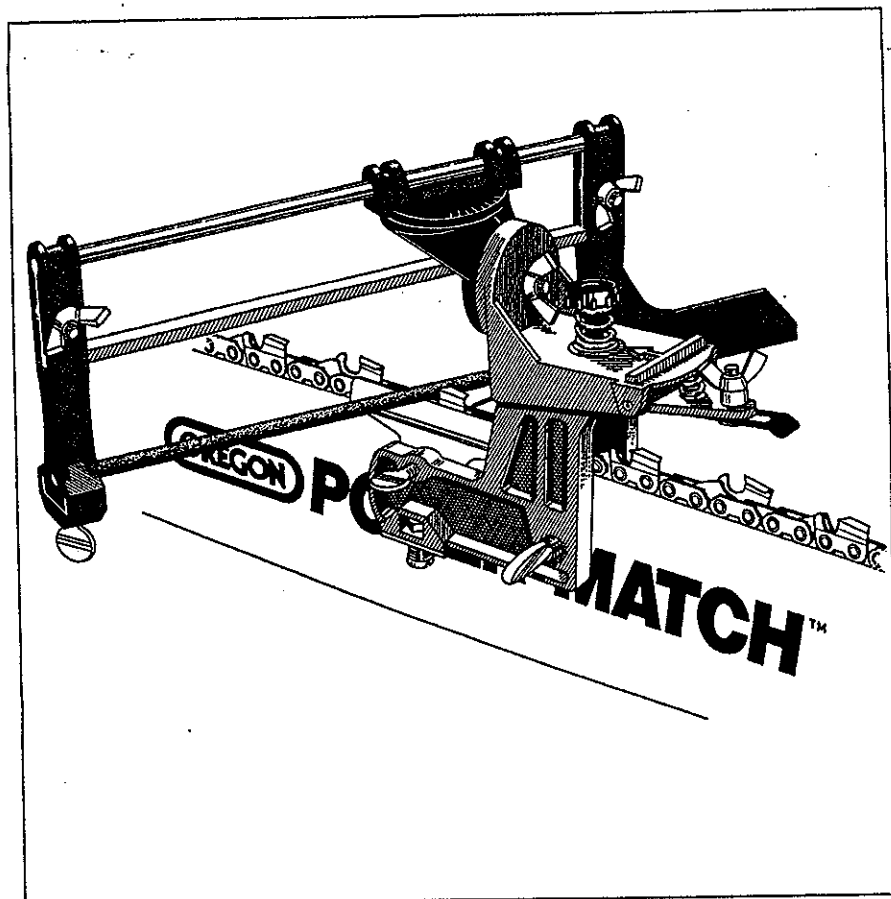




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PROFESSIONAL FILING GUIDE
GUIDE-LIME PROFESSIONNEL
TECHNISCHE FEILENFÜHRUNG
PROFESSIONELL FILSTYRARE
GUIA PROFESIONAL PARA LIMAS
GUIDA PER LIMA PROFESSIONALE
AMMATTIKÄYTTÖÖN TARKOITETTU VIILANOAJAUSLAITE
VIJLGELEIDER VOOR DE VAKMAN



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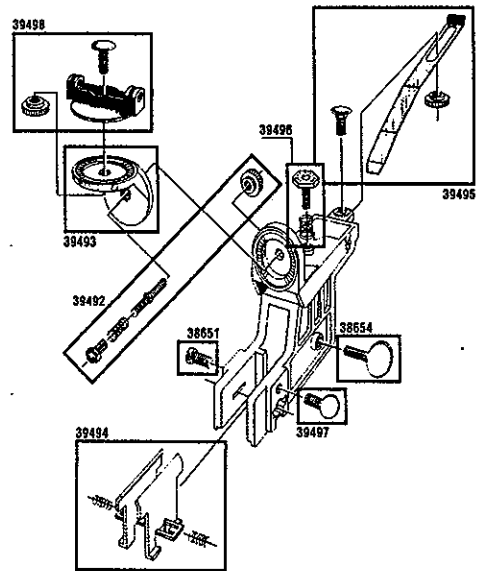
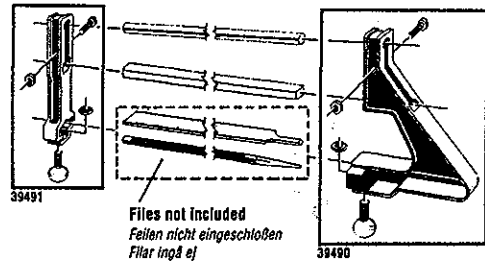
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HECHO EN ITALIA

Replacement Parts

Ersatzteile Reservdelar Pieces de remplacement Piezas de repuesto



58-59AC, CP	7/32" 5.5mm	.030" .75mm	90°	35°	90°	?	MICRO BIT®
20-21-22BP	3/16" 4.8mm	.025" .65mm	10°	30°	85°	7	MICRO CHISEL®
25AP	5/32" 4.0mm	.025" .65mm	10°	30°	85°	7	MICRO CHISEL®
26(A)(P), 27(A)(P)	7/32" 5.5mm	.030" .75mm	10°	35°	85°		
20-21-22LP	3/16" 4.8mm	.025" .65mm	10°	25°	60°	7	ROUND GROUND CHISEL
33-34-35LG, SL	5/32" 4.0mm or 4.5mm	.025" .65mm	10°	25°	60°		
50-51-52L	7/32" 5.5mm	.025" .65mm	10°	25°	60°	7	ROUND GROUND CHISEL
58-59LG, JG	7/32" 5.5mm	.025" .65mm	10°	25°	60°		
72-73-75JG, JP, LG, LP	7/32" 5.5mm	.025" .65mm	10°	25°	60°		
72-73-75V	4.5mm	.030" .75mm	10°	25°	60°		
72AP/72-73-75D, DP	7/32" 5.5mm	.025" .65mm	90°	35°	85°	7	SEMI-CHISEL
72DJ/72-73-75DD, SG	3/16" 4.8mm	.030" .75mm	90°	30°	85°		
91VG, 91VS	5/32" 4.0mm	.025" .65mm	90°	30°	80°		
28-27R, RA	7/32" 5.5mm	.030" .75mm	10°	10-15°	75°	7	RIPPING CHAIN
72-73-75RD	7/32" 5.5mm	.025" .65mm	10°	10-15°	75°		
52AX/50-51-52AJ, AL 72-73-75CJ, CJX, CK, CKX, CL, CLX		.025" .65mm	45°	15°	90°	7	SQUARE GROUND CHISEL
16H	7/32" 5.5mm	.050" 1.2mm	10°	35°	85°	7	MICRO CHISEL®
18H	7/32" 5.5mm	.050" 1.2mm	10°	35°	85°		

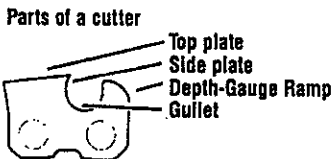
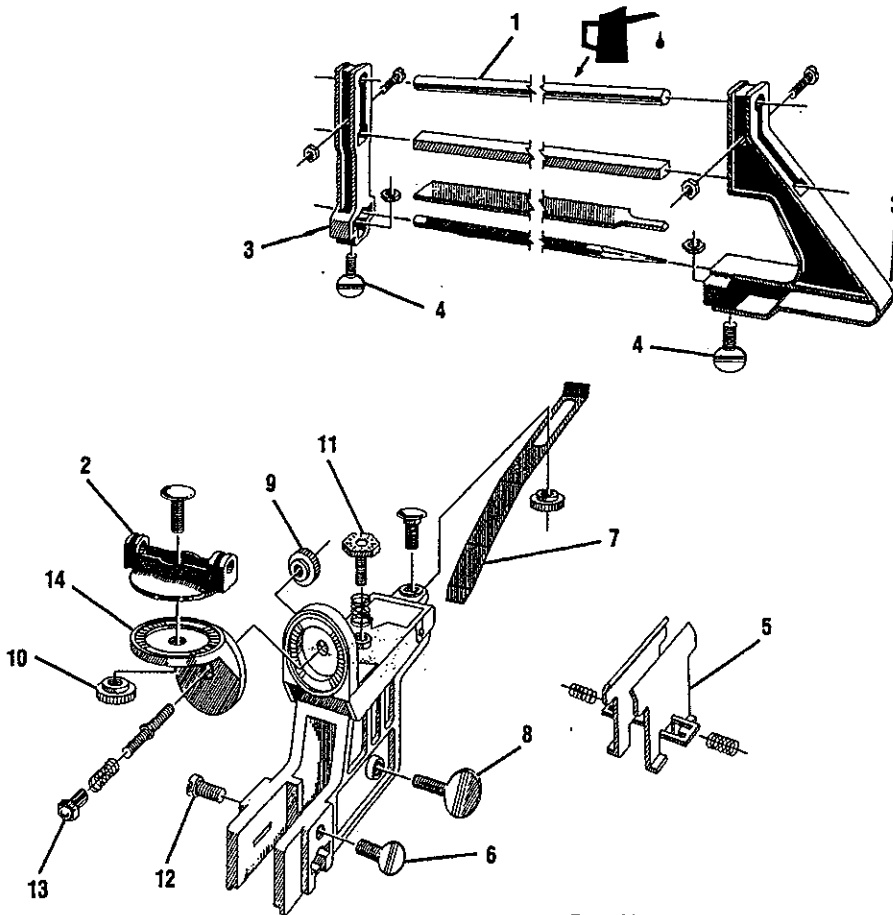
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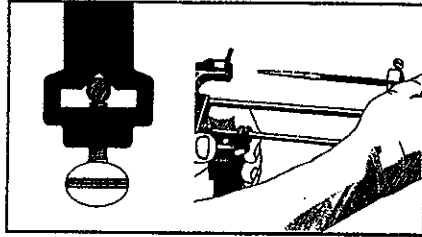
Parts List

- 1 Slide Rod
- 2 Guide Swivel
- 3 File Holder
- 4 Thumb screw (small)
- 5 T-bars
- 6 Thumb screw (medium)
- 7 Chain stop
- 8 Thumb screw (large)
- 9 Swivel knob (a)
- 10 Swivel knob (b)
- 11 Depth adjustment screw
- 12 Slotted screw
- 13 Stop screw
- 14 Tilt and swivel base

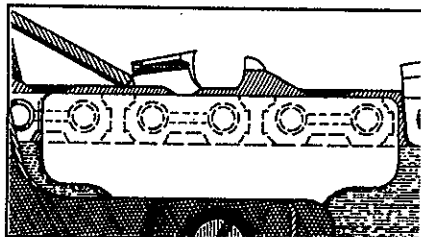
Chain Filing Chart

9-10 AC 57-58-59AC, CP	1/4" 6.3 mm 7/32" 5.5 mm	.040" 1.02 mm .030" .75 mm	0° 0°	35° 35°	90° 90°	7 CHIPPER & MICRO BIT*
20-21-22BP 25AP 26(A)(P), 27(A)(M)(P), 28(A)	3/16" 4.8 mm 5/32" 4.0 mm 7/32" 5.5 mm	.025" .65 mm .025" .65 mm .030" .75 mm	10° 10° 10°	30° 30° 35°	85° 85° 85°	7 MICRO CHISEL*
20-21-22LP, JP 33-34-35LG, SL 50-51-52LP 57-58-59LG, JG 72-73-75JG, JP, LG, LP 76-77-78LG, SL	3/16" 4.8 mm 4.5 mm 7/32" 5.5 mm 7/32" 5.5 mm 7/32" 5.5 mm 4.5 mm	.025" .65 mm .025" .65 mm .025" .65 mm .025" .65 mm .025" .65 mm .030" .75 mm	0° 0° 0° 0° 0° 0°	25° 25° 25° 25° 25° 25°	60° 60° 60° 60° 60° 60°	7 ROUND GROUND CHISEL
72AP/72-73-75D, DP 72DJ/72-73-75DG, SG 91G, 91S, 91SG	7/32" 5.5 mm 3/16" 4.8 mm 5/32" 4.0 mm	.025" .65 mm .030" .75 mm .025" .65 mm	0° 0° 0°	35° 30° 30°	85° 85° 85°	7 SEMI-CHISEL
26-27R, RA 72-73-75RJ, RL	7/32" 5.5 mm 7/32" 5.5 mm	.030" .75 mm .025" .65 mm	10° 0°	10-15° 0°	75° 50°	7/7 RIPPING CHAIN

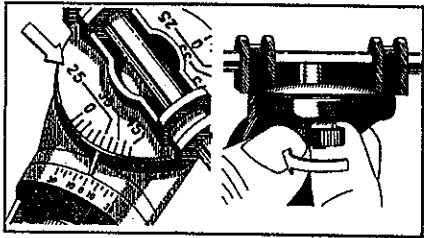
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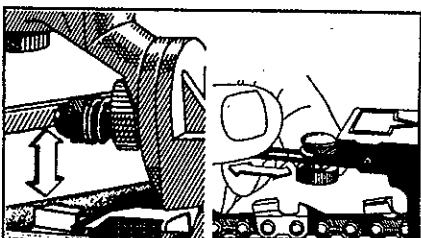
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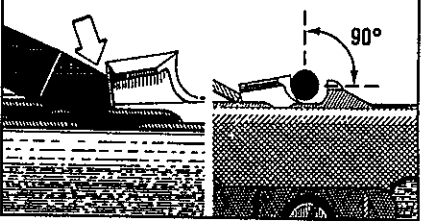
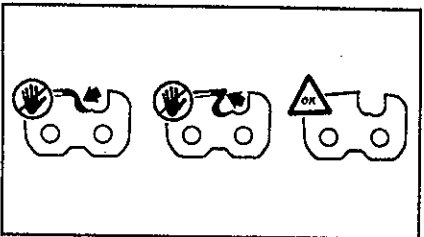
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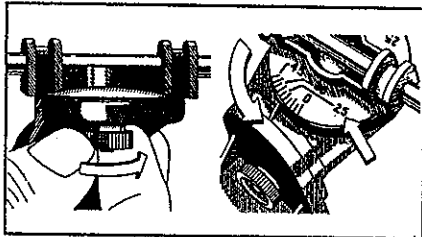
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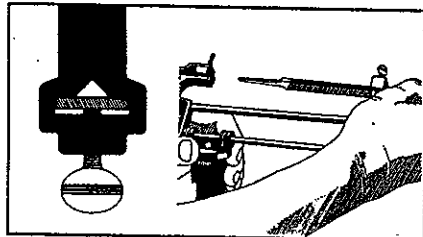
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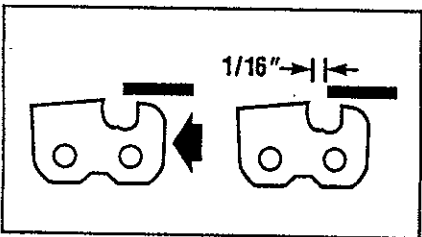
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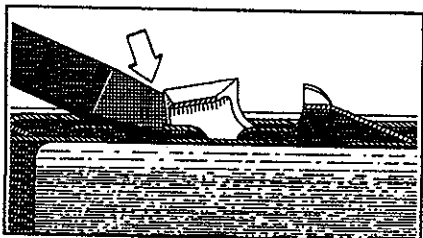
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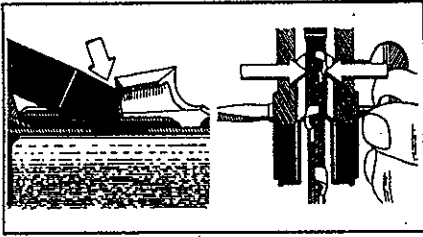
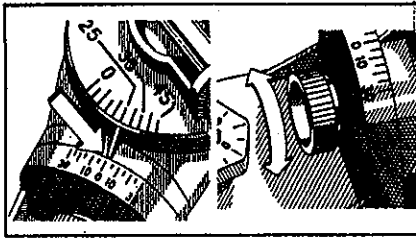
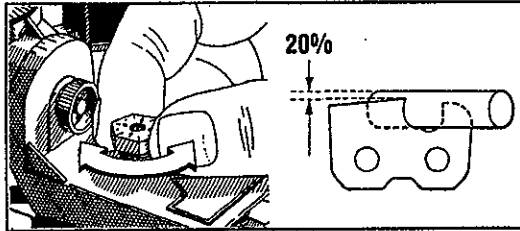
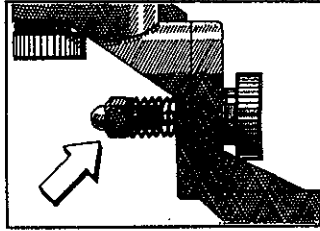
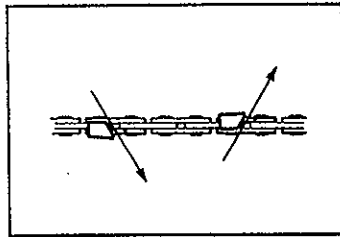
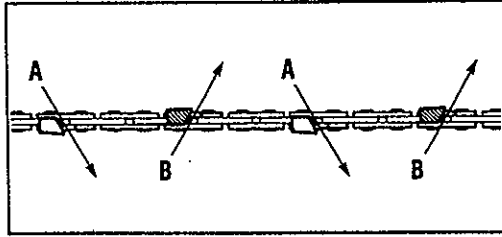
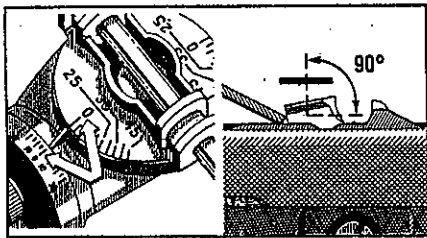
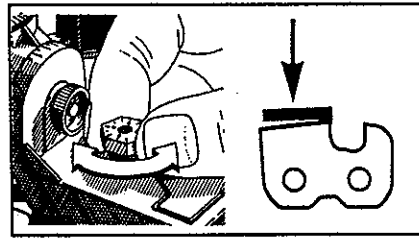
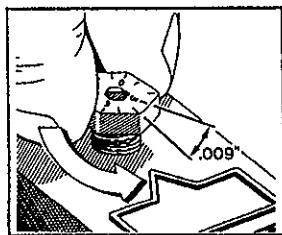
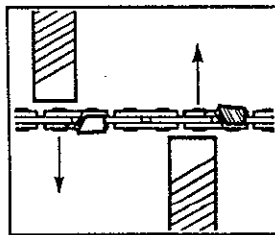
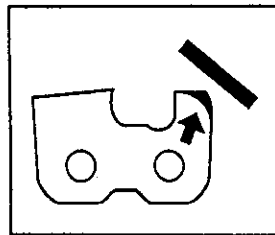


P



Q



C**D****G****H****J****K****N****O****R****S****T**

ENGLISH

WARNING

Incorrect sharpening of angles, excessive depth-gauge settings or incorrectly shaped depth-gauges may increase the risk of chain saw kickback. Follow all instructions for depth-gauge setting and cutter filing angles. Kickback can result in severe injury to the saw operator or to bystanders.

Safety Information

- Always wear gloves and eyewear for protection when using this tool.
- Always work on a clean, flat working surface.
- Secure to chainsaw guide bar before sharpening.
- Check components on file guide regularly for wear and general condition.



Assembly Instructions

File guide comes fully assembled. See exploded view of product. (Oregon® Round files and flat depth gauge file not included; purchase separately.)

HINT: Oil rod (1) at guide swivel (2) for better movement of file guide assembly.



MOUNTING AND SET UP

- Select the proper file size for the chain to be sharpened (see chain filing chart).
- Insert the file into the chain-file holder (3) and secure by tightening both locking thumb screws (4). See A.
- Mount file guide assembly on to the guide bar so that the chain guide T-bars (5) are flush with the top of the rivets. Tighten assembly with locking thumb screw (6). See B.
- Position back of cutter against chain stop (7). See C.
- Secure the T-bars (5). Adjust chain position using thumb screw (6) and slotted screw (12). See C.

Operating Instructions

TO SET CUTTER ANGLES

- Step 1.** Set the tilt and swivel base (14) to either the "0°" to "10°" angle marks. See chain filing chart for proper degree mark setting. See D.
Lock into place using swivel knob (9).
- Step 2.** Set top guide swivel (2) and lock into position with swivel knob (10). See chain filing chart for proper degree mark setting. See E.
- Step 3.** Insert file into the gullet of the cutter, making sure file assembly is positioned at 90° to the guide bar (5). Lock chain stop (7) to back of cutter. See F.
- Step 4.** Set file height by turning the depth adjustment screw (11) so that 1/8th (approx. 20%) of file diameter is above the top plate of the cutter. See G.
- Step 5.** Adjust the stop screw (13) to control the amount of cutter to be filed. See H.
See illustration I for proper cutter shape.

FILING

- Step 6.** File all cutters from the inside to the outside. See J. File one side of the chain at a time. See K.
NOTE: File performance is greatly reduced if filed against chrome plating on the outside of cutters.
- Step 7.** To sharpen cutters on the opposite side of chain, unlock swivel knob (10) and rotate swivel guide (2) 180°; reset angles shown in steps 1-5 of Operating Instructions and repeat filing process. See L.

DEPTH GAUGE FILING

- NOTE:** Every 2 to 3 chain sharpenings, it is necessary to file the depth gauges.
- Step 8.** Remove round file and replace with flat depth-gauge file. See M.
(Oregon P/N 12211—not supplied).
- Step 9.** Set both filing angles to "0°" so that the file is 90° to the guide bar. See N.
- Step 10.** Turn depth-adjusting screw (11) and lower file until it rests on the top plate of the cutter. See O.
- Step 11.** Move cutter backwards until file is directly above the depth gauge. See P.
Position file approximately 1/16" (1.6mm) away from the cutting edge of the cutter to protect the edge from damage during this step.
- Step 12.** Position the chain stop (7) against the back of the cutter to maintain cutter position. See Q.
- Step 13.** Rotate depth-adjustment screw (11) counter-clockwise to the recommended depth-gauge setting. See depth-gauge on chain filing chart. See R.
- NOTE:** Each increment mark on depth-adjustment screw (11) equals 0.009" of file travel.
- Step 14.** Always file depth gauges so filing stroke is from the inside to the outside.
File all depth gauges on one side of the chain, then rotate swivel guide (2) 180° reset same angles for opposite side of chain and repeat filing process. See S.
- Step 15.** After each depth gauge has been filed to the recommended height, round off front corner to original shape by free-hand filing. See T.

