Zhen Knife Kits

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#153655, #153656, #161804, #153929,
#159483, #154324, #159203, #159204,
#159205, #159206, #161805, #161800,
#161801, #161802, #161803, #161806

Warning:

The blade comes pre-sharpened! Make sure you cover the cutting edge of the blade with several layers of painter's/masking tape to prevent injury to yourself.

Supplies Needed to Complete Kit:

- ❑ Whiteside Pilot Drill & Countersink (#153927)
- ❑ $^9/_{64}$" Brad-Point Bit (Optional)
- ❑ $^{15}/_{64}$" Brad-Point Bit (Optional)
- ❑ $^3/_8$" x 1-$^1/_2$" x 5" Knife Scale Material (x2)
- ❑ Bandsaw/Scrollsaw/Coping Saw
- ❑ Drill Press
- ❑ F-Style Clamps
- ❑ Wood Files/Rasps
- ❑ 5-Minute Epoxy
- ❑ Sandpaper
- ❑ Eye & Ear Protection
- ❑ Dust Mask

Layout & Cutting:

The knife handles or "scales" can be made from any quality hardwood. Hard, tight grained woods are easier to polish and resist damage better than soft woods. You will need two pieces 3/8" thick, at least 1-1/2" wide and minimum length of 5". Determine the side of each scale that will face out and be seen. Mark the opposite side which will face the tang (face in) portion of the knife blade. Lay the tang of the blade on one of the handle scales, on the side marked face our in the previous step, and trace around the tang. Repeat the same process for the other side.

Using a scroll saw, band saw or coping saw, cut the tang's outline from both scale pieces. Cut to the outside of the traced lines. Using 120 grit sandpaper sand the sides of the scales which will contact the tang.

Note: If rivets are not being utilized skip to the next step.

If rivets are going to be utilized use a few small pieces of double sided tape to adhere the interior sides of the knife scales together. Matching the profile of the tang place it on top of one the scales and mark the location of the holes for the rivets. Using **#153927 Whiteside Pilot Drill & Counter** bore both scales together, this will ensure that the holes mate perfectly. If you choose to not utilize **#153927 Whiteside Pilot Drill & Counter**, you will need to use a $^{15}/_{64}$" Brad-Point Bit to countersink the head of the rivet and a $^9/_{64}$" Brad-Point Bit for the through hole. Depending on the thickness of your scale material you will need to calculate the depth for you counter bore. For example; if using 3/8" thick (x 2 = 3/4" scale material, 3/4" scales + 1/8" tang) and an interior measurement of 5/8" for the rivet leaving you with a counter bore that will need to be 1/8" deep per side. Once completed separate scales and remove tape. Next clean the scales with acetone to remove and remaining dirt, oil or adhesive.
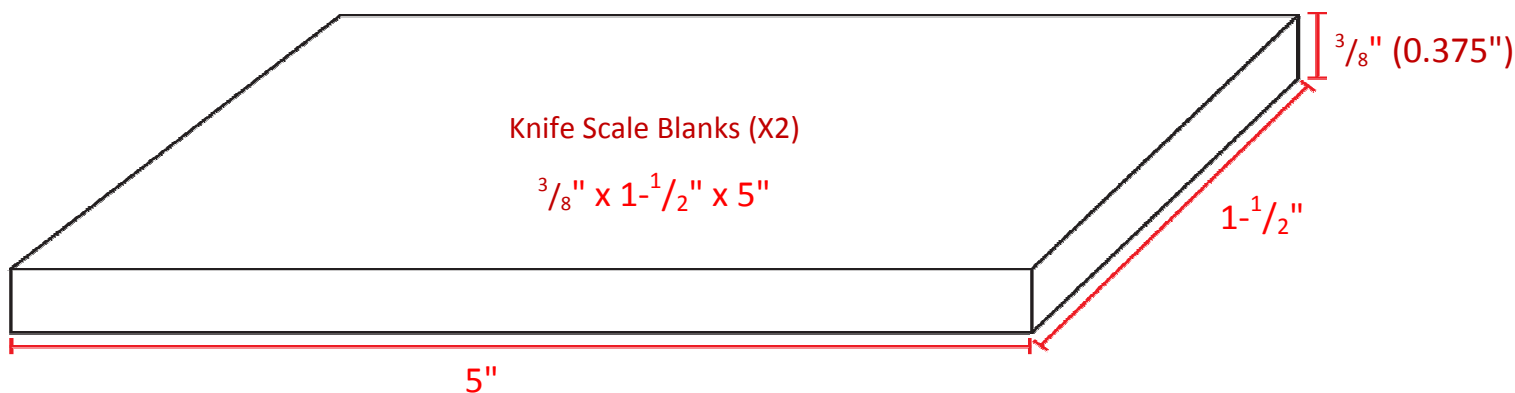
Adhering Scales:

Before gluing your scales you will need to take a piece of 120

Knife Scale Blanks (X2)

$^3/_8$" x 1-$^1/_2$" x 5"

$^3/_8$" (0.375")

1-$^1/_2$"

5"

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grit sandpaper and lightly scuff the tang. Once completed take a clean rag and wipe with acetone to remove any dirt or oil as this will help ensure a strong bond. Next, mix up enough 5 minute epoxy to evenly coat both sides of the tang and begin gluing scales, ensure that the scales fit flush to the bolster and line up to the profile of the tang and are not too high or low. Clamp lightly and allow for proper curing per the manufactures recommendations. If rivets are being utilized follow the same steps as above but you will need to press the rivets together until firmly seated utilizing a hammer and punches.

Shaping & Assembly:

After the epoxy has thoroughly dried, remove the clamps and begin contouring and shaping the handle. Half round and flat rasps and files or sanding drums can be used to rough in the handle shape. Final shaping and sanding should be done by hand and with sandpaper wrapped around an appropriate diameter dowel. Do not remove too much material from the thickness; concentrate on contouring the edges and finger groove. How the handle fits and feels in your hand is the best test of your progress. Finish sanding starting at 220 grit and progress through the grits to 400. Apply a durable finish of your choice and enjoy.

Use & Care:

Please take the time to learn how to care for your new ZHEN knives; they can become a cherished heirloom to be handed down to the younger generations. Using your knife correctly isn't just about how to maintain the edge or sharpen the blade; it's about how you use the knife on a daily basis. One key to keeping your knife sharp is to use an appropriate cutting surface. There are a wide variety of options available to you and choosing the right cutting surface is almost as important as choosing the right knife. A good cutting board will keep your blade sharp for substantially longer. Hardwoods such as maple, bamboo, and polypropylene boards are all excellent choices for cutting on. Tile, ceramic, marble, granite, or any kind of glass, or acrylic cutting boards are all very hard on the sharpness of your knives. It is important to take the best care possible in order to prolong

the life of your knife. Woodcraft recommends that you protect your investment by not cleaning them in the dishwasher but choosing to hand wash your blades with gentle dish soap. Rinse and towel dry immediately. Do not leave your knife sitting in a sink full of soapy water. It is hard on metals to be submerged in water for prolonged periods of time, but moreover it can be a danger to you or others.

After you have washed and dried your knives, store them in a knife block, knife case, magnetic bar or in the original box. We do not recommend storing the knives unsheathed in a drawer, as this can be a potential hazard to the blades as well as your fingers. In order to maximize the life of your blade, regular honing with a steel or ceramic rod will be necessary. Weekly honing will extend the time between sharpening significantly. When the time comes to sharpen these premium blades, we recommend using whetstones to perform this function.