

INSTRUCTIONS FOR KITS WITH PINNED GUARDS AND HANDLES

MATERIALS

BLADE
HANDLE MATERIAL
SLOTTED GUARD
PINS
EPOXY
SANDPAPER 200-600 GRIT
MASKING TAPE

TOOLS

SCRIBE
DRILL
DRILL BITS
JEWELERS SAW
VISE
BALL PEIN HAMMER

1. SELECT MATERIALS AND TOOLS REQUIRED FOR YOUR CUSTOM KNIFE. **READ ALL INSTRUCTIONS CAREFULLY BEFORE BEGINNING.**
2. SAND FLAT THE SIDE OF THE GUARD THAT WILL FIT NEXT TO THE HANDLE MATERIALS TO INSURE A GOOD FIT. PRE-SHAPE THE GUARD FRONT (THE SIDE NEXT TO THE BLADE) AND POLISH. NOW SCRIBE A PATTERN IN THE DESIRED SHAPE ON THE FRONT OF YOUR GUARD TO USE LATER IN SHAPING AND FINISHING THE GUARD AND HANDLE MATERIAL INTO ONE. THIS IS EASIER TO DO BEFORE YOU PIN YOUR GUARD PIECE TO THE BLADE.
3. COVER SHARP EDGE OF BLADE WITH MASKING TAPE. THIS WILL PROTECT YOU AND THE BLADE.
4. FIT YOUR GUARD BY ALIGNING PIN HOLE IN GUARD AND BLADE. THE GUARDS ARE SLIGHTLY OVERSIZE, THEREFORE A SMALL AMOUNT OF MATERIAL MUST BE REMOVED FROM EACH SIDE WITH A FILE OR SANDPAPER UNTIL GUARD IS PRECISELY FITTED TO SLOT ON BLADE AND HOLES ARE ALIGNED. THE CENTER HOLE MUST BE SQUARE WITH THE SLOT. PIN GUARD TO BLADE MAKING SURE PIN PROTRUDES EQUALLY FROM BOTH SIDES. IF GUARD DOES NOT FIT TIGHTLY TO BLADE (IF ANY GAP SHOWS) IT WILL BE NECESSARY TO CLAMP AT TOP OF GUARD BEFORE GOING TO STEP 5.
5. PEIN PIN TO GUARD BY PLACING FIRMLY ON ANVIL. PEIN ONE SIDE THEN THE OTHER, ALTERNATING SIDES UNTIL PIN HAS SCULLED OUT INSIDE THE HOLE MAKING A VERY TIGHT FIT. AS YOU WORK DOWN ON YOUR GUARD, THE METALS WILL MESH AND YOU WILL NOT SEE THE PIN AT ALL, THE GUARD WILL APPEAR AS ONE PIECE.
6. MARK THE SIDE OF THE HANDLE MATERIAL THAT WILL FIT NEXT TO THE TANG BEING CAREFUL TO MATCH ANY COLOR PATTERNS THAT YOUR MATERIAL MAY CONTAIN. MARK END OF EACH PIECE THAT WILL FIT AGAINST THE GUARD.
7. FIT HANDLE MATERIAL TO GUARD BY FILING AND SANDING UNTIL YOU HAVE A GOOD SQUARE FIT WITH NO LINES OR GAPS SHOWING. DO BOTH PIECES.
8. LAY BLADE ON HANDLE MATERIAL CAREFULLY MAKING SURE IT LIES SQUARELY AND TIGHTLY AGAINST GUARD. SCRIBE OUTLINE OF BLADE ONTO HANDLE. YOU MAY WISH TO CLAMP FIRST SO THE HANDLE WILL NOT SLIP. REPEAT WITH SECOND PIECE OF HANDLE MATERIAL USING OPPOSITE SIDE OF TANG.
9. LEAVING SLIGHTLY OVERSIZE, REMOVE EXCESS HANDLE MATERIAL WITH JEWELERS SAW, BELT SANDER, OR OTHER MEANS AVAILABLE. **DO NOT OVER GRIND.**
10. USING 220 GRIT SANDPAPER, SAND THE MATERIAL FLAT ON THE SIDE THAT WILL FIT

AGAINST THE TANG OF THE BLADE. SAND THE TANG OF THE BLADE WITH THE SAME PAPER. THIS WILL REMOVE ANY FOREIGN MATERIAL AND ASSURE A GOOD ADHESION OF THE TO BLADE TO THE HANDLE MATERIAL.

11. CAREFULLY ATTACH ONE PIECE OF HANDLE MATERIAL TO TANG OF THE BLADE WITH EPOXY. MAKE SURE THE HANDLE MATERIAL IS CENTERED PROPERLY AND THAT IT FITS PERFECTLY AGAINST GUARD WITH NO GAPS. CLAMP AND ALLOW EPOXY TO SET. YOU MAY WANT TO ALLOW IT TO DRY OVERNIGHT.
12. USING PIN HOLES IN BLADE AS A TEMPLATE, DRILL THESE HOLES WITH THE PROPER SIZE DRILL BIT. BE SURE TO DRILL IN CENTER OF HOLES, DRILL SLOWLY AND CAREFULLY SO YOU WILL NOT SPLINTER HANDLE MATERIAL, A DRILL PRESS IS BEST IF AVAILABLE. **EXTREME CAUTION** IS ADVISED WHEN USING YOUR BLADE AS A PATTERN FOR DRILLING HOLES. BE SURE THE BLADE AND HANDLES ARE CLAMPED SECURELY AND THE BLADE IS PROTECTED WITH TAPE PROTECT THE OPERATOR FROM BEING CUT OR OTHERWISE INJURED IF THE DRILLING OPERATION TRIES TO TWIST OR GRAB THE WORK OUT OF THE VISE.
13. REPEAT STEP 11 USING SECOND PIECE OF HANDLE MATERIAL.
14. DRILL HOLES FOR PINS AS IN STEPS 11 AND 12 USING HOLES THROUGH HANDLE MATERIAL AS GUIDES. HOLES MUST BE DRILLED STRAIGHT AND PROPERLY CENTERED FOR PINS TO FIT PROPERLY.
15. INSERT PINS THROUGH HOLES DRILLED IN HANDLE MATERIAL. IT MAY BE NECESSARY TO POLISH YOUR PINS AND THONG HOLE TUBING WITH EMERY CLOTH TO ASSURE THEY WILL SLIDE IN AND OUT OF THE HOLES EASILY. THEY SHOULD BE SNUG, BUT NOT TIGHT ENOUGH TO RISK CRACKING WOOD WHEN PUSHING IN OR OUT.
16. MIX A SMALL AMOUNT EPOXY, ROLL PINS IN EPOXY. INSERT PINS IN HOLES AND ALLOW TO DRY UNTIL SET. EXCESS PIN MATERIAL WILL BE SANDED OFF WHEN SHAPING AND BUFFING THE HANDLE.
17. YOU ARE NOW READY TO SHAPE YOUR GUARD AND HANDLE INTO ONE. POWER TOOLS SUCH AS BELT SANDERS AND DREMEL TOOLS WITH SANDING DRUMS AID GREATLY IN SPEEDING UP THE SHAPING AND ROUGHING WORK. HOWEVER, FINAL HANDWORK AND SANDING PRODUCE THE BEST RESULTS. USING A FILE, A HALF-ROUND SECOND CUT WORKS BEST, SHAPE YOUR HANDLE AND GUARD TO DESIRED DESIGN, FINISHING WITH 600 GRIT WET/DRY SANDPAPER. IF A POLISHED LOOK IS DESIRED, BUFF WITH A MUSLIN WHEEL AND WHITE ROUGE.
18. REMOVE MASKING TAPE, CLEAN AND SHARPEN YOUR KNIFE TO A FINE EDGE.