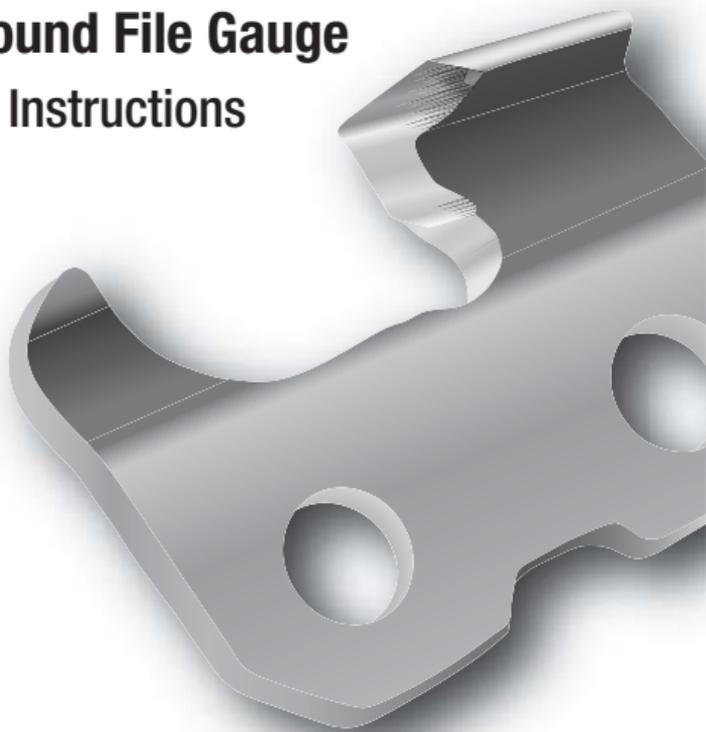


ATOP Racing Cut®

**Square Ground File Gauge
Sharpening Instructions**



Operator's Manual

Safety Instructions

WARNING!

- Please read the operator's manual carefully.
- The file gauge is designed for sharpening saw chains. All other use is not recommended.
- Always wear protective gloves, and eye protection when sharpening.
- Do not modify the file gauge or use it if it appears to have been modified by others.
- The risk of kickback is increased with a badly sharpened chain.
- The risk of kickback is increased if the depth gauge setting is too large.
- Never allow children to use the file gauge.
- Chainsaws can be dangerous. Careless or incorrect use can result in serious or fatal injuries to the operator or others. Never use a chainsaw without proper training! Read the operator's manual supplied with the chainsaw before use.

Thank you for choosing Atop Square Ground File Gauge!

The Atop Square Ground File Gauge is the ultimate tool for sharpening saw chains!

Advantages and Benefits

- Increased cutting speed
- Saved time re-sharpening
- Reduced fuel consumption
- Reduced vibrations
- Reduced kickback

ECO Cutting

A sharp saw chain enables high cutting speed at 70-80% of maximum output, which reduces fuel consumption.

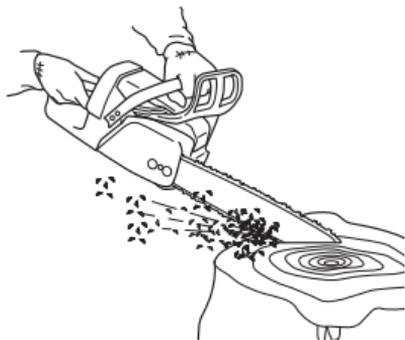
When to Sharpen?

- When the chain no longer self-feeds.
- When the saws discharge is dusty.
- When the chain looks shiny.

Preparations

Clean the Chain

- Clean the chain from oil, dirt, and debris by cutting in non valuable wood before sharpening.
- Make sure that the chain is undamaged.



Secure the Chain and Bar

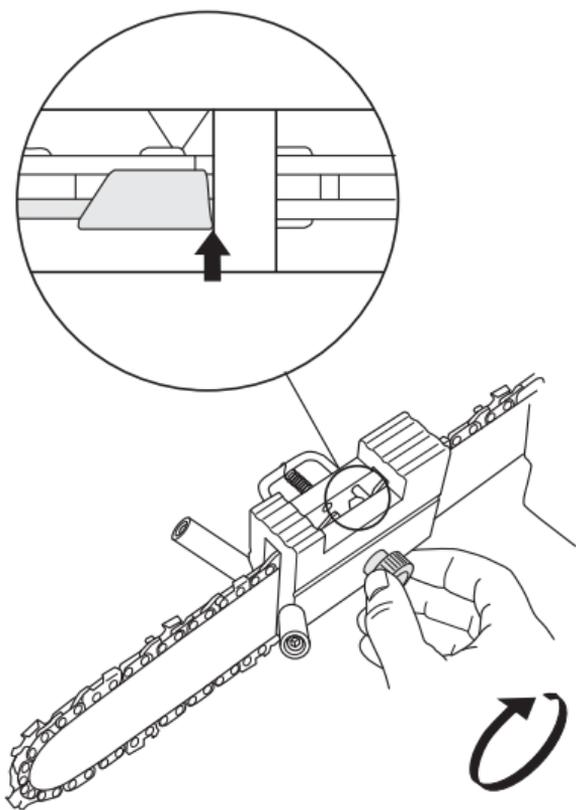
- Make sure the chain is properly tensioned.
- Secure the guide bar firmly.



Preparations

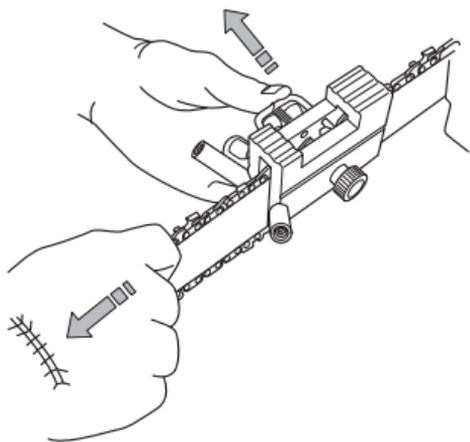
Set the File Gauge

- Place the file gauge over the chain with the lock pin behind a cutter.
- Let the guide bar rest against the spacer pins and tighten the locking screw firmly.

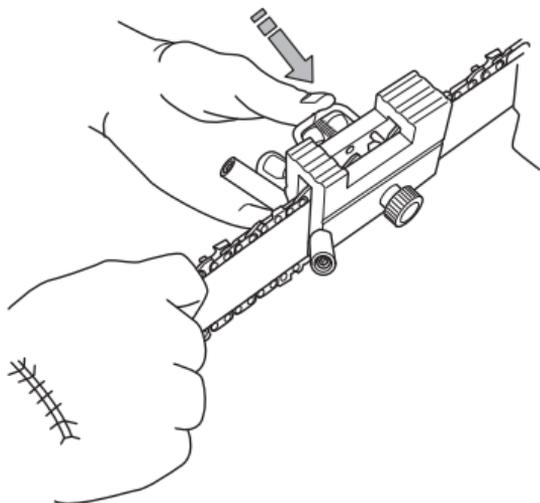


Preparations

- Pull the locking pin to move the chain.



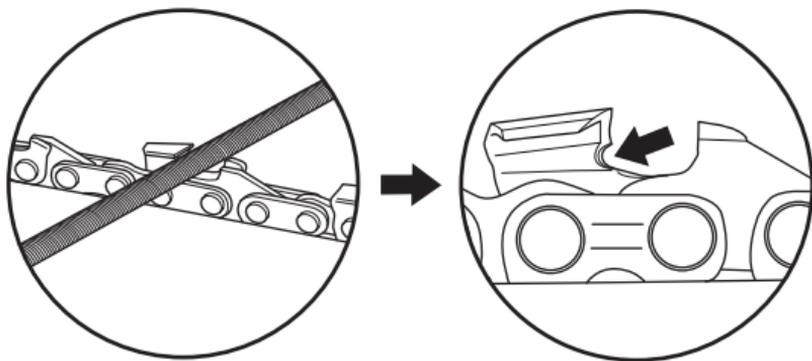
- Place the lock pin behind next cutter and release the locking pin.



Sharpen the Chain

Clean out the Gullet Area

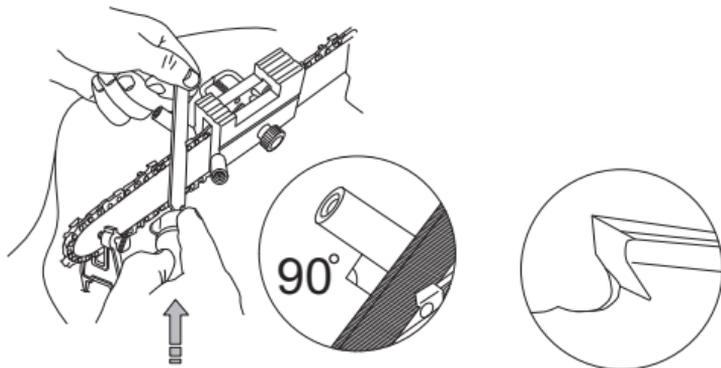
- Clean out gullet area using a round file (4 mm, 1/8”).
- A clean gullet area increases the space for the saw dust to evacuate which contributes to increased cutting speed.
- It also opens the area for the flat file to move when sharpening the cutter.



Sharpen the Chain

Sharpen the Cutter

- Let the flat file rest against the support rollers at a 90° angle.
- Hold the file with both hands.
- File from outside the cutter to inside using full strokes. By filing from the outside in, the edge of the cutter becomes stronger which prevents the edge from cracking.

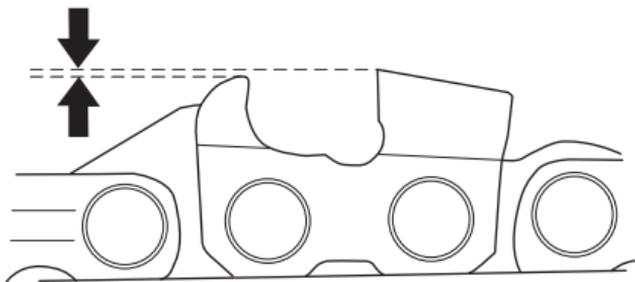


- The file will sharpen the top plate and the side plate simultaneously. An angle of about 90° between support rollers and flat file gives a top plate angle of 20-25° and a side plate of 85-90°.
- File each cutter, on both the right, and left-hand, until you've removed all signs of damage. Use approximately 8-10 file strokes on a new chain.
- A chain can be re-sharpened about 3-5 times.

■ Depth Gauge Setting

Adjust the Depth Gauge Setting

- Check the depth gauge setting after sharpening.
- The depth gauge setting should be about 0,4-0,5 mm (0,016"-0,020").
- The depth usually needs to be adjusted after re-sharpening the chain a few times.



⚠ WARNING!

The risk of kickback is increased if the depth gauge setting is too large.

Accessories

Vallorbe LC2270-7 – Flat File

The Vallorbe LC2270-7 flat file is especially developed for sharpening saw chains.

Racing Kit

The Racing Kit support rollers are designed for faster cutting performance.

The 13 mm polyamid rollers give a 30° top plate angle and a 90° side plate angle.

Assembly of New Rollers

- Remove the M4 bolts using an allen key. (Use a hot air gun to loosen the locking varnish if necessary.)
- Clean the threads with a tap, and the screw with a die if necessary.
- Apply new locking varnish on the thread and tighten the bolts. Be careful not to over tighten. Make sure that the rollers have free play.
- Let the locking varnish dry before use.

Test your Memory!

See how well you remember what you have learned about sharpening saw chains using Atop Square Ground File Gauge!

1. Is it important to clean the chain before sharpening?

- Yes No

2. The chainsaw must be properly secured before sharpening?

- Yes No

3. A saw chain can be re-sharpened any number of times?

- Yes No

4. A clean gullet area increases the space for the saw dust to evacuate and opens area for the flat file to move?

- Yes No

5. The risk of kickback is increased if the depth gauge setting is too large?

- Yes No

6. A sharp chain increases fuel consumption?

- Yes No

