

## Crown Stag Jigs

*Steve Bloom. IronFlower Forge*

How to get the anterior surface of a crown stag handle to be exactly parallel to the back of the guard?

Of course, a jig. The pipe section in the vise allows rotation in-and-out. The "T" section above it (connected to a smaller pipe welded at right angles to the first) allows left-and-right rotation. The third section inserted into the "T" allows rotation on the remaining axis. Add a target plane in the collet on the mill and you are ready to go.



The third section has a set of wood “V” blocks to clamp – without damage- the stag. As long as the guard’s rear surface is parallel to the mill’s cutting plane, all is well.



And the fit isn't half-bad..no?



Now – the other end.  
I like to embellish  
the crown with an  
insert – like the cast  
silver lion's face. It  
was approximately  
1.25" in  
circumference and  
my biggest end-mill  
is 1.125". So I made  
a trial depression (for  
testing) and scribed a  
1.125" circle on the  
back of the casting.



I used a plastic template for the scribe and then carefully ground away the edges of the casting until it just fits the trial depression. Voila.



The jig was reset to place the crown's surface parallel to the mill's cutting edges (and some wedges were used to be really sure that nothing moved) and the real depression was made. Not clamping enough tends to be depressing....



The result is depression with squared sides and a 1.125" depth just crying out for the cast piece.



Add some epoxy to the seat, plop the casting in place and wipe off excess epoxy and you get a nice “pop”.



From my website, here is the documented appearance of the piece (the blade is 01-L6-1095-203E at 132 layers). It was austempered. The guard is nickel silver and...



The pommel looks like this. All it takes is a jig, a mill, a big end mill, a casting (at last resort, think Tandy conchos) and a nice chunk of crown stag.

