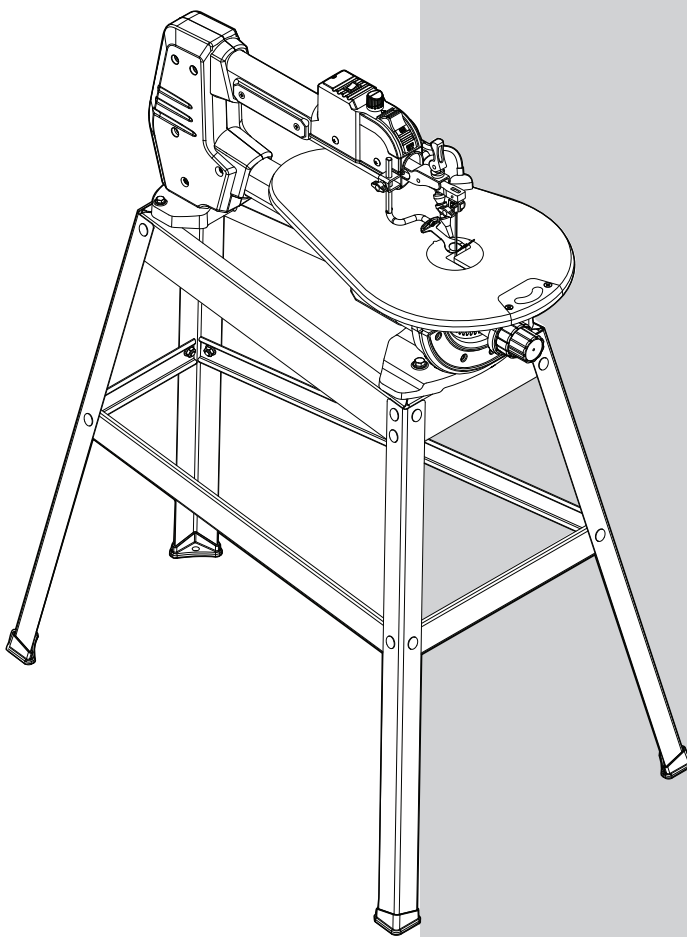


# PORTER CABLE®

**18 IN. (457 MM) VARIABLE SPEED  
SCROLL SAW**

**SCIE SAUTEUSE 457 MM  
(18 PO ) À VITESSE VARIABLE**

**SIERRA CALADORA DE  
VELOCIDAD VARIABLE,  
DE 457 MM (18 PULG.)**



**Instruction Manual**  
Manuel d'instructions  
Manual de instrucciones

[www.portercable.com](http://www.portercable.com)

INSTRUCTIVO DE OPERACIÓN, CENTROS DE  
SERVICIO Y PÓLIZA DE GARANTÍA.

⚠ ADVERTENCIA: LÉASE ESTE INSTRUCTIVO  
ANTES DE USAR EL PRODUCTO.

**CATALOG NUMBER  
PCB375SS**

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## PRODUCT SPECIFICATIONS

### MOTOR

Power Source.....	120 V, 60 Hz, 1.6 Amp
Speed.....	500-1500 RPM
Speed Control.....	Electric

### BLADE

Blade Length.....	5 in.
Type.....	Pin-end or Plain-end
Depth of Throat.....	18 in. (457 mm)
Blade Stroke.....	3/4 in. (19 mm)
Depth of 90° Cut.....	2-1/4 in. (57 mm)
Depth of 45° Cut, Left .....	1-1/4 in. (32 mm)
Depth of 15° Cut, Right .....	2-1/4 in. (57 mm)

### TABLE

Size.....	20 in. x 12-5/8 in. (506 mm × 322 mm)
Tilt.....	45° Left ; 15° Right

### SAWDUST BLOWER

Yes

### WORK LIGHT

LED

### WARNING

To avoid electrical hazards, fire hazards or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tools.

The scroll saw is wired at the factory for 110-120 Volt operation. It must be connected to a 120V, 1.6 Amp branch circuit and use a 1.6 Amp time delay fuse or circuit breaker. To avoid shock or fire, replace power cord immediately if it is worn, cut or damaged in any way.

# CALIFORNIA PROPOSITION 65

## WARNING

Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to the state of California 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, and
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemical: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

Avoid prolonged contact with dust from power sanding, sawing, grinding, drilling, and other construction activities. Wear protective clothing and wash exposed areas with soap and water. Allowing dust to get into your mouth, eyes, or lay on the skin may promote absorption of harmful chemicals.

## WARNING

Use of this tool can generate and/or disperse dust, which may cause serious and permanent respiratory or other injury. Always use NIOSH/OSHA approved respiratory protection appropriate for the dust exposure. Direct particles away from face and body.

## SAFETY GUIDELINES - DEFINITIONS

### WARNING ICONS

Your power tool and its Instruction Manual may contain “WARNING ICONS” (a picture symbol intended to alert you to and/or instruct you how to avoid a potentially hazardous condition). Understanding and heeding these symbols will help you operate your tool better and safer. Shown below are some of the symbols you may see.



**SAFETY ALERT:** Precautions that involve your safety.



**PROHIBITION**



**WEAR EYE PROTECTION:** Always wear safety goggles or safety glasses with side shields.



**WEAR RESPIRATORY AND HEARING PROTECTION:** Always wear respiratory and hearing protection.



**READ AND UNDERSTAND INSTRUCTION MANUAL:** To reduce the risk of injury, user and all bystanders must read and understand instruction manual before using this product.



**KEEP HANDS AWAY FROM THE MOVING PART AND CUTTING SURFACE:** Failure to keep your hands away from the moving part and cutting surface will result in serious personal injury.



**SUPPORT AND CLAMP WORK**

## DANGER

**DANGER:** Indicates an imminently hazardous situation which, if not avoided, will result in death or serious injury.

## WARNING

**WARNING:** Indicates a potentially hazardous situation which, if not avoided, could result in death or serious injury.

## CAUTION

**CAUTION:** Indicates a potentially hazardous situation which, if not avoided, may result in minor or moderate injury.

## CAUTION

**CAUTION:** Used without the safety alert symbol indicates potentially hazardous situation which, if not avoided, may result in property damage.






# POWER TOOL SAFETY

## GENERAL SAFETY INSTRUCTIONS BEFORE USING THIS POWER TOOL

Safety is a combination of common sense, staying alert and knowing how to use your power tool.

### **WARNING**

To avoid mistakes that could cause serious injury, do not plug the tool in until you have read and understood the following.

1.  **READ** and become familiar with the entire Instruction Manual. **LEARN** the tool's application, limitations and possible hazards. Retain this manual as it contains important information regarding safe operation of this tool.
2. **KEEP GUARDS IN PLACE** and in working order.
3. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form the habit of checking to see that keys and adjusting wrenches are removed from the tool before turning ON.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **DO NOT USE IN DANGEROUS ENVIRONMENTS.** Do not use power tools in damp locations, or expose them to rain or snow. Keep work area well lit.
6. **KEEP CHILDREN AWAY.** All visitors and bystanders should be kept a safe distance from work area.
7. **MAKE WORKSHOP CHILD PROOF** with padlocks, master switches or by removing starter keys.
8. **DO NOT FORCE THE TOOL.** It will do the job better and safer at the rate for which it was designed.
9. **USE THE RIGHT TOOL.** Do not force the tool or an attachment to do a job for which it was not designed.
10. **USE PROPER EXTENSION CORDS.** Make sure your extension cord is in good condition. When using an extension cord, be sure to use one heavy enough to carry the current your product will draw. An undersized cord will result in a drop in line voltage and in loss of power which will cause the tool to overheat. The table on page 6 shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.
11. **WEAR PROPER APPAREL.** Do not wear loose clothing, gloves, neckties, rings, bracelets or other jewelry which may get caught in moving parts. Non-slip footwear is recommended. Wear protective hair covering to contain long hair.
12.  **ALWAYS WEAR EYE PROTECTION.** Any power tool can throw foreign objects into the eyes and could cause permanent eye damage. **ALWAYS** wear Safety Goggles (not glasses) that comply with ANSI Safety standard Z87.1. Everyday eyeglasses have only impact-resistant lenses. They **ARE NOT** safety glasses. **NOTE:** Glasses or goggles not in compliance with ANSI Z87.1 could seriously injure you when they break.
13.  **WEAR A FACE MASK OR DUST MASK.** Sawing operation produces dust.
14.  **SECURE WORK.** Use clamps or a vise to hold work when practical. It is safer than using your hand and it frees both hands to operate the tool.
15. **DISCONNECT TOOLS FROM POWER SOURCE** before servicing, and when changing accessories such as blades, bits and cutters.
16. **REDUCE THE RISK OF UNINTENTIONAL STARTING.** Make sure switch is in the OFF position before plugging the tool in.
17. **USE RECOMMENDED ACCESSORIES.** Consult this Instruction Manual for recommended accessories. The use of improper accessories may cause risk of injury to yourself or others.
18. **NEVER STAND ON THE TOOL.** Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.
19. **CHECK FOR DAMAGED PARTS.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function – check for alignment of moving parts, binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
20. **NEVER LEAVE THE TOOL RUNNING UNATTENDED. TURN THE POWER "OFF".** Do not walk away from a running tool until the blade comes to a complete stop and the tool is unplugged from the power source.
21. **DO NOT OVERREACH.** Keep proper footing and balance at all times.
22. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean for best and safest performance. Follow instructions for lubricating and changing accessories.
23. **DO NOT** use power tool in presence of flammable liquids or gases.
24. **DO NOT** operate the tool if you are under the influence of any drugs, alcohol or medication that could affect your ability to use the tool properly.
25. Dust generated from certain materials can be hazardous to your health. Always operate saw in well-ventilated area and provide for proper dust removal.
26.  **WEAR HEARING PROTECTION** to reduce the risk of induced hearing loss.

# SCROLL SAW SAFETY

## SPECIFIC SAFETY INSTRUCTIONS FOR THIS SCROLL SAW

1. **READ AND UNDERSTAND** all safety instructions and operating procedures throughout the manual. Retain this manual as it contains important information regarding safe operation of this tool.
2. **DO NOT OPERATE** the Scroll Saw until it is completely assembled and installed according to the instructions.
3. **SHOULD** any part of Scroll Saw be missing, damaged, or fail in any way, or any electrical component fail to perform properly, shut off the switch and remove the plug from the power supply outlet. Replace missing, damaged, or failed parts before resuming operation.
4. **IF YOU ARE NOT** thoroughly familiar with the operation of a Scroll Saw, obtain advice from your supervisor, instructor or other qualified person.
5. **SERIOUS INJURY** could occur if the tool tips over or you accidentally hit the cutting tool. Do not store anything above or near the tool.
6. **AVOID INJURY** from unexpected saw movement. Place the saw on a firm level surface where the saw does not rock and bolt or clamp the saw to its support.
7. **YOUR SCROLL SAW MUST BE SECURELY FASTENED** to a stand or workbench. If there is any tendency for the stand or workbench to move during operation, the stand or workbench **MUST** be fastened to the floor.
8. **THIS SCROLL SAW** is intended for indoor use only.
9. **TENSION BLADE PROPERLY** before starting the saw. Recheck and adjust tension as needed.
10. **BLADE TEETH MUST POINT** downward toward the table.
11. **TABLE MUST BE CLEARED** of all debris before operating saw. Do not perform lay out, set up or assemble work on the table when the saw is in operation.
12. **TO PREVENT INJURIES**, avoid awkward hand or finger positions, where a sudden slip could cause a hand to move into the blade when operating the saw.
13. **HOLD WORKPIECE FIRMLY** against the table top.
14. **NEVER CUT MATERIAL** that is too small to be held safely.
15. **DO NOT USE** dull or bent blades.
16. **TURN THE SAW OFF AND UNPLUG THE CORD** if the blade binds in the saw kerf while being backed out of the workpiece, usually caused by sawdust clogging the kerf. If this happens, turn off the scroll saw and unplug the power cord. Wedge open the kerf and back the blade out of the workpiece.
17. **DO NOT** feed the material too fast while cutting. Only feed the workpiece at the rate the saw will cut.
18. **TURN THE POWER OFF**, make sure the scroll saw comes to a complete stop before installing or removing an accessory, and before leaving the work area.
19. **DO NOT START** the saw with workpiece pressing against the blade. Slowly feed the workpiece into the moving blade.
20. **WHEN CUTTING** a large workpiece, **MAKE SURE** the material is supported at table height.
21. **EXERCISE CAUTION** when cutting workpieces that are round or irregularly shaped, workpieces can pinch the blade.
22. **ALWAYS** release blade tension before loosening the blade holder screw.
23. **MAKE CERTAIN** table tilting lock is tightened before starting the machine.
24. **NEVER REACH** under the scroll saw table when motor is running.
25. **CHECK FOR DAMAGED PARTS** before each use. Check for alignment of moving parts, binding of moving parts, breakage of parts, mounting or any other conditions that may affect operation. Parts that are damaged should be properly repaired or replaced before using the tool.
26. **THINK SAFETY.**

# ELECTRICAL REQUIREMENTS AND SAFETY

## POWER SUPPLY AND MOTOR SPECIFICATIONS

### WARNING

To avoid electrical hazards, fire hazards, or damage to the tool, use proper circuit protection. Use a separate electrical circuit for your tool. Your tool is wired at the factory for 120V operation. Connect to a 120V, 1.6 Amp circuit and use a 1.6 Amp time delay fuse or circuit breaker. To avoid shock or fire, if power cord is worn, cut, or damaged in any way, have it replaced immediately.

## GROUNDING INSTRUCTIONS

### WARNING

This tool must be grounded while in use to protect the operator from electrical shock.

### IN THE EVENT OF A MALFUNCTION OR

**BREAKDOWN**, grounding provides a path of least resistance for electric currents and reduces the risk of electric shock. This tool is equipped with an electrical cord that has an equipment-grounding conductor and a grounding plug. The plug must be plugged into a matching receptacle that is properly installed and grounded in accordance with all local codes and ordinances.

**DO NOT MODIFY THE PLUG PROVIDED.** If it will not fit the receptacle, have the proper receptacle installed by a qualified electrician.

**IMPROPER CONNECTION** of the equipment grounding conductor can result in risk of electric shock. The conductor with the green insulation (with or without yellow stripes) is the equipment grounding conductor. If repair or replacement of the electrical cord or plug is necessary, do not connect the equipment grounding conductor to a live terminal.

**CHECK** with a qualified electrician or service person if you do not completely understand the grounding instructions, or if you are not certain the tool is properly grounded.

USE only 3-wire extension cords that have three-pronged grounding plugs with three-pole receptacles that accept the tool's plug. Repair or replace damaged or worn cords immediately.

Use a separate electrical circuit for your tool. This circuit must not be less than #18 wire and should be protected with a 1.6 Amp time lag fuse. Before connecting the motor to the power line, make sure the switch is in the off position and the electric current is rated the same as the current stamped on the motor nameplate. Running at a lower voltage will damage the motor.

## GUIDELINES FOR EXTENSION CORDS

**USE THE PROPER EXTENSION CORD.** Make sure your extension cord is in good condition. Use an extension cord heavy enough to carry the current your product will draw. An undersized cord will cause a drop in line voltage resulting in loss of power, overheating and burning out of the motor. The table below shows the correct size to use depending on cord length and nameplate ampere rating. If in doubt, use the next heavier gauge. The smaller the gauge number, the heavier the cord.

Make sure your extension cord is properly wired and in good condition. Always replace a damaged extension cord or have it repaired by a qualified technician before using it. Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

MINIMUM GAUGE FOR EXTENSION CORDS (AWG)					
(When using 120 volts only)					
Ampere Rating		Total length of Cord			
More Than	Not More Than	25 (7.62	50 15.24	100 30.48	150 ft. 45.72 m)
		AWG- American Wire Gauge			
0	6	18	16	16	14
6	10	18	16	14	12
10	12	16	16	14	12
12	16	14	12	Not Recommended	

### WARNING

This tool is for indoor use only. Do not expose to rain or use in damp locations.

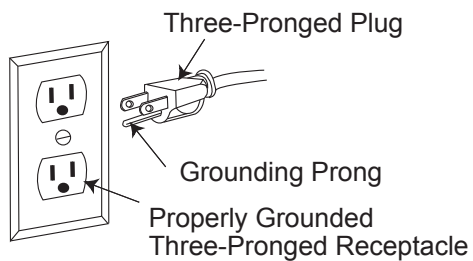


This tool is intended for use on a circuit that has a receptacle like the one illustrated in Fig. 1. Fig. 1 shows a three-pronged electrical plug and receptacle that has a grounding conductor. If a properly grounded receptacle is not available, an adapter (Fig. 2) can be used to temporarily connect this plug to a two-contact grounded receptacle. The adapter (Fig. 2) has a rigid lug extending from it that **MUST** be connected to a permanent earth ground, such as a properly grounded receptacle box.

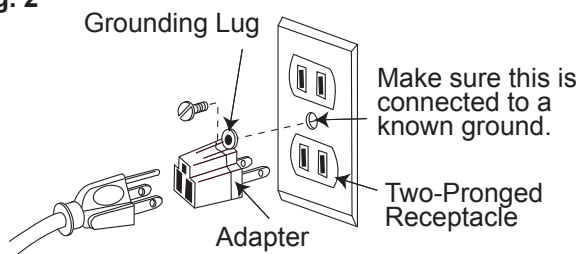
### **⚠ CAUTION**

In all cases, make certain the receptacle is properly grounded. If you are not sure, have a qualified electrician check the receptacle.

**Fig. 1**



**Fig. 2**



## TOOLS NEEDED FOR ASSEMBLY

### Supplied



3 mm hex key

### Not Supplied



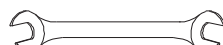
Slotted screwdriver



#2 Phillips screwdriver



Adjustable wrench



13 mm wrench

## CARTON CONTENTS

### UNPACKING AND CHECKING CONTENTS

Carefully unpack the scroll saw and all its parts, and compare against the list below and the illustration on the next page. With the help of an assistant place the saw on a secure surface and examine it carefully.

### **⚠ WARNING**

- To avoid injury from unexpected starting or electrical shock, do not plug the power cord into a source of power during unpacking and assembly. The cord must remain unplugged whenever you are adjusting/ assembling the scroll saw.
- The scroll saw is heavy and should be lifted with care. If needed, get the assistance of someone to lift and move the scroll saw.
- If any part is missing or damaged, do not attempt to assemble the scroll saw, or plug in the power cord until the missing or damaged part is correctly replaced.

### TABLE OF LOOSE PARTS

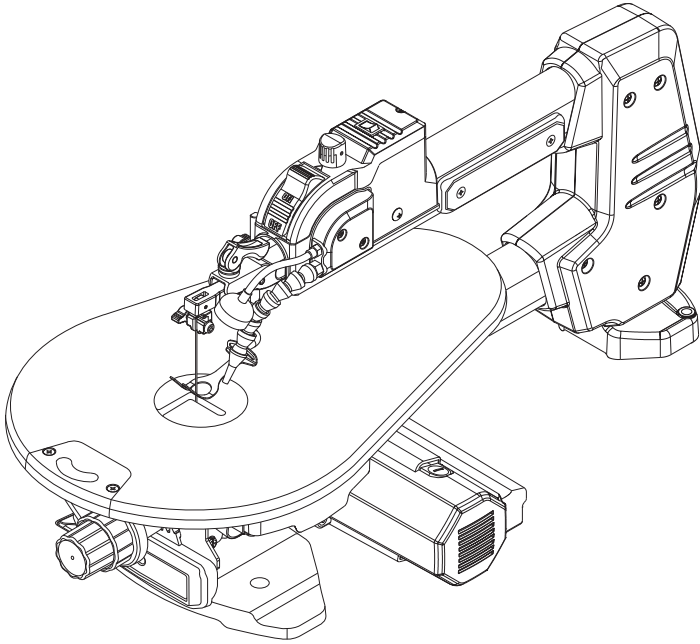
ITEM	DESCRIPTION	QUANTITY
A.	Scroll saw assembly	1
B.	Blade bag	
	5 in. pin-end blade	1
	3 mm hex key	1

### STAND

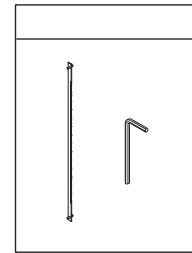
C.	Side bracket - upper support	2
D.	Side bracket - lower support	2
E.	Rear bracket - upper support	1
	Rear bracket - lower support	1
F.	Front bracket - upper support	1
	Front bracket - lower support	1
G.	Stand hardware bag	
	Cushion	4
	Serrated toothed hex. flange nut	20
	Cap hd. sq. neck bolt	24
	Hex. bolt	4
	Flat washer	4
	Sleeve	2
H.	Stand leg	4



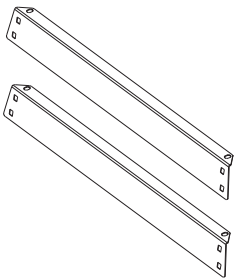
# UNPACKING YOUR SCROLL SAW



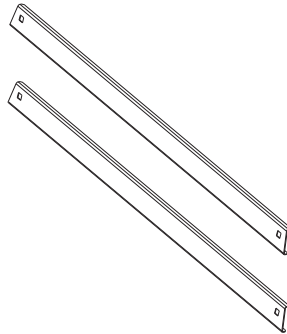
A



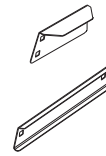
B



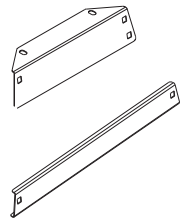
C



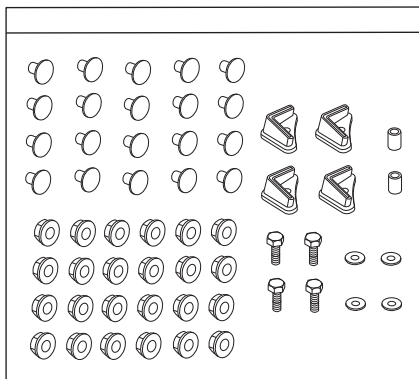
D



E



F

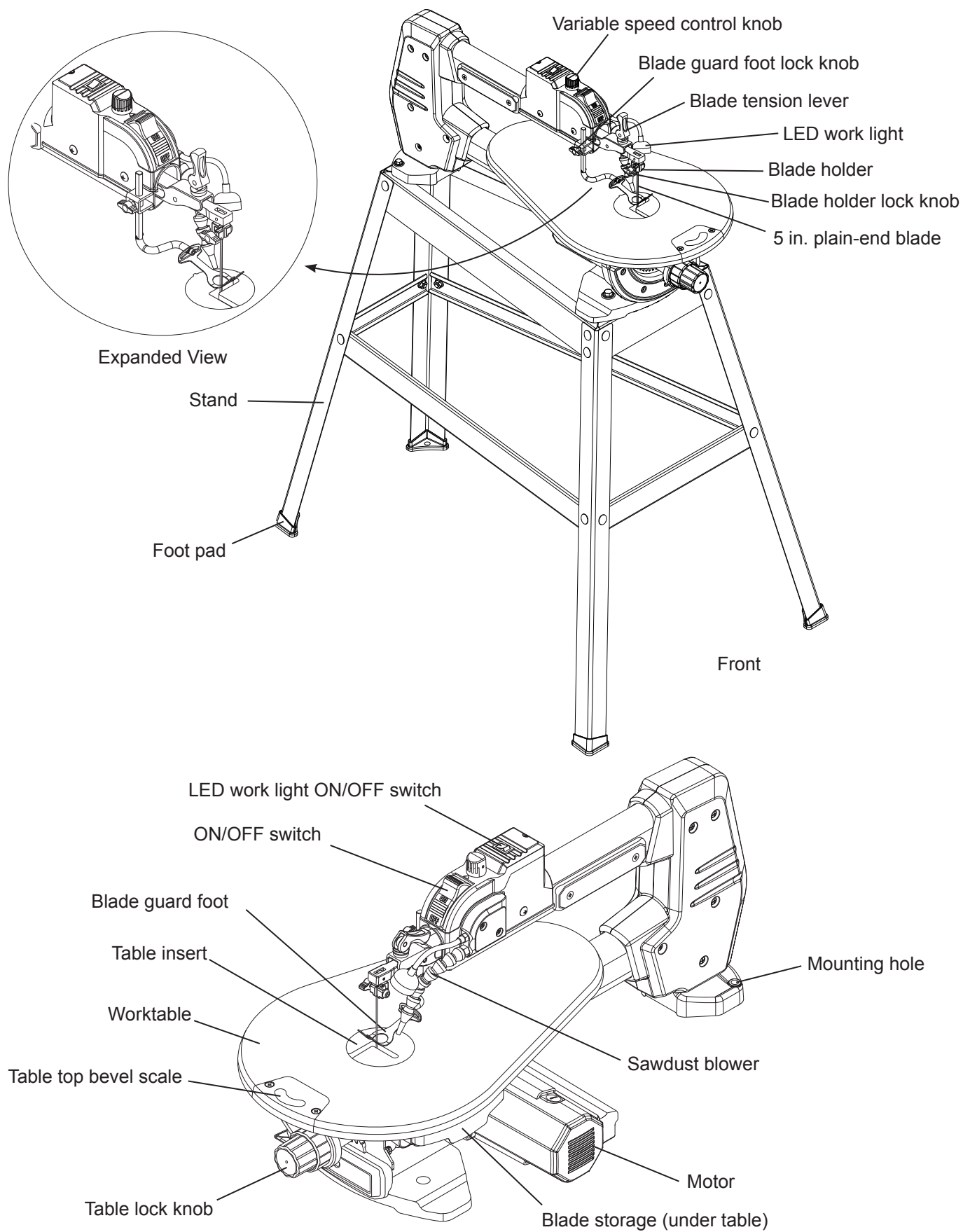


G



H

# KNOW YOUR SCROLL SAW



# GLOSSARY OF TERMS

## SCROLL SAW TERMS

**BEVEL SCALE** – Represents the degree of table angle from 0° to 45° when the table is tilted for bevel cutting.

**BLADE GUARD FOOT** – Guards the blade and keeps your workpiece from rising. Helps protect fingers from blade contact.

**BLADE GUARD FOOT LOCK KNOB** – Allows you to raise or lower the foot and lock it at the desired height.

**BLADE HOLDERS** – Retain and position the blades.

**BLADE STORAGE** – Provides convenient easy access to extra blades or wrenches.

**QUICK RELEASE TENSION LEVER** – Quickly loosens and retightens the blade to its original tension. The tension lever quickly sets and resets the blade tension when performing interior cutting operations or changing blades.

**SAWDUST BLOWER** – Keeps sawdust from covering the line of sight for more accurate cuts. The best results occur when the blower tube is directed toward the blade and workpiece.

**SAWDUST COLLECTION PORT** – Allows vacuum hose or attachments to be used to remove the sawdust from under the table and base.

**TABLE LOCK KNOB** – Securely locks the table at the angle desired for bevel cutting.

**VARIABLE SPEED ON/OFF CONTROL KNOB** – Variable switch dial allows greater versatility when cutting a variety of materials. Adjust the speed to the desired setting, between 500 to 1500 strokes per minute (SPM), by turning the control knob clockwise or counter clockwise.

## WOODWORKING TERMS

**BLADE TOOTH SET** – The total width the blade will cut based on the distance from the outside point of one bent tooth to the outside point of the next bent tooth establishing set of teeth.

**DEFLECTION** – Slight movement of blade in the horizontal direction while the blade is moving inline during cutting operation. This may be caused by the blade following the grain or the path of least resistance.

**FEED** – Rate of moving material to be cut into the blade.

**KERF** – The slot cut by the blade.

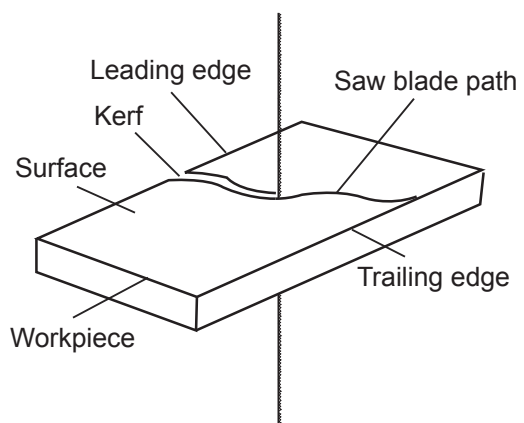
**LEADING EDGE** – The front edge of the workpiece that is guided into the blade.

**SAW BLADE PATH** – Area or line of sight of the workpiece moving in line toward the saw blade edge.

**SURFACE** – Top of workpiece being cut.

**TRAILING EDGE** – The end of the workpiece edge last cut by the saw blade.

**WORKPIECE** – Material on which the cutting operation is being performed.



# ASSEMBLY AND ADJUSTMENTS

**Estimated Assembly Time: 25 - 40 Minutes.**

## INSTALLING THE STAND (FIG. A)

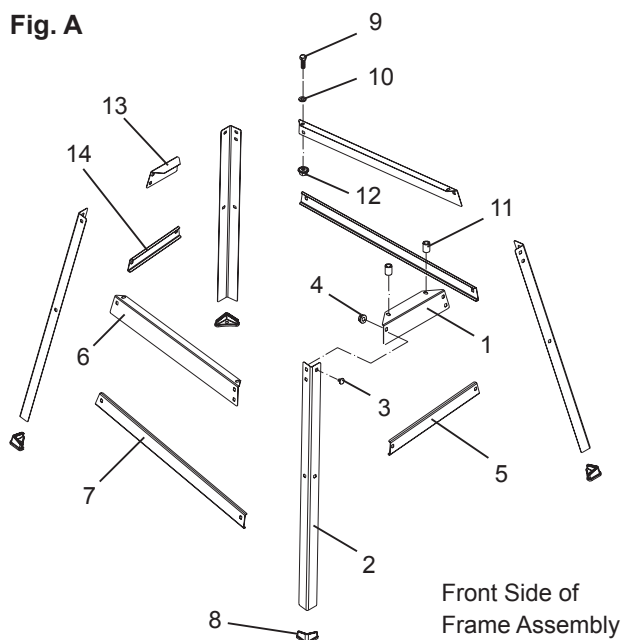
1. Unpack all parts and group by type and size. Refer to the table of loose parts list on page 8 & 9 for correct quantities.
2. **Bag "F" & "H"** - Attach one end of front bracket - upper support (1) to top of leg (2) using one bolt (3) and nut (4). The stand leg is placed on the outside of the brackets.

### NOTE:

- The left side of the bracket has only one hole and the right side has two holes.
  - Only hand tighten at this point. DO not tighten bolts with a wrench until stand is properly aligned (see step #8 before tightening).
  - The front and rear stand legs are different in angles and cannot be mixed.
3. Attach other end of front bracket - upper support (1) to top of another leg (2) using one bolt (3) and nut (4).
  4. Attach the front bracket - lower support (5) to center the two legs using bolt (3) and nut (4). This completes the front frame section.
  5. **Bag "E" & "H"** - Assemble rear frame section in exactly the same manner using the shorter rear brackets (12 & 13).
  6. **Bag "C" & "D"** - Join the front and rear frame sections using two brackets upper supports (6) and two lower supports (7) with bolts and nuts.
  7. **Bag "G"** - Place the four foot pads (8) into the bottom of each leg. (lightly use a rubber mallet if needed).
  8. Place the stand on level surface, adjust all legs to contact and are at similar angles to the floor. Tighten all bolts.

**NOTE:** To avoid rocking, all bolts must be tightened securely using a 13 mm or adjustable wrench.

**Fig. A**



## ⚠ WARNING

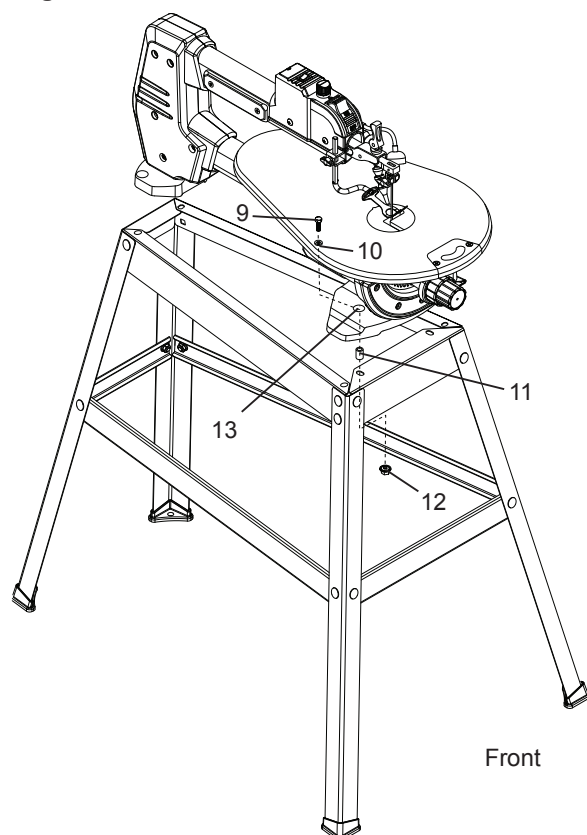
- The stand is designed only for use with a scroll saw.
- Do not climb, sit or stand on the stand assembly.
- Do not use the stand on uneven or unstable surface.
- To avoid injury, do not connect this scroll saw to the power source until it is completely assembled and adjusted and you have read and understood this instruction manual.

## MOUNTING THE SCROLL SAW (FIG. B)

1. To mount your scroll saw to the stand, position the stand leg on a firm, level surface.
2. Matching the four holes (13) in the scroll saw base with the holes in the stand leg, place the scroll saw on the stand as shown below.
3. Secure the stand and saw by the hex bolts (9), flat washers (10), sleeves (11) and nuts (12) provided in front mounting holes, and by the hex bolts (9), flat washers (10) and nuts (12) in rear mounting holes.
4. Tighten all four nuts using a 13 mm or adjustable wrenches.

**NOTE:** Do not over tighten nuts, it may damage the saw base.

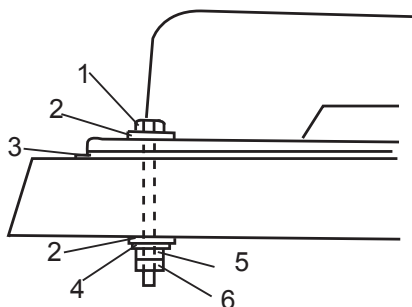
**Fig. B**



## MOUNTING SCROLL SAW TO WORK SURFACE (FIG. C)

1. If mounting the scroll saw to a workbench instead of the provided stand, a solid wood bench is preferred over a plywood board to reduce noise and vibration.
2. The hardware to mount this saw is NOT supplied with the saw. The hardware as shown in Fig. C should be used:

Fig. C

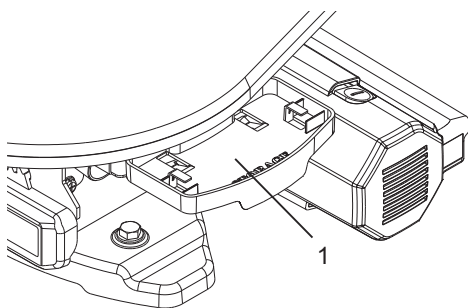


1. Hex bolts; length as required
2. Flat washers
3. Foam pad or carpet (optional)
4. Lock washers
5. Hex nuts
6. Jam nuts

## BLADE STORAGE (FIG. D)

Blade storage is located on the right side of the scroll saw body. Pull out the blade storage drawer (1) to open. The compartment can conveniently store your hex keys and both pin-end and plain-end blades.

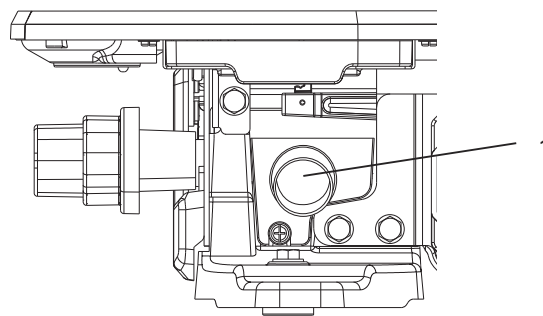
Fig. D



## SAWDUST COLLECTION PORT (FIG. E)

This scroll saw will accept 1-1/4 in. diameter hose or vacuum accessory (not provided) to be connected to the port (1) on the right side of base. This will keep your saw cutting efficiently.

Fig. E



## BLADE REMOVAL AND INSTALLATION

### PLAIN-END BLADE REMOVAL AND INSTALLATION

This scroll saw accepts 5-inch (127 mm) plain-end or pin-end blades to cut a wide variety of materials.

Plain-end type blades are recommended whenever fine, accurate and intricate work is being performed on 3/4 in. (19 mm) or thinner material. It will take slightly longer to assemble the blade and blade tension, but you will also be able to use finer blades for cutting a thinner kerf.

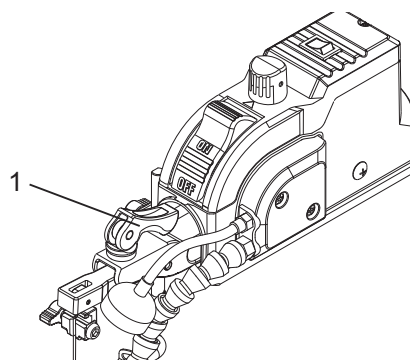
### **⚠ WARNING**

To avoid injury from accidental starting, always turn the switch OFF (O) and remove power cord plug from power source before removing or replacing the blade.

### Plain-end blade removal (Fig. F, G, H)

1. To remove the blade, loosen the blade tension by lifting the blade tension lever (1).

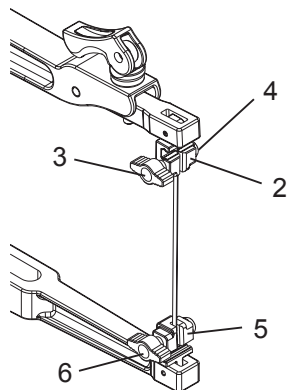
Fig. F



2. Loosen the upper blade holder (2) by turning the blade holder lock knob (3) counterclockwise. (Fig. G)

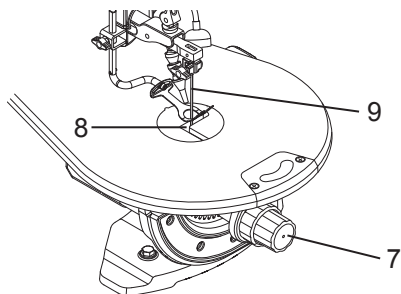
**NOTE:** The hex set screw (4) on the right side is used for fine adjustments and is only adjusted if the blade is not perpendicular to the table.

**Fig. G**



3. Tilt the table to 0° and tighten the table lock knob (7-Fig. H). Loosen the lower blade holder lock knob (6-Fig. G) on the left side of the lower blade holder (5-Fig. G) under the table by turning it counterclockwise.
4. Pull down the arm, and remove the blade (9) from the upper and lower blade holders by pulling forward and lifting the blade (9) through the access hole (8). (Fig. H)

**Fig. H**



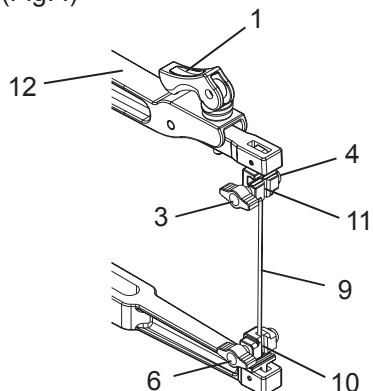
#### Plain-end blade installation (Fig. F, G, H, I)

##### **CAUTION**

**In order to avoid uncontrollable lifting of the workpiece, the teeth of the blade should ALWAYS point downward.**

1. Install the new blade (9) through the access hole (8) in the table with teeth pointing down. (Fig. H)
2. Insert the new blade (9) into the lower blade holder slot (10), then tighten the lower blade holder lock knob (6). (Fig. I)

**Fig. I**



3. Tilt the table to 0° and lock the table lock knob (7). (Fig. H)
4. Insert the other end of the blade into the upper blade holder slot (11), then tighten the upper blade holder lock knob (3). (Fig. I)

##### **NOTE:**

- Apply slight downward pressure against the upper arm (12) when installing the blade into the upper blade holder. (Fig. I)
- Clamp plain-end blades more tightly by using a hex key through the screw (4). (Fig. I)

5. Tighten the blade tension by pressing down the blade tension lever (1). If too loose, turn lever clockwise. (Fig. I)

##### **CAUTION**

Overtightening blade will cause blade breakage.

**NOTE:** The blade tension lever must always be down to make tension adjustments. Release the blade tension lever only during blade changing operations. If the blade is tightened too tight, the lever will be difficult to lower and could result in damage to the blade holder or arm assembly. (Fig. I)

#### PIN-END BLADE REMOVAL AND INSTALLATION

##### **⚠ WARNING**

**To prevent personal injury, always turn the saw OFF and disconnect the plug from the power outlet before changing blades or making adjustments.**

Pin-end type blades are thicker for stability and faster assembly. These blades are used whenever faster cutting on a variety of materials and 3/4 in. (19 mm) thickness or greater are required. Use whenever less precision or thicker kerf cutting is acceptable.

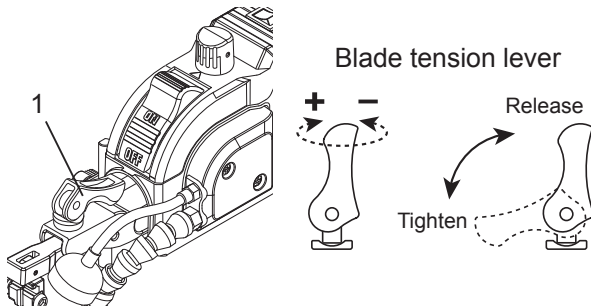
**NOTE:** When installing pin-end blades, the set screws located on the upper and lower blade holders should not be over or under tightened. The slot must be slightly wider than the thickness of the blade. After the blade is installed, the blade tension mechanism will keep the pin-end in place.



### Pin-end blade removal (FIG. J, K)

1. To remove the blade, loosen the blade tension by lifting the blade tension lever (1). (Fig. J)

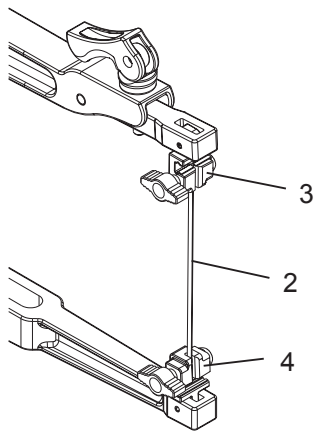
Fig. J



2. Remove the blade (2) from the upper (3) and lower (4) blade holder by pulling down the arm, then pulling forward to release the blade (2). Lifting the blade through the access hole. (Fig. K)
3. Tilt the table to 45° and lock the table lock knob to view lower blade holder (4) when removing the blade. (Fig. K)

**NOTE:** Apply slight downward pressure on the upper arm when removing blade from upper blade holder.

Fig. K



### Pin-end blade installation (Fig. L)

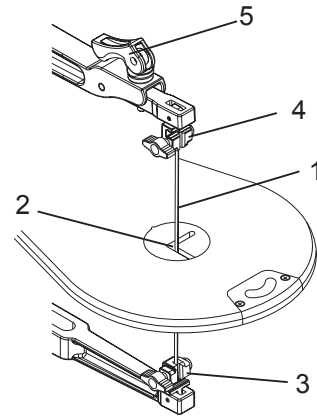
**NOTE:** Do not tighten the blade holder lock knobs when using pin-end blades.

#### **⚠ WARNING**

In order to avoid uncontrollable lifting of the workpiece, the teeth of blade should always point downward.

1. Install the blade (1) by inserting one end of it through the access hole (2) in the table. Hook the lower blade pin in the pin recess in the lower blade holder (3), upper blade pin in the upper blade holder (4). (Fig. L)

Fig. L



2. Make sure the pins are properly located in the upper (4) and the lower (3) blade holders.
3. To tension the blade (1), lower the blade tension lever (5). Check the tension on the blade. If tension is too tight, turn the blade tension lever (5) counterclockwise. If tension is too loose, turn the blade tension lever (5) clockwise.
- NOTE:** If the blade is over tightened, the lever will be difficult to lower and could result in damage to the blade holder or arm assembly.
4. Tighten both upper and lower blade holder knobs.

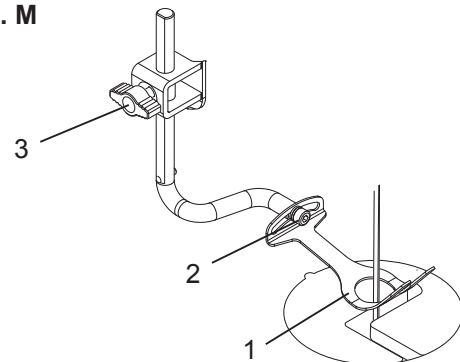
### BLADE GUARD FOOT ADJUSTMENT (FIG. M)

**NOTE:** User must keep constant downward pressure on workpiece when cutting. The blade guard foot is not designed to hold down the workpiece, but is rather to help prevent the workpiece from lifting up excessively.

When cutting at angles, the blade guard foot (1) should be adjusted so it is parallel to the table and rests flat above the workpiece.

1. To adjust, loosen the blade guard screw (2) with 3 mm hex key, adjust the foot parallel to table, and tighten the screw (2).
2. Loosen the blade guard foot lock knob (3) to raise or lower the foot until it rests slightly above the workpiece. Tighten blade guard foot lock knob (3).

Fig. M

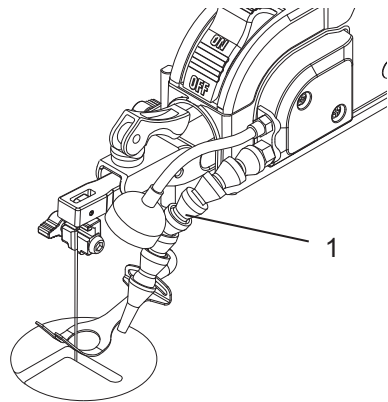




SAWDUST BLOWER (FIG. N)

The sawdust blower (1) should be positioned to point to the blade and workpiece to blow sawdust out of the line-of-sight when cutting. It is not designed to blow all of the sawdust off the table.

Fig. N



BLADE SELECTION (FIG. O)

**⚠ WARNING**

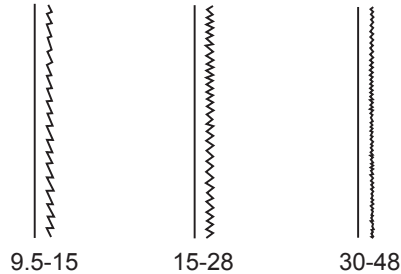
To avoid injury from accidental starting, always turn the switch OFF and unplug the scroll saw before moving, replacing the blade or making adjustments.

This scroll saw accepts 5 in. (127 mm) length blades with a wide variety of blade thickness and widths. The type of material and cutting operations (size of radius or curve) will determine the number of teeth per inch. As a rule, always select the narrowest blades for intricate curve cutting and the widest blades for straight and large curve cutting operations.

The following table represents suggestions for various materials. When purchasing blades, refer to the back of the package for the best use of blades and speeds on various materials.

Use this table as an example, but practice and your own personal preference will determine the best selection method.

Fig. O



TEETH/ INCH TPI	BLADE WIDTH INCH	BLADE THICKNESS INCH	BLADE/ SPM	MATERIAL CUT
9.5-15	0.110 (2.8 mm)	0.018 (0.46 mm)	400-1200	Medium turns on 1/4 in. (6.35 mm) to 1-3/4 in. (44.45 mm) wood, soft metal, hardwood
15-28	.055-.110 (1.4-2.8 mm)	.010-.018 (0.25-0.46 mm)	800-1800	Small turns on 1/8 in. (3.18 mm) to 1-1/2 in. (38.1 mm) wood, soft metal, hardwood
30-48	.024-.041 (0.6-1.0 mm)	.012-.019 (0.3-0.48 mm)	Varies	Non-ferrous metals/hardwoods using very slow speeds

**NOTE:** When using blades, sometimes speeds must change to compensate for smaller curves, radii or smaller diameters. Thinner blades will have more possibilities for blade deflection when cutting angles which are not perpendicular to the table. Read RECOMMENDATION FOR CUTTING for more suggestions.

**NOTE:** The blade must be installed with the teeth pointing downward, to prevent the workpiece from being pulled upward by the saw blade action.

# OPERATION

## VARIABLE SPEED CONTROL AND ON/OFF SWITCH

### ⚠ CAUTION

For your own safety, always push the switch “OFF” when the scroll saw is not in use. Also, in the case of power failure (all of your lights go out) push the knob “OFF”. Remove the plug from the power source outlet to avoid accidental starting.

### ON/OFF SWITCH (FIG. P)

1. To turn power ON, press on/off switch (2) to “ON” position.
2. To turn power OFF, press on/off switch (2) to “OFF” position.

### VARIABLE SPEED CONTROL KNOB (FIG. P)

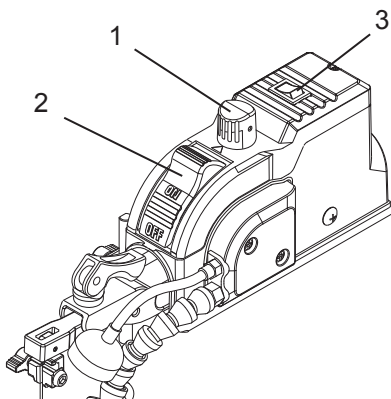
The variable speed control allows greater versatility to cut a variety of materials such as wood, plastics, non-ferrous metals, etc. Depending on the hardness and thickness of material, the speed should be reduced to allow the blade teeth to remove cut material from the kerf.

1. Your saw is equipped with a variable speed control knob (1). The blade stroke rate may be adjusted by simply rotating the variable speed control knob (1).
2. Turn the speed control knob clockwise to increase up to 1,500 strokes per minute (SPM). Turn the speed control knob counterclockwise to reduce down to 500 strokes per minute (SPM).

### WORK LIGHT (FIG. P)

1. To turn work light on, press the rocker switch (3) to “ON” position.
2. To turn work light off, press the rocker switch (3) to “OFF” position.

Fig. P



## RECOMMENDATIONS FOR CUTTING

1. When feeding the workpiece into the blade do not force the leading edge of the workpiece into the blade because it will deflect the blade, reduce the accuracy of cutting and possibly break the blade. Allow the saw to cut material by guiding the workpiece into the blade as it cuts.
2. The blade teeth cut material ONLY on the down stroke.
3. You must guide the wood into the blade slowly because the teeth of the blade are very small and they can only remove wood when they are on the down stroke.
4. There is a learning curve for each person who wants to use this saw. During that period of time it is expected that some blades will break until you learn how to use the saw and receive the greatest benefit from the blades.
5. Best results are achieved when cutting wood less than one inch (25.4 mm) thick.
6. When cutting wood thicker than one inch (25.4 mm), the user must guide the wood very slowly into the blade and take extra care not to bend or twist the blade while cutting in order to maximize blade life.
7. When teeth of scroll saw blade worn out, must replace the new blade. Check the blade frequently for best cutting results. Scroll saw blades generally stay sharp for 1/2 to 2 hours of cutting.
8. To get accurate cuts, be prepared to compensate for the blade's tendency to follow the wood grain as you are cutting.
9. This scroll saw is intended to cut wood or wood products.
10. When choosing a blade to use with your scroll saw, consider very fine, narrow blades to scroll cut in thin wood in 1/4 in. (6.4 mm) thick or less. Use wider blades for thicker materials but this will reduce the ability to cut tight curves.
11. This saw uses 5 in. (127 mm) long pin or plain end type blades.
12. Blades wear faster when cutting plywood or particle board which is very abrasive. Angle cutting in hardwoods reduces blade tooth set faster due to the blade deflection.

### FREEHAND CUTTING (FIG. Q)

1. Lay out desired design, or secure design to the workpiece (1).
2. Raise the blade guard foot (2) by loosening the blade guard foot lock knob (3).
3. Position the workpiece against the blade and place the blade guard foot slightly above the top surface of the workpiece.
4. Secure the blade guard foot (2) by tightening the blade guard foot lock knob (3).
5. Remove the workpiece from the blade before turning the scroll saw ON. Set the desired speed by turning the speed control knob (4) clockwise or counterclockwise.

#### **CAUTION**

In order to avoid uncontrollable lifting of the workpiece and to reduce blade breakage, do not turn saw ON while the workpiece is against the blade.

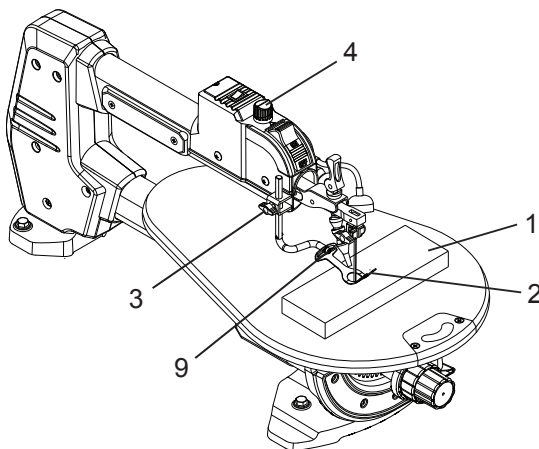
6. When turning the scroll saw ON, position the workpiece against scrap wood prior to touching the leading edge of the workpiece against the blade.  
**NOTE:** For your own safety, use the scrap wood to perform the cutting especially for the small workpiece.
7. Slowly feed the workpiece into the blade by guiding and pressing the workpiece down against the table.

#### **CAUTION**

Do not force the leading edge of the workpiece into the blade, it may deflect the blade, reduce accuracy of cutting, and possibly break the blade.

8. When the cut is complete, move the trailing pieces of the workpiece beyond the blade guard foot. Turn the scroll saw OFF.

Fig. Q



### ANGLE CUTTING (FIG. Q, R, S)

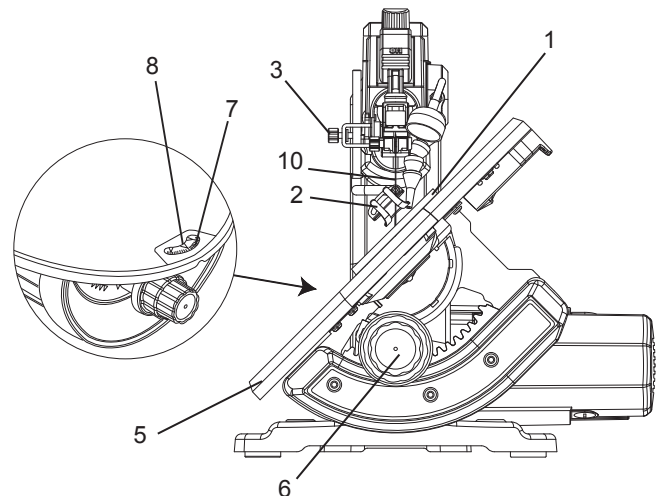
#### **WARNING**

To avoid injury, always keep your hands off the underneath of the table during operating.

#### Left Bevel Cutting (maximum 45 degrees)

1. Lay out or secure design to workpiece (1).
2. Move the blade guard foot (2) to the highest position by loosening the blade guard foot lock knob (3) and retighten.
3. Tilt the table (5) to the desired angle by loosening the table lock knob (6) and move the table to the proper angle, using the degree scale (7) and the pointer (8).
4. Tighten the table lock knob (6).
5. Loosen the blade guard screws (9-Fig. Q), and tilt the blade guard to the same angle as the table (5). Retighten the blade guard screw.
6. Position the workpiece on the left and right side of the blade (10). Lower the blade guard foot slightly above the surface of the workpiece by loosening the blade guard foot lock knob (3).
7. Follow steps 4-8 under FREEHAND CUTTING OPERATION.

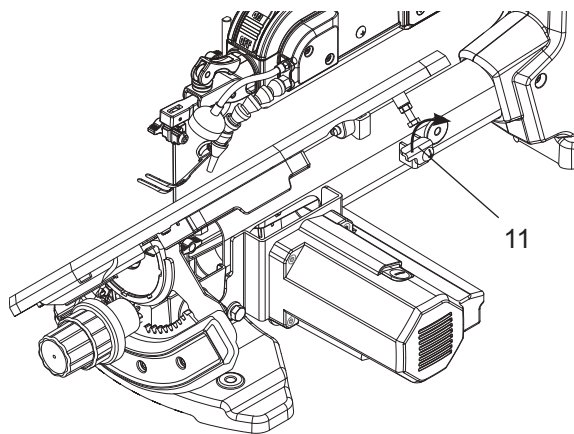
Fig. R



### Right Bevel Cutting (maximum 15 degrees)

1. Lay out or secure design to workpiece (1).
2. Move the blade guard foot (2) to the highest position by loosening the blade guard foot lock knob (3) and retighten.
3. Tilt the table (5) to the left by loosening the table lock knob (6), and lifting the anchor plate (11) to the rear of the saw. Tilt the table to the right, it will stop at the angle of 15°.
4. Tighten the table lock knob (6).
5. Follow steps 5-7 under **Left Bevel Cutting**.

Fig. S



### RIP OR STRAIGHT LINE CUTTING (FIG. T)

#### Tools Needed (Not Included)

QUANTITY	DESCRIPTION
2	Small C-clamps
1	Ruler or measuring tape
1	12-inch (304.8 mm) -straight scrap of wood (Thickness to match workpiece)
1	A piece of wood, metal, plastic etc. with a straight edge

1. Raise the blade guard foot (1) by loosening the blade guard foot lock knob (2) on the left side of the upper arm. Measure from the tip of the blade (3) to the desired distance. Position the straight edge (4) parallel to the blade at that distance.
2. Clamp the straight edge (4) to the table (5).
3. Recheck your measurements, using the workpiece to be cut, and make sure the scrap wood (6) is secure.
4. Position the workpiece against the blade and place the blade guard foot (1) slightly above the top surface of the workpiece.
5. Secure the blade guard foot in place by tightening the blade guard foot lock knob.

6. Remove the workpiece from the blade before turning the scroll saw ON. Set the desired speed by turning the speed control knob clockwise or counterclockwise.

#### ⚠ CAUTION

In order to avoid uncontrollable lifting of the workpiece and reduce blade breakage, do not turn saw ON while the workpiece is against the blade.

7. Position the workpiece against the straight edge (4) prior to touching the leading edge of the workpiece against the blade (3).
8. Slowly feed the workpiece into the blade, guiding the workpiece against the straight edge and press the workpiece down against the table while cutting.

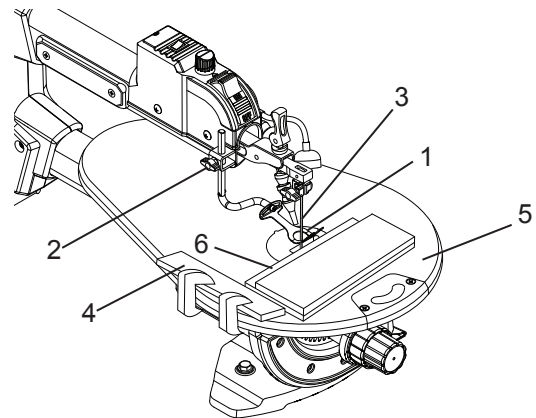
#### ⚠ CAUTION

Do not force the leading edge of the workpiece into the blade. The blade will deflect, reducing accuracy of cut and may break.

9. When the cut is complete, move the trailing edge of the workpiece beyond the blade guard foot. Turn the scroll saw OFF.

**NOTE:** Use push stick when cutting a narrow workpiece.

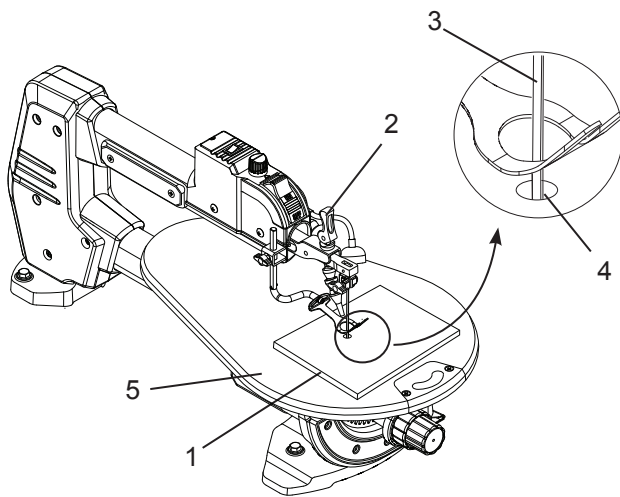
Fig. T



### INTERIOR CUTTING (FIG. U)

1. Lay out the design on the workpiece (1). Drill a 1/4 in. (6.4 mm) hole in the workpiece.
2. Lift the blade tension lever (2) and remove the blade (3). Refer to BLADE REMOVAL AND INSTALLATION.
3. Place the workpiece on the table with the workpiece hole (4) over the access hole in the table (5).
4. Install the blade (3) through the hole in the workpiece and press the blade tension lever (2).
5. Follow the process 3-8 under the section of FREEHAND CUTTING.
6. When finish the cutting, turn the scroll saw OFF, remove the blade from the blade holders and remove the workpiece from the table.

**Fig. U**



# MAINTENANCE

## WARNING

**For your own safety, turn the switch off and remove the plug from the power source outlet before maintaining or lubricating your scroll saw.**

### GENERAL MAINTENANCE

## WARNING

**Frequently blow out dust and grit that accumulates in the motor housing using compressed air.**

ALWAYS use safety glasses. Everyday eyeglasses are NOT safety glasses. Also use face or dust mask if cutting operation is dusty. ALWAYS WEAR CERTIFIED SAFETY EQUIPMENT:

- ANSI Z87.1 eye protection (CAN/CSA Z94.3),
- ANSI S12.6 (S3.19) hearing protection,
- NIOSH/OSHA/MSHA respiratory protection.

An occasional coat of paste wax on the work table will allow the wood being cut to glide smoothly across the work surface.

## WARNING

**To avoid shock or fire hazard, if the power lead is worn or cut in any way, replace it immediately.**

### LUBRICATION

Ball bearings in the scroll saw are packed with grease at the factory and require no further lubrication.

Use only mild soap and a damp cloth to clean the tool. Never let any liquid get inside the tool; never immerse any part of the tool into a liquid.

**IMPORTANT:** To assure product SAFETY and RELIABILITY, repairs, maintenance and adjustment (other than those listed in this manual) should be performed by authorized service centers or other qualified service organizations, always using identical replacement parts.

# ACCESSORIES AND ATTACHMENTS

## AVAILABLE ACCESSORIES

### WARNING

Since accessories, other than those offered by Porter-Cable, have not been tested with this product, use of such accessories with this tool could be hazardous. To reduce the risk of injury, only Porter-Cable recommended accessories should be used with this product.

A complete line of accessories is available from your Porter-Cable Factory Service Center or a Porter-Cable Authorized Warranty Service Center. Please visit our Web Site [www.portercable.com](http://www.portercable.com) for a catalog or for the name of your nearest supplier.

### WARNING

Do not use any accessory unless you have completely read the Instruction Manual for that accessory.



# TROUBLESHOOTING GUIDE

## WARNING

To avoid injury from an accidental start, turn the switch OFF and always remove the plug from the power source before making any adjustments.

## REPLACEMENT PARTS

Use only identical replacement parts. For a parts list or to order parts, visit our service website at [www.portercable.com](http://www.portercable.com). You can also order parts from your nearest Porter-Cable Factory Service Center or Porter-Cable Authorized Warranty Service Center. Or, you can call our Customer Care Center at (888) 609-9779.

## SERVICE AND REPAIRS

All quality tools will eventually require servicing and/or replacement of parts. For information about Porter-Cable, its factory service centers or authorized warranty service centers, visit our website at [www.portercable.com](http://www.portercable.com) or call our Customer Care Center at (888) 609-9779. All repairs made by our service centers are fully guaranteed against defective material and workmanship. We cannot guarantee repairs made or attempted by others.

You can also write to us for information at Power Tool Specialists, 684 Huey Road Rock Hill, SC 29704, (888) 609-9779 - Attention: Product Service. Be sure to include all of the information shown on the nameplate of your tool (model number, type, serial number, etc.).

SYMPTOM	POSSIBLE CAUSES	CORRECTIVE ACTION
Breaking blades	<ol style="list-style-type: none"> <li>1. Wrong tension.</li> <li>2. Overworking blades.</li> <li>3. Wrong blade application.</li> <li>4. Twisting blade in wood.</li> </ol>	<ol style="list-style-type: none"> <li>1. Adjust blade tension. See BLADE REMOVAL AND INSTALLATION section.</li> <li>2. Reduce feed rate. See BLADE REMOVAL AND INSTALLATION section.</li> <li>3. Use narrow blade. See BLADE SELECTION section.</li> <li>4. Avoid side pressure on blade. See BLADE REMOVAL AND INSTALLATION section.</li> </ol>
Motor will not run.	<ol style="list-style-type: none"> <li>1. Defective cord or plug.</li> <li>2. Defective motor.</li> <li>3. Blown overload breaker.</li> </ol>	<ol style="list-style-type: none"> <li>1. Replace defective parts before using saw again. See ELECTRICAL REQUIREMENTS AND SAFETY section.</li> <li>2. Call Service Center. Any attempt to repair this motor may create a HAZARD unless the repair is done by a qualified technician.</li> <li>3. Push the on/off switch to the OFF (O) position. Let the motor cool. See OPERATION-OVERLOAD BREAKER section.</li> </ol>
Excessive vibration. <b>NOTE:</b> There will always be some vibration present when the saw is running because of motor operation.	<ol style="list-style-type: none"> <li>1. Improper mounting of saw.</li> <li>2. Unsuitable mounting surface.</li> <li>3. Loose table or table resting against motor.</li> <li>4. Loose motor mounting.</li> </ol>	<ol style="list-style-type: none"> <li>1. See mounting instructions in this manual for proper mounting technique.</li> <li>2. The heavier your workbench is, the less vibration will occur. A plywood workbench will not be as good a work surface as the same size solid lumber.</li> <li>3. Tighten the table lock knob.</li> <li>4. Tighten motor mounting screw.</li> </ol>
Blade run out. Blade not in line with arm motion.	<ol style="list-style-type: none"> <li>1. Blade holders not aligned.</li> </ol>	<ol style="list-style-type: none"> <li>1. Loosen blade holder lock screw holding blade holder to arms. Adjust position of blade holders. Retighten blade holder lock screw. See BLADE REMOVAL AND INSTALLATION section.</li> </ol>

For assistance with your product, visit our website at [www.portercable.com](http://www.portercable.com) for a list of service centers, or call the Porter-Cable Customer Care Center at (888) 609-9779.

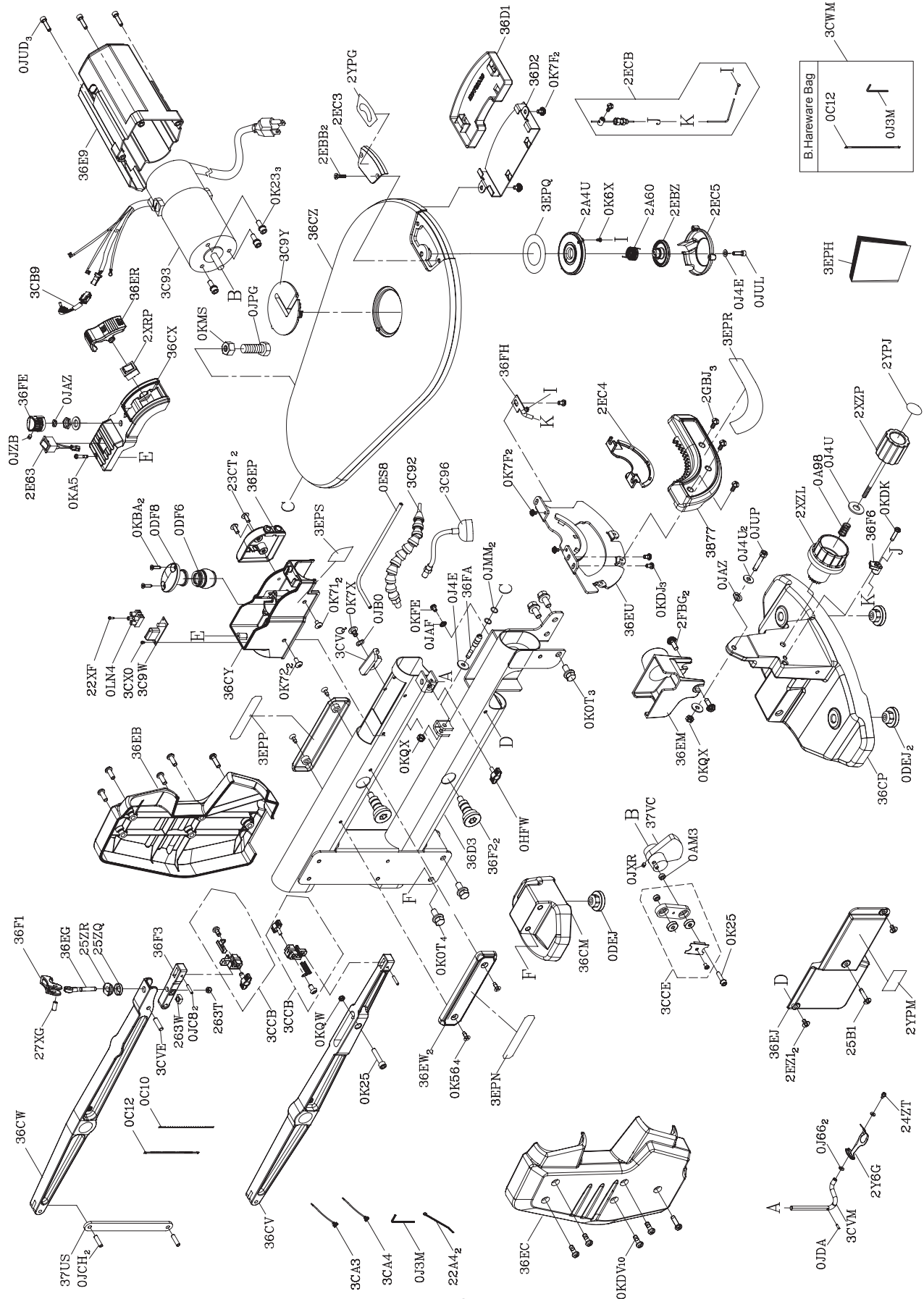
# PARTS LIST

## 18 IN. (457 MM) VARIABLE SPEED SCROLL SAW

### PARTS LIST

I.D.	Description	Size	Q'ty	I.D.	Description	Size	Q'ty
0A98	COMPRESSION SPRING		1	2ECB	WIRE ROPE ASS'Y		1
0AM3	WASHER		1	2EZ1	CR. RE. TRUSS HD. SCREW	M5*0.8-10	2
0C10	PLAIN-END BLADE	5"	1	2FBG	CR. RE. ROUND WASHER HD. SCREW	M6*1.0-12	2
0C12	PIN-END BLADE	5"	1	2GBJ	CR. RE. PAN HD. SCREW	M5*0.8-12	3
0DEJ	RUBBER PADS		3	2XRP	ROCKER SWITCH		1
0DF6	BELLOWS		1	2XZL	TENSION HANDLE		1
0DF8	PLUG HOUSING		1	2XZP	PLUNGER HANDLE		1
0ES8	PVC HOSE		1	2Y6G	FOLLOWER PLATE		1
0HFW	BOLT CLAMP		1	2YPG	CAUTION LABEL		1
0J3M	HEX. WRENCH	3 mm	1	2YPJ	CAUTION LABEL		1
0J4E	FLAT WASHER	φ6*13-1	2	2YPM	WARNING LABEL		1
0J4U	FLAT WASHER	φ6*18-1.5	3	36CM	BASE GROUP		1
0J66	FLAT WASHER	φ4*10-1	2	36CP	BASE GROUP		1
0JAF	EXTERNAL TOOTH LOCK WASHER	φ5	1	36CV	BOTTOM ARM ROCKER		1
0JAZ	WAVE WASHER		2	36CW	UPPER ARM ROCKER		1
0JB0	WAVE WASHER		1	36CX	SWITCH BOX COVER		1
0JC8	SPRING PIN		2	36CY	SWITCH BOX GROUP		1
0JCH	SPRING PIN		2	36CZ	TABLE		1
0JDA	SPRING PIN		1	36D1	BLADE BOX		1
0JMM	O-RING		2	36D2	RETAINING CLIP		1
0JPG	HEX. HD. BOLT	M6*1.0-30	1	36D3	BODY ASS'Y		1
0JUD	HEX. SOC. HD. CAP BOLT	M5*0.8-20	3	36E9	MOTOR COVER		1
0JUL	HEX. SOC. HD. CAP BOLT	M6*1.0-20	1	36EB	HOUSING RIGHT		1
0JUP	HEX. SOC. HD. CAP BOLT	M6*1.0-35	1	36EC	HOUSING		1
0JXR	HEX. SOC. SET SCREW	M8*1.25-8	1	36EG	ADJUST BOLT		1
0JZB	HEX. SOC. SET SCREW	M4*0.7-6	1	36EJ	SIDE COVER		1
0K0T	HEX. HD. SCREW AND WASHER	M8*1.25-20	8	36EM	DUST COLLECTOR		1
0K23	HEX SOC. HD. CAP SCREW	M6*1.0-16	3	36EP	SWITCH BOX COVER		1
0K25	HEX.SOCKET HD.CAP SCREWS	M5*0.8-20	1	36ER	PUSH BUTTON		1
0K56	CR. RE. COUNT HD. SCREW	M5*0.8-12	4	36EU	BRACKET-TILT		1
0K6X	CR.-RE. TRUSS HD. SCREW	M4*0.7-6	1	36EW	SIDE COVER		2
0K71	CR.-RE. TRUSS HD. SCREW	M5*0.8-8	2	36F1	CLAMP HANDLE		1
0K72	CR.-RE. TRUSS HD. SCREW	M5*0.8-12	2	36F2	SPECIAL BOLT		2
0K7F	CR. RE. ROUND WASHER HD. SCREW	M5*0.8-8	4	36F3	LOCKING ROD		1
0K7X	CR. RE. TRUSS HD. ROUND NECK SCREW	M6*1.0-10	1	36F6	GUIDE BLOCK		1
0KA5	CR.RE. PAN HD. TAPPING SCREW	M4*16-20	1	36FA	SHAFT-PIVOT		1
0KBA	CR.RE. PAN HD. TAPPING SCREW	M5*16-12	2	36FE	SPEED CONTROL BUTTON		1
0KDJ	CR. RE. PAN HD. SCREW	M5*0.8-12	3	36FH	RETAINING CLIP ASS'Y		1
0KDK	CR. RE. PAN HD. SCREW	M5*0.8-16	1	37US	STRAIGHT LINKAGE BAR		1
0KDV	CR. RE. PAN HD. SCREW	M6*1.0-16	10	37VC	ECCENTRIC		1
0KFE	CR. RE. PAN HD. SCREW	M5*0.8-6	1	3877	TRUNNION BRACKET		1
0KMS	HEX. NUT	M6*1.0 T=5	1	3C92	AIR DUCT ASS'Y		1
0KQW	LOCK NUT	M5*0.8 T=5	1	3C93	MOTOR ASS'Y		1
0KQX	NUT	M6*1.0 T=6	3	3C96	LED WORK LIGHT ASSEMBLY		1
0LN4	WIRE CONNECTOR		1	3C9W	CONTROLLER ASS'Y		1
22A4	LOCKING CABLE TIE		2	3C9Y	INSERT		1
22XF	CR.RE. PAN HD. TAPPING SCREW	M3*20-15	1	3CA3	LEAD WIRE ASS'Y		1
23CT	CR.RE. PAN HD. TAPPING SCREW	M5*12-15	2	3CA4	LEAD WIRE ASS'Y		1
24ZT	HEX.SOCKET HD.CAP SCREWS	M4*0.7-12	1	3CB9	VARIABLE RESISTOR ASSEMBLY		1
25B1	CR.-RE. TRUSS HD. SCREW	M5*0.8-25	1	3CCB	HOLDER BLADE ASS'Y		2
25ZQ	SPACER		1	3CCE	BEARING SEAT ASS'Y		1
25ZR	BRACKET STOP		1	3CVE	ROLL PIN		1
263T	CROWN NUT	M6*0.75 , T=5	1	3CVM	SUPPORT ROD		1
263W	SQUARE NUT	M6*0.75 , T=5	1	3CVQ	ANCHOR PLATE		1
27XG	ROLL PIN		1	3CX0	CR.RE. PAN HD. TAPPING SCREW	M3*24-8	1
2A4U	TURNTABLE		1	3EPH	INSTRUCTION MANUAL		1
2A60	SPRING GUARD		1	3EPN	TRADEMARK LABEL		1
2E63	ROCKER SWITCH		1	3EPP	CAUTION LABEL		1
2EBB	CR. RE.COUNT HD. TAPPING SCREW	M5*12-16	2	3EPQ	TILTING SCALE		1
2EBZ	TURNTABLE COVER	6#	1	3EPR	WARNING LABEL		1
2EC3	PLATE COVER		1	3EPS	CAUTION LABEL		1
2EC4	GUIDE HOLDER	6#	1	<b>HARDWARE BAG</b>			
2EC5	COVER	6#	1	3CWM	B. BLADE ASSEMBLY		1

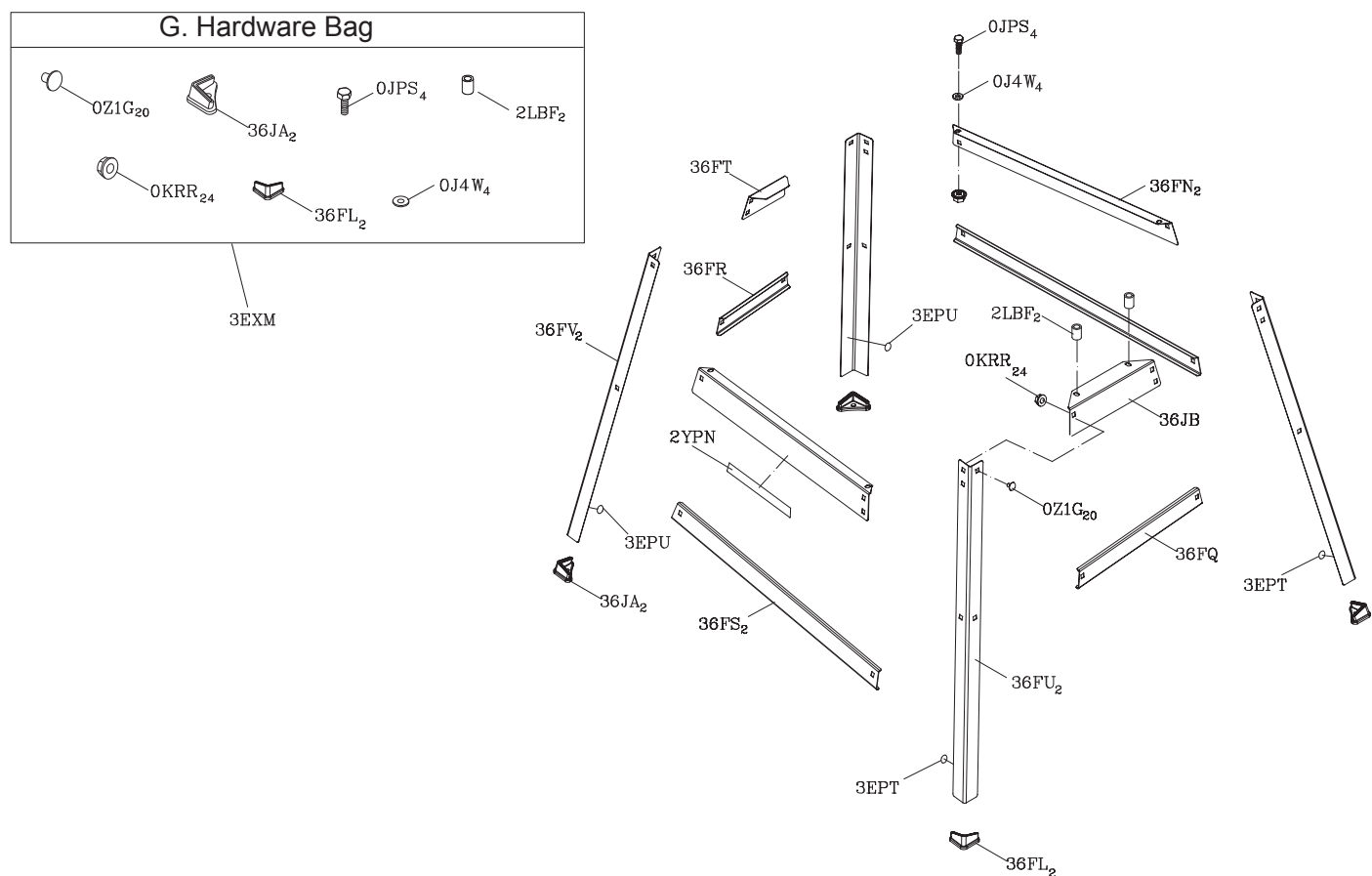
# 18 IN. (457 MM) VARIABLE SPEED SCROLL SAW SCHEMATIC



## 18 IN. (457 MM) VARIABLE SPEED SCROLL SAW

### PARTS LIST & SCHEMATIC FOR STAND

I.D.	Description	Size	Q'ty
2YPN	WARNING LABEL		1
36FN	SIDE BRACKET - UPPER SUPPORT		2
36FQ	FRONT BRACKET - LOWER SUPPORT		1
36FR	REAR BRACKET - LOWER SUPPORT		1
36FS	SIDE BRACKET - LOWER SUPPORT		2
36FT	REAR BRACKET - UPPER SUPPORT		1
36FU	STAND LEG		2
36FV	STAND LEG		2
36JB	FRONT BRACKET - UPPER SUPPORT		1
3EPT	F LABEL		2
3EPU	R LABEL		2
<b>G. HARDWARE BAG</b>			
3EXM			
0J4W	FLAT WASHER	$\phi 8.2 \times 18-1.5$	4
0JPS	HEX. HD. BOLT	M8*1.25-45	4
0KRR	SERRATED TOOTHED HEXAGON FLANGE NUT	M8*1.25 T=7.5	24
0Z1G	CAP HD. SQ. NECK BOLT	M8*1.25-12	20
2LBF	SLEEVE		2
36FL	FOOT PAD SMALL (FRONT)		2
36JA	FOOT PAD LARGE (BACK)		2



# NOTES

# WARRANTY

## THREE YEAR LIMITED WARRANTY

PORTER-CABLE will repair, without charge, any defects due to faulty materials or workmanship for three years from the date of purchase. This warranty does not cover part failure due to normal wear or tool abuse. For further detail of warranty coverage and warranty repair information, visit [www.portercable.com](http://www.portercable.com) or call (888) 609-9779. This warranty does not apply to accessories or damage caused where repairs have been made or attempted by others. This warranty gives you specific legal rights and you may have other rights which vary in certain states or provinces.

In addition to the warranty, PORTER-CABLE tools are covered by our:

**1 YEAR FREE SERVICE:** PORTER-CABLE will maintain the tool and replace worn parts caused by normal use, for free, any time during the first year after purchase.

**90 DAYS MONEY BACK GUARANTEE:** If you are not completely satisfied with the performance of your PORTER-CABLE Power Tool for any reason, you can return it within 90 days from the date of purchase with a receipt for a full refund – no questions asked.

**LATIN AMERICA:** This warranty does not apply to products sold in Latin America. For products sold in Latin America, see country specific warranty information contained in the packaging, call the local company or see website for warranty information.

To register your tool for warranty service visit our website at [www.portercable.com](http://www.portercable.com).

### WARNING LABEL REPLACEMENT

If your warning labels become illegible or are missing, call (888) 609-9779 for a free replacement.

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