

Large Folding Knife Hardware Kit Instructions

53335

⚠ DANGER Danger indicates a hazardous situation that, if not avoided, will result in death or serious injury.

⚠ WARNING Warning indicates a hazardous situation that, if not avoided, could result in death or serious injury.

⚠ CAUTION Caution indicates a hazardous situation that, if not avoided, may result in minor or moderate injury or property damage.

NOTICE Notice indicates important or helpful information and/or user tips.

⚠ WARNING

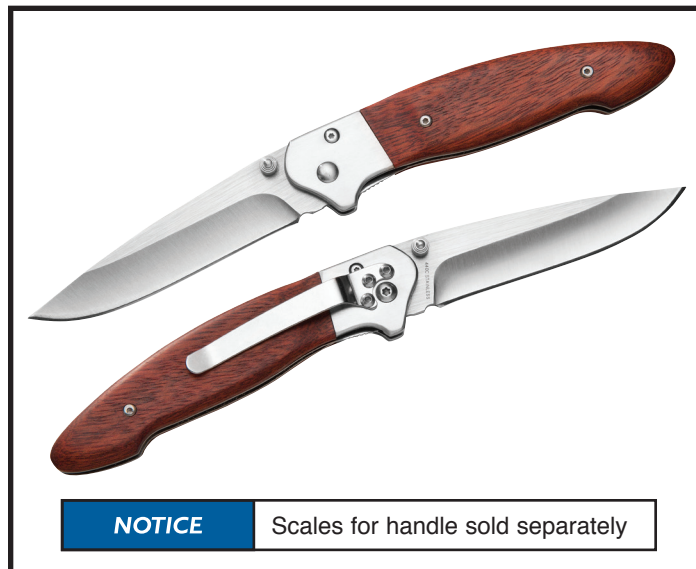
- > Please read these instructions completely before beginning.
- > Be aware that the blade comes sharpened. For your safety, cover the edge with several layers of painter's tape before you begin working on your custom knife kit. Remove the tape after assembly is complete; if necessary, remove any adhesive residue with hot, soapy water or acetone.

Select and prepare the "scales" for the handle

1. The pieces for the handle are called "scales" and can be cut from domestic or exotic hardwoods, acrylic, bone, antler or other suitable material. (They are not included with the kit.) Scales should be at least 4" long by 1½" wide and from 3/16" to 1/4" thick.
2. Identify the Left and Right Scales and determine the inside and outside faces. Label accordingly. (As used here, "right" and "left" refer to the sides of the knife handle as oriented when the knife is held in the hand.)
3. Square at least one end on each scale – preferably matching ends (to preserve the grain alignment).
4. Trace the outline of the handle onto the inside faces of the scales. Be sure to butt the flat side of the bolster tight against the squared edge of each scale, and position the handle at the same place on the scales to preserve grain alignment. Be sure you end up with mirror tracings.
5. Using a coping saw, scroll saw or band saw, cut the scales slightly oversized, staying 1/16" outside the trace line.

Mount and drill the scales

1. Apply a thin coat of CA glue or epoxy to the left side of the handle of the Knife Body (1).



2. Press the Left Scale against the left side of the knife handle, making sure to butt the squared edge of the scale tight against the flat side of the bolster.
3. Verify that the scale is properly aligned, then clamp in place. Allow adhesive to cure.
4. With the Left Scale on the bottom, use a 1/16" brad-point bit to drill a through hole at the center of the two holes in the Knife Body (1). Use a sacrificial block under the scale to prevent splitting or tear-out.
5. Repeat Steps 1-3 for the Right Scale.
6. With the Left Scale on top, use the 1/16" brad-point bit to extend the holes through the Right Scale.

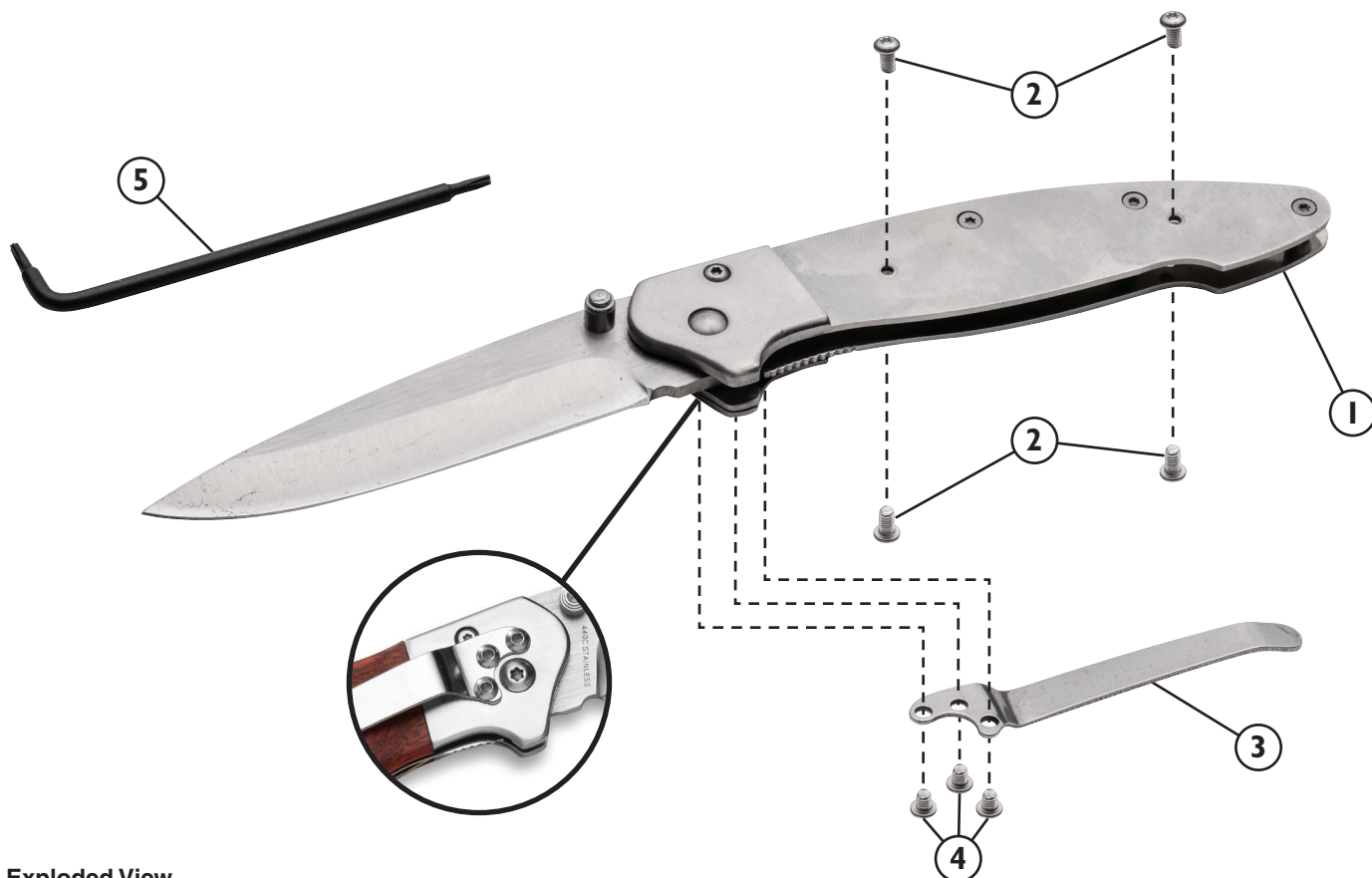
Shape and sand the scales

NOTICE Cover the bolster with tape to protect the finish.

1. Begin the shaping process with the scale edges that will abut the bolster. Using flat and round files, a power sander or handheld sandpaper, shape the thickness and profile of those edges to achieve the desired transition between scales and bolster.
2. Shape the outer edges of the scales flush with the Knife Body (1) and refine the thickness and profile of the handle until the desired contour is achieved.

⚠ WARNING

Blade is very sharp. Cover with layers of tape while working.

**Exploded View****Install mounting screws****NOTICE**

The depth of the counterbore will depend on the thickness of the scale, but a maximum of 5/64" of the Long Screw (2) threads should extend beyond the inside face of the scale.

1. Use a 5/32" brad-point bit guided by the 1/16" holes to drill stopped counterbores on the outside face of the scales to accommodate the heads of the Long Screws (2). **See Exploded View.** (To prevent splitting or tear-out at the back of the holes, drill with a sacrificial block under the scales.)
2. Switch to a 3/32" brad-point bit to drill a through hole centered in the counterbores.
3. Sand the scale surfaces through progressive grits, up to 600.
4. Apply the finish of your choice to the scales, keeping in mind that, as the knife is used, the handle will come in regular contact with oils that could degrade the finish.
5. Polish as desired.
6. Use the included wrench to install and secure the Long Screws (2) in the handle. **See Exploded View.**

PARTS LIST**Quantity**

1	Knife Body	1
2	Long Screws	4
3	Belt Clip	1
4	Short Screws	3
5	Wrench	1

Attach the belt clip

1. Position the Belt Clip (3) so its mounting holes align with the three holes machined in the right side of the bolster. **See Exploded View.**
2. Attach by using the included wrench to drive the three Short Screws (4). **See Exploded View.**

For additional questions contact SARGE Customer Service at 800.454.7448