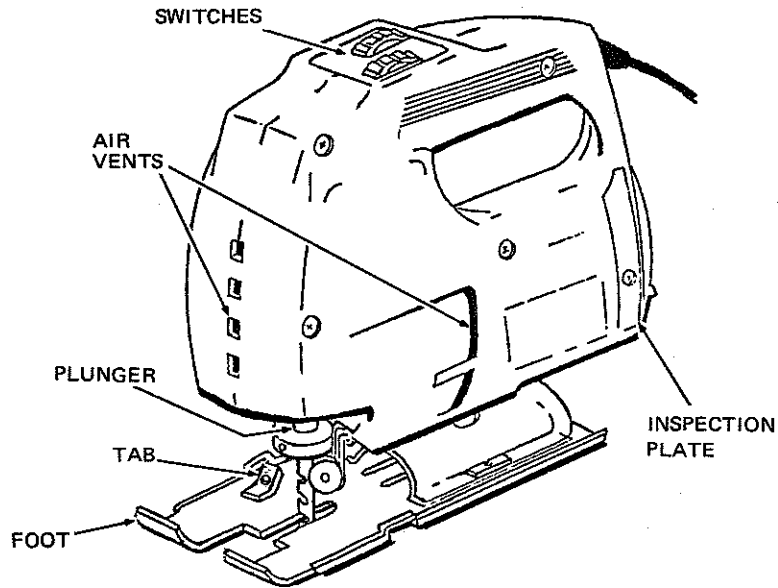


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SKILSAW®

MODEL 158 JIG SAW DOUBLE INSULATED



INSTRUCTION MANUAL

SKIL CORPORATION 4801 W. PETERSON AV. CHICAGO, IL. 60646

F-313039

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BEFORE CONNECTING YOUR TOOL TO A POWER SOURCE

Be sure you have read all safety rules and understand all the instructions in this manual for safe operation of the tool.

1. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
2. **AVOID DANGEROUS ENVIRONMENT.** Don't use power tool in damp or wet locations. Keep work area well lit. Do not expose power tool in rain.
3. **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from work area.
4. **STORE IDLE TOOLS.** When not in use, tools should be stored in dry, high or locked-up place—out of the reach of children.
5. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
6. **USE RIGHT TOOL.** Don't force small tool or attachment to do the job of a heavy-duty tool.
7. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.
8. **USE SAFETY GLASSES.** Use safety glasses with most tools. Also face or dust mask if cutting operation is dusty.
9. **DON'T ABUSE CORD.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.
10. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
11. **DON'T OVERREACH.** Keep proper footing and balance at all times.
12. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
13. **DISCONNECT TOOLS.** When not in use; before servicing; when changing blades, bits, cutters, etc.
14. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
15. **AVOID ACCIDENTAL STARTING.** Don't carry plugged-in tool with finger on switch. Be sure switch is OFF when plugged in.
16. **OUTDOOR USE EXTENSION CORDS.** When tool is used outdoors, use only extension cords suitable for use outdoors and so marked.
17. **WARNING!** Electrical repairs should be attempted only by trained repairmen. Contact the nearest SKIL Service Center or other competent repair service."

PRELIMINARY INSTRUCTIONS

Your electric tool is precision built and manufactured to satisfy the highest standards. For maximum performance, long tool life, and your safety, follow these instructions carefully.

VOLTAGE WARNING: Before connecting the tool to a power source (receptacle, outlet, etc.) be sure the voltage supplied is the same as that specified on the nameplate of the tool. A power source with voltage greater than that specified for the tool can result in **SERIOUS INJURY** to the user—as well as damage to the tool. If in doubt, **DO NOT PLUG IN THE TOOL**. Using a power source with voltage less than the nameplate rating is harmful to the motor.

DOUBLE INSULATION: Your new SKIL tool is equipped with a two wire cord and two prong plug which can be used in standard 120V A.C. outlets.

No grounding of the tool is necessary. The housing is made of a dielectric material which protects the operator in case of failure of the standard functional insulation within the electrical system. When servicing, use only identical replacement parts.

WARNING: Certain cleaning agents and solvents can damage plastic parts. Some of these are; gasoline, carbon tetrachloride, chlorinated cleaning solvents, ammonia and household detergents that contain ammonia. Avoiding use of these and other types of cleaning agents will minimize the probability of damage.

EXTENSION CORDS: When using an extension cord be sure to use one heavy enough to carry the current your tool will draw. An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating. The following table shows the correct size to use depending on cord length and nameplate amperage rating. If in doubt, use the next heavier gage. **Note:** The smaller the gage number, the heavier the cord. Repair or replace damaged or worn cord immediately.

Recommended Minimum Gage for Cord Extensions for Portable Electric Tools

Ampere Rating Range	Volts	Length of Cord in Feet								
	120V	25 Ft.	50 Ft.	100 Ft.	150 Ft.	200 Ft.	250 Ft.	300 Ft.	400 Ft.	500 Ft.
	240V	50 Ft.	100 Ft.	200 Ft.	300 Ft.	400 Ft.	500 Ft.	600 Ft.	800 Ft.	1000 Ft.
0-2		18	18	18	16	16	14	14	12	12
2-3		18	18	16	14	14	12	12	10	10
3-4		18	18	16	14	12	12	10	10	8
4-5		18	18	14	12	12	10	10	8	8

SPECIFICATIONS

Capacity	2" in soft wood
.....	1-1/4" in hard wood
.....	3/8" in soft metals
Length of Stroke	3/16" in steel
	3/4"

SWITCHES

Your jig saw is equipped with both a slide switch and a speed control dial. The slide switch has three positions; Off, On, and High. The ON position allows use of the speed control dial to select the speed best suited for the job. The HIGH position provides the top cutting speed of the saw without the necessity of setting the speed control dial.

PREPARING THE JIG SAW

Inserting the Blade—Figure 2: 1. Make sure switch is in off position. 2. Disconnect cord. 3. Loosen the two set screws in the collar with the hex wrench provided, remove and discard filler blade. 4. Insert a cutting blade as far as it will go in the slot. Make sure teeth face out. 5. Tighten each set screw to secure blade. **Do not use canted blades.**



TO ADJUST FOOT—Figure 3: Disconnect cord, turn the saw upside-down and loosen the 4 phillips head screws located in the foot. Hold the saw firmly with one hand and slide the foot with the other. Slide the foot to the desired position described below; then tighten the 4 screws firmly.

NOTE: When moving foot to splinter free cutting position; make sure blade is centered in slot..

Splinter Free Cutting: Position the foot all the way forward when minimum of splintering is required. Use only taper ground blades. Set tooth blades may not clear the slot.

General Cutting: This position is for preliminary or rough cutting. Either taper ground or set tooth blades can be used.

Bevel Cutting: Slide the foot toward the back of the saw and adjust to the desired angle from 0° to 45°. A sample cut should be made to check out exact angle of cut.

JIG SAW APPLICATIONS

Hold the saw firmly, exerting pressure downwards to keep saw foot flat against the work. At the same time, push tool slowly in the direction of cut. **DO NOT FORCE. Let the saw do most of the work.** If the teeth appear to rub and wear without cutting, you may be forcing the saw, and blade breakage may occur. As you cut, it may be necessary to adjust the work in the vise or to relocate the clamps. Cut close to the line, unless you want to leave stock for finish sanding. **Do not operate saw without a blade.**

Free Hand Sawing: Draw your lines or design on the material. Secure the work in a bench vise or clamp it down. Place the front edge of the foot on the work. Line up the blade with the line to be cut.

Straight Cutting with Straightedge: To make a straight cut: 1. Position front edge of foot on the work with blade at the line of cut. 2. Place a mark on the work at the inside edge of foot. 3. Clamp a piece of wood (straightedge) on the work lined up with the mark and parallel to line of cut. 4. Position the jig saw foot against the inside of the straightedge, see Figure 4. This position should place your jig saw blade at the line of cut. 5. Make sure to keep the saw foot edge flush against the straightedge and flat on the work for the length of the cut.

Plunge Cutting in Soft Materials—(Figure 5): It is not necessary to use a drill for starter holes on inside cuts with your Jig Saw. Plunge cutting is very useful and time saving when openings for electrical fixtures, pipes, vent, etc. are required.

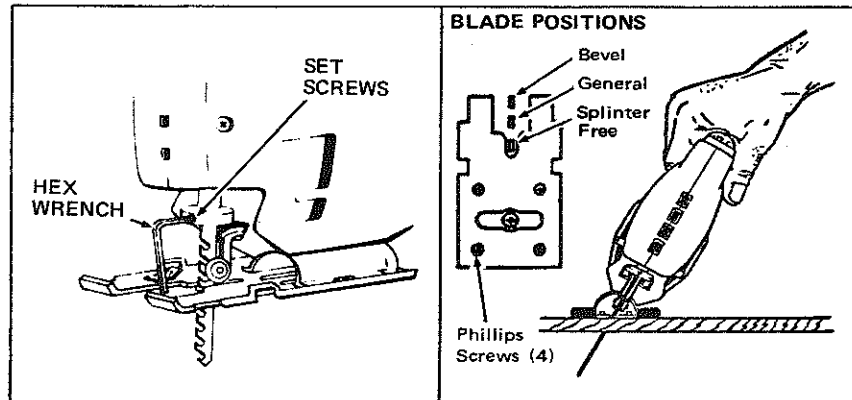


Figure 2. Inserting Blade

Figure 3. Bevel Cutting.

Tilt the saw forward until the blade clears the work. With the toe of the foot held firmly in position, start the motor and very gradually lower the saw blade into the work. When the blade touches the work, continue to maintain pressure on the toe of the foot and slowly pivot the tool downwards with a hinge-like motion as shown in Figure 5, until the blade cuts through and the foot rests flat on the material. Then saw ahead on the marked line.

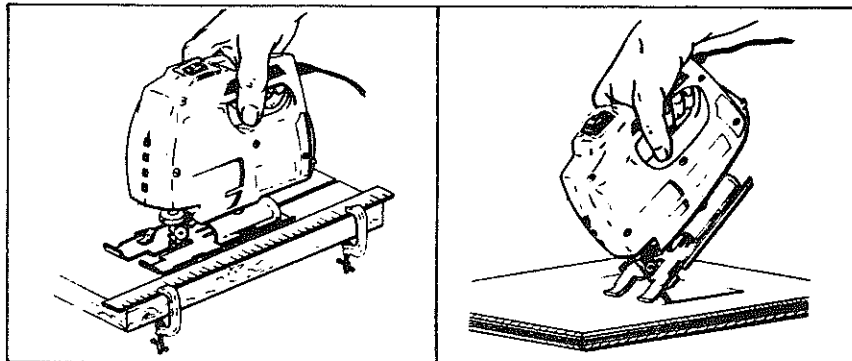


Figure 4. Use of Straightedge

Figure 5. Plunge Cutting

If sharp corners are desired, cut right up to the corner, back off a little, and round the corner. Continue cutting to the next corner and follow the same procedure. After the opening is complete, go back and square off each corner by cutting up to it in the opposite direction.

Scroll Cutting: In scroll or curved cutting, using the right blade is important. Sharp turns require narrower blades than wide turns or curves.

Metal Cutting—(Use Low Speed): Many kinds and types of metals can be cut with your jig saw, but be careful not to twist or bend the blade. Above all, **DO NOT FORCE** the blade. If the blade chatters or jumps excessively, use a finer toothed blade, or select a more efficient speed. If the teeth become clogged when cutting soft metal, use a coarser toothed blade.

When sawing aluminum extrusion or angle iron, clamp the material in a bench vise, if possible, and saw close to the vise jaws.

When cutting tubing, and the diameter is larger than the depth of the blade, cut thru tubing wall and insert the blade into the cut. Cut through the wall as the tube is rotated.

Thin metal materials are cut easier "sandwiched" between two pieces of wood. Draw the design on the "sandwich." One piece of wood on top of the metal being cut can be used effectively with adequate clamping.

For easier metal cutting, lubricate the blade. A cutting wax in stick form is convenient to use and will keep the blades cool and cutting freely. If this wax is not available, use kerosene when cutting aluminum and cutting oil when cutting steel.

RIP FENCE

Use this handy accessory (optional at extra cost) for fast and accurate straight and circle cutting. The rip fence permits straight cuts up to 6" from the edge of the board, and circle cuts from 3" to 13" diameter.

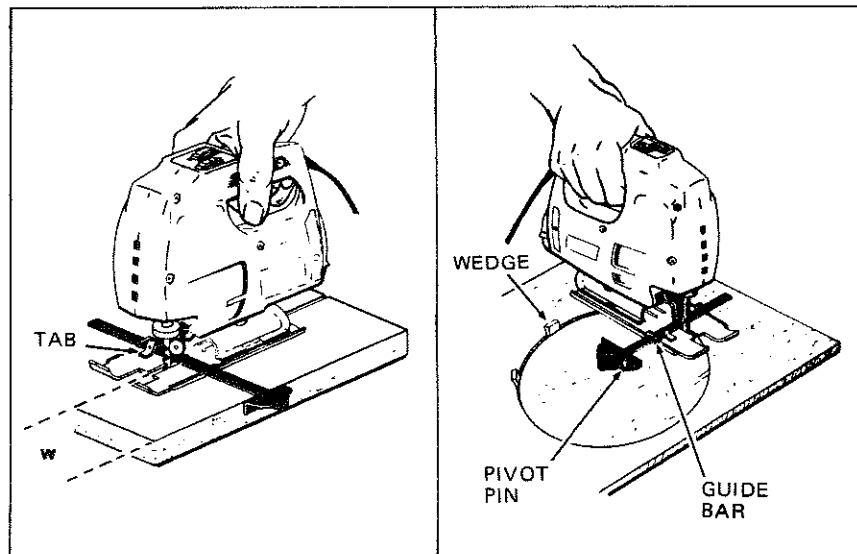


Figure 6. Rip Fence

Figure 7. Circle Cutting

Straight Cutting with Rip Fence—(Figure 6): 1. Thread screw provided with accessory into tab. 2. Slide rip fence bar from either side under tab with edge guide face down. 3. Determine the width of cut that you want and adjust rip fence. The width of cut (w) is equal to the distance from the inside of the blade to the inside of the rip fence edge guide. 4. Tighten screw to lock rip fence in desired position. 5. To insure true accurate cuts, make sure that the edge guide is always in contact with the piece being cut.

Circle Cutting with Rip Fence: The distance between the saw blade and the front center hole on the rip fence edge guide equals the radius of a circle.

NOTE: The rip fence edge guide has two sets of five holes each. The center hole marked "A" of the set facing the direction of cut (front) is used in circle cutting. The edge guide faces up when circle as cutting shown in Figure 7.

To circle cut with rip fence: 1. Draw circle and drive pivot pin into center. 2. Drill or plunge cut a starting hole near the circle edge. Start from inside the circle line if making a hole; plunge cut from outside of the line if making wheels or discs. 3. Guide your saw to the circle line; turn tool off with saw still on the work. 4. Place rip fence in position and place a mark on the rip fence bar flush with saw foot. 5. Remove saw from the work. Attach rip fence clamp and tighten screw from under side of saw foot keeping the marked rip fence in place. 6. Reposition the saw on the work as in step 3 and proceed to cut. Continue until about 3/4 of the circle has been cut, or until the disc appears unsteady, insert wedges in the work at intervals and finish cut.

CAUTION: The use of any other accessories not specified in this manual may create a hazard.

PREVENTIVE MAINTENANCE

Preventive maintenance of your Skil Saw is very easy. There are just 3 simple steps below to follow:

1. After each use: Disconnect the power plug from the outlet. Clean deposits of dust and dirt from around the air vents and wipe the cord to prevent deterioration from oil and grease.
2. The gear case has been completely lubricated at the factory, however, after six months to one year, depending upon use, you should return your tool to the nearest Skil Service Center for the following:
 - Brushes replaced.
 - Parts cleaned and inspected.
 - Relubricated with fresh lubricant.
 - Electrical System tested.
 - All repairs.

SKIL FACTORY SERVICE CENTERS

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ARIZONA : Phoenix; Flagstaff	ARKANSAS : Fayetteville; Hot Springs
CALIFORNIA : Bakersfield; Eureka; Redding; Santa Barbara; Ventura; Visalia	DELAWARE : Wilmington
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SKIL CORPORATION, 4801 W. PETERSON AVENUE, CHICAGO, ILLINOIS 60646

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