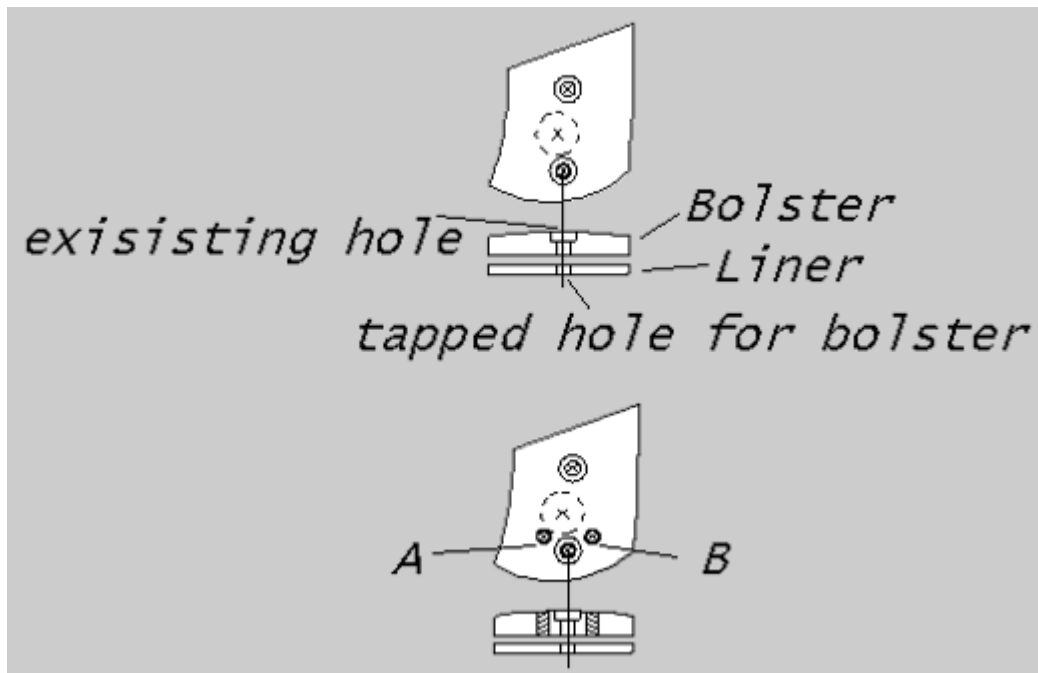


CLASSIC KNIFE KITS

Clip Assembly Instructions • Adding a clip to your new knife.



ASSEMBLY INSTRUCTIONS:

Clip assembly kit **DDRCAK** includes the following items.

- #1 - 1 ea. longer replacement screw for the existing forward bolster screw.
- #2 - 1 ea. tap wrench
- #3 - 1 ea. tap drill
- #4 - 1 ea. 1-72 tap

1. Assemble lock side liner and bolster ONLY
2. Remove screw from existing front hole as seen in the diagram.
3. Assemble new longer 1-72 screw into center hole of clip and place in existing bolster hole. Snug the screw down (DO NOT OVER TIGHTEN) . The screw should be loose enough to position the clip for drilling new holes.
4. Position the clip to the ideal position on the frame where you want it. Tighten it up enough to hold it for drilling the other holes.
5. Now, cut the screw off flush with the liner . There are several ways to do this, but be very careful not to gouge the liner.
 - A: You can mark the screw, disassemble and cut to length.
 - B: If you feel your skill level is good enough not to gouge the liner, you can use a cut off disk in the dremmel tool.
 - C: You can use a flat disk grinder and flush off screw.

NOTE: The screw CANNOT protrude below the liner after assembly. This will cause problems with the washer and blade set up.

6. Once the screw is cut and you are satisfied with it, reassemble the clip onto the bolster and position it to the idea position for your purpose. Tighten up the clip with the center screw (existing hole).
7. Place the drill bit (#3) in a hand drill or preferably a drill press. Drill the other two holes at least the depth of the bolster width. If the holes go all the way through the bolster, this will be OK. If the holes go all the way through the liner, make sure to de burr the holes before final assembly.

NOTE: Be careful not allow the clip to move while drilling. This will cause the holes to NOT line up after drilling. Make sure to drill the holes SQUARE to the bolster top.

8. Disassemble the bolster from the knife at this point.

9. Deburr all of the holes .

10. Place the tap (#4) in the tap handle (#2) supplied. The square end goes into the jaws. Place the bolster in a secure fashion so it may be tapped. This cannot turn while tapping.

Remember that the tap MUST not be interfered with when tapping. If you jam it, the tap will break. There is NO repairing the bolster. We DO NOT supply just the bolster for the kits. The tapped hole needs only go through the bolster. This means that the hole must be clear on the bottom for each tapped hole. The liner does not need to be tapped.

Make sure to hold the tap SQUARE to the hole when starting the tap. The secret is to take your time. Back the tap in and out of the hole while cutting. Cut a little, then back out a turn, etc. I suggest some cutting fluid for the tap also. This can be found at any supply house. If you don't have any, WD-40 will substitute in a pinch although it is not the best lubricant for this job.

11. Deburr once again.

12. Assemble the knife complete with the new clip using the short screws that comes with the clip. Use the extra long screw that we modified in the center hole . DO NOT OVER TIGHTEN.
