

# Why and How We Continue to Make Our Own Throwing Knives

After months of throwing commercially made knives, adjusting for different balance points, weights, form factors, etc., we decided to design and make our own knives based on our throwing styles and experiences. To this end, we developed a detailed spreadsheet for accurate determination of proper dimensions, weight and balance. We then set about to establish design goals based on our experience—good and bad—with commercially available knives. I prefer to make a knife that fits my style rather than change my style to fit the knife. The following are some of our design criteria and comments, refined as we continue to throw:

- **No ear damage and angry neighbors.** While throwing commercially made knives, we observed that weight alone was not the reason for ear shattering ringing on bad throws. We determined that the weight to length ratio is a major factor. We found that a minimum weight to length ratio of 25 grams/inch does the trick. Our Neon green powder coat dampens ringing and also, glows brightly when hit with UV light.
- **Material:** O1 tool steel. We evaluated S7 due to the hype over its supposed toughness, but found that O1 tool steel is tougher when heat treated at HRC 49-50 (good range for a throwing knife) than S7 at any hardness. We recently made a video comparing O1 and S7. S7 had an edge in strength (bent slightly less in the 50 hits test), but not in toughness.
- **Thickness:** min. 0.25" and max. 0.312".
- **Length:** 10.5" ± 0.5". We have made larger and smaller knives, but this is our the normal size range.
- **Weight:** min. 250 grams (10" knives) and max. 307 grams and > 25 grams/inch for reduced ringing.
- **Establish proper balance for our two basic styles of instinctive knife throwing.** Over time we've determined from testing that meeting two criteria made our knives feel and perform better for us. The combination of the following two balance point references allows us to pick up any of our knives, no matter weight, length, thickness or design (Standard vs. Offset) and throw consistently with little or no adjustment to our styles.
  1. A balance point no lower than 38% and no higher than 40% provides what we believe is the best balance range for no spin throwing. We find that 39% ± 0.5% works best for us.
  2. A balance point located approximately one (1) inch behind the handle/blade interface provides the best feel for us. All of our knife designs are now within ± 0.2" of this requirement.
- **Robust tip that still provides great penetration.** This required several considerations:
  1. Tip angle of 16° for deep penetration (originally 20°).
  2. Two offset (asymmetrical) 20° tip bevels with a 3° taper, to increase tip strength without reducing penetration. All other throwing knives that we've seen use symmetrical two or four-bevel tips.
  3. HRC of 50±1 for O1 tool steel. We continue to perform destructive testing (hitting other knives, unintentionally) to observe the effect of different levels of hardness on tip performance—bending vs. chipping. We found O1 tool steel to be extremely tough at this hardness.
  4. Broad (~0.100"), rounded and polished tip instead of narrow or blunt. The broad tip increases tip strength. Rounding and polishing the broad point reduces the effect of hard surface (another knife, sticking slightly sideways) impact. We learned this one the hard way, chipping a bit of each extremely pointy tip when striking other knives that stick sideways.
- **Other considerations:**
  - ◆ Beveled handle to reduce probability of impact on handle from successive throws at the same target, when not sticking sideways. Also, on a really bad throw the handle will stick—embarrassing!
  - ◆ Distinct blade/handle interface for consistent acquisition for finger placement on the knife spine instead of having to find the balance point for proper finger placement.
  - ◆ Use of an electric furnace, instead of the original gas forge. My paper on electric vs. gas addresses issues we had with gas.

# Knife Making Spreadsheet: Inputs and Outputs

Example: My Heavy Darts

Sweep angle =	8 degrees	.140 Radians
Tip taper =	8 degrees	.140 Radians

Metal Thickness =	0.312 inches
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New 10.35" knife design: "The Heavy Dart"						
	In inches					
	Length or dia	Thickness	Width	Cubic inches	Weight (oz)	Wgt (gms)
handle	5.050	0.312	1.200	1.89	5.191	244.4
blade	5.300	0.312	0.68	1.12	5.191	145.4
				0.00	0.000	0.0
				0.00	0.000	0.0
Total length	10.350			Total	13.921	389.8
Minus the following						
Tip taper	2.419	0.31 inches	0.34	0.26	1.185	33.18
Handle sweep	1.85	0.31 inches	0.260	0.15	0.693	19.40
Round end	1.2	0.31 inches		0.048208157	0.223	6.23
handle wedge				Measured	0.33	9.24
Tip bevel*				Measured	0.51	14.28
Handle hole	0.312	0.31 inches		0.023853585	0.110	3.08
				expected knife wgt	10.870	304.36

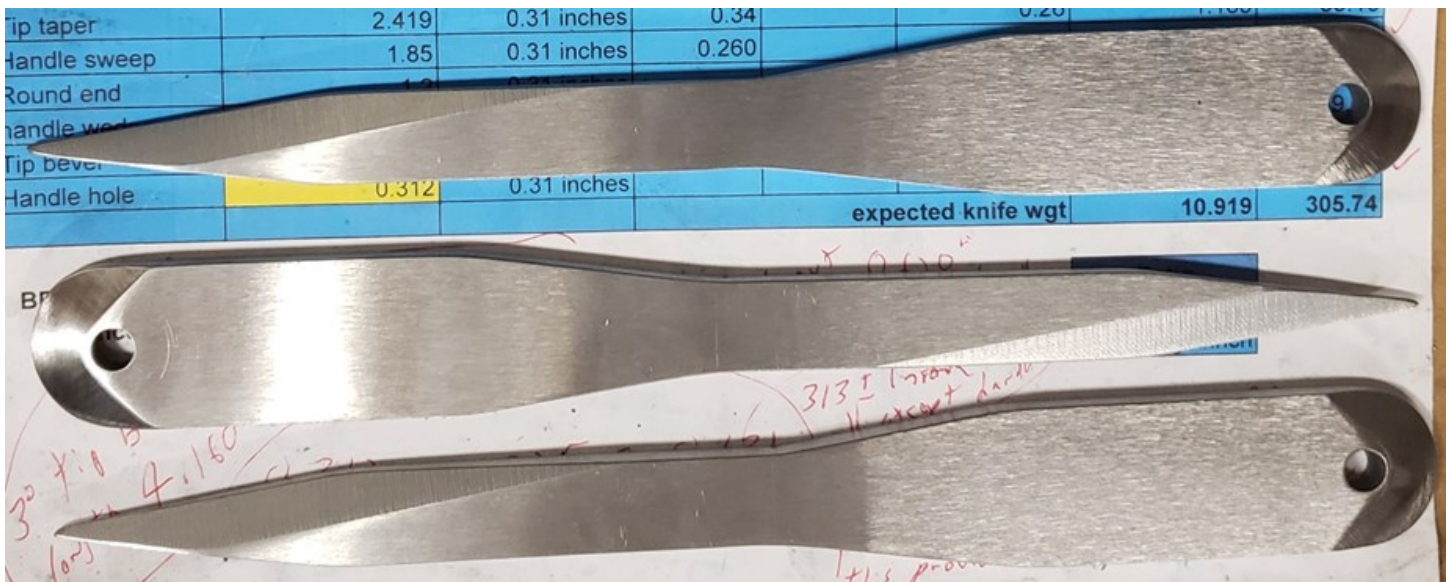
As built spreadsheet: Blunting and rounding reduced length by 0.050" and weight by 2 grams from original design.

Key Parameters	
BP dist to blade:	1.04 inches
Balance Point:	38.72%
BP to end of handle:	4.008 inches

Ratio
1.050 oz/inch
29.4 gm/inch

Inputs are the Yellow cells. All others are outputs.

My new Heavy Darts, ready for heat treat, powder coat and abuse!



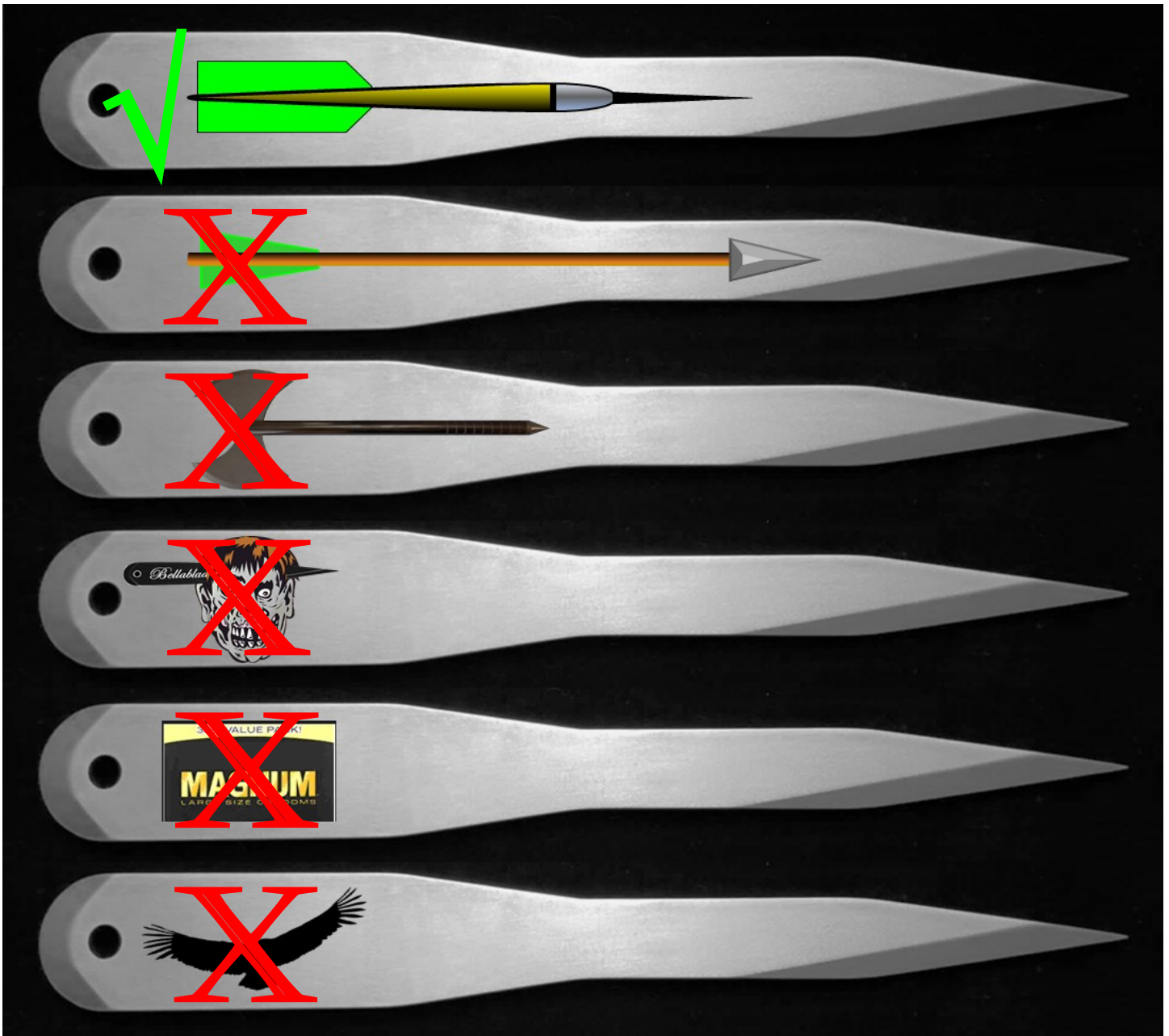
## Early Efforts (1)



### Improved Dart (3rd Gen Improved Dart shown):

- Original Dart was the second knife style we made—this is the improved version
- BP = 39.2% ( 1.02" from Handle/Blade interface)
- Length = 10.4"
- Weight 9.53 oz. (267 grams)
- 16° tip (same as Original Dart)
- Thickness = 0.250"
- Improvements—Beveled handle, longer tip bevel taper (3°) rounded and polished tip.
- Latest improvement—broader (0.100") tip—this increased the weight by ~1 gram
- This is the one that I use and it's the one we sell as a Standard Dart.
- Started using our electric furnace with 2nd Gen

## Why Do We Call Them Darts? Why Do They Call Them Arrows?



### What's in a name?

#### Some categories of knife names that I have seen:

**Descriptive**—Conceptually similar in shape to another object that is not a knife.

Examples: Dart (Oh yeah, I see it now!), Arrow (I hear good things about these.), Axe (No, I don't get it.)

**Symbolic**—Conjures an image of strength, power, size, performance, etc.

Examples: Zombie Killer (Makes sense!), Magnum (Could also represent protection!), Condor (Could also represent carrion eater or endangered?), Sure Balance (Obviously well balanced!)

**Knife Style**—Bowie, Dagger, Spike, Tanto, Kukri, etc. Makes the most sense to me!

Examples: What I just called them!

**So, it's a Dart!**

## A Brief History of Our Improved Darts

**Dart: Dec 16, 2016\***



\*The date when photo was taken.

The reason for calling them "Improved" was the rear bevel. It did fit the hand nicely, but its main function was to reduce the probability of an impact on the back of the handle from another knife. The one above was the first attempt at improvement. The primary variable over time has been the tip bevel taper. The 5° tip taper was also used on all of our previous knives, as well.

**Dart: Feb 28, 2017\***



\*The date when photo was taken.

In order to further improve penetration, we tried a 4° tip bevel taper, shown above. We made several of these before testing a 3° tip bevel taper. We still prefer 4° for our thicker knives. These were also the first knives to be heat treated in our electric furnace.

**Dart: Aug 11, 2018\***



\*The date when photo was taken.

Experimenting over time, we settled on a 3° tip bevel taper (shown above) for all of our 0.25" thick Darts. These are the Standard Darts that we decided to offer first. No matter which generation or size of dart, they all have the same balance point: 39% ± <1%. They now also have a broader, rounded and polished tip for extra strength.

## Early Efforts (2)



### First Bellablade:

- BP = 39.8% (0.73" from Handle/Blade interface)
- Length = 10.5"
- Weight 10.95 oz. (306 grams)
- 20° tip (1st asymmetrical tip)
- Thickness = 0.281"

#### Comments:

- Feels good in the hand, but handle/blade not distinct enough.
- Just over 1 oz. per inch—a tad on the heavy side.
- Feels good for any type of instinctive throw. Still in use.
- We believed that yellow would be good for visibility when searching for lost knives—neon green is better.

### Dart 2:

- BP = 38.4% (0.93" from Handle/Blade interface)
- Length = 11.125"
- Weight 12.04 oz. (337 grams)
- 16° tip
- Thickness = 0.281"

#### Comments:

- We wanted to try a bit longer knife, but realized we prefer shorter, lighter knives.
- Feels good in the hand, but a bit too heavy for us.
- Handle/blade interface not distinct enough for indexing
- Still gets occasional use, but not from me.

### Improved Dart (after 5 refurb)s:

- Length = 9.9" (original 10.13")
- Tip was reduced by refurb)s more than by chips.

#### Comments:

- Refurb)s were originally required due to tip and handle damage caused by sideways knife collisions. Gouges in the soft handles, due to hardening of only the blade, caused numerous finger injuries upon releasing knife.
- Two of these finally snapped at the hard/soft interface. This prompted the design of an electric furnace to totally harden our knives. No more issues with breakage or damaged fingers!

## Early Efforts (3)

### First "Shorties"

- Closely resemble my prototype thrower.
- Shown here (yellow) after two refurb.
- Went to yellow, for better visibility, after the original copper powder coat (below).
- Originally had no handle bevel. It was added, using our bevel jig, during second refurb.



### Second "Shorties"

- Same as the originals, but with (free-hand) handle bevel done after 1st refurb.
- We liked the first ones so much, we made this set about two weeks later.
- Shown here (neon green handle) after three refurb.
- Originally there were four, but we lost one in the woods after I stupidly Parkerized them during second refurb.



### Shorties (original specs with bevel added):

- BP = 39.7% (0.76" from Handle/Blade interface)
- Length = 9.05"
- Weight 8.25 oz. (231grams)
- 16° tip
- Thickness = 0.250"

### Comments:

- Great little throwers!
- Still in use today.
- Apparently too small for no spin competition. They require a minimum of 10".
- Feels good for any type of instinctive throw that uses smaller knives.
- Bearded RAT really enjoys throwing these instinctive half spin.

# Some Dead End Knives

## Experimental—only one ever made



### Mini-dart:

- BP = 39.4%
- 7.9" long
- Throws well, but too small
- Nine inch "Shorties" are as short as we go now.
- Still fun to throw, though.

### 1st Offset Knife:

- BP = 36.3%\*
- 10.5" long
- Too handle heavy
- Tip angle = 12°
- HRC = 46—too soft
- Narrow, soft tip broke (~1/8") in a

hard part (knot) of target! I have since come to realize that the tip failure was most probably due to burning the narrow tip in the propane forge during the hardening process.

### Experimental 12" Offset:

- BP = 39.4%
- Too light (22.2 grams/inch)
- Rings like a bell on a miss—painful
- 0.218" thick—shipped by mistake—we ordered 0.281"
- We decided to use it anyway, that was our mistake.

\* I assumed that if a little handle-heavy is good a lot handle-heavy should be better. **I was wrong!**



# Knives We Like to Throw and Sell

## 3rd Generation Improved Dart (also called “Standard Dart”)

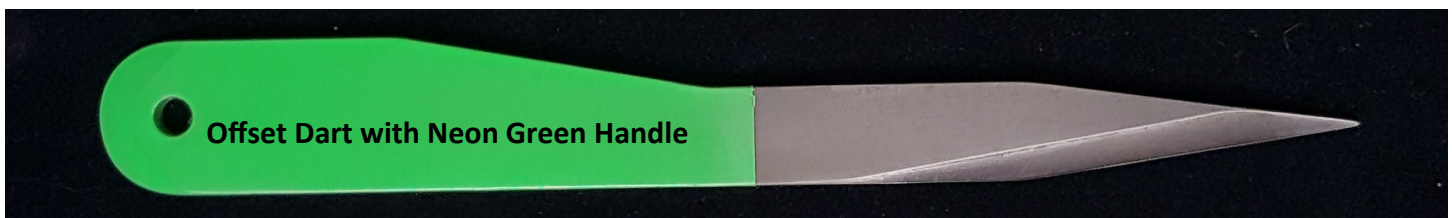


### Improved tip profile:

As you can see on the right, the tip comes to a narrow point from the side, but when viewed edge-on, it appears to be quite broad and rounded. This design provides a strong tip, but still allows for deep penetration while. All of our knives now have this tip style.



We have found that for our throwing styles, these and the Offset Darts are the best. We offer the Offset Darts for those, like the Bearded RAT, who prefer both a flat and a contoured side. All other Darts shown in the following “Knife Info” sections may be ordered, but have a hefty price because we’re lazy and they take more material, time (we don’t stock the necessary metal) and effort. All of our Darts are tougher now as well, due to our improved quenching system.



# Knives We Like

These later knives were all heat treated using our electric furnace. This allows for heat treating of the entire knife. We also use our improved quench oil agitation system for extra toughness. We have found both of these to be important for making tough throwing knives, especially when thrown by RATs.



## Fat Boy (in the white):

- BP = 39.3% (0.8" from Handle/Blade interface)
- Length = 10.36"
- Weight 10.6 oz. (297 grams)
- 16° tip
- Handle width = 1.5" (Fat!)
- Thickness = 0.250"

### Comments:

- Improvement on the original Bellblade.
- More distinct handle/blade interface.
- Feels good for any type of instinctive throw, but especially for instinctive half-spin.
- One of the Bearded RAT's favorite throwing knives, along with his Thick Offset Shorties.



## Offset Dart:

- BP = 39.3% (0.97" from Handle/Blade interface)
- Length = 10.5"
- Weight 9.5 oz. (266 grams)
- 16° tip

### Comments:

- May be thrown from flat or slope side.
- Feels good for any type of instinctive throwing.
- Young RAT retired his original Bellblades for these. He throws from the flat side of the spine.

### Needle 1:

- BP = 39.3% (1.04" from Handle/Blade interface)
- Length = 10.95"
- Weight 9.04 oz. (253 grams)
- 16° tip
- Thickness = 0.281"

#### Comments:

- Rings like a bell on misses—too loud—23.1 grams/inch.
- Nice weight, but feels a bit too light for its length.
- Feels good for a thorn style, acceptable for a finger spring.
- Eric, the Brew RAT uses them quite well!



### Needle 2:

- BP = 39.2% (1.0" from Handle/Blade interface)
- Length = 10.35"
- Weight 9.17 oz. (257 grams)
- 16° tip
- Thickness = 0.312"

#### Comments:

- Feels good in the hand.
- Feels almost too light, but still throws really well.
- After more time throwing, we considered 250—300 grams to be an excellent range for 10—10.5" knives.
- Feels good for any type of instinctive throw.



### Offset Needle:

- BP = 38.5% (1.1" from Handle/Blade interface)
- Length = 10.35"
- Weight 10.97 oz. (307 grams)
- 16° tip
- Thickness = 0.375"

#### Comments:

- Great weight (almost too heavy) and feel.
- Rear bevel really sits well in the hand.
- The combination of offset and increased spine thickness allows for finger spring technique without slips.
- Penetrates too deep and really reduces target life.
- I still occasionally throw these, they feel great!

### 5160 Dart (Improved Dart, but with 5160):

- BP = 38.12% (1.14" from Handle/Blade interface)
- Length = 10.5"
- Weight 9.03 oz. (253 grams after 3 refurbis)
- 16° tip
- Thickness = 0.250"
- Handle Width = 1.25"
- Blade Width = 0.65"

### Updated comments (October 2-2020):

- Made in August 2017.
- I semi-retired these Darts in favor of my Improved Darts—slightly heavier and shorter.

- < 0.12" loss in length after 3 refurbis!



They're still in good shape, but they feel a bit too light after throwing my Standard Darts (266 grams).

### Original Heavy Dart (Heavy Improved Dart):

- BP = 39.08% (0.97" from Handle/Blade interface)
- Length = 10.30"
- Weight 10.72 oz. (300 grams)
- 16° tip
- Thickness = 0.312"

### Comments:

- Feels great in the hand.
- More forgiving than 5160s (above) due to extra weight.
- This is my new upper weight limit for this size knife.
- Feels good for any type of instinctive throw.
- Went to 10.35" (303 grams) on newer versions.
- Now switch between these and my Standard Darts



### Thick Dart:

- BP = 39.2% (0.97" from Handle/Blade interface)
- Length = 10.2"
- Weight 10.5 oz. (294 grams)
- 16° tip
- Thickness = 0.281"

### Comments:

- Feels really nice in the hand.
- Heavier than my Improved Darts, but lighter than my Heavy Darts.
- Like the Heavy Dart—no fun to make!
- I avoid selling these by charging a hefty fee.
- They do throw nice though.



### Perfect Dart (actually, a "Thick Dart" with perfect balance numbers):

- BP = 39.00% (1.00" from Handle/Blade interface)
- Length = 10.16"
- Weight 10.28 oz. (288 grams)
- 16° tip
- Thickness = 0.281"

### Comments:

- My design numbers fell perfectly into place, especially the BP.
- I Liked it so much that I Decided to polish the blades, Garnet blast the handles and hot blue them.
- They're a "three of a kind" set. I don't even throw them—too pretty.
- No, I don't sell them. They're too much work! Besides, who would want to throw them?



## Bearded RAT's Thick Offset Shorties (TOS)

Thick (.281"), Offset (Offset handle), Shorties (Less than 10")

The Bearded RAT really likes throwing "Shorties" with his instinctive half-spin style. Having observed, over time, that heavy knives are generally more forgiving than lighter knives, he decided to make a set of "Shorties" that had more heft than our standard "Shorties". He went with an offset design just for fun.

The results of our design efforts are below, ready for heat treatment, blasting, powder coating and finally, throwing! He'll probably throw them immediately after heat treating. Update: He did!



### Thick Offset Shorties:

- BP = 39.09% (0.85" from Handle/Blade interface)
- Length = 9.1"
- Weight 9.03 oz. (253 grams)
- 16° tip
- Thickness = 0.281"

### Comments:

- Shorter than most of our knives, but still feels great in the hand.
- Nice weight for a 9" knife.
- Heavier than many commercially made 10+ inch knives!
- I'm looking forward to no spin throwing them. Update: I did!
- Due to short length, Bearded RAT prefers to throw them from the flat side. Since I throw no spin, I prefer to throw them from the sloped side.

## Bearded RAT's Latest Thick Offset Fat Boys (TOF)

Thick (.281"), Offset (Offset handle) Fat Boy Darts (10" or longer)

The Bearded RAT liked his Thick Offset Shorties so much that he decided to make yet another variation, combining his "Fat Boys" and Thick Offset Shorties. He just made them longer!

He wants to see how well he can throw them at greater distances. Personally, I'm considering a set of longer (11.5" - 12") Standard(?) Darts. We like to play!

The TOFs below were still awaiting heat-treat when I took the pix. He plans to blast and neon green the handles before ever attempting to throw them. He learned his lesson last time when he decided to throw a new set of Standard Darts that I hot blued for fun. It took about a week to find one of them with the metal detector because, as he stated it, "That had to be my worst throw ever!" I had no reason to argue.



### Thick Offset Fat Boys:

- BP = 38.8% (0.88" from Handle/Blade interface)
- Length = 10.45"
- Weight 10.93 oz. (306 grams)
- 16° tip
- Max. handle width= 1.4" (Fat)
- Thickness = 0.281"

### Comments:

- None available until he throws them.



We get a lot of requests for knife prices. Since we do all, not just some, of the knife-making work, we tend to place a great value on them. We answer every request. Sometimes, that's the last contact with a prospective customer. Oh well, less work for me! Did I mention I'm retired?

We continue to say, "Buy Arrows, they're fine throwers." But there are some who decide that our Darts may be pretty good for the price. That is why I am rewarding those who make it to the end of our latest update with our price list. Now you don't have to ask before making a request or buying something else.

As usual, we continue to assist any DIYers who want to make their own stuff: Kydex press, furnace, foundry, powder coat booth, knives, etc. We also continue to learn and improve our processes.

### Improved Darts (our favorites) Prices



In the White (most common)



Neon Green with Black Oxide (rust protection)



Neon Green White blade