

## 1. Parts

- 1) Blade : 1 pc.
- 2) Lock Bar : 1 pc.
- 3) Spring : 1 pc. (709182 and 709189 2 pcs.)
- 4) Handle : 2 pcs.
- 5) Blade Pin : 1 pc.
- 6) Center Pin : 1 pc.
- 7) Spring Pin : 2 pcs.
- 8) Tube : 1 pc. (709189)

## 2. Assembly

### 2.1 Preparation



- a) Insert the blade pin and the center pin in one of the handle pieces.



- b) Press the end of the lock bar into the notch in the blade.

### 2.2 Adjust the fit of the blade and the lock bar:



Made sure the joint (A) between the lock bar and the notch in the blade is tight. If the fit is not perfect, adjust it using a fine file.

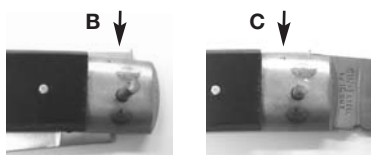
### 2.3 Check and adjust the alignment of the lock bar and handle:



Closed



Opened



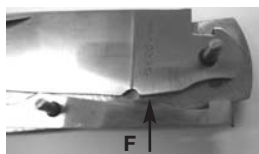
The position of the lock bar must be similar in both the opened and closed position.



If B is higher than C, file E.  
If C is higher than B, file D.



- 2.4 The tip of the blade must be inside the handle when in the closed position.



If the tip is outside the handle, file F (the inside of the lock bar).

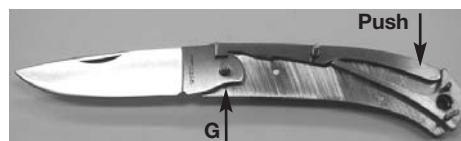
**Steps 2.2, 2.3 and 2.4 are very important for the proper function of the folding and locking mechanism.**



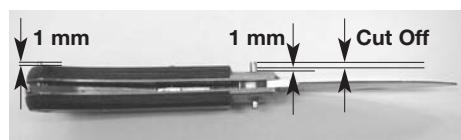
- 2.5 Place the spring pins (ø 2.0 x 18 mm) and the center pin (ø 2.5 x 18 mm) into the handle.



- 2.6 Place the springs (2 pcs.) onto the spring pin and the lock bar onto the center pin.



- 2.7 Place the blade onto the blade pin (G) and check to make sure the locking mechanism is functioning properly. Then place the second handle piece onto the pins.



- 2.8 Trim each pin, leaving 1 mm protruding above the surface of the handle.



- 2.9 Rivet the pins in place using a small hammer. Insert a thin metal plate, about 0.3 to 0.4 mm thick, between the blade and the handle to ensure smooth opening and closing action of the blade.

- 2.10 Apply a light oil (e.g. camellia oil) to all of the moving parts.

## 3. Finishing the handle and sharpening the blade:

- 3.1 Open the blade and place it in a vise. File and polish the handle with files (rough, medium, then fine) and sandpaper (#150, #180, #240, #320 and #400). The wooden portion of the handle should be flush with the metal fittings and have nicely rounded edges.

- 3.2 Finish the edges of the handle first, then the two flat faces.

- 3.3 Sharpen the blade with waterstones, starting with a coarse stone (#80-#220, e.g. the Sun Tiger #220, No. 711999) and then gradually move to finer stones (e.g. the King combination stone #1000/#6000, No. 711005). For finishing the blade we recommend very fine water stones (e.g. the King Gold Stone #8000, No. 711004) or Micro-Mesh cushioned abrasive cloth in grit 8000 (No. 705109) and grit 12000 (No. 705109).

Keep the bevel angle constant at 18° - 20°.



We wish you best of luck with your home-made folding knife.