

RUANA[®]

Knife Works, Inc.



SINCE
1938

A MONTANA TRADITION



COMPANY HISTORY AND PHILOSOPHY



Rudy Ruana circa 1958

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Having left the decimated family farm in North Dakota and looking for greener pastures, 1938 found Rudy Ruana in Bonner, Montana working as a mechanic and welder at a small garage. In order to help his family survive during the post depression era, Ruana began to make a few knives on the side—a skill that originated in the 1920's when he was a farrier in the cavalry, making his first knives for a couple of Native Americans in need of a better tool for skinning horses. As time passed and the reputation of Ruana's knives grew, demand became so great that Rudy began making knives full time in 1952, calling his business Ruana Knife Works. In 1964 Ruana's son-in-law, Vic Hargas left a job with the phone company and put his artistic talents to work, joining

Ruana in the business. Hargas' son Mark began working at the company in 1976. At the end of 1983 Ruana retired at the age of 80 and sold the business to the Hargas family. In 1984 Mike Hargas joined his brother and Dad and the business was incorporated. Rudy Ruana passed away in April of 1986. He received the honor of being posthumously inducted into the American Bladesmith Society Hall of Fame in 1997 and BLADE Magazine's Cutlery Hall of Fame in 2002. As of 2008, Vic, Mark and Mike Hargas have combined Ruana Knife making experience in excess of 100 years.

In an era of outsourcing and diminishing Made in America products, Ruana Knives are still handcrafted in the small shop where Rudy Ruana began



RUANA KNIVES ARE STILL HANDCRAFTED IN THE SMALL SHOP WHERE RUDY RUANA BEGAN FORGING OUT BLADES NEARLY 70 YEARS AGO AND ARE AMERICAN MADE AS MUCH AS A PRODUCT POSSIBLY COULD BE.

forging out blades nearly 70 years ago. While a few things have changed over the years, we are still using the same methods and much of the same equipment Rudy used. Our goals are to never rest on our laurels and give our best effort on a daily basis while maintaining Rudy Ruana's work ethic

and emphasis on uncompromising quality over quantity. We proudly craft knives that are American Made as much as a product possibly could be, with a continued commitment to knife creations that are first and foremost usable and durable, and as evidenced by customer demand, increasingly collectible.



CAST HANDLE KNIVES AND HATCHET



ALL RUANA KNIVES AND THE HATCHET ARE MADE FROM TOUGH CAST ALUMINUM HANDLES WITH ELK ANTLER INSERTS AND COME WITH A HIGH QUALITY SHEATH. RUANA STICKERS ARE VERY VERSATILE AND WILL WORK WELL IN A VARIETY OF SITUATIONS. SKINNERS ARE A LITTLE MORE SPECIALIZED IN THEIR DESIGN, BUT WILL WORK WELL FOR ALMOST ANY JOB.

STICKERS

S/H-Steelhead—Blade: 3 1/2", 1/8" stock. Handle: 4 1/2". Our unofficial trout and bird knife that works well on anything from small fish to big game.

5 AD-Drop Point Sticker—Blade: 4", 1/8" stock. Handle: 4 1/2". Very versatile knife with long handle for larger hands. Great for all around outdoor use on game small and large.

95 AD-Drop Point Sticker—Blade: 4 1/4", 3/16" stock. Handle: 4 1/2". A flat grind blade that is excellent for hunting and all purpose use. Handle is usually a little more streamlined than other models.

12 A-Sticker—Blade: 5", 3/16" stock. Handle: 4 1/4". A basic knife blade suitable for jobs that require more size.

21 A-Sticker—Blade: 5", 3/16" stock. Handle: 4 3/4". Same blade as model 12 A, with a comfortable finger grip handle and thumb grooves on top of blade.

27 AC-Custom Finn—Blade: 5", 3/16" stock. Handle: 4 1/2". A classic Ruana design with blade that has nice lines and is very functional. Thumb rest ground in top of blade.

25 AC-Custom Workman—Blade: 6", 3/16" stock. Handle: 4 1/2". A modified Bowie blade that has been carried for years by members of the U. S. Armed Forces. Works well as a combat and survival knife.

SKINNERS AND HATCHET

10 B-Skinner—Blade: 3 1/2", 1/8" stock. Handle: 2 3/4". Our most popular knife, recently used by Mike to fully field dress a 6 point bull elk. Referred to by many as the "Smokejumper" because of its popularity among those firefighters bearing the same name.

6 BD-Drop Point Skinner—Blade: 4", 1/8" stock. Handle: 4 1/2". A nice size and shaped hunting blade with a longer handle for larger hands.

95 MP-Multi-Purpose—Blade: 4 1/4", 3/16" stock. Handle: 4 1/2". A flat grind blade, originally developed for an avid hunter who deemed this blade to be the very best for all around hunting use. After using it, and seeing its popularity, we agree.

14 B-Skinner—Blade: 5", 3/16" stock. Handle: 4 1/4". The most basic of hunting knives and very popular.

20 B-Skinner—Blade: 5", 3/16" stock. Handle: 4 3/4". Same blade as 14 B, with a comfortable finger grip handle. Thumb notches on top of blade. Knife used on our logo makes it the most recognizable Ruana knife made.

26 CD-Custom Semi-Skinner—Blade: 5", 3/16" stock. Handle: 4 1/2". Good all around knife for hunting and general use. Includes notched thumb rest on top of blade.

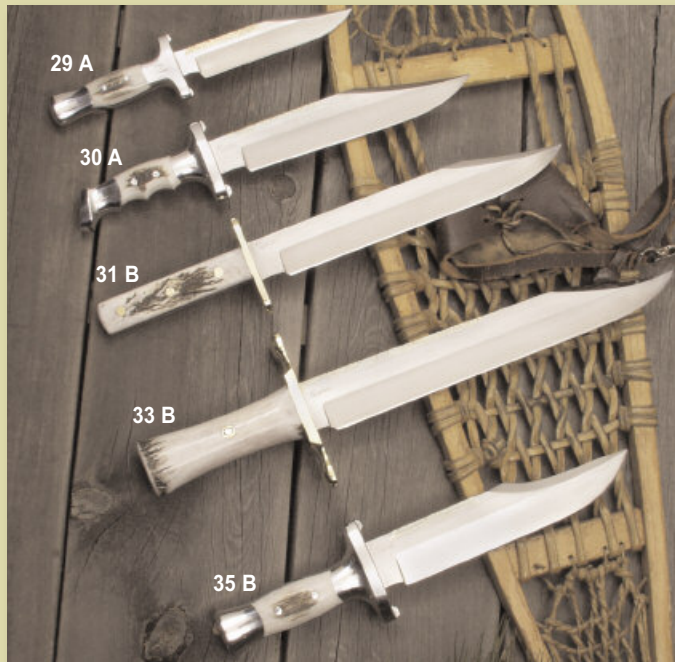
28 CD-Custom Skinner—Blade: 4 1/2", 3/16" stock. Handle: 4 1/2". A pure skinning knife with thumb rest on top of blade. Blade was favorite of famous Alaskan hunting guide.

22 H-Hatchet—Bit: 4 3/4", 3/8" stock. Handle: 4 3/4". Overall length: 10 1/2". Very popular light duty hatchet. Great around the camp or out in the field quartering large game. The tool to use for chopping instead of a knife.





BOWIE KNIVES



BOWIE KNIVES PLAYED A VITAL ROLE IN THE DAILY ACTIVITIES OF EARLY AMERICAN SETTLERS, BEING AS IMPORTANT AS THEIR RIFLES AND AXES.

Bowies were originally designed as a fighting knife, but were also used on the trail for survival and as a camp knife. Although Ruana Bowies are made for heavy use, they have become increasingly popular as collector items. Many customers consider the Bowies works of art and display them in their homes.

Each Ruana Bowie blade is forged from heavy chrome alloy spring steel, and ground with an edge angle that is

excellent for chopping and other heavy duty use. Several Bowie models contain a braze welded brass parry strip on top of the blade that was originally intended as a fighting tool, with the hope that a knife fighter's opponent would sink their Bowie blade into the softer brass strip and enable the fighter with the parry strip to disarm their opponent. The parry strip on Ruana Bowies is intended for decorative purposes. All Bowies come with a Standard Bowie Sheath.

29 A-Junior Bowie—Blade: 6 1/2", 1/4" stock, with parry strip. Handle: 4 1/2"; cast aluminum with elk antler inserts. The smallest Bowie offered. Carried by several U. S. Troops in Vietnam. Also handy for camping.

30 A-Deluxe Bowie—Blade: 9 1/2", 5/16" stock, with parry strip. Handle: 4 7/8"; cast aluminum with elk antler inserts. Slim blade combined with easy to hold finger grip handle make this an excellent combat and survival knife. Our best selling Bowie.

31 B-Early American Bowie—Blade: 11 1/2", 5/16" stock. Handle: 5 1/2"; brass guard, full tang, elk antler slabs with brass rivets. Style popular in England from 1830's on. An elegant Bowie useful for heavy duty chores.

33 B-Classic Bowie—Blade: 14", 3/8" stock, with parry strip. Handle: 5 3/4"; brass guard, elk antler with brass rivet and recessed brass butt cap. Replica of knife possibly carried by James Bowie (original was lost at the Alamo). This brute of a Bowie is the largest knife in our brochure.

35 B-Standard Bowie—Blade: 9 1/2", 3/8" stock, with parry strip. Handle: 5 1/2"; cast aluminum with elk antler inserts. Designed as a combat knife, but also popular with outdoor enthusiasts.

38 C-Civil War Bowie—Blade: 12", 3/8" stock, with parry strip. Handle: 5 3/4"; brass guard, with elk antler and brass butt cap. Longtime Bowie pattern used before and during the Civil War.

41 D-Mexican Border Bowie—Blade: 10", 3/8" stock, with parry strip. Handle: 5 1/2", brass guard, with elk antler and brass butt cap. Bowie popular on the Mexican border.

42 D-Toothpick Bowie—Blade: 9 1/2", 5/16" stock. Handle: 5", brass guard, with elk antler and brass butt cap. Early south-eastern Bowie with a unique blade shape.

43 D-Arkansas Toothpick Bowie—Blade: 9 1/2", 5/16" stock, with parry strip. Handle: 5", brass guard, with elk antler and brass butt cap. Another toothpick type Bowie with streamlined blade.

CB CK-Custom Brass Camp Knife—Blade: 9", 5/16" stock, with file work on top. Handle: 5", brass guard, micarta and brass spacers, with elk antler and brass butt cap. Introduced in 2001, this handsome Bowie/Camp Knife works well on the den wall or in camp.





THE MAKING OF A RUANA KNIFE



Anyone who has tried to make a knife on his or her own is aware that it is not always the easiest of work. For about 70 years a little blood, a lot of sweat and an occasional tear have gone into making Ruana Knives. Hot, loud, dirty, physically demanding, monotonous, and dangerous are just a few of the words used to describe the work that takes place at the Ruana Knife Works shop. Each knife is manufactured using power and hand tools and machinery that literally require hands on work throughout the entire production process. All knives are crafted one at a time with attention to detail given at every step along the way, enabling us to keep quality our number one priority while making the knives.

The Blades. Rudy Ruana was once quoted as saying, "you pay for the blade and the rest is free." While not totally true, the main goal at Ruana Knife Works, Inc. has been and will always remain to produce a cutting tool that will be reliable for its owner. Each Ruana blade is made from high carbon steel that is hammer forged, hollow ground, individually oil quenched, and heat treated using a zone tempering method that makes the spine of the blade a little softer than the cutting edge. Our high carbon blades are not stainless, but they contain the best steel for a knife that provides a great cutting edge, will stay sharp, and is relatively easy to resharpen. With minimal care, they will last you a lifetime and then some.

The Handles. Ruana Knife handles come in several different forms. The most common knife handle is aluminum cast directly on the tang with elk antler inserts that are beveled and riveted. The tang runs inside the entire length of the handle and cast aluminum produces a strong handle that will not fall apart – it is there to stay unless you take a cutoff saw to it. We also make custom handles that have full tangs with slabs from elk antler, micarta, or wood that are epoxy glued and contain rivets

to strengthen the handles. Our brass-handled knives are the prettiest, but they too are made with usage in mind. The guards are braze welded for strength. The tang runs through the entire length of the handle and the butt cap is threaded onto the tang with some butt caps being recessed. Epoxy glue is used to strengthen and secure these handles, which are most commonly made with elk antler although other materials are used occasionally.



THE FOLLOWING ARE STEPS INVOLVED IN MAKING A RUANA MODEL 20 B KNIFE. THE AMOUNT OF TIME FOR EACH STEP VARIES FROM A COUPLE MINUTES UP TO JUST SHY OF HALF AN HOUR.

- 1 Cut steel to length for blade
- 2 Grind blade to basic shape
- 3 Mark blade to proper length
- 4 Forge out tang
- 5 Forge out blade
- 6 Rough grind blade to basic outline shape
- 7 Grind tang to shape
- 8 Grind end of tang for hooking into mold
- 9 Hollow grind blade
- 10 Hook end of tang to fit into mold
- 11 Grind hooked end of tang
- 12 Harden blade by quenching in oil
- 13 Wipe oil off blade
- 14 Cut elk antler to proper length for inserts
- 15 Mill elk antler flat
- 16 Sand flat side of elk antler
- 17 Dovetail mill elk antler
- 18 Round ends of elk antler to fit into handle
- 19 Cast aluminum handle onto tang
- 20 Cut knob off end of handle
- 21 Rough grind handle
- 22 Trim shoulder of guard on handle
- 23 Mill dovetails in handle
- 24 Hammer elk antler inserts into handle
- 25 Trim elk antler inserts on band saw
- 26 Drill handle for rivets
- 27 Countersink rivet holes
- 28 Cut aluminum rod for rivets
- 29 Hammer rivets in handle &peen
- 30 Grind handle
- 31 Sand handle
- 32 Polish handle
- 33 Final grind blade
- 34 Polish blade with felt wheel
- 35 Heat treat blade
- 36 Sand choil
- 37 Stamp trademark on handle
- 38 Check blade for straightness
- 39 Polish shoulder of guard
- 40 Final polish blade with felt wheel
- 41 Grind thumb notches in top of blade
- 42 Final buff blade
- 43 Final buff handle
- 44 Sharpen blade
- 45 Spray blade with silicone & wipe clean
- 46 Put knife into sheath



LEATHER SHEATHS, SHARPENING STONES AND KNIFE CARE PRODUCTS



A NO FRILLS, FUNCTIONAL SHEATH ACCOMPANIES ALL RUANA KNIVES AND THE HATCHET.

Ruana sheaths are made from full grain English bridle leather that is drum-dyed and lightly hot stuffed with an extra tallow top dressing. They are sewn with durable, bonded high strength nylon thread and brass nailed for safety. All knives, hatchets and Bowie knives come with the sheaths shown on this page. Sheaths can be purchased separately

FS-Full Length Sheath—All cast handle knives come with a full sheath that is designed for protecting your knife. The knife is fully covered with a flap that comes over the butt of the handle and snaps to the main part of the sheath.

with the prices depending on size and style. Please contact us for prices.

We highly recommend that you invest in some Montana Pitch Blend Leather Dressing (on page 11) for your sheath. Pitch blend will prolong the life of your sheath while keeping moisture from condensing around your knife, which in turn helps keep it clean.

22 S-Hatchet Sheath—Heavy leather sheath for the hatchet that allows you to carry it on a belt.

SBS-Standard Bowie Sheath—Heavy leather Bowie sheath with decorative frog lace and saddle tie. Strap that crosses guard diagonally keeps knife in place.

DBS-Diamond Bench Stone—Coarse grit diamond stone in plastic storage box with non-skid feet and easily mountable base. Favorite in our shop that is used on each blade we make.

DDS-Diamond Diafold Stone—Coarse grit diamond stone with convenient fold up butterfly handle. Works great for touching up blades in the field.

DDSX2-Double Sided Diafold—Two stones in one. Same as Diafold stone with coarse grit on one side and fine grit on the other.

DMA-Diamond Mini-Sharp Angler—Coarse grit compact stone that will fit in a shirt pocket and includes a groove for sharpening fish hooks.

VEE-Diamond V Sharpener—Take the guesswork out of most important part of sharpening a knife which is maintaining a proper angle. Perfect for the kitchen; it works well on all types of knives including serrated blades.

STEEL-Diamond Steel—Classic steel for touching up any knife. Fine diamond grit creates a long lasting sharp edge.



WE OFFER A WIDE VARIETY OF AMERICAN MADE DMT SHARPENING STONES AND OTHER ACCESSORIES TO KEEP YOUR KNIFE INVESTMENT LOOKING GOOD AND FUNCTIONING WELL.

STROP-Ruana Strop—Handmade, 19" leather strop with old Ruana sheath stamp for collectability. Just like the barber shops



use to take the wire edge off of blades and create a scary sharp edge. Comes with .07 ounce pack of Flitz polish for dressing. **FLITZ-Flitz Metal Polish**—Cleans, polishes, and protects virtually all metals. A fine

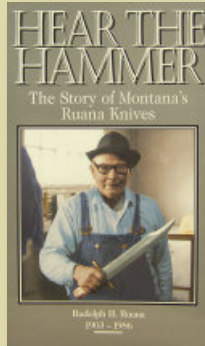
complement to our knives and the maintenance of knife blades, and brass handles. One 1.76 oz. (50 gram) tube will provide numerous applications.

FPC-Flitz Microfiber Polishing Cloth—12" x 12" microfiber polishing cloth removes dust, dirt and fingerprints from your Ruana Knives and other valuables. Washable and reusable up to 500 times.

MPB-Montana Pitch Blend Leather Dressing—A superior all natural water repellent leather dressing that uniquely combines pine pitch, mink oil, and beeswax. Great for protecting a variety of leather products against wet elements and also prevents leather from drying out. Highly recommended if you'll have your sheath outdoors. Available in 4 oz. container.



RUANA BOOK, HATS AND TEE SHIRTS



WE WILL SIGN BOOKS UPON REQUEST AT NO EXTRA CHARGE.

BOOK—Hear The Hammer—The Story of Montana's Ruana Knives. A must for anyone interested in the history of Ruana Knives. Published in 1995, it tells the story from Rudy Ruana's start in knife making, to his son in law, Vic Hangas joining him in the trade, to present day operations at Ruana Knife Works, Inc. Sections include insight into

Rudy Ruana's life, previously published articles, customer comments, technical information on older knives and their markings, past brochures and price lists. It's what we use as a resource for dating old Ruana Knives. Published by Mandell and Towsley. Written by Stephen Smith. 140 pages. 100 black and white photos.

SEE PRICE LIST FOR SPECIAL PRICING ON HATS & TEES WHEN SHIPPED WITH A KNIFE.

HAT—Hats—One size fits most with adjustable straps on all models. When ordering, please specify style and color. Catalog numbers are in parentheses.

Top Row: Hunting hats from Mossy Oak® Camo Brand. Style ~ Hunting.

From left to right: **Shadow Grass (H-SG), Orange (H-OC) & Mossy Oak (H-MO).**

2nd Row: Heavy duty canvas hats with khaki crown and colored bill made for the outdoors. Style ~ 2-Tone Canvas.

From left to right: **Gray (C-G), Forest Green (C-F) & Blue (C-B).**

3rd Row: Stylish lighter weight hats great for fishing, golfing or relaxing. Style ~ Sandwich Bill. From left to right: **Olive (S-O), Navy (S-N) & Khaki (S-K).**

Bottom Row: Classy leather bill hats for cooler weather wear. Style ~ Leather Bill. From left to right: **Maroon (L-M), Forest Green (L-F) & Navy (L-N).**

TEE—T Shirts—Heavy duty, comfortable Hanes Beefy T-Shirts that are a Ruana and Montana souvenir in one. Silk screened Ruana blade being forged out on the back (top row) & Ruana logo on the front (bottom row). 99/1-Cotton/Poly blend. Available in **Blue, Gray, Black & White in adult sizes: M, L, XL, 2XL & 3XL** (2XL & 3XL are priced higher). Please specify color and size when ordering. For faster shipping include extra color choices in order of preference.

RUANA® IS A REGISTERED TRADEMARK OF RUANA KNIFE WORKS, INC.