Select, label and cut 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.) For this knife kit, the scales should be at least 8" long by 1 1/2" wide and from 1/4" to 3/8" 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, blade open, edge down.)

3. Use the Left Liner (1) to trace the outline of the knife body on the inside faces of both Left and Right Scales. Be sure to trace mirror images and preserve the grain orientation.

4. Using a coping saw, scroll saw or band saw, cut the scales slightly oversized, at least 1/16" outside the trace line.

Glue the scales to the liners

1. Apply CA glue or epoxy to the outside face of the Right Liner (2), taking care not to get any glue on the blade-lock mechanism (the part that extends toward the inside of the knife).

2. Align the Right Scale with the Right Liner (2) and hold or clamp together until the adhesive sets.

3. Apply CA glue or epoxy to the outside face of the Left Liner (1).

4. Align the Left Scale with the Left Liner (1) and hold or clamp together until the adhesive sets.

Drill the scales

1. Position the Left Liner/Scale with the liner side up and use a 1/16" brad-point bit drill a hole at the center of the hole in the liner for the Pivot Bolt (4) and Pivot Bolt Fastener (5). To prevent splitting or tear-out at the back of the holes, drill with a sacrificial block under the scales.

2. Using a 3/32" brad-point bit and the holes in the liner as a guide, drill through holes for the Brass Pins (10 and 11).

3. Use a 5/32" brad-point bit to drill the larger hole at the rear of the liner to accommodate the Brass Sleeve (12) for a lanyard (not included).

4. Bring the Right Liner/Scale and the Left Liner/Scale together, taking care to precisely align the liners. Place them on the sacrificial block (Left Liner/Scale on top) and clamp to the work surface to maintain liner alignment.

5. Use a 1/16" brad-point bit to extend the hole at the center of the opening for the Pivot Bolt (4) and Pivot Bolt Fastener (5) through the Right Liner/Scale.

6. Use a 3/32" brad-point bit to extend the holes for the Brass Pins (10 and 11) through the Right Liner/Scale.
7. Use a 5/32" brad-point bit to extend the hole for the Brass Sleeve (12) through the Right Liner/Scale.

8. Release the Right Liner/Scale and Left Liner/Scale.

9. Use a 5/16" brad-point bit guided by the 1/16" hole to drill a stopped counterbore for the head of the Pivot Bolt (4) or Pivot Bolt Fastener (5) on the outside face of each scale.

10. Switch to a 13/64" brad-point bit to drill a through hole centered in each counterbore.

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

### NOTICE
The depth of the counterbore will depend on the thickness of the scale; it should stop 1/8" short of the liner.

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**Exploded View**

**PARTS LIST**

<table>
<thead>
<tr>
<th>PARTS LIST</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 Left Liner</td>
<td>1</td>
</tr>
<tr>
<td>2 Right Liner</td>
<td>1</td>
</tr>
<tr>
<td>3 Blade</td>
<td>1</td>
</tr>
<tr>
<td>4 Pivot Bolt</td>
<td>1</td>
</tr>
<tr>
<td>5 Pivot Bolt Fastener</td>
<td>1</td>
</tr>
<tr>
<td>6 Rear Spacer</td>
<td>1</td>
</tr>
<tr>
<td>7 5/32&quot; Spacer</td>
<td>1</td>
</tr>
<tr>
<td>8 Small Plastic Washer</td>
<td>1</td>
</tr>
<tr>
<td>9 Large Plastic Washer</td>
<td>1</td>
</tr>
<tr>
<td>10 Long Brass Pins</td>
<td>2</td>
</tr>
<tr>
<td>11 Short Brass Pins</td>
<td>2</td>
</tr>
<tr>
<td>12 Brass Sleeve</td>
<td>1</td>
</tr>
<tr>
<td>13 Torx T10 Wrench</td>
<td>1</td>
</tr>
</tbody>
</table>
Assemble the knife

1. Press the Brass Sleeve (12) for the lanyard into the large hole at the back of the knife, making sure it extends all the way through and protrudes a little out both sides.

Shape the scales and finish the knife

1. Using an oscillating spindle sander, flat and round files or sandpaper, shape the scales until the edges are flush with the liners and the desired handle contour is achieved.

2. Sand the handle through progressive grits, up to 600. Polish metal surfaces, if necessary.

3. Apply the finish of your choice, keeping in mind that, as the knife is used, the handle will come in regular contact with oils that could degrade the finish.

For additional questions contact SARGE Customer Service at 800.454.7448

Refer to the Exploded View on page 2 for the following steps.

1. With the liners facing up, press a Short Brass Pin (11) into the center hole of each liner/scale assembly until the pin is flush with the liner. Make sure the pins don’t extend past the inside face of the liners; otherwise, they could hit the blade.

2. Insert two Long Brass Pins (10) in the two holes toward the rear of the Left Liner/Scale assembly. Push in the pins in until they protrude slightly from the outer side of the Left Scale.

3. Insert the Pivot Bolt (4) in the front hole in the Left Liner/Scale. The head of the Pivot Bolt should fit in the counterbore in the scale.

4. With the liner side of the Left Liner/Scale assembly facing up, install the Large Plastic Washer (9) on the Pivot Bolt (4).

5. Press the Rear Spacer (6) onto the two Long Brass Pins (10) at the back of the Left Liner (1).

6. Place the 5/32” Spacer (7) in the hole next to the Pivot Bolt (4).

7. Carefully install the Blade (3) on the Pivot Bolt (4). The cutting edge should face the top of the knife when the Blade is in the closed position.

8. Install the Small Plastic Washer (8) on top of the Blade (3) on the Pivot Bolt (4).

9. Place the Right Liner/Scale on the Pivot Bolt (4), aligning it with the Left Liner/Scale. Press down to fit the two Long Brass Pins (10) and the 5/32” Spacer into the appropriate holes in the Right Liner (2).

10. Thread the Pivot Bolt Fastener (5) into the Pivot Bolt (4) and tighten with the included Torx T10 wrench (13). Make sure the liners and the Rear Spacer are pressed together.

NOTICE

To prevent mushrooming or bending, insert a 1/8” drill bit in the sleeve to serve as a support during installation.