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作刀研究

日本刀製法研究會々誌

第三巻第拾號

目次

昭和十七年四月二十日發行

將校用軍刀々身加工
仕様書

第一條　本品ハ別紙圖面竝左記各號ニヨリ製作シ上研ヲ施シ納入スルモノトス

一、全般的外觀ハ寸法、形狀ニ均衡アリ上品ニシテ强キ形姿ヲ有シ切味良好ニシテ特ニ平打及棟打ニ對シテ强靱ナル性質ヲ有シ容易ニ折損セザルモノナルヲ要ス

二、形狀ハ鎬造リニシテ華表反リトス

三、本品ハ玉鋼及庖丁鐵ヲ以テ木炭ヲ使用シ製作スルモノトシ製作者ノ最モ得意トスル鍛錬方法及硬軟組織ノ組合セニテ可ナルモ其ノ實施要領ニ就キテハ作業着手前ニ届出ヅルモノトス（別紙樣式四通）

刄鋼ノ炭素含有量ハ〇・五――〇・七％ノ範圍トス

心鐵ハ庖丁鐵ニ炭素ヲ吸收セシメタルモノニシテ數回ノ鍛錬ヲ施シ介在物尠ク炭素含有量ハ〇・〇五――〇・二五％ノ範圍トス

四、刄文ハ隨意トスルモ刄文ノ深サハ中程度トス

五、中心ノ形狀、鑢仕上及刻銘ハ特ニ入念ニ行ヒ銘ハ外裝ノ一般型式ト一致セシメ佩裏ニ製作年月日（干支ニテモ可ナリ）彫刻スルモノトス

六、刀身ノ肉置ハ棟地、鎬地平ニシテ地及刄ハ適度ナル弧形ヲ有スル蛤刄トシ凹凸ナク地研ヲナシ筋及角ハ一ノ曲線又ハ直線ニシテ表裏對稱ノ形狀ヲ有シ砥石跡及「シケ」ナク地肌ヨク現レ燒刄ニ沿ヒテ刄ヲ拾ヒタルモノトス鎬地及棟地ハ磨棒ヲ用ヒテ研磨シ鎺附近ハ附刄セズ小鎬ト松葉角ノ交點ニ於テ重ネヲ若干增ス如ク研磨ス刄區、棟區ノ寸度ハ定寸ニ對シテ負ヲ許サズ

七、反、身巾、重、切先ノ長サ其ノ他各部ノ寸法ハ圖示ノ通トス

八、長サ及重量

刄渡　小　二、〇―二、一尺　一九五―二〇五匁
　　　中　二、一―二、二尺　二〇五―二一五匁

大　二、二―二、三尺　二一五―二二五匁

中心　七　寸

九、大、中、小ノ製作區分ニツキテハ別ニ示ス

十、完成品ノ寸法、形狀ハ添付圖面ト僅少ノ相違ハ許容シ得ベキモ重量ノ相違ハ許容セザルモノトス

十一、鍛刀者（燒人ヲ含ム）ト刻銘者ハ同一人ナルヲ要ス

十二、鍛錬方法及硬軟組織ノ組合セヲ改變セントスル時ハ官ノ許可ヲ得ルヲ要ス

第二條　製作上疑義ノ點ハ作業着手前當廠ノ指示ヲ受クルモノトス

第三條　本加工ノタメ別紙交付材料調書ノ通素材ヲ交付ス

交付材料ヲ以テ全數ヲ製作シ得ザルトキハ不足分ヲ有償交付ス但シ材料不良ニ基因スル不足分ハ無償交換スルモノトス交付材料ヨリ生ズル過剩品（未加工材料及半途品）竝不合格品ハ官ニ返付スルヲ要ス

第四條　檢査ハ左記各號ニ依リ行フモノトス

一、持込ノ上撓擊試驗、、切味試驗、外觀檢査及材質檢査ヲ行フ

撓擊試驗、切味試驗ハ第一次持込（中名倉）ノ際行ヒ外觀檢査ハ第二次持込（研磨完了）ノ際行フモノトス

撓擊試驗及材質檢査ハ所要ニ應ジ檢査官ノ抽出スル任意ノ一振ニ就テ行ヒ切味試驗、外觀檢査ハ全數ニ就テ行フモノトス

二、撓擊試驗ハ鋼管（直　八拾粍）ニ對シ平打ヲ行ヒ六拾度彎曲スルモ折損セザルモノタルヲ要ス撓擊試驗ニ不合格ノ際ハ合格品ヲ得ル迄檢査ヲ繰返スヲ本則トスルモ爾後ノ作業ニ關シテハ官ノ指示ヲ受クルモノトス

三、材質檢査ハ前項供試品ニツキ斷面ノ顯微鏡檢査ヲ行フモノトス

四、切味試驗ハ卷藁（直徑約拾糎ノモノ二束）及極軟鋼板（厚二粍、幅一糎）ニツキ試驗スルモノトシ前者ハ切味良好ニシテ切込量拾二糎以上後者ハ刃コボ

レナク切斷シ曲リナキヲ要ス

五、外觀檢査

（一）全般的外觀ハ均衡ヲ保チ寸法、形狀及重量ハ規定ノ範圍內ナルヲ要ス

（二）刀身ハ双切レ、地金疵、燒割レ、其ノ他有害ナル疵ノ存在ナキヲ要ス

（三）研ノ程度ハ仕上見本ト略同等トス

~~軍刀々身加工要領許可願~~

~~昭和十六年　月　日~~

~~現住所~~

~~氏　　名　印~~

~~東京第一陸軍造兵廠　御中~~

~~今般貴廠ノ軍刀々身加工方御下命相成候處左記ノ要領ニヨリ實施可仕屆出候間此段御許可相成度候~~

~~左　記~~

~~一、鍛錬區分~~

~~二、鍛錬方法~~

~~三、鍛錬回數~~

~~双鋼~~
~~皮鋼~~
~~棟鋼~~
~~心鐵~~

~~四、硬軟組織組合セ~~

~~五、組合セ割合（材料貳百匁トシテ）~~

~~双鋼~~
~~皮鋼~~
~~棟鋼~~
~~心鐵~~

~~六、研師現住所氏名~~

Imprint page.

編輯後記

○大東亞戰爭の輝く大戰果は第四回目の大詔奉戴日を迎へて遂に米英の最大據點を屠り去つた、皇軍傳統の攻擊は疾風枯葉を卷くに等しく、其勇戰奮闘は將に世界に冠絕す、豈感謝感激の極ならむや。一方大東亞建設の礎石として散華せる忠魂英靈に對し心からなる默禱を捧げ、今後の推移に對處して皇國を萬代の安きに置かむ事を誓ふ、英靈忠魂永久に神靜まり給ひ。

○去る二月軍刀鑑査委員會が設立され、三月一日より其業務が開始された、同會委員は軍民の斯界に於ける權威者を以て網羅されて居り、その目的とするところは優秀なる武人刀を量的に確保する爲に、必要なる研究指導が行はれ、且又協力者に對する助成が爲される。決戰態勢下從來の昭和刀を徹底的に葬り去つて、鍛錬刀としての優秀なる武人刀を量的に提供することこそ現代刀匠に課せられたる重大使命であり、之の實踐は躍進途上にある皇國に翼賛する所以でもある。刀匠、研匠、外裝師の一大奮起を要望すると共に、一丸となつて軍刀鑑査委員會の傘下に結集されむことを切に希求するものである。

○三月末發行豫定のところまた遲延してしまつた。誠に申譯ない、御寬容を乞ふ。

作刀研究 奥付

【非賣品】

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振替東京一三六、九〇五番

Commissioned Officer’s Gunto Manufacturing Specifications. (English Translation)

English Translation by George Trotter, Documents provided by K. Morita

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 *hocho-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. *Hocho-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 (*chunagura*). 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 itemsubmitted 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*, *jiganekizu*, *yakiware* and suchlike flaws are not present.
    3. The standard of polish is to appear as close as possible to the sample specimen.