

Saw Chain Sharpening

⚠ CAUTION: Sharp chain. Always wear protective gloves when handling the chain. The chain is sharp and can cut you when it is not running.

⚠ WARNING: Sharp moving chain. To prevent accidental operation, insure that the tool is unplugged before performing the following operations. Failure to do this could result in serious personal injury.

To get the best possible performance from your chain saw it is important to keep the teeth of the chain sharp. Follow these helpful tips for proper saw chain sharpening:

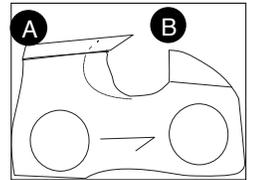
1. For best results:

- Use a 4mm file and a file holder or filing guide to sharpen your chain.
- REMOVE CHAIN AND BAR FROM SAW BEFORE SHARPENING AS CHAIN GUARDS WILL INTERFERE WITH SHARPENING PROCESS.
- Hold the chain bar in a vice and then place the chain on it (vice is a means to help hold the bar and the bar to hold the chain).

2. Place the file holder flat on the top plate and depth gauge of the cutter.

3. **(Figure 1)** Keep the correct top plate (A) filing angle line of 30° on your file guide parallel with your chain (file at 60° from chain viewed from above).

4. **(Figure 2)** Sharpen cutters (B) on one side of the chain first. File from the inside of each cutter to the outside. Then turn your saw around and repeat the processes (2,3,4) for cutters on the other side of the chain. Use a flat file to file the tops of the rakers (portion of chain link in front of the cutter) so that they are about .025" below the tips of the cutters.



5. **(Figure 3)** Keep all cutter lengths equal.

6. If damage is present on the chrome surface of the top plates or side plates, file back until such damage is removed.

⚠ CAUTION: After filing, the cutter will be sharp, use extra caution during this process.

NOTE: Each time the chain is sharpened, it loses some of the low kickback qualities and extra caution should be used. It is recommended that a chain be sharpened no more than four times.

