
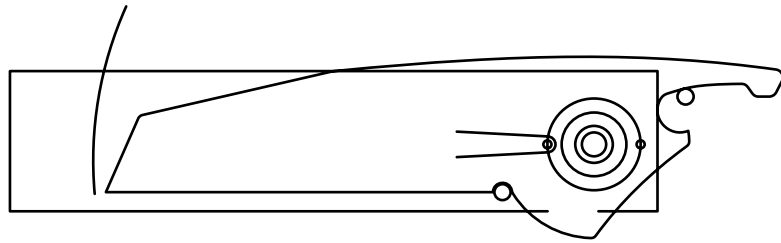




# Sketches & Prototypes

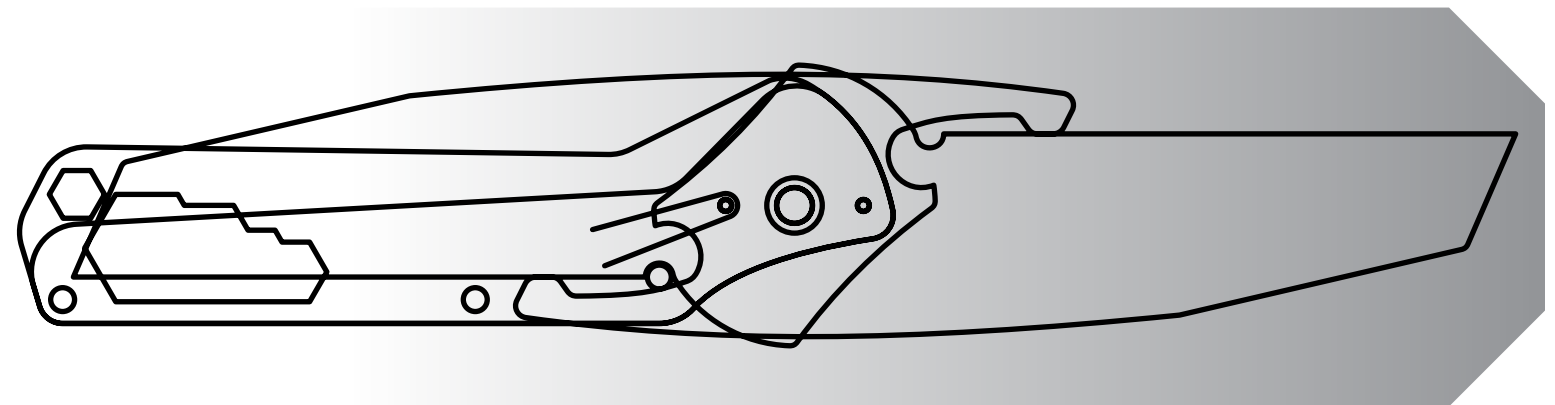
## Round 3

At this point I continued to develop for this time with the addition of more geometry.



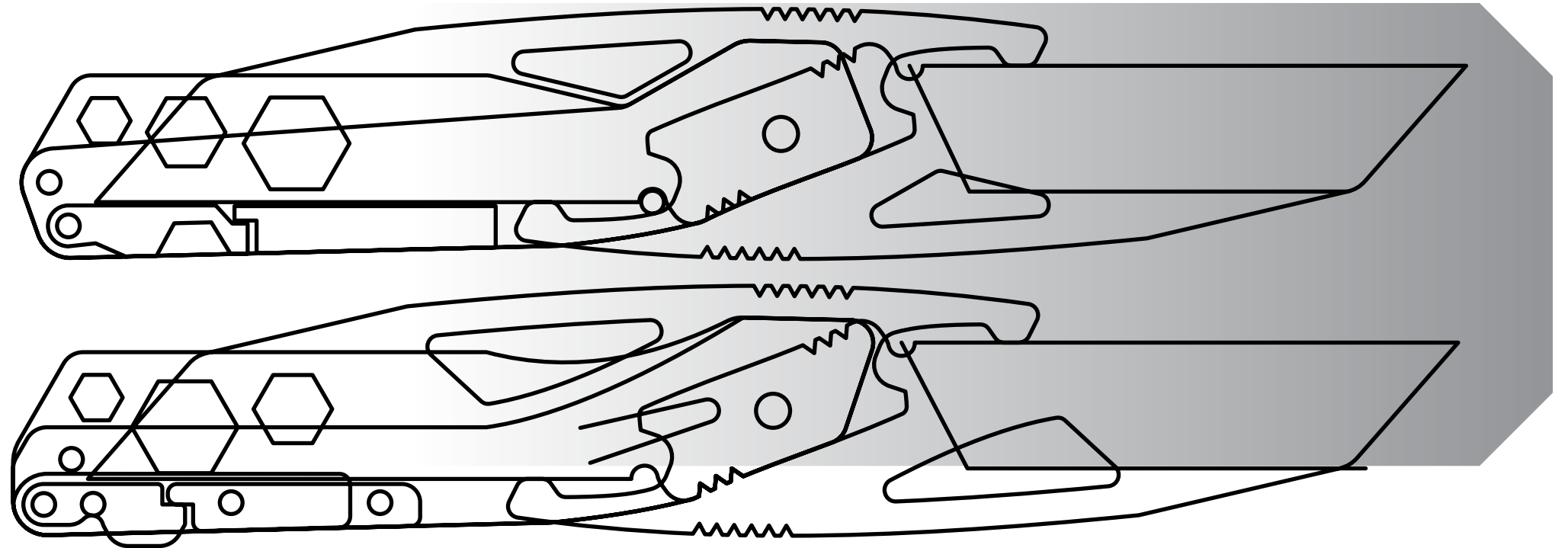
## Mock-ups 2

Though thinner than the cardboard, the acrylic mock-up allows for testing of chosen stop pin and action of opening the knife.



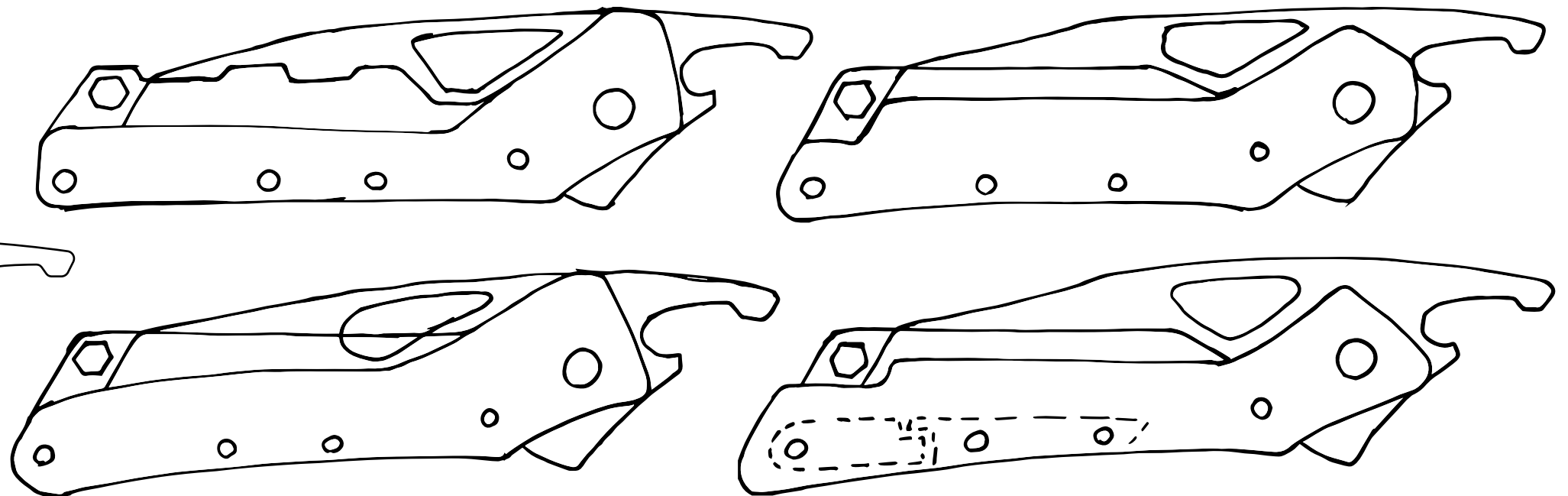
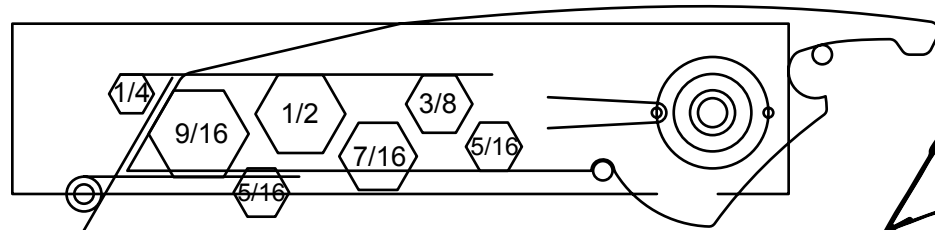
## Mock-ups 3

A few more changes done to the form to see interaction of all functional parts.



## Round 4

The final round of sketches were to finalize the form of the scales. The template held many essential geometry from the mock-ups above.

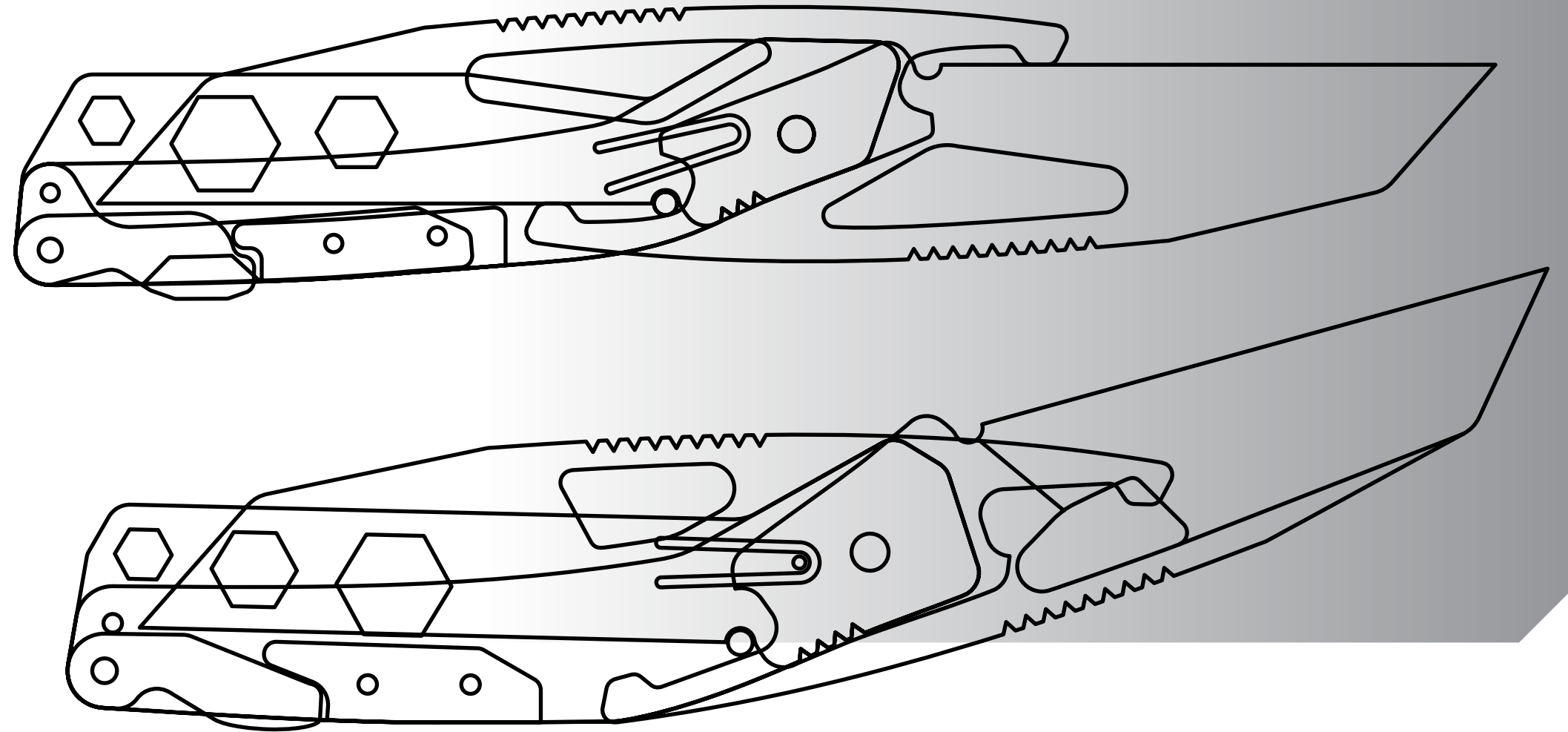




# Mock-ups

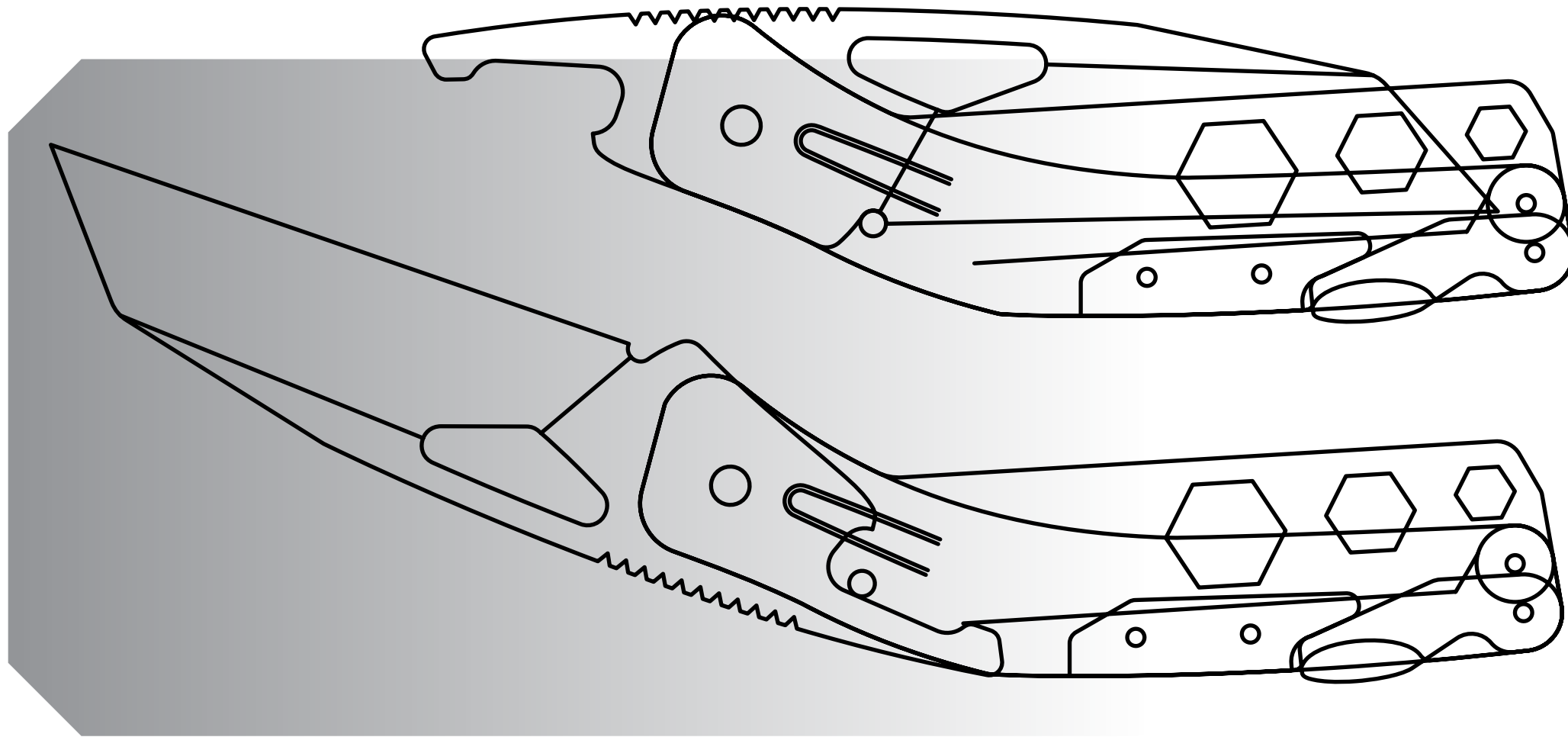
## Mock-ups 4

At this point all further development happened through cad and mock-ups. A simple change of pivot location was made changing the pivoting action 160 degrees instead of a full 180.



## Mock-ups 5

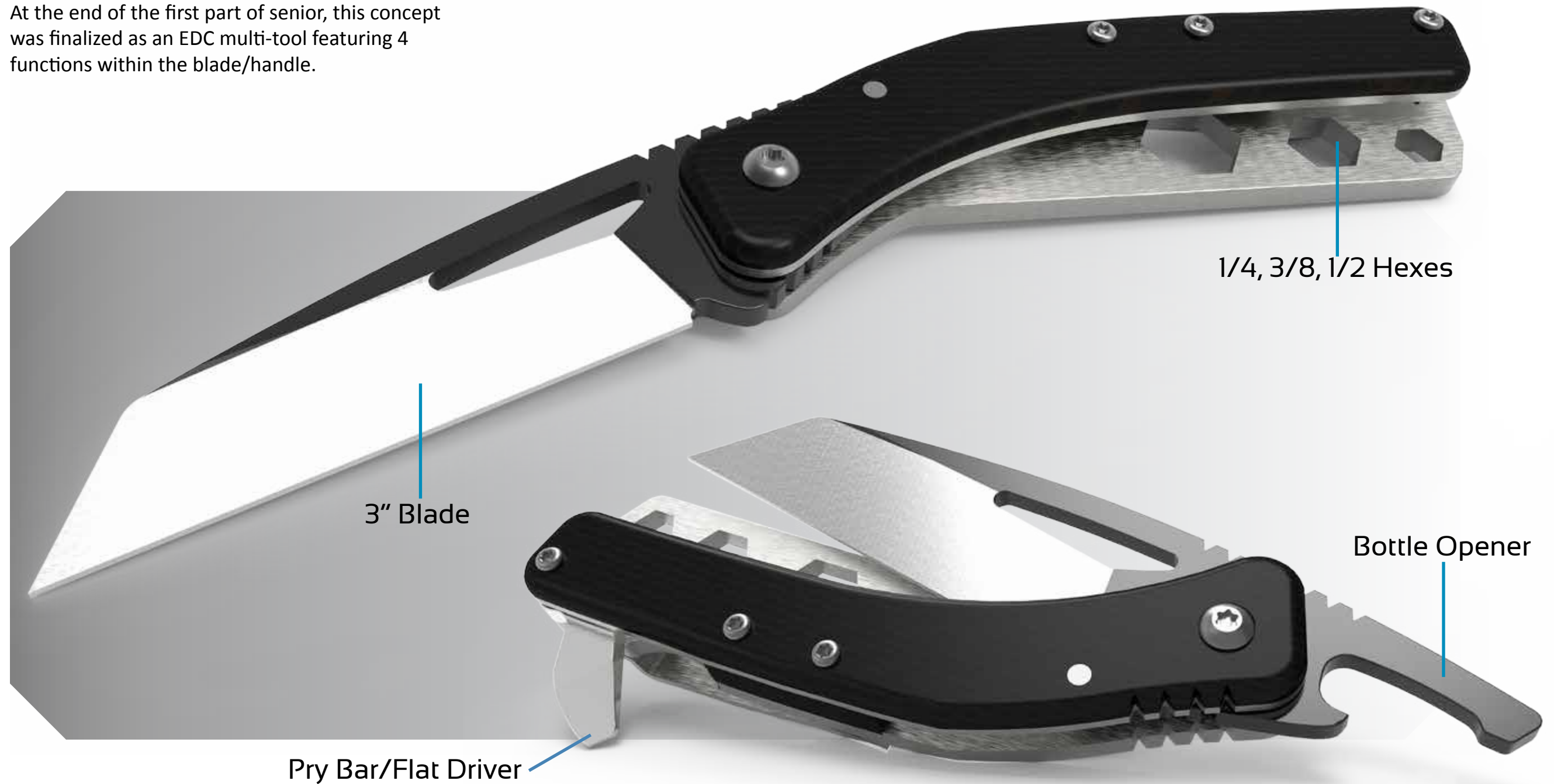
Finding the new pivot location better in grip and overall fit, a few more adjustments were made to solidify the form within this mock-up.





## Multi-tool

At the end of the first part of senior, this concept was finalized as an EDC multi-tool featuring 4 functions within the blade/handle.



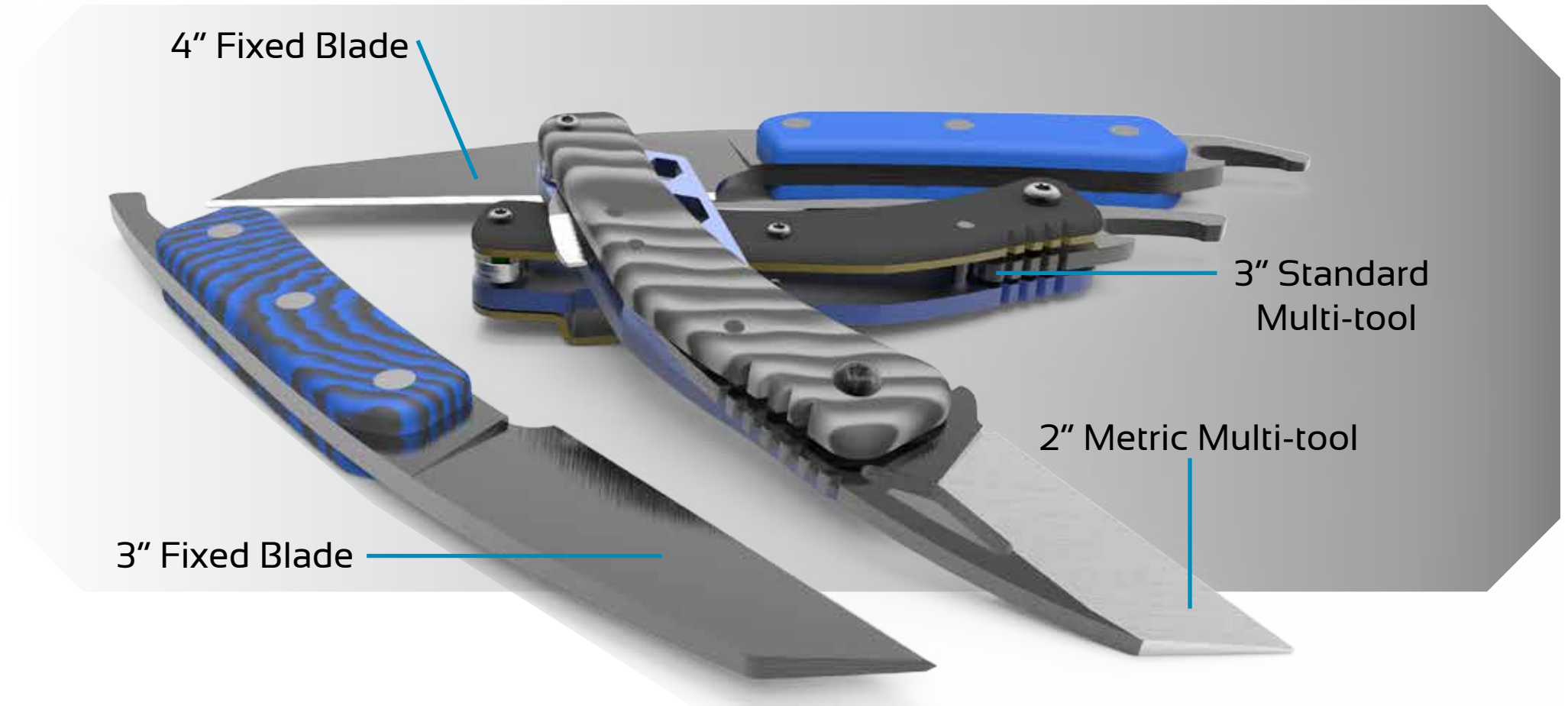
## Initial Family

By adjusting the mutli-tool, a family was made to add other possible price points and markets to my concept.



## Insights

Upon further editing of the design and user interactions with the mock-ups over a week, it became clear that the multi-tool was hard for users to figure out and would also cause build time and final cost of each piece to go beyond a marketable price.



"What is this 'thing' on the end?"



"How much extra time does these take to produce?"



"The other tools cheapens the overall design."



"How does the hex sizes work? Do you hold the blade?"



"I just want the knife part."

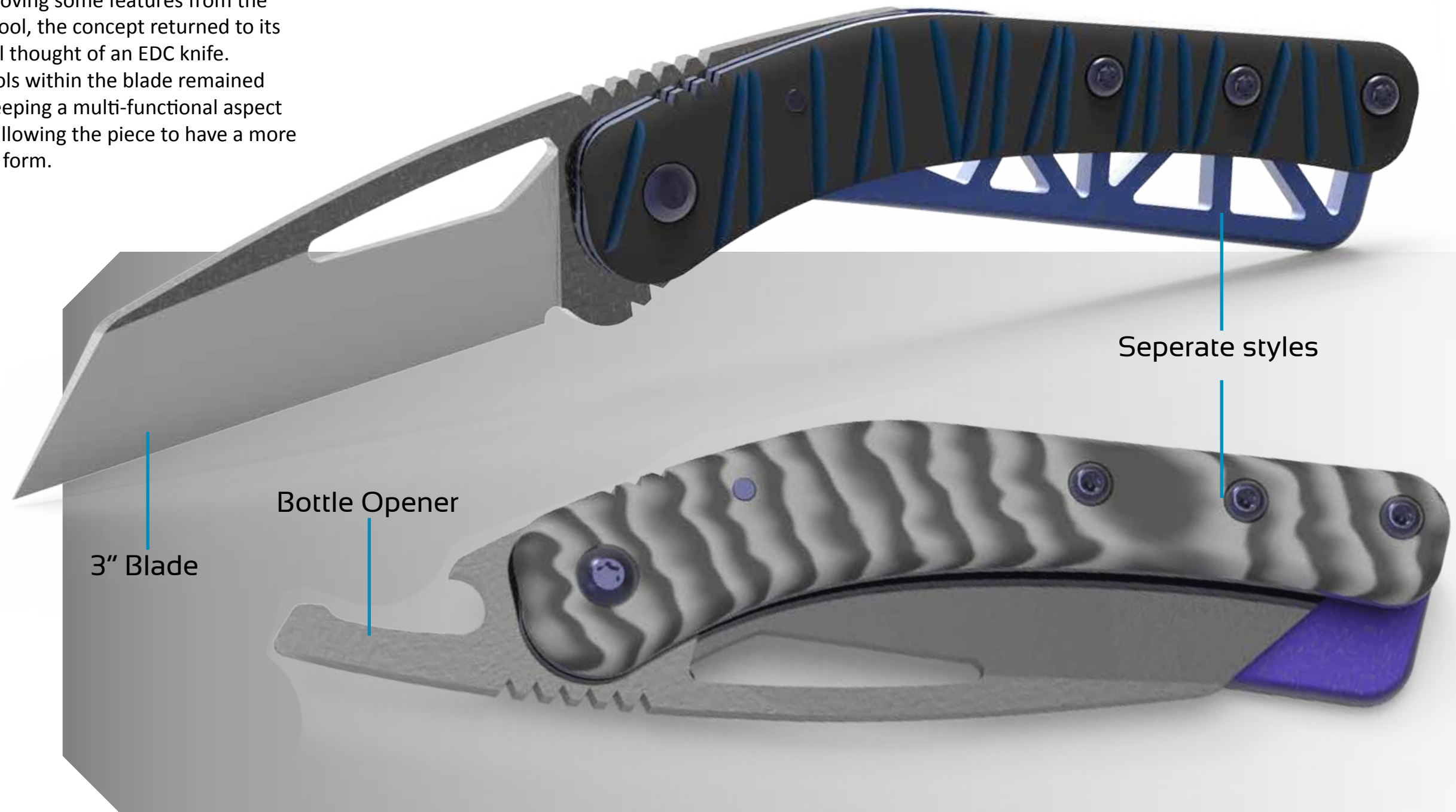


"Why not just design everything into the blade?"



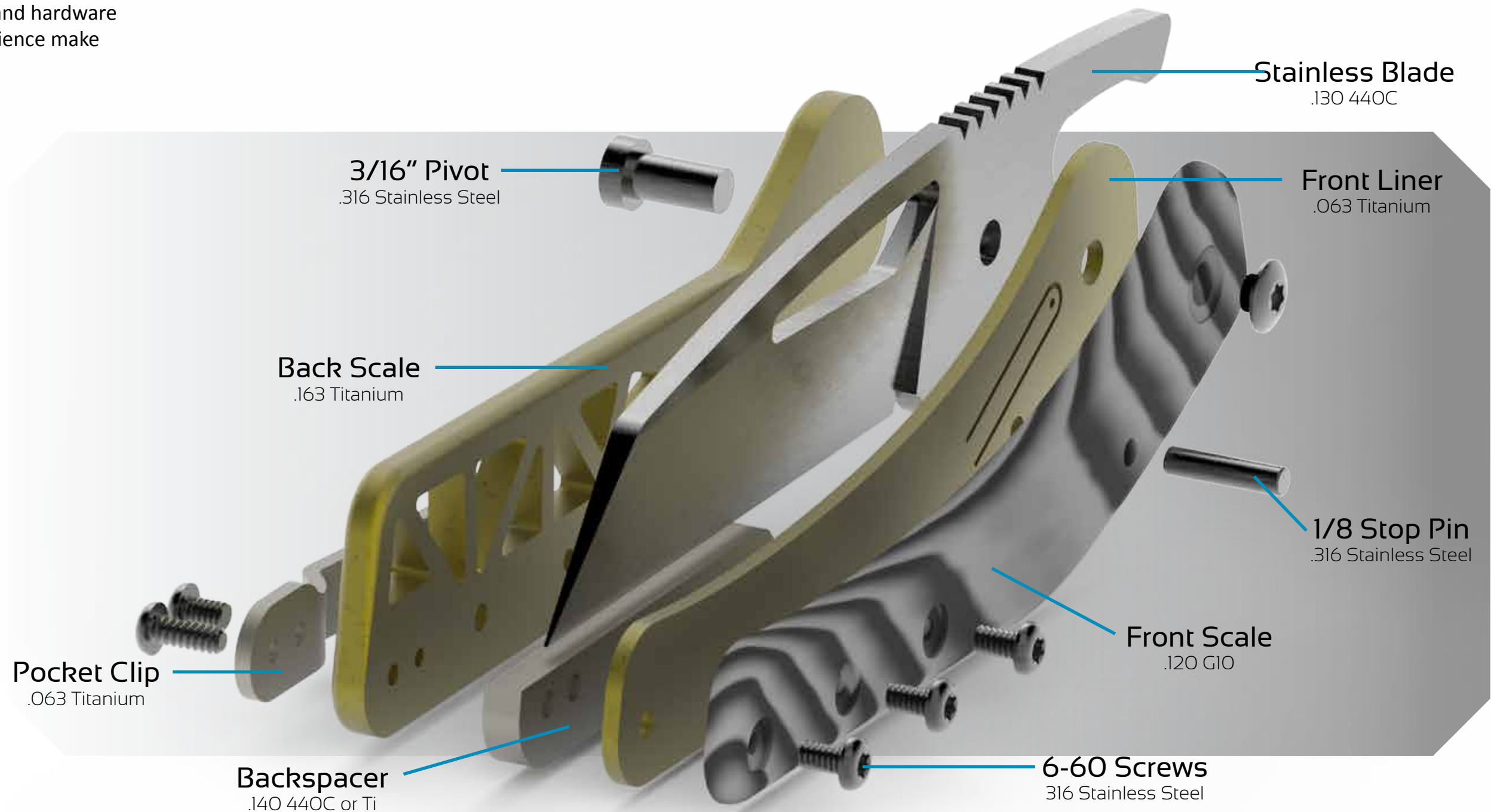
## EDC Knife

By removing some features from the multi-tool, the concept returned to its original thought of an EDC knife. The tools within the blade remained thus keeping a multi-functional aspect while allowing the piece to have a more artistic form.



# Break Down

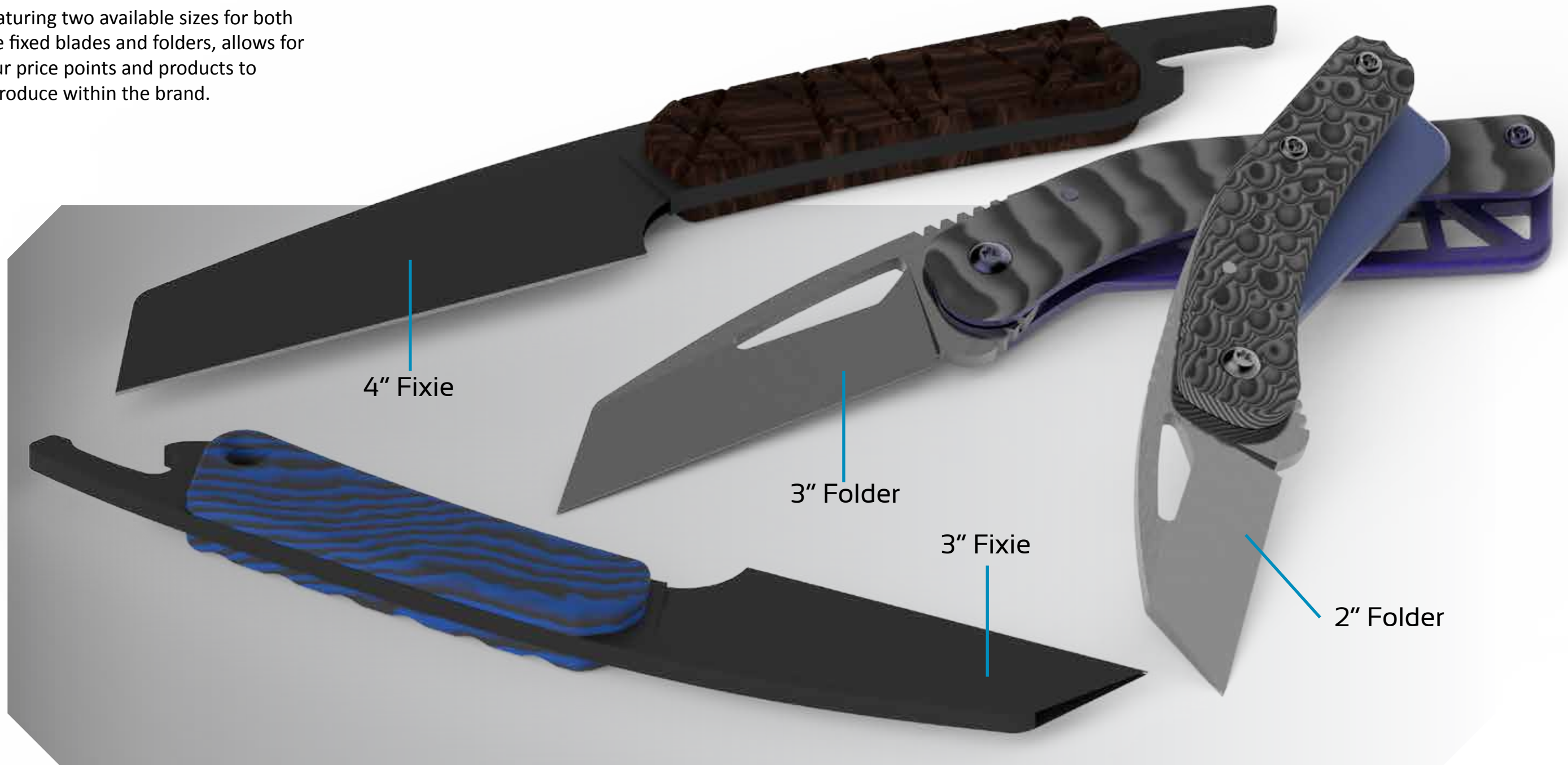
High quality materials and hardware along with skill and patience make quality knives.





# The Family

Featuring two available sizes for both the fixed blades and folders, allows for four price points and products to introduce within the brand.



# Family Mock-ups

One final group of mock-ups were made for further user interaction/ feedback while preparing for the first prototype production of the fix blades.

Small adjustments to both the folders and fix blades while gathering supplies and preparing for waterjet.





As told by any man who has made a knife the expense of your knife is only by what you are willing to spend on it. Thus the cost of a knife is mostly due to the time it takes to craft the piece.

Supplies Gathering

A long list of gear in the form of tools, abrasives, and materials would be needed to build the knives.



4-40 taps

Straight-flute Carbide bits



2" x 72" belts



Carbide Reamers

Carbide Mill bits

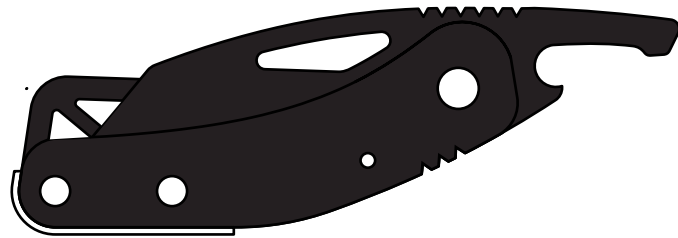
Files



Sandpaper

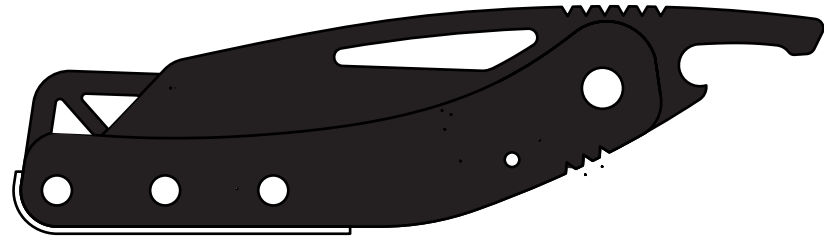
# Cost Breakdown

## Price Range:



### 2" Folder

\$400  
- 15 hr/piece  
- 5 pieces total



### 3" Folder

\$500  
- 15 hr/piece  
- 5 pieces total



### 3" Fixie

\$150  
- 5 hr/piece  
- 4 pieces total



### 4" Fixie

\$200  
- 5 hr/piece  
- 3 pieces total

Estimated Total Sales: \$5,700

## Tools

McMaster	-	\$380	- Drill bits etc
Rio Grande	-	\$55	- Files
Otto Frei	-	\$90	- More Files
Lakeshore	-	\$125	- Mill bits

## Consumables

Pop's Sandpaper	-	\$240	- Belts
Home Depot	-	\$50	- Sandpaper
Cerakote	-	\$70	- Coating

## Material/Hardware

USA Knifemaker	-	\$200	- Fixie hardware
Alpha Knife Supply	-	\$270	- Hardware/G10
New Jersey Steel	-	\$210	- Steel
AMX Metals	-	\$240	- Titanium
McMaster	-	\$80	- Screws
Ghost CF	-	\$20	- Carbonfiber

## Services

Waterjet	-	\$300	
Paul Bos	-	\$115	- Heat treat
Etsy	-	\$70	- Felt cases

## Branding

Moo Cards	-	\$40	- Business cards
Photo Props	-	\$95	- Notebooks
Webbly	-	\$180	- Website

Total: \$ 2,830



## The Serpents

The sea serpents first arised from a for-  
seen need to practice grinding and other  
techniques. The name came from their  
form and was to allow complete freedom  
in the handles since sea serpents come in  
all shapes and sizes.







Some drop points were made for grind practicing as well but are not part of the design family.



# Production

## Metal Work



Laser cut templates used for scribing metal



Practice blanks cut first using bandsaw



Sea serpents cut using college facilities



Profiles ground cleaning up dimensions



Bottle openers ground with small wheel



Main bevels ground freehand using a Bubble Jig guide



Everything sanded to 120g



Cerakote after heat treat



## Heat-Treat



Twenty blades ready for heat treat



Heated to slightly over 1500° in forge



Dunk in vegetable oil to cool/harden blades



Tempered in oven in cycles

## Handle Work



G10 cut with first alignment hole



Blades used as drilling guide



Handles shaped to blades



Small wheel attachment used for patterning



Samples of texture/finish



## The Chimeras

Named because of the form of the three tools built into blade. The addition of the bottle opener and flat driver/pry bar makes the Chimera a function piece of art designed to bring something extra to the average EDC pocket knife.







Bright and Colorful



G10 Fronts



Felt cases made in Poland



Anodized Titanium back handles



# Production

## Waterjet



GoPro used to record the cuts



Three styles of handles



Total of 11 blades cut for grinding



Parts made in .140 440C stainless, .160 and .060 Titanium

## Grinding bevels



Draft from waterjet removed



Triangle jipping filed clean and straight



Dykem used to mark blades



Primary bevels ground



Laser cut package for heat treat



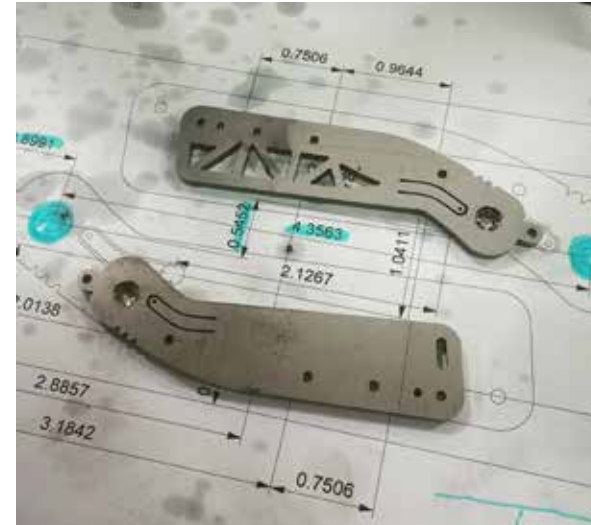
## Machining Scales



A .5 thick aluminum block machined square



Hole pattern machined and tapped



Highlighted dimensioned guides



Counterboring titanium spring with 3/16 bit

## Finishing Scales



Extra machining tab ground off



File clean up of triangle patterns



Parts all sanded to 320 grit before anodizing



Heat anodizing with smith torch





"At face value, the knife is a simple tool ... Yet, it looms large not only in human history but in literature and legend... But as conceived and created by metalsmiths, this ancient instrument becomes an astounding work of [art](#)"

- 500 Knives - Lark Books

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You actually made it to the end of this book? Thanks!

Today, I have moved shops many times and even moved from Georgia where I started this wild knife making journey to Portland, Oregon where I try to keep learning and practicing with the daily grind, literally.

Cheers,  
- Ted

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