

no such luck in the shop at work. So i clamped a piece of 2x4 into the vice and used it to hammer the flare over. Like everything else, you have to do this in a number of passes, if you go to fast you could warp the boss, or cause the flange to crack or tear. Just keep going, pass after pass until you get the flange down to about 90 degrees and even enough to make you happy. I found it worked best to do a pass with the peen end, stretching the metal, then a pass with the face to fold it out, and just kept alternating until i was happy.

After a lot of digging around the shop i found a piece of 1"x1" bar stock to use as a stake to clean up the flange. I wish I had found it when I was flaring it out in the first place. Anyways, a quick trip to the grinder left me with one nice edge to work on and a smooth area on the top.

Once I had my stake made up cleaning up the flange was as simple as holding the flange against the top of the stake and making a few passes around it with the flat face of the hammer to make the whole flange flat. Then to sharpen it I made a few more passes, gently hammering the crease itself against the corner of the stake with my dishing hammer. Any hammer with a curved face will work for this, but the dishing hammer was what I had.

Step 6: The Body of the Buckler



First thing you'll need to do is decide how big your buckler will be. In my case I've got a small barrel clamp that says my buckler is going to be as big as the lid it was meant to go around.

Now just mark out an appropriate sized circle and cut it out.

If your fortunate enough to scavenge a barrel clamp like mine, you'll need to remove the clasp from it. This is actually really easy to do. All you need to do is slide a chisel under the clasp and give it a few solid knocks to break the spot welds holding the clasp onto the ring. To break the other half of the clasp free use a hacksaw to score it at the base of the lever, then bend it back and forth to snap it off. now just clean up with a file and your good to go. I recommend keeping the little loop thing so that you can hang up your buckler when it isn't in use. If you do want to take it off, then cut it in the center, pry it open then slip the chisel under it and take it off just like the rest of the clamp.

Step 7: Edging Your Buckler



You don't need to edge your buckler with steel, other things I've seen used include rope, leather, rawhide, even old bicycle tires. However, since I've got this awesome ready made rim for my buckler I'm going to go over how i mounted it.

From what I understand, historically a steel rim would either be riveted to the edge, or held on with clamps. I don't have enough overlap on this rim for rivets, so clamps it is.

The first step is to figure out how you want your clamps to look, and where you want to put them.

I'm opting for 2 large clamps, and 2 small clamps, spaced evenly around the edge.

I built my clamps out of pallet banding, the larger 2 from 1 1/4", the smaller 2 from 3/8". To form them I scrounged up a chunk of appropriately sized bar stock to use as a punch of sorts, and used the jaws of the vice as a die.

simply put, i laid my banding across the vice, with the jaws opened just a little

more than the width of the bar stock, then laid the bar stock across the banding and bashed it with a big hammer.

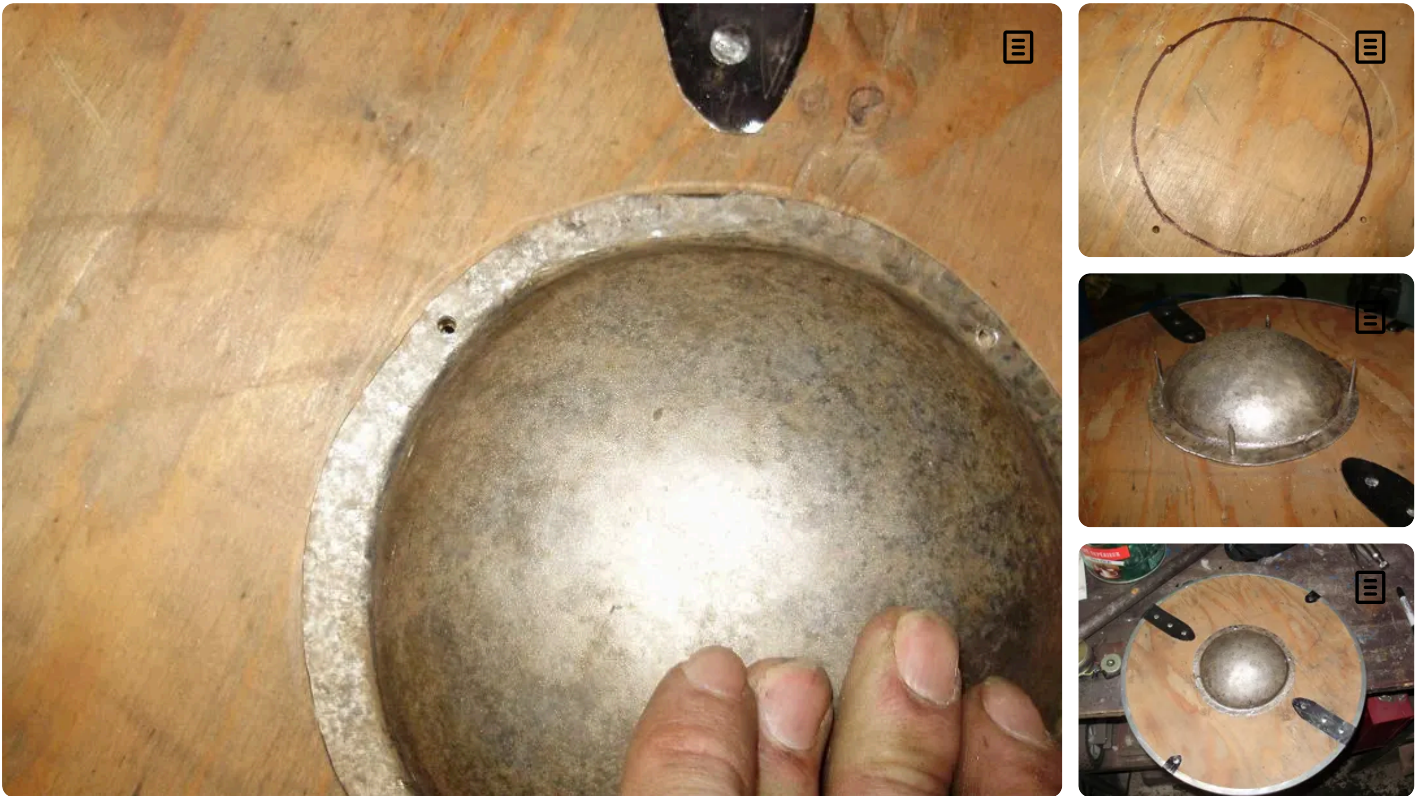
From there I cleaned up the shape with some pliers and put nice ends onto them.

Once you have clamps made mounting the rim is just a matter of clamping the clamps in place and riveting them down.

I recommend starting opposite the opening in the rim and working your way around so that the split is done last. that way you can make sure that each clamp is holding the rim tight against the wood underneath.

This should be obvious, but make sure you have 1 clamp over the split in the rim when you are done.

Step 8: Mounting the Boss and Building a Handle



At this point I realized that I hadn't drilled any rivet holes in the boss. So, if you haven't done that yet drill 4 or more evenly spaced holes around your flange. Once you've done that lay the boss where you want to it and scratch an outline on the buckler. Use a sharpie to mark where the holes go, then take the boss off and mark out a second ring on the inside. Now just pick up the jigsaw, cut out the inside ring, and were ready to rivet on the boss.

If you pre-drilled your holes like I did, then you'll most likely have to fiddle around a bit to get them to all line up again. If not, plop your boss down, drill your holes, slip in some nails, clip em to length and peen them nice and tight. I didn't use any washers on mine, but it's probably a good idea to put some on the wood side. just to make sure the nail doesn't pull through the wood. all kinds of weird stresses are put on gear in combat.

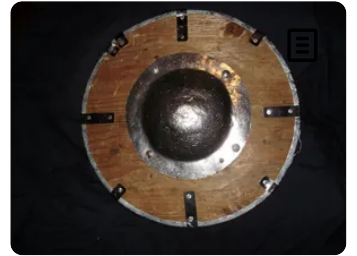
There are a few ways to build a handle. The easiest is probably a length of hockey stick riveted or bolted in place, I'd say next up comes a length of electrical conduit with the ends flattened out. I opted for a bar with scales.

The first thing I did was cut some 1/8" bar stock down to a length I liked and cleaned up the ends a bit. Then I marked out the area that would have the scales on it, and bashed up the rest with a heavy hammer to give it some character.

Next I traced the grip area onto some scrap plywood, cut it out, and rounded off all the outside surfaces. Then I clamped it onto the bar, drilled a few holes and riveted it in place. Once your grip is assembled just rivet it into the body of the buckler and your good to go.

For whatever reason, I only made a scale for one side. That left me with a D shaped grip that was rather uncomfortable. I solved that by putting a leather shim on the other side and then a cord wrap over the whole thing to hold it in place and add a little cushion. I really dont know what i was thinking with the D shaped grip though, I mean, sheesh, that was dumb.

Step 9: Congratulations It's Finished



Now I just have to let my girlfriend break in her buckler and in no time it'll be almost haggard as mine is.

If you decide to build a buckler yourself send me some pics, I like seeing other peoples projects.