

# M8 Smoke Signal Device

## A Do-It-Yourself Kit

Rev 2.1



### Mixture Filling & Assembly Instructions

**Video Instructions  
On YouTube**



**A product exclusively by  
NFE Tactical LLC**



**[www.nfetactical.com](http://www.nfetactical.com)**



**nfe\_tactical**



**Touch of Tism**

## Items you will need (Not included in the kit)



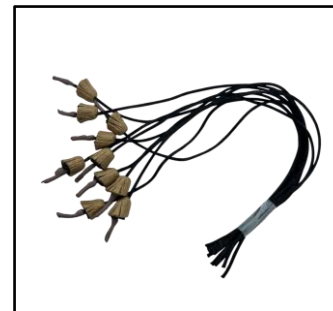
Coffee Grinder



Pocket scale



Metal Spoon



Pull String Igniters



Single burner  
Cooktop



Small 5-6" pot



Potassium  
Nitrate  
(Technical Grade)



Sugar



Paraffin Wax  
Pellets



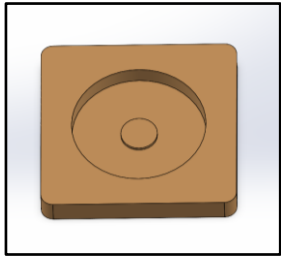
# SAFETY FIRST



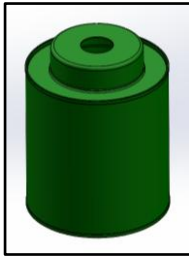
It is highly recommended to use a respirator when handling potassium nitrate. Over exposure may lead to respiratory issues.



# Items Included in the kit



Wood Fixture 1X



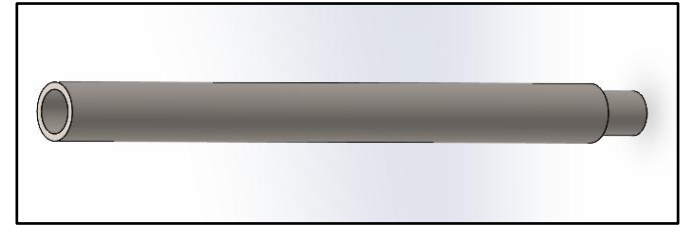
8oz Can with cap  
4X



Silicone Plug 1X



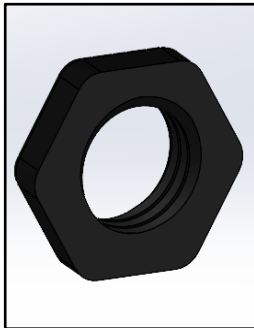
Clear Mixing cup  
4X



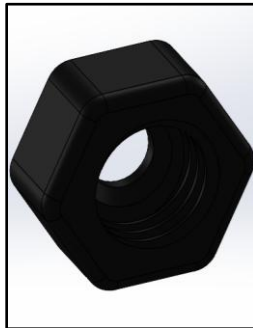
Steel Core Rod  
1X



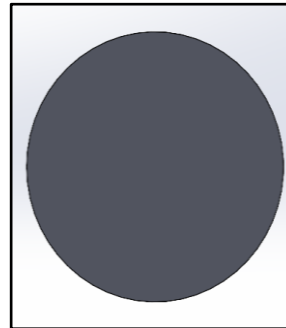
Head Assembled  
4X



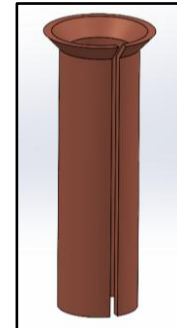
Head Nut 4X



Tube Nut 4X



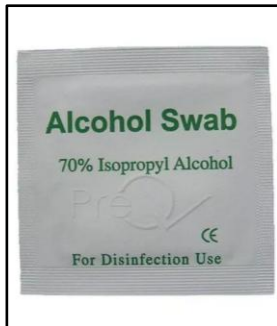
Vinyl Sticker 4X



Copper Tube  
4X



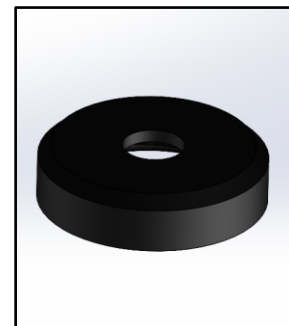
1g Super Glue  
4X



Alcohol Swabs  
4X



Funnel 1X



Can Cap 1X

# This mixture to be used by Certified Pyrotechnicians only

Other smoke mixtures can be substituted.

## PART 1 THE MIXTURE

Items you will need in this section



Pocket  
scale



Metal  
Spoon



Non-Scented  
Candles



Potassium  
Nitrate  
(Fireworks Grade)



Sugar



Clear Mixing cup

1

Place a cup on the scale and hit tare. This will zero out the scale, so the measurement is accurate.

2

Using the spoon, place **60 grams of potassium nitrate** into the cup. Do a little at a time to reach 60 grams. Set this cup aside.

3

With a new cup on the scale, using the spoon, place **30-45 grams of sugar** into the cup. Do a little at a time to reach the desired amount. Set this cup aside

**More sugar produces a faster/hotter burn**

4

Put **40-50 grams of wax** into the cup and set aside.

**Start with 40 grams of wax. The composition when mixed with the other ingredients should resemble a slushy. You can add more wax while mixing if needed.**

**Try to stay within +/- .5 - .8 grams. Any extreme deviation from the above amounts will result in an undesired result.**

**1X mixture for M8 Mini  
2X mixture for M8**

# PART 2

## THE MIXING

Items you will need in this section



Coffee  
Grinder



Single burner  
Cooktop



Small 5-6" pot

5

Take your 60 grams of potassium nitrate and 40 grams of sugar and combine them in the coffee grinder. Mix for 1-2 minutes while tapping the sides, shaking it, turning it upside down, ensuring the mixture is even. These grinders are good, but a lot of the powder falls below the blade. When this is complete place the mixture into an empty cup and set aside.

6

Plug in your cook top with the pot on the burner and set to the lowest setting. Dump your 35 grams of candle wax into the pot and melt. Stir with a metal spoon so all the chunks melt faster.

7

When the wax is completely melted, dump your potassium nitrate and sugar mix into the wax. Using the metal spoon stir the mixture until the combined powder is fully coated. This mixture we **DO NOT** want to caramelize like other recipes so you may have to turn off your heat to prevent this. Stir until smooth.

8

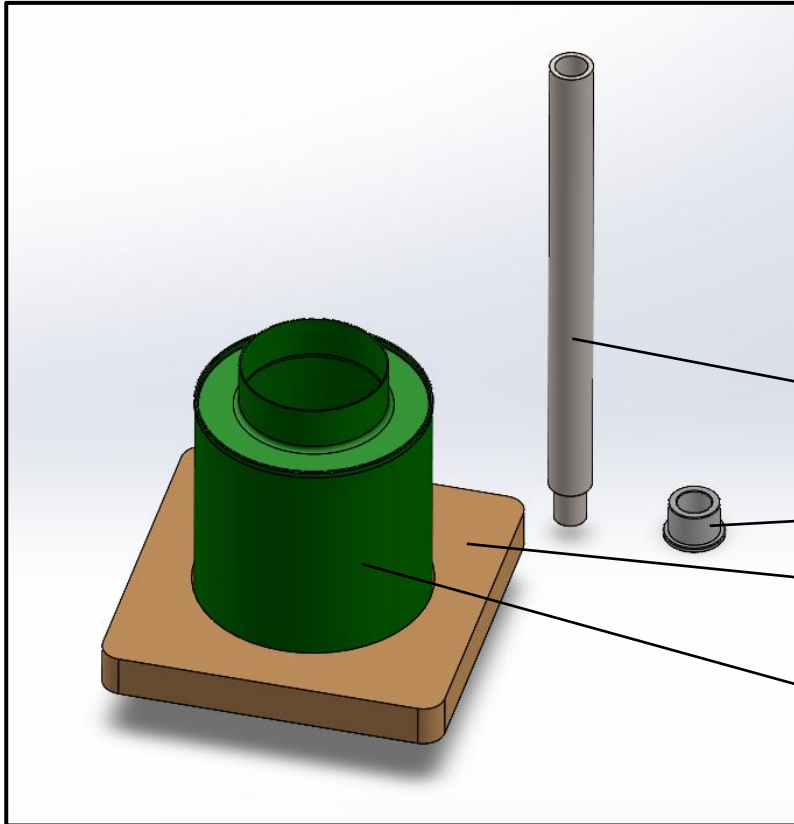
Once the combined mixture of potassium nitrate and sugar is coated with melted wax, the mixture should form a slurry or a smooth wet paste. Turn your burner off and let sit while you prepare for pouring. Turn the burner on again to keep warm if you need to.

**You will need to repeat this process twice to fill the 8oz can**



# PART 3

## THE POUR



Each kit comes with one wooden fixture to hold the can in place during mixture filling. The kit also includes a silicone plug and steel core rod.

Steel Core Rod

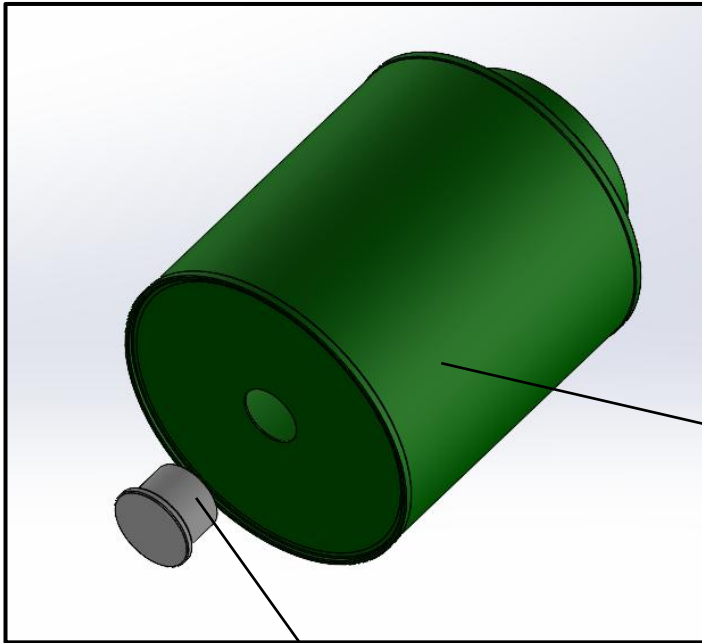
Silicone Plug

Wood Fixture

Can (Smoke Device body)

9

Install the Silicone plug in the bottom end of the can. Make sure the plug is seated all the way in to ensure a good seal.

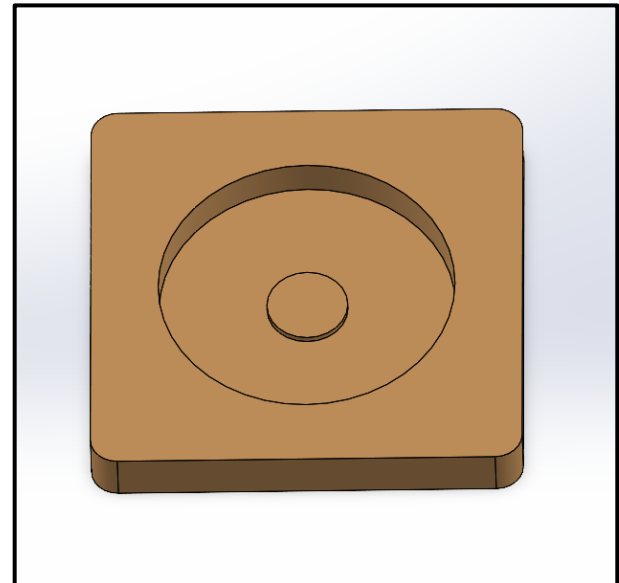


Can (Smoke Device body)

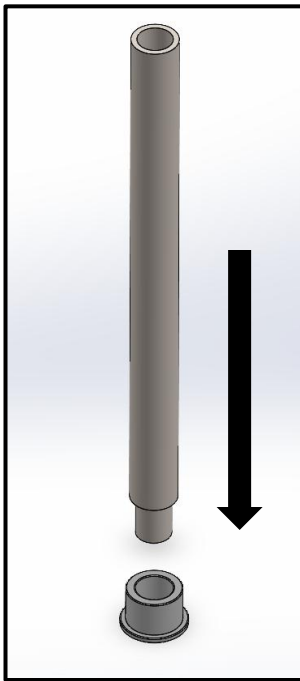
Plug

10

The wood fixture has a disc in the bottom for the silicone plug to rest on. Place the can into the fixture.







11

Place the small end of the steel core rod into the inside of the expansion plug. Place the funnel on top of the opening of the can. Pour the smoke mixture into the funnel and push down, if necessary, with a spoon.

12

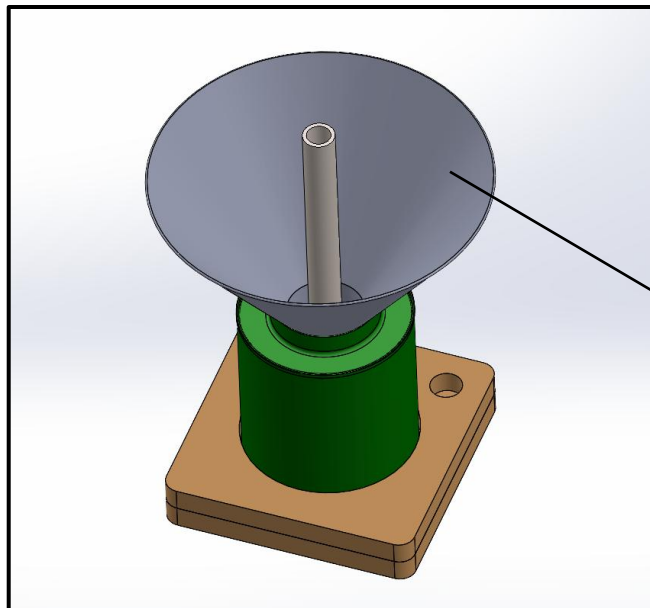
Remove the funnel.

13

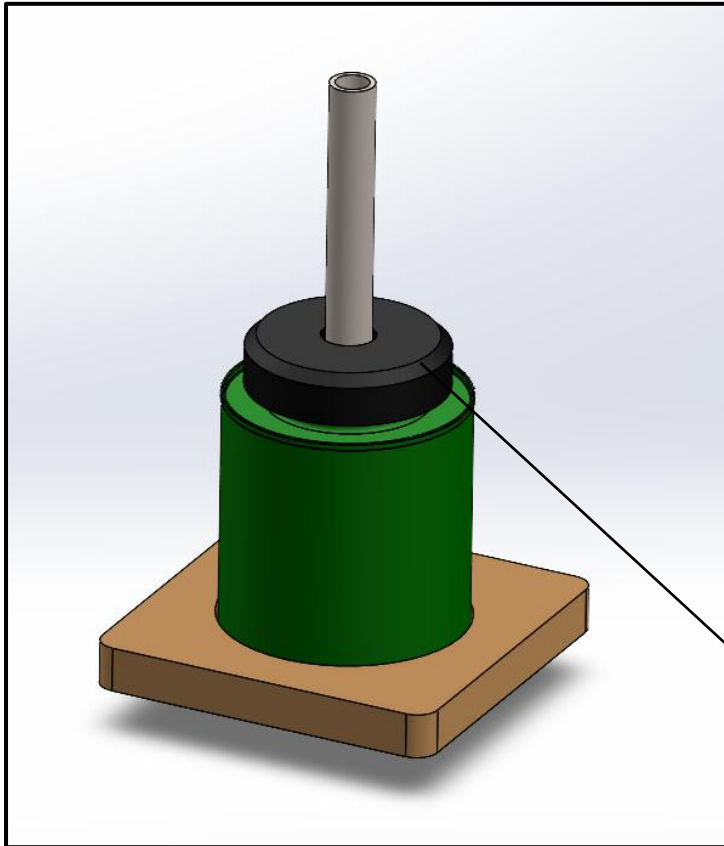
Keeping the can held down flat, jog the fixture back and forth to get the hot mixture to level out.

14

Make new mixture of potassium nitrate, sugar and wax. Repeat steps 1-14.



Funnel



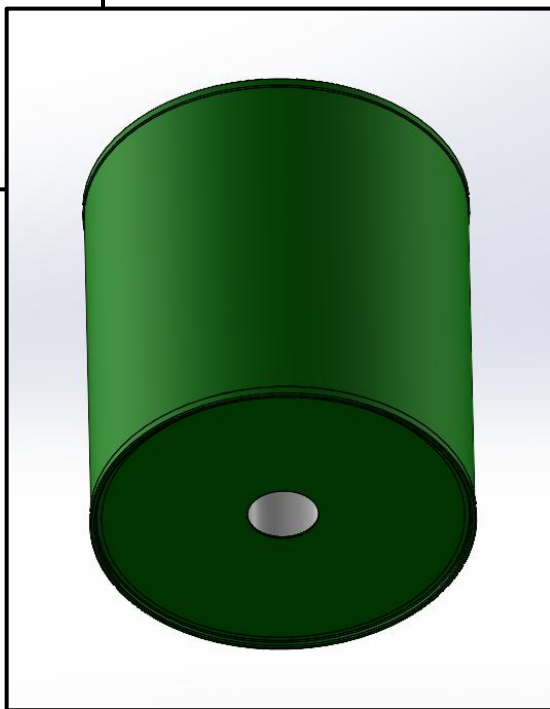
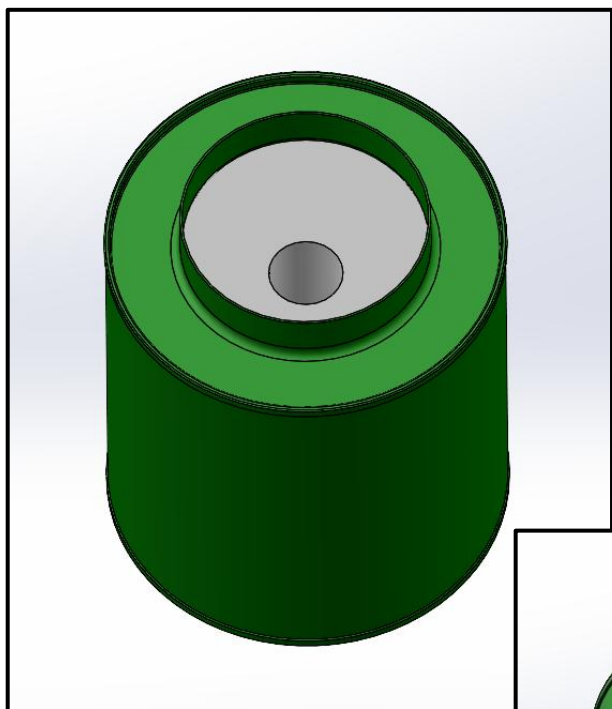
15

Install the plastic can cap with the steel core rod still inside. The cap will help keep the steel core rod centered.

16

Place in freezer for 45min to 60min. Air cooling can be done but cooling times may vary.

Can Cap



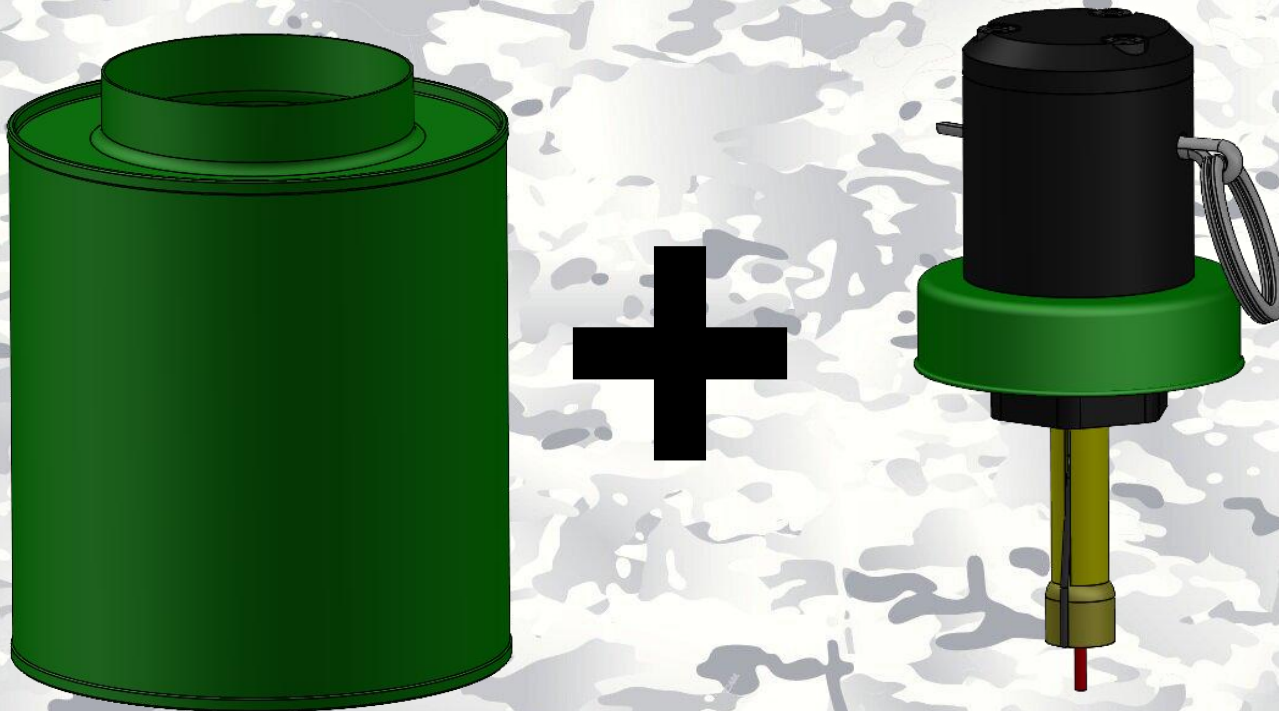
17

When the mixture has completely cooled, remove the steel core rod, the expansion plug and can cap. If the steel core rod is stuck, use a heat gun and let the heat transfer from the top of the steel core rod down to the bottom. Do not aim the heat towards the mixture inside the can. Vise Grip pliers can be used but it will damage the metal. Do not put the damaged end inside the can when you make more.

Repeat the whole process for the other cans provided in the kit.

# PART 4

# FINAL ASSEMBLY



**Watch this detailed video on how to attach the  
igniter to the M8 head.**

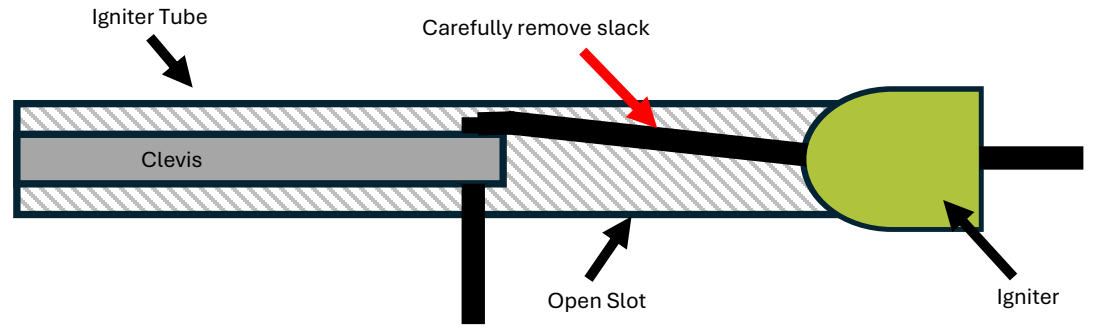
**This method includes the M8 Instant Deployment  
and Spoon Version**



## Setting the igniter to the M8 Head

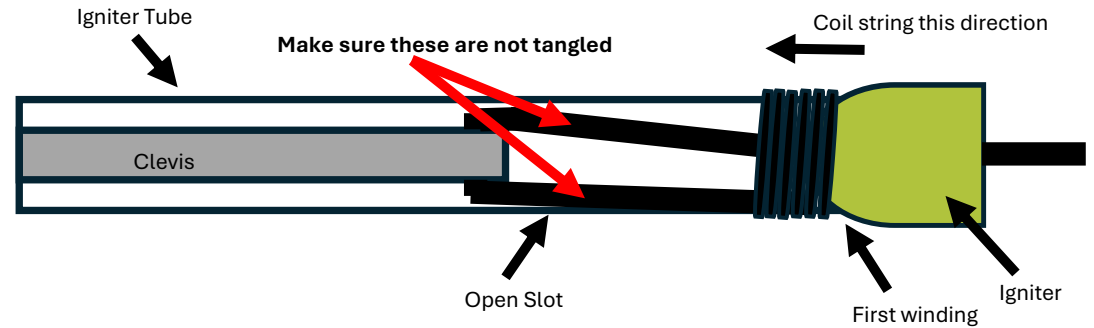


1



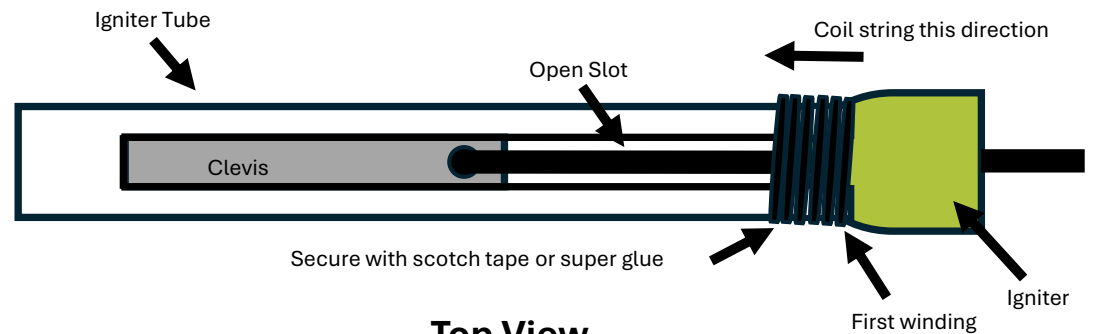
Side Cross Section View

2



Side Cross Section View

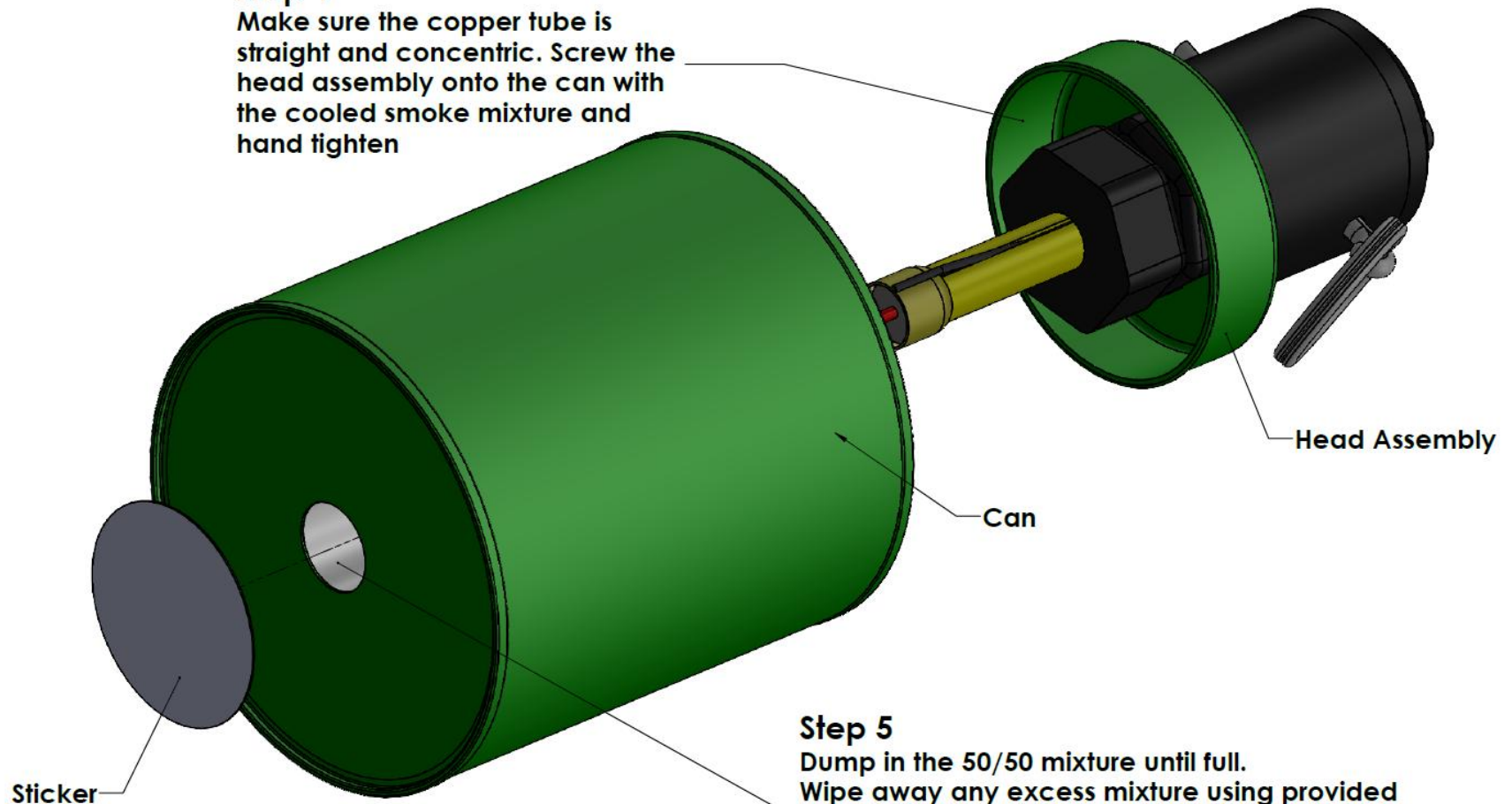
3



Top View

#### Step 4

Make sure the copper tube is straight and concentric. Screw the head assembly onto the can with the cooled smoke mixture and hand tighten



#### Step 5

Dump in the 50/50 mixture until full. Wipe away any excess mixture using provided alcohol wipe. Allow to dry and place supplied round sticker to the bottom centered to the hole

**LIGHTLY PACK MIXTURE IN AS YOU MAY ACCIDENTLY TRIGGER THE IGNITOR**





**Homemade smoke devices must be used the day of construction or it becomes a regulated explosive and you must abide by all requirements from the ATF.**

- Always hold the smoke device with the bottom facing directly down.
- Never point it at anyone and do not have it on an angle towards yourself.
- Hold the smoke device with your arm extended with your dominant hand.
- Pull the keyring with your opposite hand.
- The ignition is instantaneous.
- Immediately throw the smoke device to a safe distance.
- The reaction of the mixture is hot. **Do not throw it or launch it in any area that can catch fire, or you don't want burned.**
- **Wait 20 minutes before picking up spent smoke device**