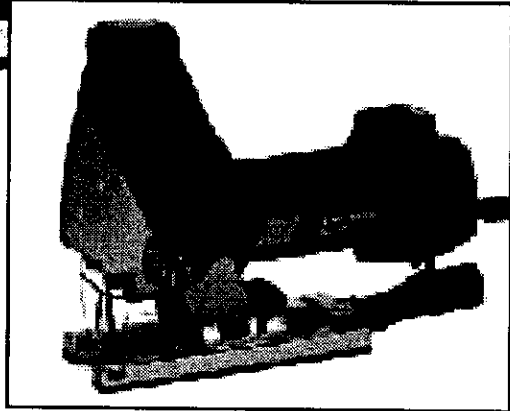
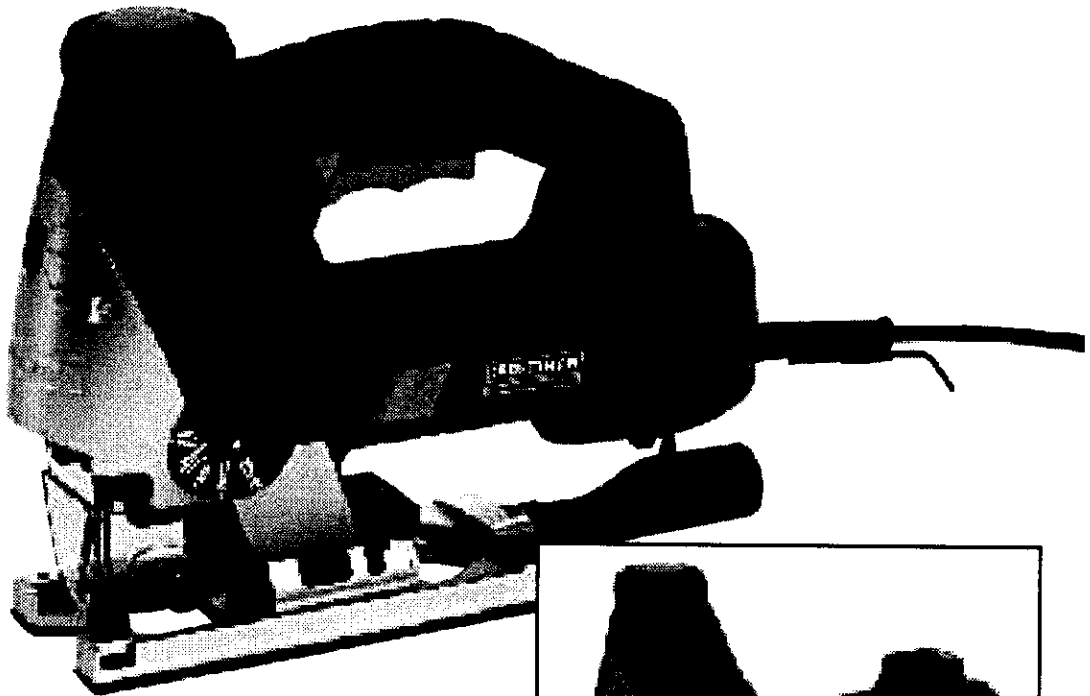


Owner's Manual

CRAFTSMAN®

P R O F E S S I O N A L

2-in-1 Handle Scrolling Sabre Saw with Laser Trac®



**Model No.
320.27245**

0744430
0247

CAUTION: Read, understand and follow all Safety Rules and Operating instructions in this manual before using this product.

- SAFETY
- OPERATION
- MAINTENANCE
- ESPAÑOL

Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.

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ONE FULL YEAR WARRANTY ON CRAFTSMAN PROFESSIONAL TOOL

If this Craftsman Professional Tool fails due to a defective in material or workmanship within one years from the date of purchase, **RETURN IT TO THE NEAREST SEARS PARTS AND REPAIR CENTRE IN THE UNITED STATES** and Sears will replace it, free of charge.

This warranty gives you specific legal rights, and you may also have other rights which vary from state to state.

Sears, Roebuck and Co., Dept. 817 WA, Hoffman Estates, IL 60179

SAVE THESE INSTRUCTIONS!
READ ALL INSTRUCTIONS!

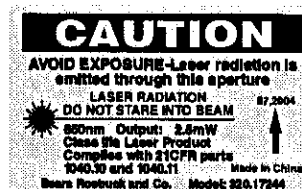
SAFETY INSTRUCTIONS

⚠ WARNING: BE SURE to read and understand all instructions in this manual before using the sabre saw. Failure to follow all instructions may result in hazardous radiation exposure, electric shock, fire and/or serious personal injury.

SAFETY PRECAUTIONS FOR LASER

This **CRAFTSMAN PROFESSIONAL** Sabre Saw has a built-in laser light. The laser is a Class IIIa and emits output power of a maximum 2.5mW and 650nm wavelengths. These lasers do not normally present an optical hazard. However, **DO NOT** stare at the beam because it can cause flash blindness.

IMPORTANT: The following label is on your tool. It indicates where the laser light is emitted by the saw. **ALWAYS BE AWARE** of its location when using the sabre saw. **ALWAYS MAKE SURE** that any bystanders in the vicinity of use are made aware of the dangers of looking directly into the laser.



⚠ WARNING! LASER LIGHT. LASER RADIATION. Avoid Direct Eye Exposure. **DO NOT** stare into beam. Only turn laser beam on when the sabre saw is on the work piece. Class IIIa laser.

⚠ WARNING: Use of controls, adjustments or performance of procedures other than those specified in this manual may result in hazardous radiation exposure.

⚠ WARNING: The use of optical instruments with this product will increase eye hazard.

1. The tinted glasses that were included will enhance the laser light in bright light conditions. **DO NOT** wear these glasses if they interfere with the safe operation of this saw.
2. **NEVER** aim the beam at any person or object other than the workpiece.
3. The laser beam can be harmful to the eyes. **ALWAYS** avoid direct eye exposure. **DO NOT** look directly into the laser beam output aperture during operation.
4. The laser on the sabre saw is not a toy. **ALWAYS** keep out of the reach of children. The laser light emitted from this device **SHOULD NEVER** be directed towards any person for any reason.
5. **ALWAYS** be sure the laser beam is aimed at a sturdy workpiece (such as wood or rough coated surfaces) that does not have a reflective surface.
6. **DO NOT** use on surfaces such as sheet steel that have a shiny, reflective surface. The shiny surface could reflect the beam back at the operator.
7. **ALWAYS** be aware that laser light reflected off of a mirror or any other reflective surfaces can also be dangerous.

⚠ CAUTION: ALWAYS follow only the instructions contained in this manual when using this laser. Use of this feature in any manner other than what appears in this manual may result in a hazardous radiation exposure.

SAFETY INSTRUCTIONS cont.

8. **DO NOT** attempt to modify the performance of this laser device in any way. This may result in a dangerous exposure to laser radiation.
9. For further information regarding lasers, refer to ANSI - Z136.1 **The STANDARD FOR THE SAFE USE OF LASERS**, available from the Laser Institute of America (407) 380-1553.

⚠ WARNING: **BE SURE** to read and understand all instructions in this manual before using the sabre saw. Failure to follow all instructions may result in hazardous radiation exposure, electric shock, fire and/or serious personal injury.

**SAVE THESE INSTRUCTIONS!
READ ALL INSTRUCTIONS!**

WORK AREA SAFETY

1. **ALWAYS** keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.
2. **DO NOT** operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. Power tools create sparks which may ignite the dust or fumes.
3. **ALWAYS** keep bystanders, children and visitors away while operating a power tool. Distractions can cause you to lose control.

ELECTRICAL SAFETY

1. Double insulated tools are equipped with a polarized plug (one blade is wider than the other.) This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install a polarized outlet. Do not change the plug in any way.
2. Double insulation eliminates the need for the three-wire grounded power cord and grounded power supply system. Applicable only to Class II (double insulated) tools.
3. Before plugging in the tool, **BE SURE** that the outlet voltage supplied is within the voltage marked on the tool's data plate. **DO NOT** use "AC only" rated tools with a DC power supply.
4. **ALWAYS** avoid body contact with grounded surfaces, such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is grounded.
5. If operating the power tool in damp locations is unavoidable, **ALWAYS** use a Ground Fault Circuit Interrupter to supply power to your tool. **ALWAYS** wear electrician's rubber gloves and footwear in damp conditions.
6. **DO NOT** expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
7. **DO NOT** abuse the cord. **NEVER** use the cord to carry the tools or pull the plug from the outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock.
8. When operating a power tool outside, **ALWAYS** use an outdoor extension cord marked "W-A" or "W". These cords are rated for outdoor use and reduce the risk of electric shock.

NOTE: The extension cord must have adequate wire size AWG (American Wire Gauge) for safe, efficient use. Smaller gauge wires have greater capacity (16 gauge wire has more capacity than 18 gauge wire).

SAFETY INSTRUCTIONS cont.

SAFETY SYMBOLS

The purpose of safety symbols is to attract your attention to possible dangers. The safety symbols, and the explanations with them, deserve your careful attention and understanding. The safety warnings **DO NOT** by themselves eliminate any danger. The instructions and warnings they give are no substitutes for proper accident prevention measures.

SYMBOL MEANING



SAFETY ALERT SYMBOL: Indicates danger, warning or caution. May be used in conjunction with other symbols or pictographs.



DANGER: Failure to obey a safety warning will result in serious injury to yourself or to others. Always follow the safety precautions to reduce the risk of fire, electric shock and personal injury.



WARNING: Failure to obey a safety warning can result in serious injury to yourself or to others. Always follow the safety precautions to reduce the risk of fire, electric shock and personal injury.



CAUTION: Failure to obey a safety warning may result in property damage or personal injury to yourself or to others. Always follow the safety precautions to reduce the risk of fire, electric shock and personal injury.

NOTE: Advises you of information or instructions vital to the operation or maintenance of the equipment.

PERSONAL SAFETY

1. **ALWAYS** stay alert, watch what you are doing and use common sense when operating a power tool. **DO NOT** use tool while tired or under the influence of drugs, alcohol or medication. A moment of inattention while operating power tools may result in serious personal injury.
2. **ALWAYS** dress properly. **DO NOT** wear loose clothing or jewelry. Pull back long hair. Keep your hair, clothing and gloves away from moving parts. Loose clothes, jewelry or long hair can be caught in moving parts.
3. **ALWAYS** avoid accidental starting. **BE SURE** switch is in the "Off" position before plugging in. **DO NOT** carry tools with your finger on the switch. Carrying tools with your finger on the switch or plugging in tools that have the switch in the "On" position invites accidents.
4. **ALWAYS** remove adjusting keys or wrenches before turning the tool "On". A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.
5. **DO NOT** overreach. **ALWAYS** keep proper footing and balance at all times. Proper footing and balance enables better control of the tool in unexpected situations.
6. **ALWAYS** use safety equipment. Always wear eye protection.

TOOL USE AND CARE SAFETY


1. **ALWAYS** use clamps or other practical ways to secure and support the workpiece to a stable platform. Holding the work by hand or against your body is unstable and may lead to loss of control.
2. **DO NOT** force tool. Use the correct tool and blade for your application. The correct tool and blade will do the job better and safer at the rate for which it is designed.

SAFETY INSTRUCTIONS cont.

SAFETY RULES FOR SABRE SAWS cont.

5. **ALWAYS** hold tool by insulated gripping surfaces when performing an operation where the cutting tool may contact hidden wiring or its own cord. Contact with a "live" wire will make the exposed metal parts of the tool "live" and shock the operator.
6. **ALWAYS** use blades that have the correct size and shape . Blades that do not match the mounting hardware of the saw will run erratically and will cause loss of control.
7. **ALWAYS BE SURE** that all adjusting screws and the blade holder are fastened tightly **BEFORE** making a cut. Loose adjusting screws can cause the tool to slip and loss of control may result.

ADDITIONAL RULES FOR SAFE OPERATION

 **WARNING: BE SURE** to read and understand all instructions in this manual before using the sabre saw. Failure to follow all instructions may result in hazardous radiation exposure, electric shock, fire and/or serious personal injury.

1. Know your power tool. Read operator's manual carefully. Learn the applications and limitations, as well as the specific potential hazards related to this tool. Following this rule will reduce the risk of electric shock, fire or serious injury.
2. **ALWAYS** wear safety glasses or eye shields when using this saw. Everyday eyeglasses have only impact-resistant lenses; they are **NOT** safety glasses. Following this rule will reduce the risk of serious personal injury.
3. **ALWAYS** protect your lungs. Wear a face mask or dust mask if the operation is dusty. Following this rule will reduce the risk of serious personal injury.
4. **ALWAYS** protect your hearing. Wear hearing protection during extended periods of operation. Following this rule will reduce the risk of serious personal injury.
5. **ALWAYS** inspect the tool cords periodically and if damaged have them repaired at your nearest Sears Service Center or other Authorized Service Facility. **ALWAYS** be aware of the cord location. Following this rule will reduce the risk of electric shock or fire.
6. **ALWAYS** check for damaged parts. Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine if it will operate properly and perform its intended function. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the tool's operation. A guard or other part that is damaged should be properly repaired or replaced at a Sears Service Center. Following this rule will reduce the risk of electric shock, fire or serious injury.
7. **DO NOT** abuse the cord. **NEVER** use the cord to carry the tool or pull the plug from the outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock. Following this rule will reduce the risk of electric shock or fire.

SAFETY INSTRUCTIONS cont.

ADDITIONAL RULES FOR SAFE OPERATION cont.

8. **ALWAYS** make sure that your extension cord is in good condition. When using an extension cord be sure to use one that is heavy enough to carry the current that your tool will draw. A wire gauge (AWG) of at least 14 is recommended for an extension cord 25 feet or less in length. When working outdoors, **ALWAYS** use an extension cord that is suitable for outdoor use. The cord's jacket will be marked WA. Smaller gauge wires, have greater capacity (16 gauge wire has more capacity than 18 gauge wire). An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating.
9. **ALWAYS** inspect and remove all nails from lumber before sawing. Following this rule will reduce the risk of serious personal injury.
10. **DO NOT** use the tool while tired or under the influence of drugs, alcohol or any medication. Following this rule will reduce the risk of electric shock, fire or serious personal injury.
11. **SAVE THESE INSTRUCTIONS.** Refer to them frequently and use them to instruct others who may use this tool. If someone borrows this tool, make sure they have these instructions also.



⚠ WARNING: The operation of any sabre saw can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Before beginning power tool operation, **ALWAYS** wear safety goggles or safety glasses with side shield and a full face shield when needed. We recommend A Wide Vision Safety Mask for use over eyeglasses or standard safety glasses with side shield, available at Sears Retail Stores.

⚠ WARNING: Some dust particles created by power sanding, sawing, grinding, drilling and other construction jobs contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- Lead from lead-based paints.
- Crystalline silica from bricks and cement and other masonry products.
- Arsenic and chromium from chemically-treated lumber.


Your risk from these exposures varies, depending upon how often you do this type of work. To reduce your exposure to these chemicals:

Work in a well-ventilated area.

- Work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

SAFETY INSTRUCTIONS cont.

The label on your tool may include the following symbols.


V.....	Volts
A.....	Amperes
Hz.....	Hertz
W.....	Watts
min.....	Minutes
~.....	Alternating current
n_0	No-load speed
<input type="checkbox"/>	Class II construction
RPM.....	Revolutions or Strokes per minute
	Indicates danger, warning or caution. It means attention! Your safety is involved.


IMPORTANT! READ ALL INSTRUCTIONS

ASSEMBLY

UNPACKING

Your sabre saw has been shipped completely assembled as a barrel sabre saw, except for the saw blade and top handle which are packed unassembled. Inspect the tool carefully to make sure that no breakage or damage has occurred during shipping. If any parts are damaged or missing, return the sabre saw to your nearest Sears Service Center to have it replaced.

 **WARNING:** If any parts are missing, **DO NOT** operate this tool until the missing parts are replaced. Failure to do so could result in possible serious personal injury.

 **WARNING:** Your sabre saw should **NEVER** be connected to a power source when you are assembling parts, making adjustments, installing or removing blades, cleaning or when it is not in use. Disconnecting the tool will prevent accidental starting that could cause serious personal injury.

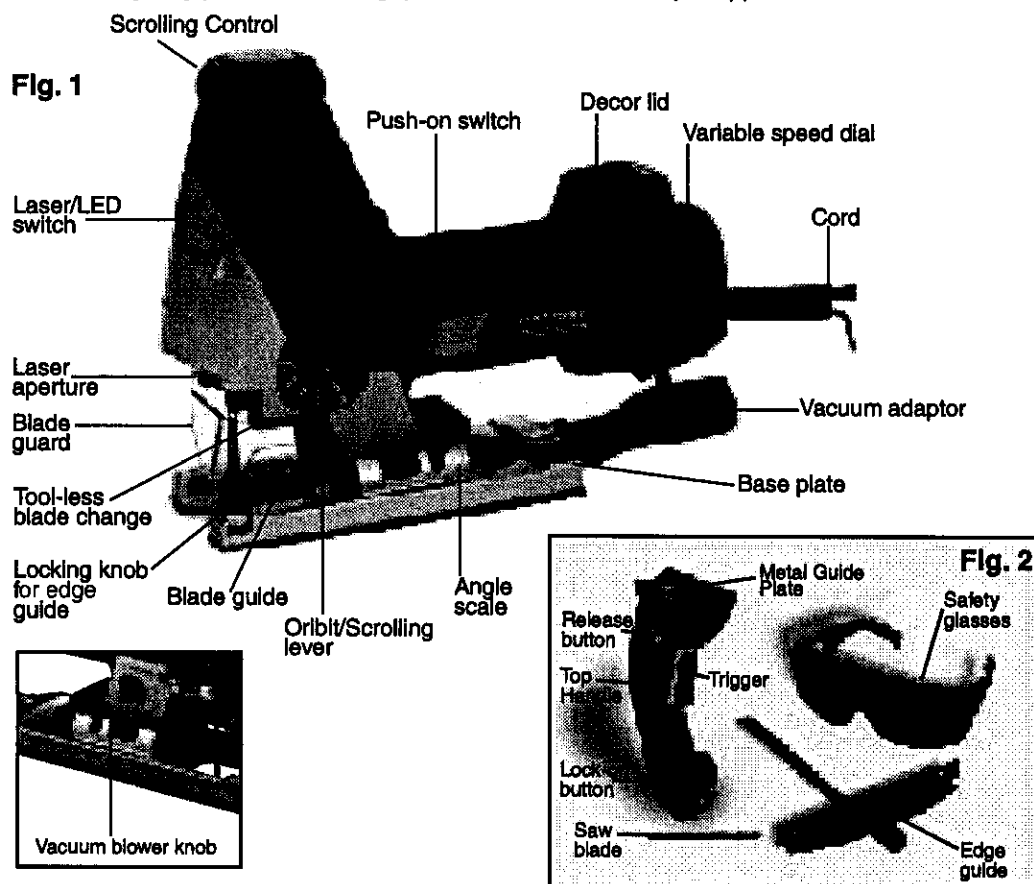
DESCRIPTION

Before attempting to use any tool, be sure to familiarize yourself with all the operating features and safety instructions.

DESCRIPTION cont.

KNOW YOUR SABRE SAW (See Fig.1 & Fig.2)

Your sabre saw has many built-in convenience features for fast, efficient cutting. These features include the laser beam that projects a line of light along the cutting line for accurate cutting. It has scrolling feature that allows the blade to be rotated 360°, ideal for cutting curves and detailed work. The saw's 2-in-1 soft-grip top handles allow you to guide the saw with the "top handle" attached or to guide the saw with the "barrel grip" for low center of gravity precision, giving you a choice of grip locations to match the job application.



PRODUCT SPECIFICATIONS

Input	5 Amps
Laser Diode Type	Red Laser Diode 650 nm
Laser Class	Class IIIa, power output <2.5 mW
No load Speed	800-3000 RPM
Rating	120 volts, 60Hz AC
Cutting angle range	0-45° left and right
Cutting depth in wood	3 3/8 in. (85mm)
Cutting depth in steel	1/4 in. (6mm)

OPERATION

⚠ CAUTION! The blade guide supports the blade when cutting and must at all times rest against the back edge of the blade except when in the scrolling mode. It should rotate freely.

TURN POWER "ON-OFF" WHEN USING AS A BARREL GRIP SABRE SAW (Fig. 3)

1. Connect the power cord of your saw to a standard household power outlet.
2. Turn your saw "ON" by sliding the "ON-OFF" switch forward until it 'clicks' into the start position (Fig. 3).
3. To turn power "OFF", press in on the rear section of the "ON-OFF" switch to stop the tool.

Fig. 3

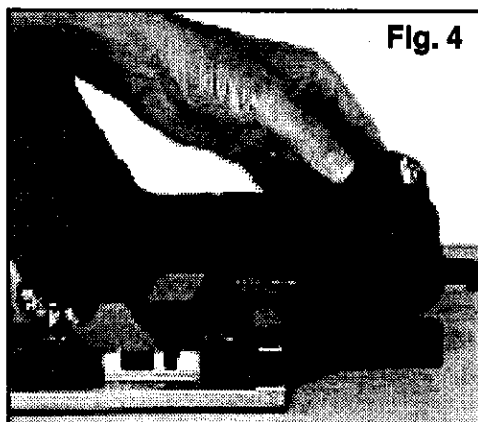
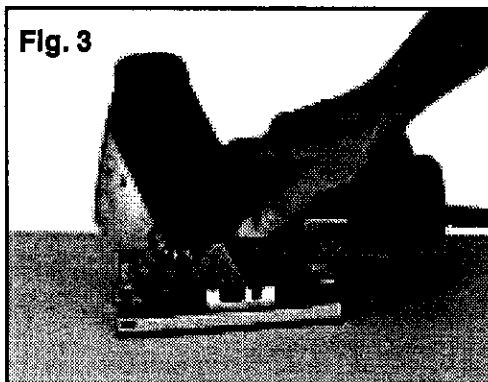


Fig. 4



Fig. 5

Metal plate in top handle

Release Button

ATTACHING TOP HANDLE ONTO SABRE SAW (Figs. 4, 5)

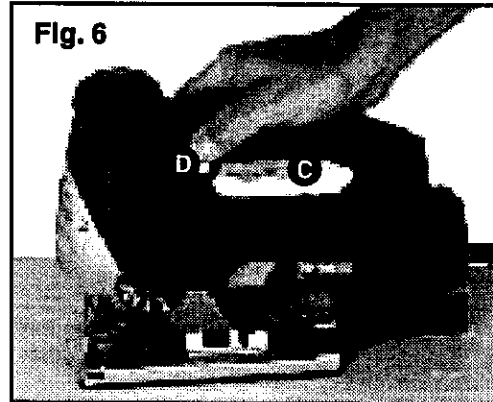
Remove the "top handle attaching plate" from the rear top of the barrel (Fig. 4) by sliding the "plate" completely off the saw's motor housing in the direction of the arrow.

Guide the metal attaching plate located in the inside front of the "top" handle toward the slot located in the front of the sabre saw just beneath the scrolling knob (Fig. 5). At the same time, align and slide the rear bottom of the "top" handle into the attaching compartment which had been covered by the attaching plate (Fig. 4) that you removed earlier. When sliding the "top" handle onto the attaching plate compartment, hold down the handle-release buttons until "top" handle snaps and locks into place (Fig. 5).

OPERATION cont.

TURN POWER ON-OFF WHEN USING AS A TOP HANDLE GRIP SABRE SAW (Fig. 6)

1. Connect the power cord of your saw to a standard household power outlet.
2. Start the tool by squeezing the "ON-OFF" trigger switch (C) (Fig. 6).
3. Release the trigger switch to stop the tool.
4. If you press in on either side of the lock-on button (located on both sides of the top handle (D) while the trigger switch is depressed, the trigger switch remains in the "locked-on" operating position. This feature is convenient for continuous sawing applications.
5. The lock-on button allows the operator to keep the sabre saw motor running without continuously holding the trigger switch.
6. To release the lock-on button, press and release the trigger switch.



CAUTION: DO NOT let familiarity with your saw make you careless. Remember that a careless fraction of a second is sufficient to cause severe injury.

WARNING: If the "LOCK-ON" button is continuously being depressed, the trigger cannot be released.

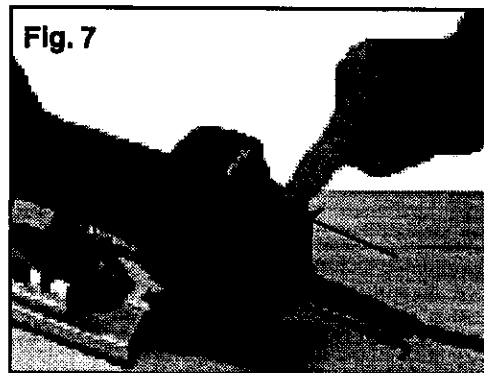
NOTE: Determine the optimum speed for cutting your workpiece by making a trial cut in a scrap piece of material. Your experience will determine the best results for a particular application. However, as a general rule, use slower speed for harder, denser materials and faster speed for soft materials.

ADJUSTING THE CUTTING SPEED WITH THE VARIABLE SPEED DIAL (Fig. 7)

The variable speed feature of this sabre saw enhances the cutting performance of your saw and saves the blade from undue wear.

1. The variable speed dial is used to adjust the speed of the blade.
2. Turn the dial to increase or decrease the speed of the blade (Fig. 7).
3. Position '1' selects the slowest blade speed, position '6' selects the fastest blade speed. Adjust blade speed for optimum performance.

NOTE: Determine the optimum speed for cutting your workpiece by making a trial cut in a scrap piece of the material.



OPERATION cont.

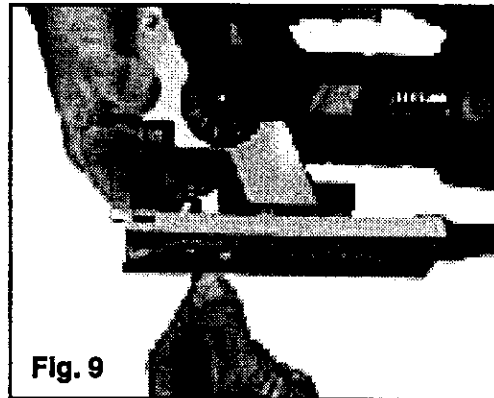
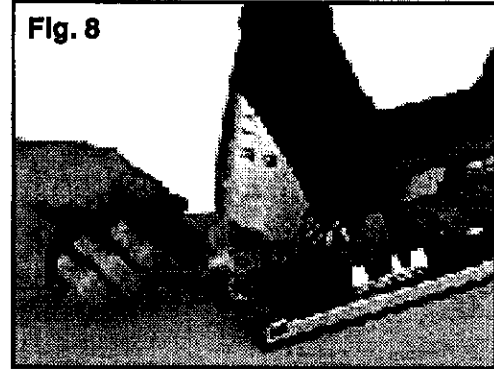
⚠ WARNING! Failure to unplug the saw from the power source when assembling parts, making adjustments or changing blades could result in accidental starting causing possible serious injury.

TOOL-LESS BLADE INSTALLATION (Fig. 8, 9)

The tool-less blade change control allows you to remove and replace the saw blade quickly and easily without the use of additional tools.

1. Place your finger on the lower edge of the see-through blade guard and pull forward until it locks in place (Fig. 8).
2. Slide the tool-less blade-change cover up, then insert the blade into the slot of tool-less blade change holder (Fig. 9).
3. Release the tool-less blade-change cover to lock the blade in place.
4. Pull down on the blade to be sure the blade is securely locked in place. Blade teeth should be pointing forward and down.

NOTE: For use with both 'T' & 'U' shanked blades.



REMOVING THE BLADE (Fig. 8, 9)

1. Unplug the sabre saw.

⚠ WARNING: Failure to unplug the saw could result in accidental starting causing possible serious personal injury.

2. Follow steps 1 through 3 on tool-less blade installation (above).
3. Carefully remove the blade.

⚠ WARNING: ALWAYS CLAMP WORKPIECE. Failure to clamp workpiece could result in workpiece being thrown or kicked back causing serious personal injury.

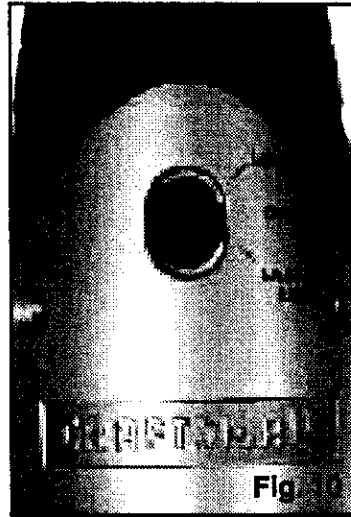
OPERATION cont.

TURN THE LASER LIGHT "ON/OFF" (Fig. 10)

Your sabre saw has a built-in laser light.
To activate laser light, plug in your sabre saw.

SAFETY PRECAUTIONS FOR LASER

This saw has a built-in laser light. The laser is a Class IIIa and emits output power of a maximum 2.5mW and 650nm wavelengths. These lasers do not normally present an optical hazard. However, **DO NOT** stare at the beam because it can cause flash blindness.



IMPORTANT: The following label is on your saw. It indicates where the laser light is emitted by the saw. **ALWAYS BE AWARE** of its location when using the saw. **ALWAYS MAKE SURE** that any bystanders in the vicinity of use are made aware of the dangers of looking directly into the laser.

⚠ WARNING! LASER LIGHT. LASER RADIATION. Avoid Direct Eye Exposure. Do Not Stare into beam. Only turn laser beam on when tool is on the workpiece. Class IIIa.

⚠ CAUTION: The tinted glasses that were included will enhance the laser light in bright light conditions. **DO NOT** wear these glasses if they interfere with the safe operation of this saw.

1. Move the **LASER/LED** switch to the "**LASER LINE**" position. The laser light will be projected out from the laser aperture (See Fig. 10). Use the laser line as cutting line guide by focusing it on a fixed "target" and following its path.
2. To turn off the laser light, move the **LASER / LED** switch to the "**OFF**" position.

TURN THE LED WORK LIGHT "ON/OFF" (Fig. 10)

Your sabre saw has a built-in **LED** work light (See Fig. 10) for illuminating the cutting area. To activate the **LED** work light, plug in your sabre saw.

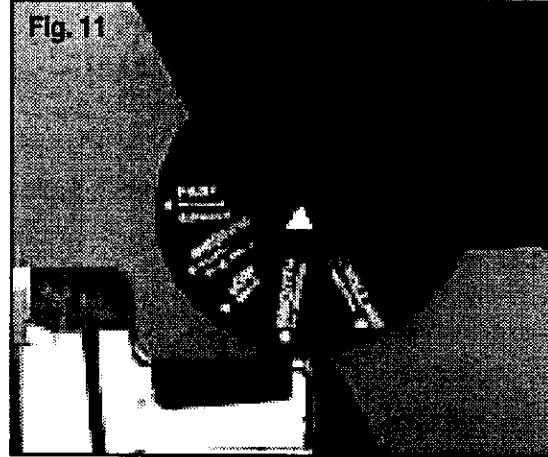
1. Move the **LASER/LED** switch to the "**LED**" position. The **LED** lamp will come on.
2. To turn off the **LED** work light, move the **LASER / LED** switch to the "**OFF**" position.

OPERATION cont.

ORBITAL ACTION

ORBIT CONTROL LEVER (Fig. 11)

This saw has an orbital control that allows you to choose the best cutting action for your material. Simply turn the lever to the position you need for the type of cut you are making.



To increase orbit action, turn the lever to a higher setting. To decrease orbital action turn the lever to a lower setting.

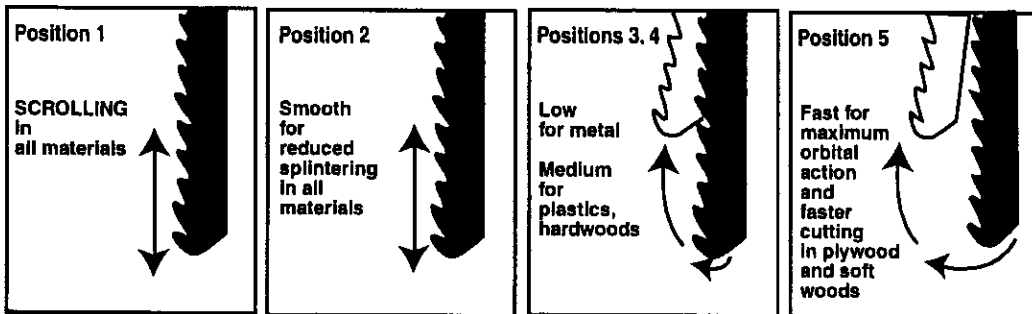
When minimal splintering desired, we recommend using the "Smooth" position.

1. **SCROLLING** in all Materials allows manual 360° rotation of the blade using the scrolling knob.
2. **SMOOTH** for cutting mild steel / soft materials / all materials with normal up and down blade motion with minimal splintering.
3. **LOW** for cutting most metal.
4. **MEDIUM** for cutting plastics, and hardwoods.
5. **FAST** for maximum orbital action and faster cutting in plywood and soft woods.

Choose the scrolling or smooth cut positions for normal up and down motion (see Position 1 and 2).

Choose the low or medium cut positions for orbital action for cutting metal, plastic, and hardwoods (see Position 3 and 4).

Choose the fast cut position for maximum orbital action that will provide faster, more aggressive cutting in softer materials (see Position 5).



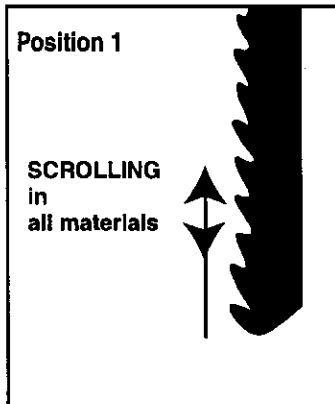
NOTE: In order to reach full orbital action, the blade **MUST BE FACING STRAIGHT FORWARD** and the back of the blade must rest in the groove of the guide roller. The foot must be all the way in the forward position. Orbital action is not observable when the saw is free-running. The saw must be cutting for orbital action to occur. The speed of cut is easier to see in thicker materials.

OPERATION cont.

ORBIT CONTROL LEVER cont.

SCROLLING CONTROL FEATURE (Fig.12)

Choose the scrolling position for normal up and down motion (see Position 1).



The scrolling feature allows the blade to be rotated 360°. It is ideal for cutting curves and detailed work.

1. To engage the scrolling function, move the Orbit/Scrolling lever to the **SCROLLING** position, see Fig. 11, page 15.
2. Grasp the scrolling control knob (Fig. 12).
3. The scrolling control knob can be rotated 360° to the left or right while guiding the saw to follow intricate cutting lines.

NOTE: The blade can be locked in any scrolling position within 360° by switching the Orbit/Scrolling lever to the "**SMOOTH**" position.

IMPORTANT: When you are manually scroll cutting **ALWAYS** hold the saw handle in one hand and rotate the scrolling knob with your other hand.

CAUTION: Excessive side pressure to the blade could break the blade which could damage the material being cut.

NOTE: When scroll cutting intricate designs, we recommend that you use a scroll cutting blade.

WARNING: To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** making any adjustments or attaching accessories.

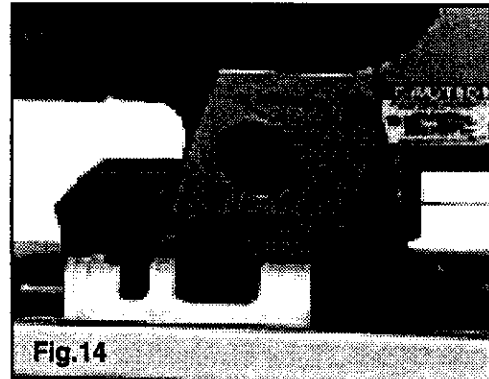
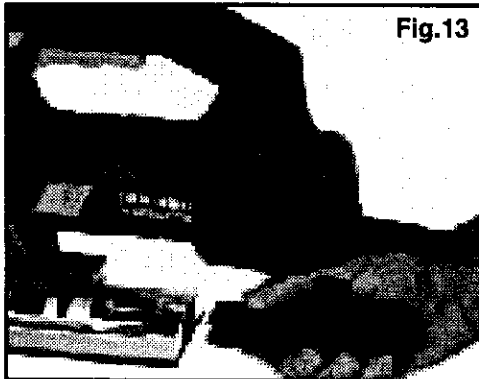
OPERATION cont.

⚠ WARNING: The use of attachments or accessories that are not recommended might be dangerous.

2-WAY SAWDUST REMOVAL

Your sabre saw is equipped with a 2-way (vacuum and blower) sawdust removal system. Use the detachable vacuum adapter (dust port) shown in **(Fig. 13)** for removing dust and chips from the immediate work space to help keep the cutting line clear.

1. Switch the Vacuum/Blower knob **(Fig. 14)** to the "VACUUM" position and connect the sabre saw through the adapter to a standard shop vacuum (sold separately) for vacuuming sawdust, metal and plastic chips.
2. Switch the Vacuum/Blower knob to the "BLOWER" position to blow sawdust, metal and plastic chips away from the cutting area.



GENERAL CUTTING TIPS

1. Place the best side of the material face down and secure it in a bench vise or clamp it down.
2. Draw your cutting lines or designs on the side facing you.
3. Place front edge of saw foot on the material to be cut and line up the blade with your cutting line.
4. Hold saw firmly and turn it on.
5. Press down (to keep saw foot flat against the workpiece) as you slowly push the saw in the direction of the cut.
6. Gradually build up the blade speed, cutting as close to the line as possible (unless you want to leave enough room for finished sanding).
7. As you cut, you may need to reposition the vise or clamps to keep the workpiece stable.
8. **DO NOT** force the saw because the blade teeth may rub and wear without cutting which may result in breaking the blade.
9. **ALWAYS** let the saw do most of the work.
10. **ALWAYS** cut slowly when following curves, so the blade can cut through cross grain. This will provide an accurate cut and will prevent the blade from wandering.

OPERATION cont.

CUTTING METAL


When cutting metal **ALWAYS** clamp down the metal workpiece. Be extremely careful to move the saw very slowly as you cut. Use slower speeds (Position 1, 2 or 3 on the Variable Speed Dial). **DO NOT** twist, bend or force the blade. If the saw jumps or bounces as you cut, change to a blade with finer teeth. If the blade begins to clog when cutting soft metal, change to a blade with coarser teeth.


For easier cutting, lubricate the blade with a stick of cutting wax (if available) or cutting oil when cutting steel. Thin metal should be sandwiched between two pieces of wood or tightly clamped on a single piece of wood (wood on top of the metal). Draw the cut lines or design on the top piece of wood.

When cutting aluminum extrusion or angle iron, clamp the work in a bench vise and saw close to the vise jaws.

When sawing tubing with a diameter larger than the blade is deep, cut through the wall of the tubing and then insert the blade into the cut, rotating the tube as you saw.

1. When cutting metals, a suitable cooling / cutting oil must be used.
2. Spread the oil onto the blade or workpiece at regular intervals during cutting in order to reduce wear or overheating the blade.

 **WARNING:** To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** making any adjustments or attaching accessories.


 **WARNING:** The use of attachments or accessories that are not recommended might be dangerous.


CUTTING WITH A STRAIGHTEDGE (Fig. 15)

1. **ALWAYS** use a rough-cut blade whenever possible.
 2. Mark the line-of-cut, then position the straightedge parallel to cut line and at the same distance as between the blade and the side edge of the saw foot.
- OR**
3. Mark the side edge of the saw foot and then clamp the straightedge on the mark and parallel to the cut.
 4. As you cut, keep the saw foot edge flush against the straightedge and flat on the workpiece.



OPERATION cont.

 **WARNING:** To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** making any adjustments or attaching accessories.

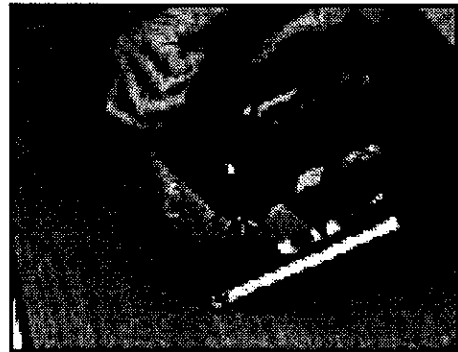
 **WARNING: DO NOT** let familiarity with your saw make you careless. Remember that a careless fraction of a second is sufficient to cause severe injury.

 **WARNING! ALWAYS** wear safety goggles or safety glasses when operating this tool.

PLUNGE CUTTING (Fig. 16)

Plunge cutting is useful and time-saving for making rough openings in soft materials. It makes it unnecessary to drill a hole for an inside or pocket cut.

1. Draw lines for the opening.
2. Hold saw firmly and tilt it forward so the toe of the saw foot rests on the workpiece.
3. **MAKE SURE** that the blade is well clear of the workpiece.
4. Start the saw and then gradually lower the blade.
5. When the blade touches the workpiece, continue pressing down on the toe of the saw foot.
6. Slowly pivot the saw like a hinge until the blade cuts through and the foot rests flat on the workpiece.
7. Then begin sawing on the cut line.



NOTE: DO NOT use a scroll blade for plunger cutting.

IMPORTANT: DO NOT try to plunge cut into hard materials, such as steel.

TO MAKE SHARP CORNERS

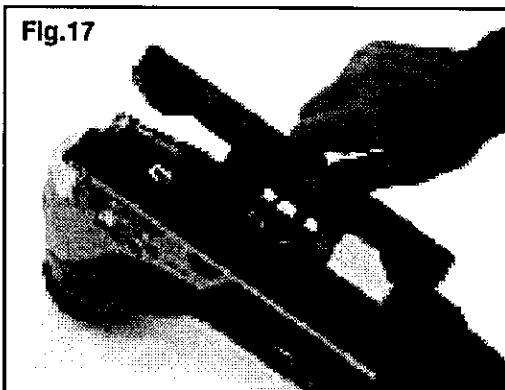
1. Cut up to the corner, then back up slightly before rounding the corner.
2. After the opening is complete, go back to each corner and cut it from the opposite direction to square it off.

OPERATION cont.

TO ADJUST BASE PLATE FOR BEVEL CUTTING (Figs. 17, 18)

⚠ CAUTION: To prevent damage to the tool when angle or bevel cutting, the scroll mechanism **MUST BE** locked in place with the cutting edge of the blade facing the front of the tool.

1. To adjust the cutting angle, first turn the tool upside down and loosen the hex screw that secures the blade guide assembly located on the underside of the tool using the hex key provided (Fig. 17).
2. Loosen the hex screw securing the base plate. Move the base plate slightly forward and tilt it to the required angle between 0° and 45° using the scale marked on the base bracket. The base plate has indents at 0°, ±45° for easy angle setting.
3. Slide the blade guide assembly until the blade guide rests against the back edge of the blade.
4. Re-tighten the hex screws. For accurate work, it is necessary to make a trial cut, measure the work and reset the angle until the correct setting is achieved.



⚠ WARNING: To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** making any adjustments or attaching accessories.

⚠ WARNING: **DO NOT** let familiarity with your saw make you careless. Remember that a careless fraction of a second is sufficient to cause severe injury.

⚠ WARNING: The use of attachments or accessories that are not recommended could be dangerous.

OPERATION cont.

THE EDGE GUIDE (Fig. 19)

This accessory (included) is used for straight cutting:

1. Insert the bar of the edge guide through the slots in the base of the sabre saw (**See Fig.19**) It can be inserted from either side of the base with the edge guide facing down.
2. Screw the edge guide locking knob into the threaded hole in the base to tighten the edge guide bar in place.
3. Once the edge guide is attached, measure the distance from the edge of the workpiece to the line-of-cut.
4. Set the edge guide to the same distance and then securely tighten the edge guide in place with the locking nut tightened down (**see Fig. 19**).

Fig. 19

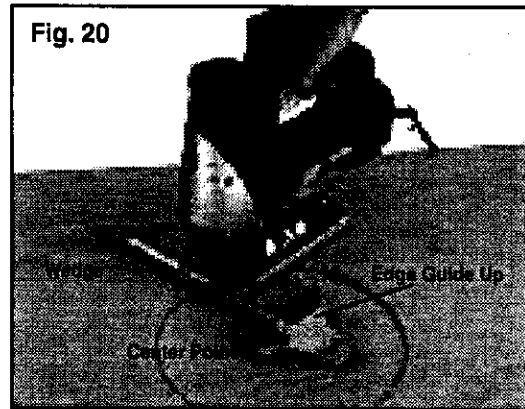


CIRCLE CUTTING (Fig. 20)

This requires using the Circle Cutting / Straight Edge Guide (9-27959) sold separately at your local Sears Store.

1. **BEFORE** attaching the edge guide, draw a circle and drill a hole in the center of the circle (**see Fig. 20**).
2. Drill or plunge cut near the edge of the circle.
3. Turn off saw and disconnect plug from power source.
4. Attach the edge to saw (the same way you attached the included edge guide) with the edge guide facing up
5. Place the metal center point on the edge into the hole in the center of the circle. In order for the edge guide to cut a circle, the metal center point **MUST BE** in alignment with the saw blade (**see Fig. 20**).
6. Measure the distance from the selected hole to the blade; this distance is equal to the circle radius.
7. Insert saw plug into power source.
8. Hold saw firmly, squeeze the trigger switch and slowly push the saw forward.

Fig. 20



NOTE: To make a hole, cut from inside the circle; to make wheels or discs, cut from the outside.

MAINTENANCE

SERVICE

⚠ WARNING: Preventive maintenance performed by unauthorized personnel may result in misplacing of internal wires and components, which could cause a serious hazard.

1. When servicing a tool, use only identical replacement parts. Follow instructions in the maintenance section of this manual. Use of unauthorized parts or failure to follow maintenance instructions may create a risk of electrical shock or serious personal injury.
2. All service that requires opening the sabre saw **MUST** only be performed by a Sears Service Center. All motor parts represent an important part of the double insulation system and **MUST** only be serviced by a Sears Service Center. Service performed by unqualified personnel could result in a risk of injury.
3. Avoid using solvents when cleaning plastic parts. Most plastics are susceptible to damage from various types of commercial solvents and may be damaged by their use. Use clean cloths to remove dirt, carbon dust, etc.

GENERAL

⚠ WARNING! To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** cleaning or performing any maintenance.

⚠ WARNING! **DO NOT** at any time let brake fluids, gasoline, petroleum-based products, penetrating oils, etc. to come in contact with plastic parts. They contain chemicals that can damage, weaken or destroy plastic.

4. It is a known fact that electric tools are subject to accelerated wear and possible premature failure when they are used to work on fiber glass boats and sports cars, wallboard, spackling compounds or plaster. The chips and grindings from these materials are highly abrasive to electrical tool parts, such as bearing, brushes, commutators, etc. Consequently, it is not recommended that this tool be used for extended work on any fiber glass material, wallboard, spackling compound, or plaster. During any use on these materials, it is extremely important that the tool is cleaned frequently by blowing with an air jet.

LUBRICATION

All of the bearings in this tool are lubricated with a sufficient amount of high-grade lubricant for the life of the tool under normal operating conditions. Therefore, no further lubrication is required.

⚠ WARNING! **ALWAYS** wear safety goggles or safety glasses with side shields when using this tool or blowing dust. If operation is dusty, also wear a dust mask.

DOUBLE INSULATION

Double insulation is a concept in safety in electric power tools which eliminates the need for the standard 3-wire grounded power cord. All exposed metal parts are isolated from the internal motor components with protecting insulation. Double insulated tools do not need to be grounded.

TROUBLESHOOTING

PROBLEM	CAUSE	USE	SOLUTION
Laser line is not projected		Laser/LED switch is not in "LASER LINE" position or the tool isn't plugged in.	Make sure to plug in tool and Laser/LED switch is in "LASER LINE" position.
Laser line is hard to see		Working condition is too bright	Use laser enhancing glasses
LED lamp does not light		Laser/LED switch is not in "LED" position or the tool isn't plugged in.	Make sure that plug in tool and Laser/LED switch is in "LED" position.
The scrolling control cannot be turned.		The Orbit/Scrolling lever is not in position 'Scrolling'.	Put the lever into position 'Scrolling'

ACCESSORIES

The following recommended accessories are currently available at your local Sears Store.

⚠ WARNING: The use of attachments or accessories that are not recommended might be dangerous and could result in serious injury.

EXTENSION CORDS

Sears offers a large selection of extension cords that help extend your working range. The use of any extension cord will cause some loss of power. To keep the loss at a minimum and to prevent overheating, use an extension cord that is heavy enough to carry the current that the tool will draw.

A wire gauge (AWG) of at least 14 is recommended for an extension cord 25 feet or less in length. When working outdoors **ALWAYS** use an extension cord that is suitable for outdoor use. The cord's jacket will be marked WA.

⚠ CAUTION! Keep extension cords away from the cutting area and position the cord so it will not get caught on lumber, tools, etc. during the cutting operation..

⚠ WARNING! Check extension cords before each use. If damaged, replace it immediately. **NEVER** use a tool with a damaged extension cord because touching the damaged area could cause electrical shock resulting in serious injury.

BLADES

Sears has a large selection of sabre saw blades for fast, efficient cutting in a variety of materials and applications.

6-in. long, 7 teeth per in.	Fast-cutting wood Blade
3 1/8-in. long, 10 teeth per in.	Fine scrolling in wood
2 3/4-in. long, 20 teeth per in.	Super-fine wood scrolling
3 5/8-in. long, 10 teeth per in.	Super-fine wood scrolling
3 1/2-in. long, 8 teeth per in.	Wallboard, plaster
2 3/4-in. long, 20 teeth per in.	General metal cutting
3 5/8-in. long, 10 teeth per in.	Bi-metal; general wood
3 5/8-in. long, 6 teeth per in.	Bi-metal; fast-cut wood
2 3/4-in. long, 12 teeth per in.	Bi-metal; general metal
3-in. long	"Knife-edge"-linoleum, rubber, leather

Sears also offers Combination Squares, Framing Squares and various length Edge Guides to help you with all your cutting needs.

SABRE SAW WITH LASER TRAC – MODEL NUMBER 320-27245

The Model Number will be found on the Nameplate.

Always mention the Model Number in all correspondence regarding your tool.

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No.	Part No.	Description	Quantity
1	L01311903B	Down enclosure	1
2	L01311902B	Up enclosure	1
3	L00311906A	Internal wire	1
4	L00311907A	Internal wire	2
5	DSJS1901	Brush box	1
6	L07311901A	Carbon brush	2
7	L09311901A	Spring	2
8	L07311903A	Stator	1
9	DSJS1902	Rotor Set	1
10	DSJS1903	Middle holder	1
11	L04310904A	Washer	1
12	L04311911A	Washer	1
13	L04311912A	Washer	1
14	T.02.3.301021	Screw M3x10	2
15	L04311910A	Balance plate-B	1
16	L04311909A	Balance plate-A	2
17	L04311306A	Washer	1
18	L04310102A	Washer	3
19	T04061303	Safety ring	2
20	L05311902A	Pendulum block	1
21	T09208599M	Roller bearing	1
22	DSJS1904	Gear	1
23	L04310903A	Washer	1
24	T04081303	Safety ring	1
25	DSJS1905	Rolling ring	1
26	L01311908A	Scrolling Knob	1

No.	Part No.	Description	Quantity
27	L01311910A	Knob cover	1
28	L01311909A	Bearing holder	1
29	L05311304A	Guiding block	1
30	T0113512211	Screw M3.5x12	2
31	L01311917A	Switch cover	1
32	L03311902B	Front cover	1
33	L04311301B	Bearing slot	1
34	L05311901A	Sliding bearing	1
35	L03311906A	Sliding bearing holder	1
36	T040403021	Washer	1
37	T0113508212	Screw 3.5x8	1
38	L09320904A	Spring	1
39	L06311905A	Pendulum Pin	1
40	L01311926A	Guide Block	1
41	L01311301A	Ring	1
42	T020301231	Screw 3x12	2
43	T04030903	Washer	2
44	T04030302	Washer	2
45	L06311313A	Pin	1
46	L06311302A	Pin	2
47	L01311907A	Transparence guard	1
48	DSJS1906	Sliding shaft assemble	1
49	L01311911A	Back cover	1
50	T011402056	Screw 4x20	17
51	L09311303A	Steel bracket	1
52	L01311923A	Blowing knob	1
53	L03311903A	Up aluminium guard	1

SEE BACK PAGE FOR PARTS ORDERING INSTRUCTIONS.

SABRE SAW WITH LASER TRAC – MODEL NUMBER 320-27245

The Model Number will be found on the Nameplate.

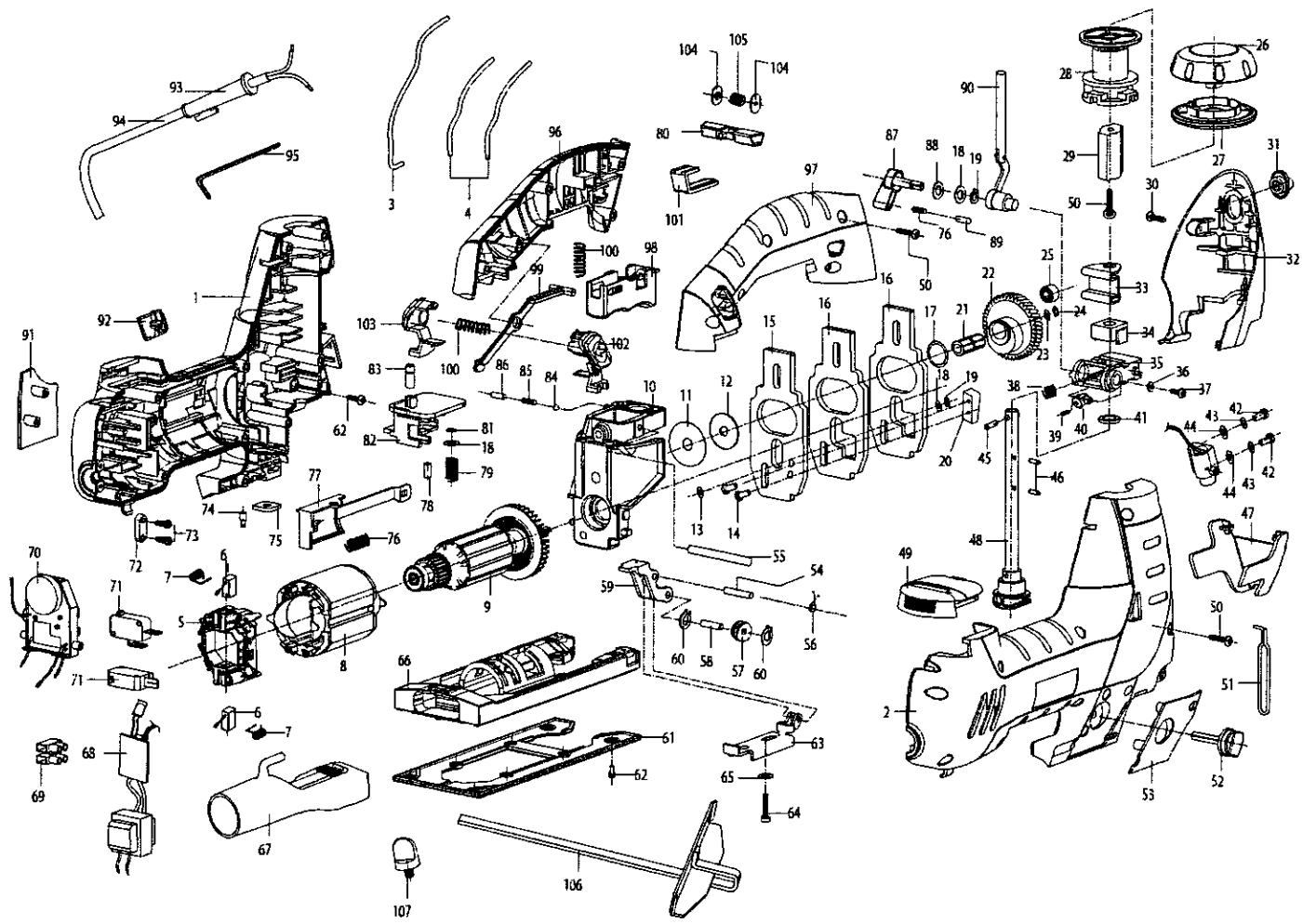
Always mention the Model Number in all correspondence regarding your tool.

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No.	Part No.	Description	Quantity
54	L06311305A	Pin	1
55	L06311312A	Pin	1
56	L09311904B	Spring	1
57	L06311304A	Guide wheel	1
58	L06310106A	Pin	1
59	L04311303A	Guide wheel holder	1
60	T040317031	Safety ring	2
61	L01312006A	Base plate cover	1
62	T013300835	Screw 3x8	12
63	L04311906B	Bracket	1
64	T020402534	Screw 4x25	1
65	L04310902A	Washer	1
66	L03312002A	Base plate	1
67	L99312001A	Adapter for dust collector	1
68	DSJS1907B	Transformer	1
69	L07310405A	Junction port	1
70	L07311904B	Speed adjuster	1
71	T12433201G	Switch	2
72	L01140103A	Anchorage	1
73	T011351621	Screw 3.5x16	2
74	L06310101A	Pin	1
75	L04310502A	Nut	1
76	L09311903A	Spring	1
77	L01311916A	Switch pole	1
78	L01311922A	Active button	1
79	L09311902A	Spring	1
80	L01311914A	Lock of switch	1

No.	Part No.	Description	Quantity
81	T04041703	Safety ring	1
82	L01311920A	Fixing board	1
83	L01311921A	Orientation button	1
84	T07000004	Steel ball	1
85	L09310902A	Spring	2
86	L01030118B	Cap of spring	1
87	L00311904A	Pendulum knob	1
88	L08311301A	Woollen	1
89	L04310911A	Cap of spring	1
90	DSJS1908	Linker assemble	1
91	L03311904A	Down aluminium guard	1
92	L01311915A	Switch button	1
93	L02310101A	Cable guard	1
94	T146D96051	Cord and plug	1
95	L99310102A	Hexagon wrench	1
96	L01311905B	Down handle	1
97	L01311904B	Up handle	1
98	L01311912A	Switch button	1
99	L03311905A	Switch pole	1
100	L09321201A	Spring	2
101	L04311905A	Connecting piece	1
102	L01311918A	Up handle locking button	1
103	L01311919A	Down handle locking button	1
104	L01311404A	Limiting piece	2
105	L09311401A	Spring	1
106	L99310901A	edge guide	1
107	L99311705C	Locking knob on guide	1

SEE BACK PAGE FOR PARTS ORDERING INSTRUCTIONS.



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