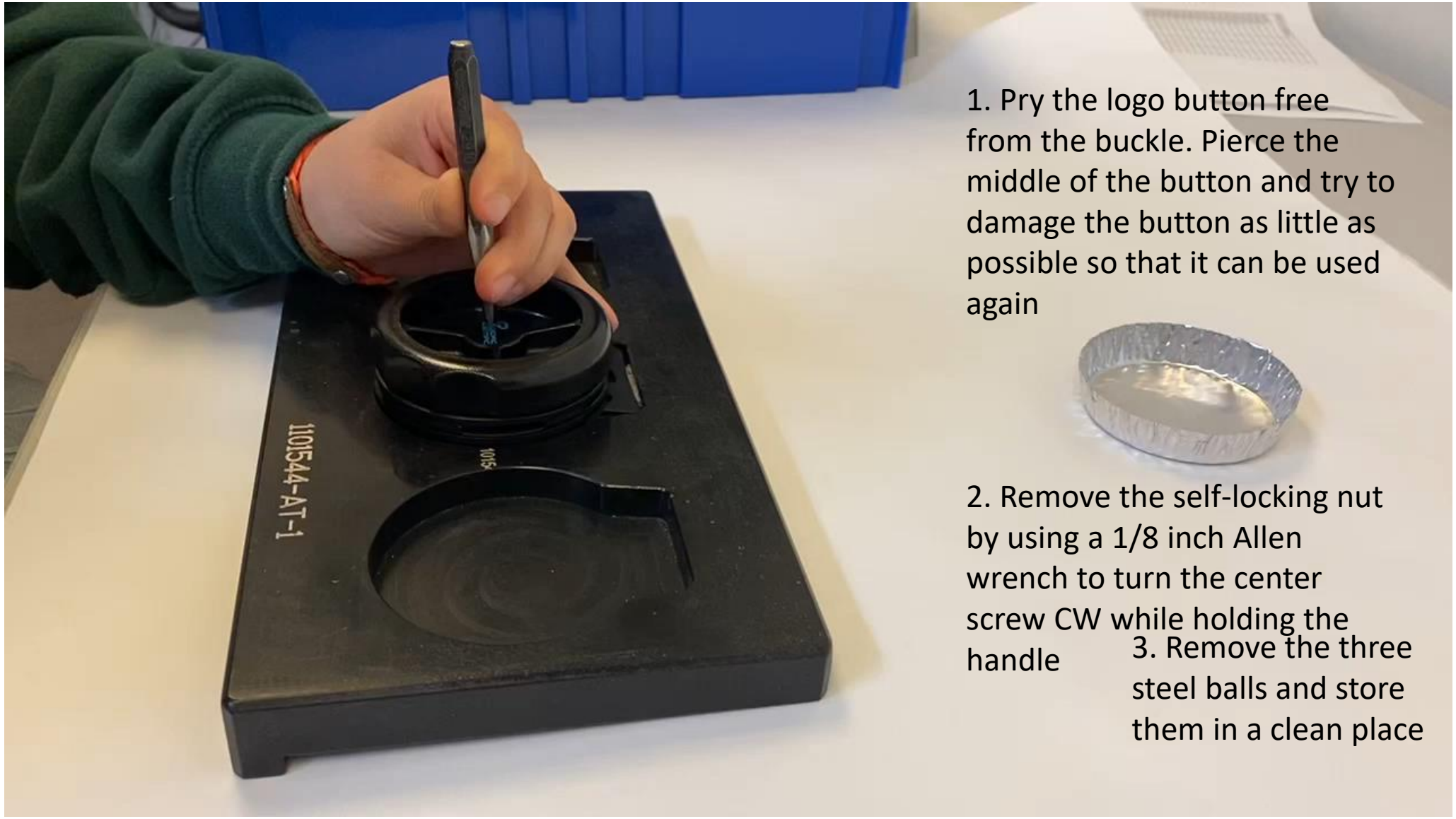
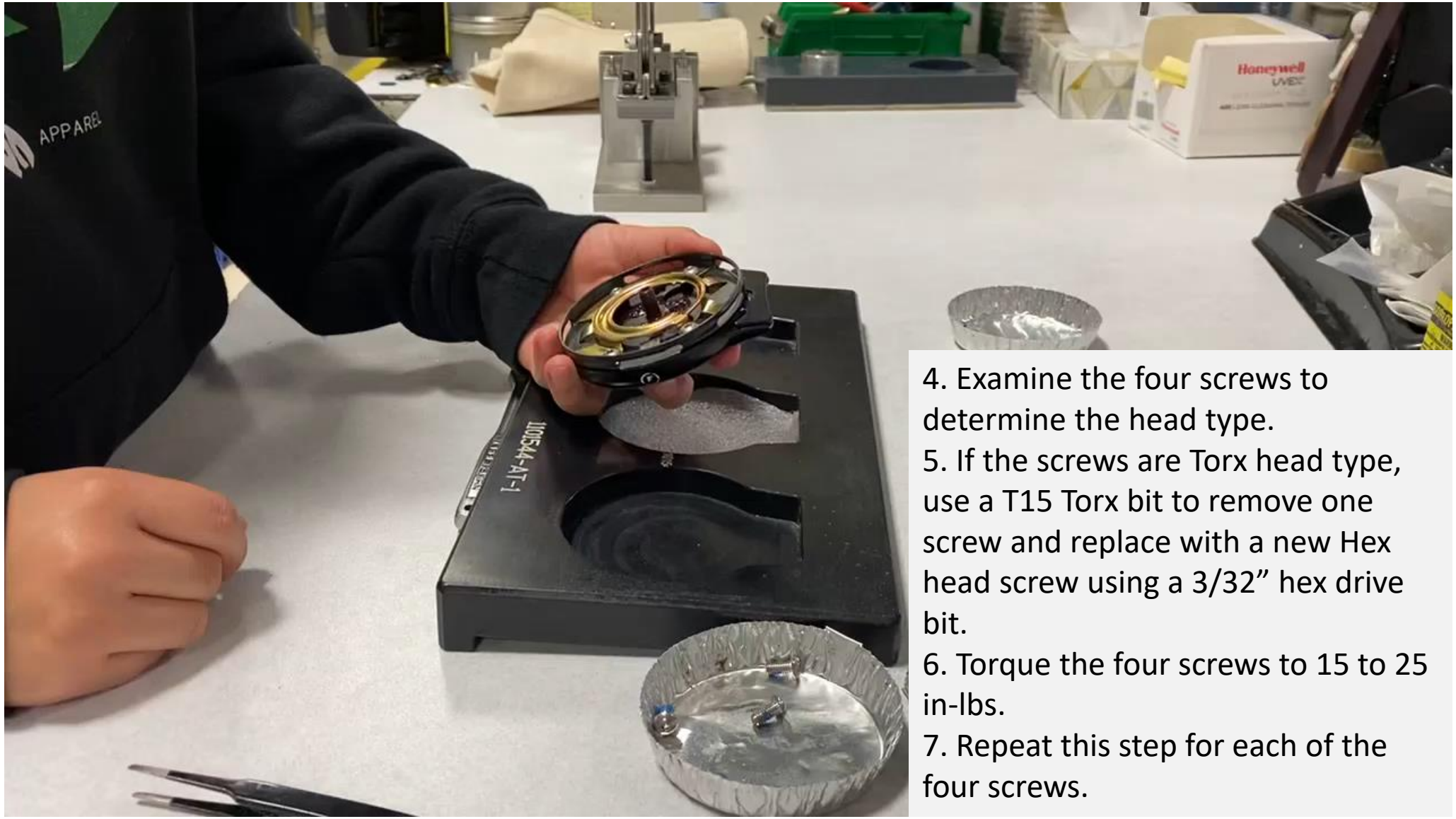


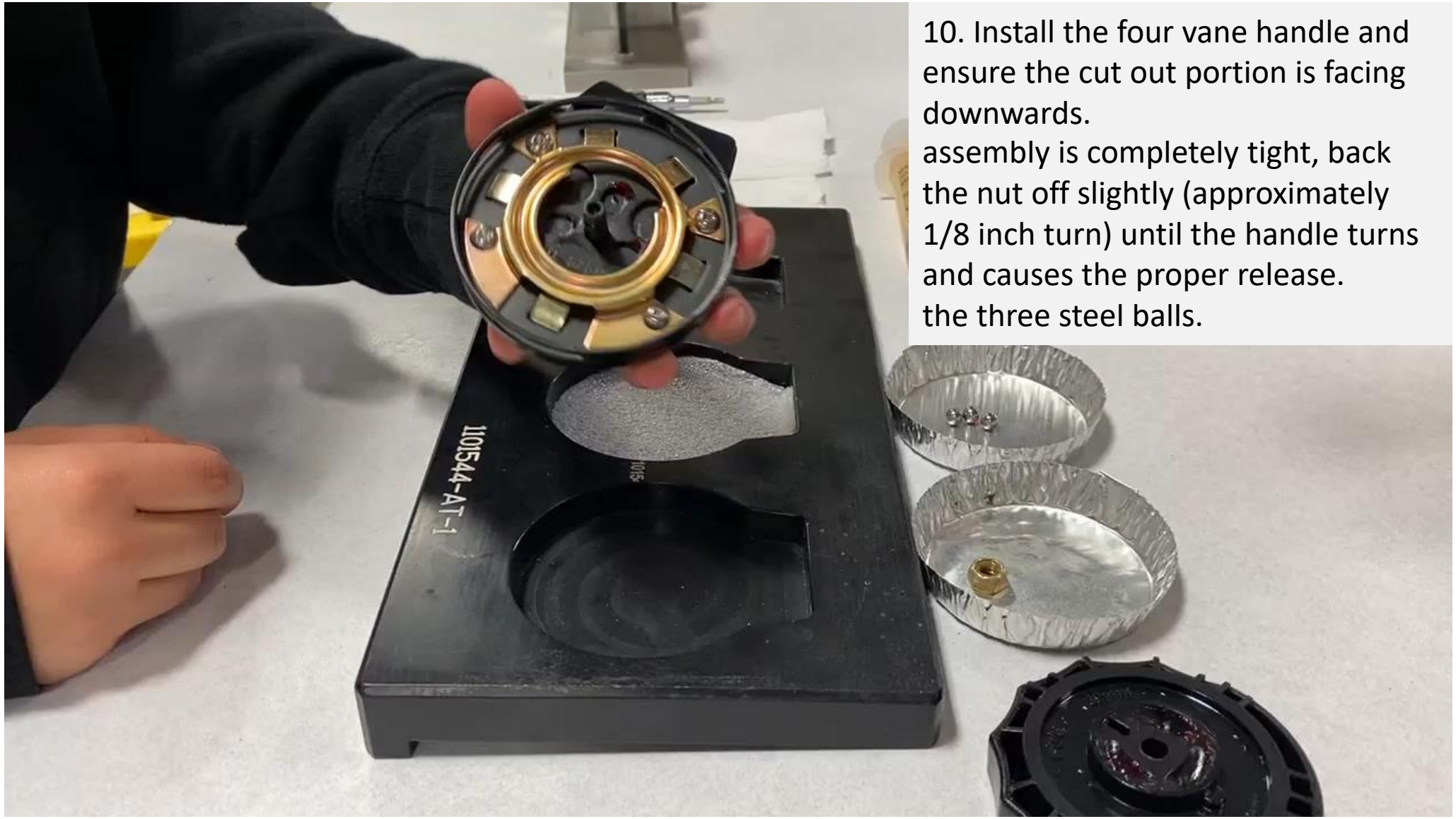
1. Pry the logo button free from the buckle. Pierce the middle of the button and try to damage the button as little as possible so that it can be used again

2. Remove the self-locking nut by using a 1/8 inch Allen wrench to turn the center screw CW while holding the handle

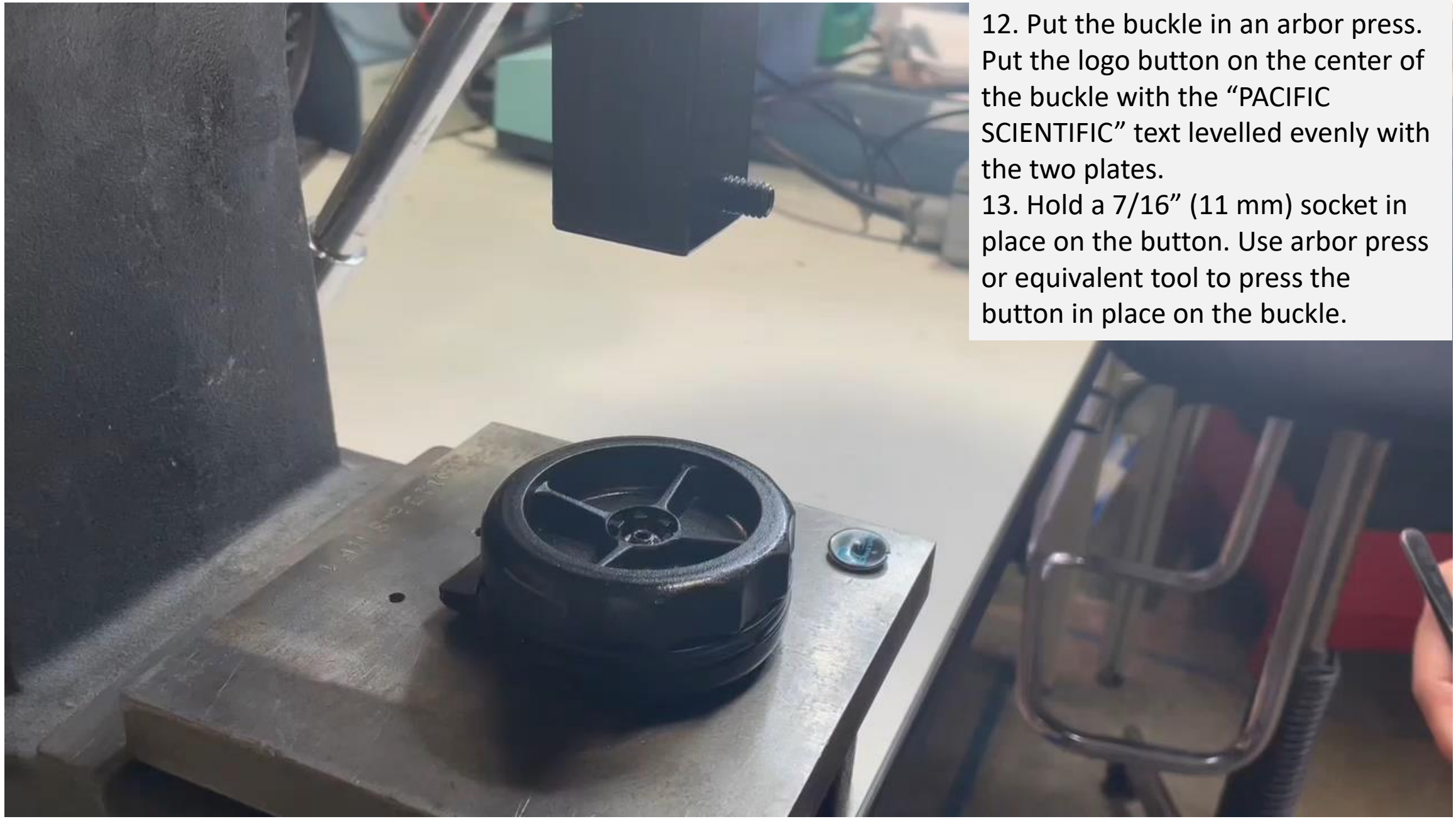
3. Remove the three steel balls and store them in a clean place



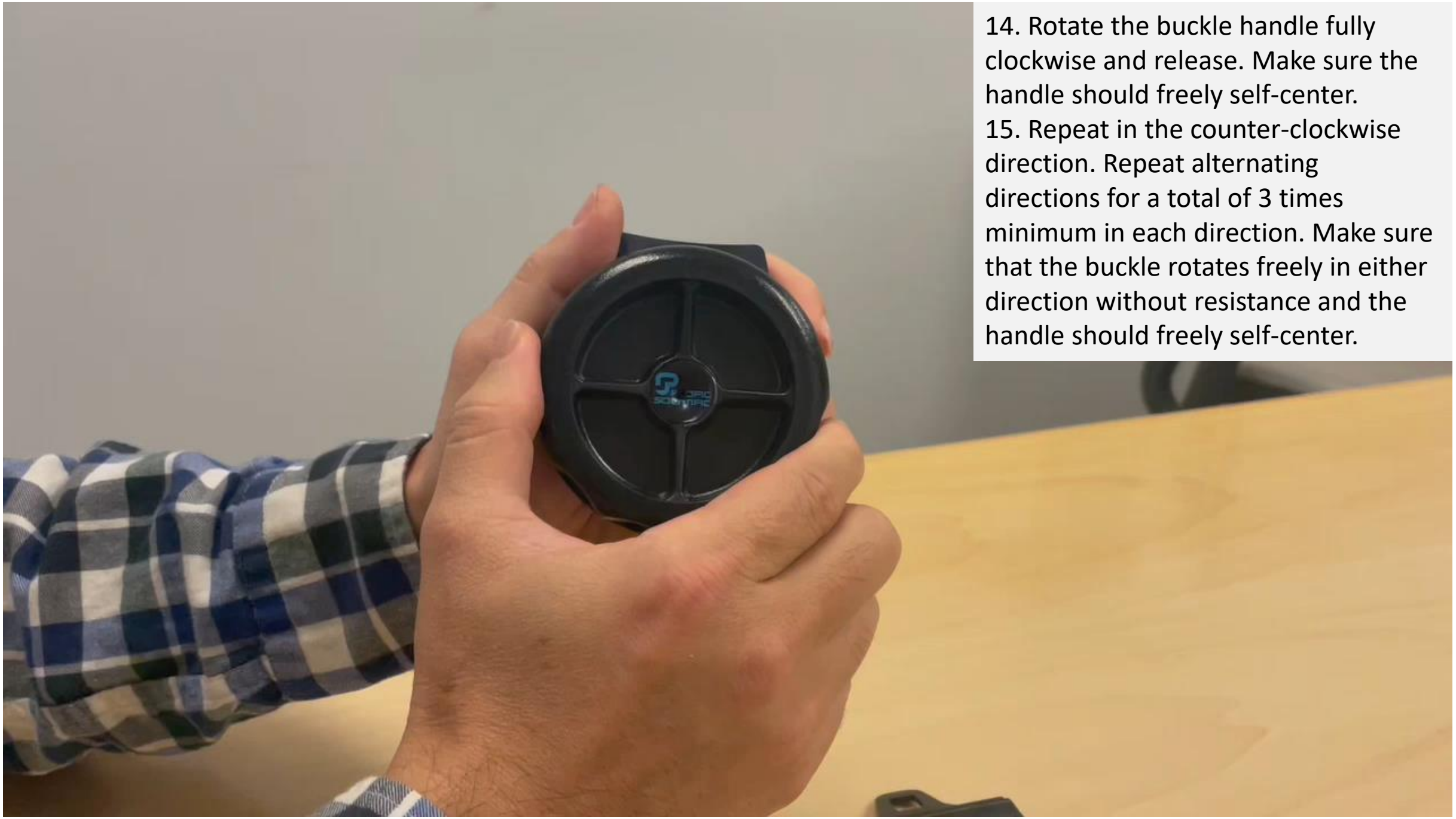
4. Examine the four screws to determine the head type.
5. If the screws are Torx head type, use a T15 Torx bit to remove one screw and replace with a new Hex head screw using a 3/32” hex drive bit.
6. Torque the four screws to 15 to 25 in-lbs.
7. Repeat this step for each of the four screws.



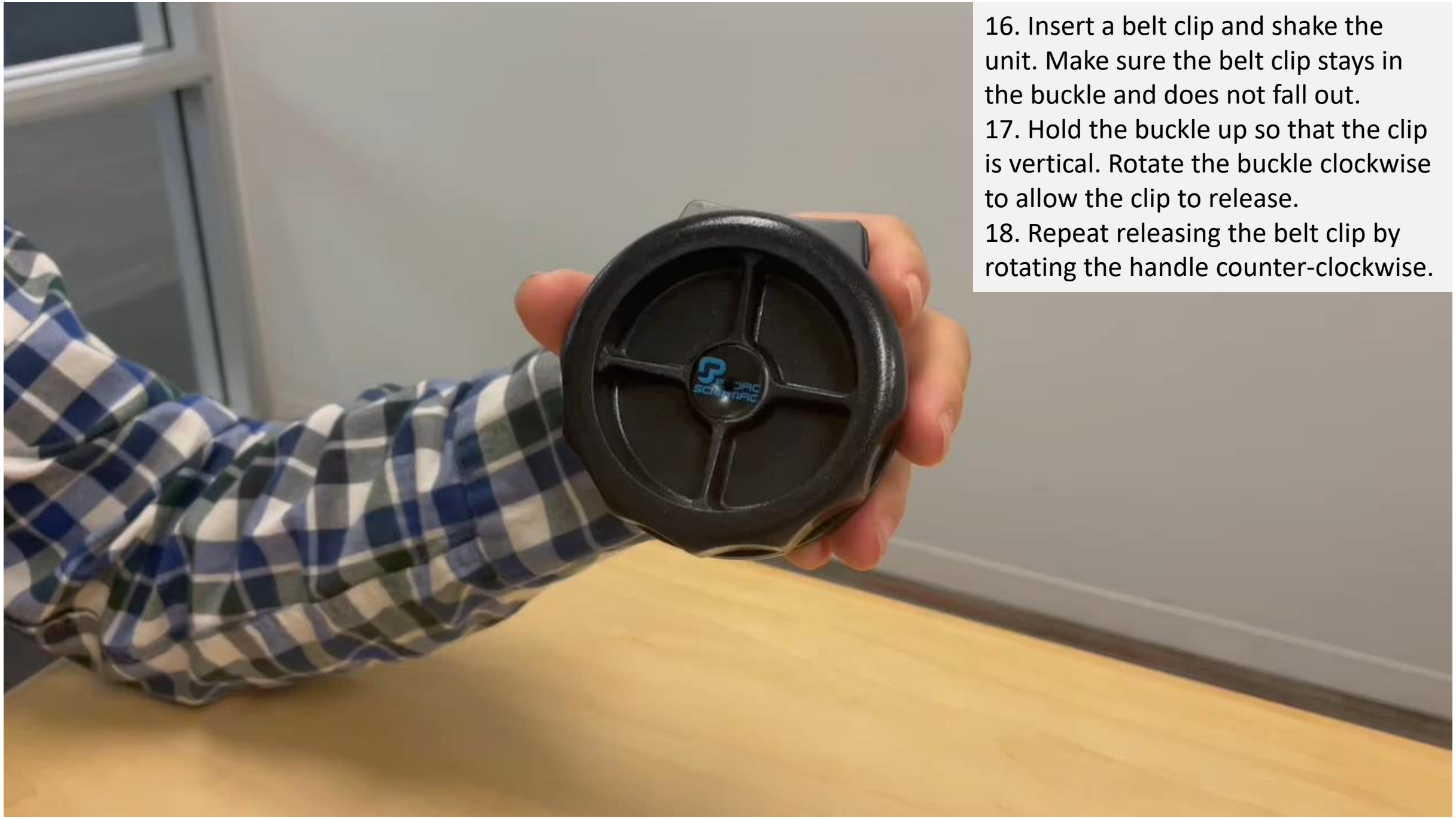
10. Install the four vane handle and ensure the cut out portion is facing downwards.
assembly is completely tight, back the nut off slightly (approximately 1/8 inch turn) until the handle turns and causes the proper release.
the three steel balls.



12. Put the buckle in an arbor press. Put the logo button on the center of the buckle with the “PACIFIC SCIENTIFIC” text levelled evenly with the two plates.
13. Hold a 7/16” (11 mm) socket in place on the button. Use arbor press or equivalent tool to press the button in place on the buckle.



14. Rotate the buckle handle fully clockwise and release. Make sure the handle should freely self-center.
15. Repeat in the counter-clockwise direction. Repeat alternating directions for a total of 3 times minimum in each direction. Make sure that the buckle rotates freely in either direction without resistance and the handle should freely self-center.



16. Insert a belt clip and shake the unit. Make sure the belt clip stays in the buckle and does not fall out.
17. Hold the buckle up so that the clip is vertical. Rotate the buckle clockwise to allow the clip to release.
18. Repeat releasing the belt clip by rotating the handle counter-clockwise.