究研刀作
誌々会究研法製刀本日
号拾第卷三第

将校刀製作に関する研究（其一）

戦前戦後

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序

将校刀製作

行發日十二月四年七十和昭
仕様書

将校用軍刀々身加工

一、全般的外観ハ寸法、形状ニ均等アリ上品ニシテ強

半形ヲ有シ切味良好ニシテ特ニ打及着打ニ對シ

二、形状ハ鎚造ニシテ華表反リトス

三、本品ハ玉鋼及施丁鐵ヲ以テ木炭ヲ使用シ製作スル

蒙古ノ製作者ノ最モ得意トスル鍛造方法及硬軟組

織ノ組合ニテ可ナルモノ実施要領ニ就テハ作

業着手前＝屆出ヲモトス（別紙様式四通＝）

四、刃身ノ肉置ハ棟地ハ鎚地平ニシテ地及双ハ適度ナ

ハノニ曲线又ハ直線ニシテ表裏對称ノ形状ヲ有シ延

獲ハノ曲線又ハ直線ニシテ表裏對称ノ形状ヲ有シ延

五、中心ノ形状、鎚仕上及刻銘ハ特ニ入念＝行ヒ銘ハ

外装ノ一般型式＝致セシメ佩裏＝製作年月日（干

ニ＝）形モ可リノ彫刻スルモトス

六、刀身ノ肉置ハ棟地＝鎚地平ニシテ地及双ハ適度ナ

ハノニ曲线又ハ直線＝シテ表裏對称ノ形状ヲ有シ延

獲ハノ曲線又ハ直線＝シテ表裏對称ノ形状ヲ有シ延

ロノ曲線又ハ直線＝シテ表裏對称ノ形状ヲ有シ延

七、反、身上＝重＝切先＝長サ其ノ他各部ニ寸法ハ圖

ハノ長サ及重量

八、長サ及重量

中

双渡

小

二（寸）一寸二尺

二（寸）五寸二尺

一寸二尺

于二尺

示ノ通トス

于二尺

于四尺

于四尺

于四尺

于四尺

于四尺

于四尺
一、持込ノ上達試験、切味試験、外観検査及材質検査ハ所要ニシテ検査官ニ卜抽出スル交付材料ヲ以テ全数ヲ製作シ得タルノヲハ不良ナルノヲ有す場合、健全ノヲ欠クノヲ有す場合、不十分ナルノヲ有スルモノナルス。

第二条 製作上要義ノ點ハ作業者手前當駄ノ指示ヲ受ヒ、制作ヲ行フモノナルス。

第三条 本加工ノタケ別紙交付材料調書、通素材ヲ交付スラルモノナルス。

第四条 検査ハ左記各号＝依り行フモノナルス。
作刀研究

編輯

後記

平重

作刀研究

発行所

日本刀製法研究會
Commissioned Officer’s Gunto Manufacturing Specifications.

Article 1. The drawings and writings appended at left describe the specifications for the manufacture and polishing of each blade to be delivered/supplied.

1. Generally the shape and length will be a balance of elegance and strength. Cutting ability will be good and especially as regards the forging of the hira-uchi and the mune-uchi, these will be tough but light, so as not to bend or break.

2. Shape will be shinogi-tsukuri and torii-zori.

3. Blades will be of tamahagane and hacho-tetsu and charcoal will be used. The strongest methods of sword forging, combining toughness and structure will be enforced on commencement (as described in the enclosure for style in Form 4). Ha-ko carbon content will be 0.5 – 0.7% range. Hacho-tetsu carbon carburizing will be controlled by multi fold-forging. Carbon control will be in the 0.05 – 0.25% range.

4. Hamon is optional but must be chu in width.

5. Nakago shape and file work will be of quality and mei cutting will be scrupulously done. The mei will be on the outside in the normal way and on the reverse/opposite side will be the date of manufacture as year, month, day (sexagenary cycle is also permissible).

6. The blade body will have a degree of niku, but mune and shinogi-ji surfaces will be flat. Ji and ha roundness to be moderately hamaguri-ba. There will be no unevenness in the polishing of the corner lines, curves or straight lines, nor in the symmetry of the omote and ura. There will be no grinding marks and “scratches”. Ji-hada will be clearly apparent. Yakiba borderline to be wiped with nugui. The shinogi-ji and mune-ji to be polished using migaki-bo (burnishing needle) to the area of the habaki. The ko-shinogi and the matsuba-kado interception point kasane will also be polished leaving it a little thick, the dimensions of the ha section and the mune section to be at the regulation dimensions and not less.

7. Curvature, width, thickness, tip length and other dimensions are to be consistent with the explanatory diagrams.

8. Length and weight.

   Ha-watari. Small: 2.0 - 2.1 shaku (60.6 - 63.6 cm). 195 - 205 momme (731.3 - 768.8 g).
   Medium: 2.1 - 2.2 shaku (63.6 - 66.7 cm). 205 - 215 momme (768.8 - 806.3 g).
   Long: 2.2 - 2.3 shaku (66.7 - 69.7 cm). 215 - 225 momme (806.3 - 843.8 g).

   Nakago. 7 sun (c. 21.2 cm).

9. Long, medium and short manufacture is to be carefully advised.

10. Concerning the shape and dimensions of completed swords, a little variation to the appended drawings is acceptable, but exceeding the weight must be with approval.

11. It is a requirement that manufacturer who does yaki-ire is the same man who does the mei cutting.

12. Small changes, variations or overlaps in the forging method or hardening component, requires government approval.
**Article 2.** Where there is any doubt about manufacture, the manufacturer will receive the appropriate sword workshop direction.

**Article 3.** Drawings, instructions and materials will be supplied for the purpose of correct manufacturing process. Where the delivery of materials for use in manufacturing is partly insufficient, the deficiency will be made up without charge, provided the cause is due to inferior material. Conversely, where a surplus of materials occurs (unused material and unfinished items) or items failing inspection, it is required to be returned to the government.

**Article 4.** Inspection is conducted according to the information appended at left.

1. Compliance examinations will be conducted with a quality test, a sharpness test, an external appearance inspection and a quality of materials inspection. The first test will be for cutting ability (*chu nagura*). At that time a second test for the appearance (by an experienced polisher) will be conducted. In conformity with government examination for quality testing and materials inspection, eligible swords will be selected at their discretion from those submitted to conduct sharpness tests and external appearance inspections.

2. For compliance testing it is required that a section of steel tube (dia. 80 mm) to strike from 60 degrees across the blade flat to ascertain its bend or break quality. On the occasion of failing the test the manufacturer concerned will receive instructions from the government before further inspections that thereafter he must comply with the rules.

3. Concerning the item submitted for quality of material testing in the previous paragraph, a microscopic cross-section inspection will be conducted.

4. Cutting test will consist of rolled-up straw (2 mm thick, 10 cm diameter) as well as a soft steel plate (2 mm thick, 1 cm wide). The former will be cut satisfactorily and the cut will be at least 12 cm. In the latter, it is required that the *ha* does not sustain damage nor the blade bend.

5. External appearance inspection.
   1. Generally, external appearance requires a keeping to the regulations on balance, shape and weight.
   2. It is required that in the blade that *hagire*, *jigane kizu*, *yakiware* and suchlike flaws are not present.
   3. The standard of polish is to appear as close as possible to the sample specimen.