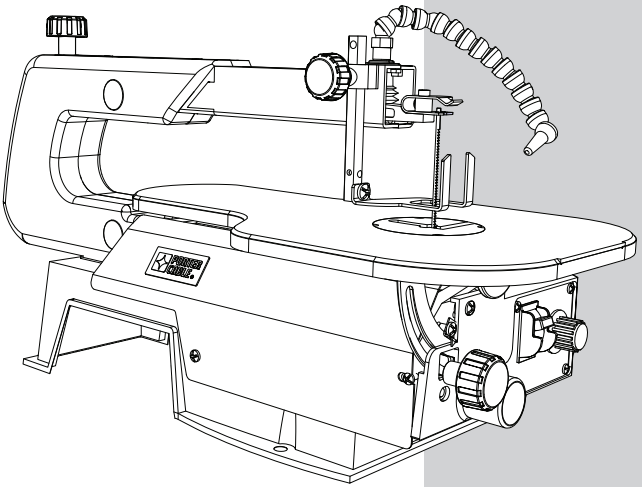
PORTER CABLE®

16 IN. (406 MM) VARIABLE SPEED SCROLL SAW

406 MM (16 PO) SCIE VARIABLE DEROULEMENT RAPIDE

SIERRA CALADORA DE VELOCIDAD VARIABLE, DE 406 MM (16 PULG.)



Instruction Manual
Manuel d'instructions
Manual de instrucciones

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INSTRUCTIVO DE OPERACIÓN, CENTROS DE SERVICIO Y PÓLIZA DE GARANTÍA.
⚠ **ADVERTENCIA:** LÉASE ESTE INSTRUCTIVO ANTES DE USAR EL PRODUCTO.

CATALOG NUMBER
PCXB340SS

TABLE OF CONTENTS

PRODUCT SPECIFICATIONS

MOTOR	
Power Source	120 V, 60 Hz, 1.2 A
Speed Control	Electric
BLADE	
Blade Length	5 in.
Type	Pin-end or Plain-end
Depth of Throat	16 in. (406 mm)
Blade Speed	550-1600 SPM
Blade Stroke	3/4 in. (19 mm)
Depth of 90° Cut	2 in. (50.8 mm)
Depth of 45° Cut, Left	3/4 in. (19 mm)

TABLE	
Size	16-9/32 in. x 10 in. (414 mm x 254 mm)
Tilt	45° Left
SAWDUST BLOWER	Yes

⚠ 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 120 Volt operation. It must be connected to a 120 V, 1.2 Amp branch circuit and use a 1.2 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.

SAVE THESE INSTRUCTIONS

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.

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

⚠ 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 chemicals: 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.

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.**
- **Read all instructions before operating product. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.**

1.  **READ** and become familiar with the entire Instruction Manual. **LEARN** the tool's application, limitations and possible hazards.

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 or wet 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 7 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. Nonslip 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. **⚠ WARNING**
People with electronic devices, such as pacemakers, should consult their physician(s) before using this product. Operation of electrical equipment in close proximity to a heart pacemaker could cause interference or failure of the pacemaker.

27.  **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 120 V operation. Connect to a 120 V, 1.2 Amp circuit and use a 1.2 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 1.2 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 m)	50 (15.24 m)	100 (30.48 m)	150 (45.72 m)	ft.
		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

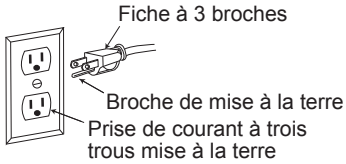
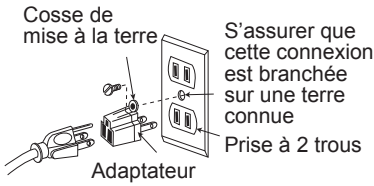


Fig. 2



TOOLS NEEDED FOR ADJUSTMENT

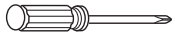
Supplied

2.5 mm hex key

3 mm hex key

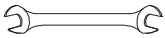
Not Supplied

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.

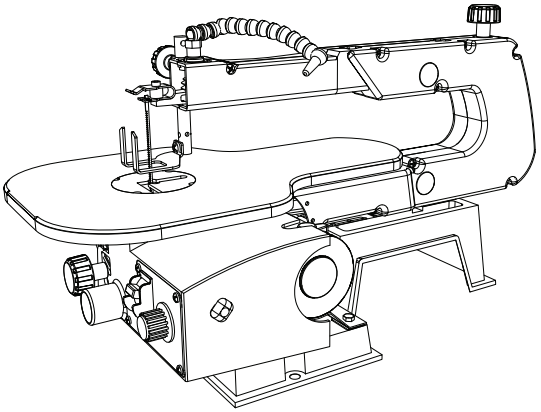
⚠ WARNING

- **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.**

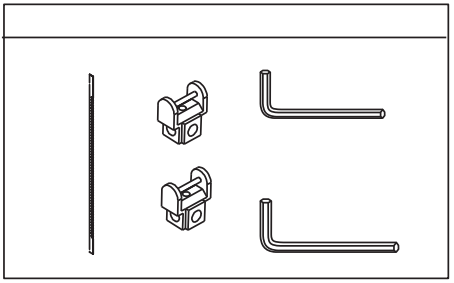
TABLE OF LOOSE PARTS

ITEM	DESCRIPTION	Q'TY
A.	Scroll saw assembly	1
B.	Blade bag	
	Plain-end blade	1
	Blade adaptors	2
	2.5 mm hex key	1
	3 mm hex key	1

UNPACKING YOUR SCROLL SAW

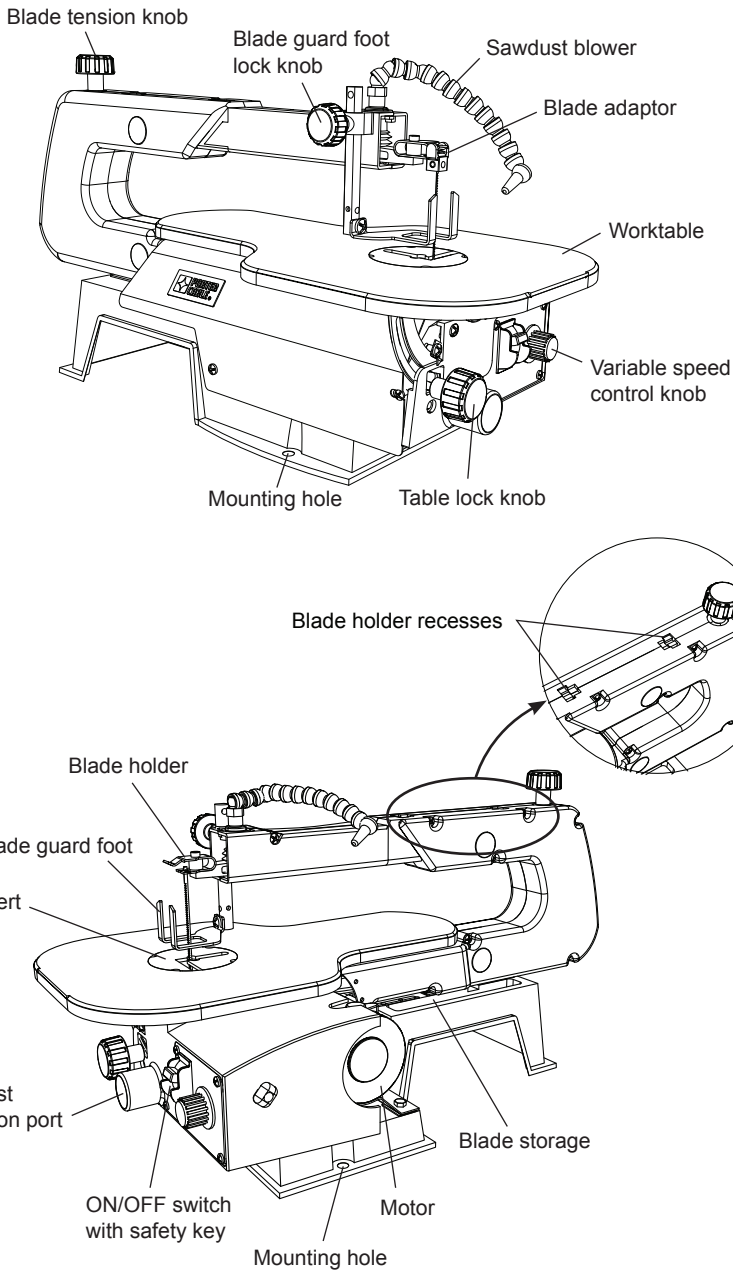


A



B

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.

BLADE TENSION KNOB – The blade tension knob 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 550 to 1600 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.

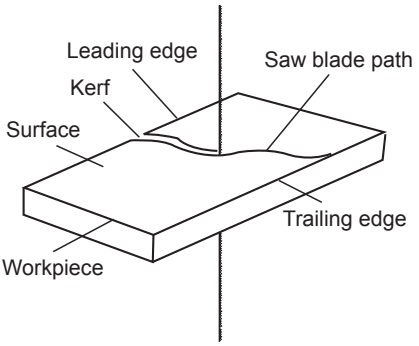
LEADING EDGE – The front edge of the workpiece that is guided into the blade.

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: 5 minutes.

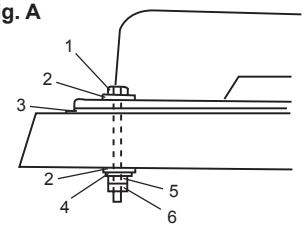
MOUNTING SCROLL SAW TO WORK SURFACE (FIG. A)

⚠ WARNING

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.

1. There are two mounting holes on the saw base for mounting the scroll saw to a workbench or 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. A should be used:

Fig. A

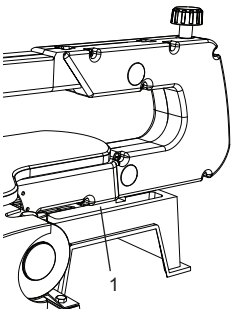


1. Hex bolts; length as required
2. Flat washers
3. Foam pad or carpet (optional)
4. Lock washers
5. Hex nuts
6. Jam nuts

BLADE STORAGE (FIG. B)

The blade storage (1) is located on the right rear side of the scroll saw body. The blade storage can conveniently store pin-end and plain-end blades.

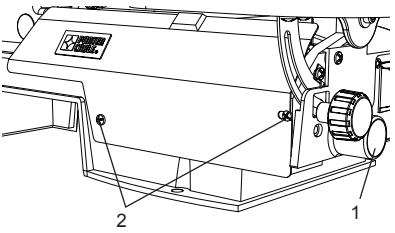
Fig. B



SAWDUST COLLECTION PORT (FIG. C)

This scroll saw will accept a hose or vacuum accessory (not provided) to be connected to the sawdust collection port (1) on the front of base. If excessive sawdust buildup occurs inside the base, use a wet/dry vacuum cleaner or manually remove sawdust by first unplugging the saw from the power source, then removing the two screws (2) on the left side of saw holding the plate cover. After cleaning all sawdust buildup, reattach the plate cover and screws (2) before restarting the saw. This will keep your saw cutting efficiently.

Fig. C



BLADE REMOVAL AND INSTALLATION

PIN-END BLADE REMOVAL AND INSTALLATION

⚠ WARNING

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

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

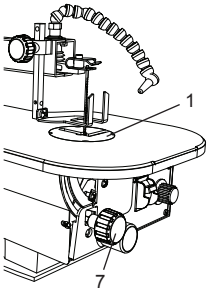
Pin-end type blades are often thicker than plain-end blades and offer more stability and faster assembly. These blades are used whenever faster cutting on a variety of materials and 3/4 in. (19 mm) thickness or greater are required. Use whenever less precision or thicker kerf cutting is acceptable.

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. D, E, F)

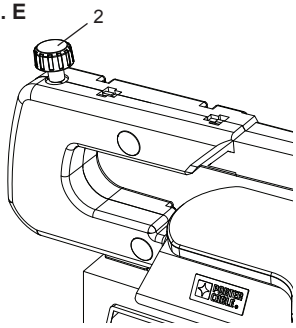
1. Remove the table insert (1) by pushing it up from under the worktable. (Fig. D)
   NOTE: Be careful not to make contact with the blade.

Fig. D



2. Loosen the blade tension by trurning the blade tension knob (2) counterclockwise. (Fig. E)
   NOTE: The hex set screw (3) on the top side is used for fine adjustments and is only adjusted if the blade is not perpendicular to the table. (Fig. F)

Fig. E

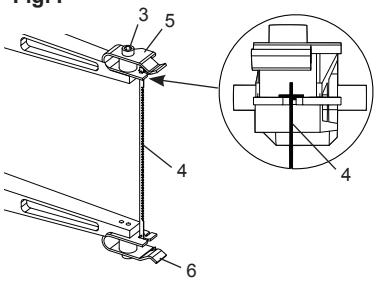


3. Remove the blade (4) from the upper (5) and lower (6) blade holders by pulling blade forward to release, and lift the blade through the access hole. (Fig. F)

NOTE:

- Apply slight downward pressure on the upper arm when removing the blade from the upper blade holder.
- If the tension is still too tight to remove blade, turn the tension konb counterclockwise no more than one rotation. (Do not over-loosen.)

Fig. F



Pin-end blade installation (Fig. D, E, G, H)

CAUTION

In order to avoid uncontrollable lifting of the workpiece, the teeth of the blade should ALWAYS point downward. (Fig. G)

Fig. G

1. Remove the table insert (1) by pushing it up from under the worktable. (Fig. D)
2. Loosen the blade tension by trurning the blade tension knob (2) counterclockwise. (Fig. E)
3. Tilt the table to the 0° and tighten the table lock knob (7). (Fig. D)
4. Install the blade by inserting one end of it through the access hole (8) in the table. Hook the lower blade pin in the pin recess of the lower blade holder (6) and then the upper blade pin of the upper blade holder (5). (Fig. H)
5. Check the pins are properly located in the pin recess of upper and the lower blade holders.
6. Tighten the tension on the blade by turning the blade tension knob (2) clockwise. If the tension is too tight, turn counterclockwise. If too loose, turn the knob clockwise. Do not make too tight or blade will easily break in use. (Fig. E)

Fig. H

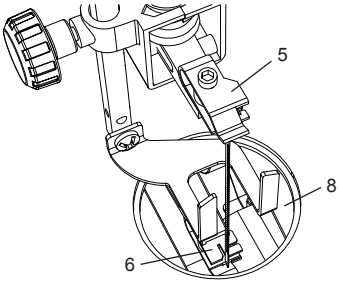
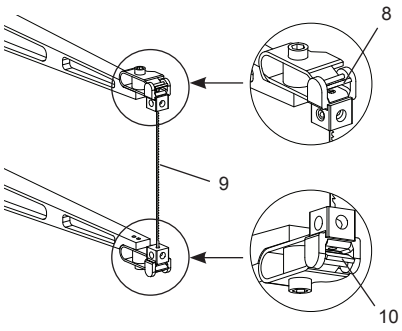


Fig. I



PLAIN-END BLADE REMOVAL AND INSTALLATION

⚠ WARNING

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

This scroll saw accepts 5 in. (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 and tension the blade, but you will also be able to use finer blades for cutting a thinner kerf.

Plain-end blade removal (Fig. D, E, I)

1. Remove the table insert (1) by pushing it up from under the worktable. (Fig. D)
2. Loosen the blade tension by trurning the blade tension knob (2) counterclockwise. (Fig. E)
3. Tilt the table to the 0° and tighten the table lock knob (7). (Fig. D)
4. Apply slight downward pressure on the upper arm to remove the blade adaptor set from the upper blade holder clip (8) and then from the lower blade holder clip (10). (Fig. I)
5. Remove the plain-end blade (9) from the upper and lower blade adaptor set.

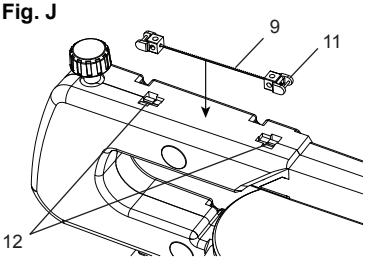
Plain-end blade installation (Fig. D, E, I, J)

CAUTION

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

1. Insert the plain-end blade (9) into the blade adaptors (11). (Fig. J)
2. Put the blade adaptor set into the recesses (12) on the rear top of the saw to adjust the blade length, and then secure the blade by fixing the inner screws of the blade adaptors with 2.5 mm hex wrench.

Fig. J



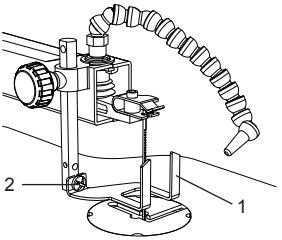
3. Remove the table insert (1) by pushing it up from under the worktable. (Fig. D)
4. Loosen the blade tension by trurning the blade tension knob (2) counterclockwise. (Fig. E)
5. Tilt the table to the 0° and tighten the table lock knob (7). (Fig. D)
6. Hang the blade adaptor set on the lower blade holder clip (10). (Fig. I)
7. Apply slight downward pressure against the upper arm when hanging the other end of the blade adaptor set on the upper blade holder clip (8).

8. Tighten the tension on the blade by turning the blade tension knob (2) clockwise. If the tension is too tight, turn counterclockwise. If too loose, turn the knob clockwise. Do not make too tight or blade will easily break in use. (Fig. E)

BEVEL ADJUSTMENT (FIG. K, L)

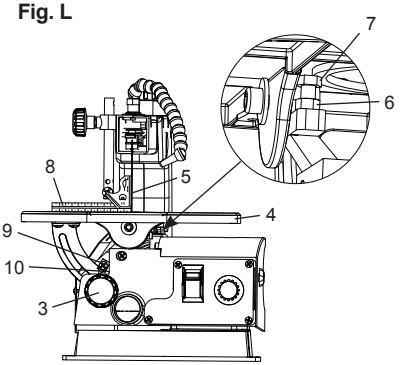
1. Remove the blade guard foot (1) by using the Phillips screwdriver to loosen the screw (2). (Fig. K)

Fig. K



2. Loosen the table lock knob (3) and move the table (4) until it is approximately at a right angle to the blade (5). (Fig. L)
3. Loosen the lock nut (6) and adjust the adjusting screw (7) under the table by turning counterclockwise.
4. Lower the adjusting screw (7) by turning clockwise.
5. Use a combination square (8) to set the table exactly 90° (0°) to the blade. If there is space between the square and blade, adjust the table angle until the space is closed.
6. Lock the table lock knob (3) to prevent movement. Raise the adjusting screw (7) under the tabel until the tip of the screw touches the table.
7. Tighten the lock nut (6).
8. When the blade is exactly 90° (0°) to the table, loosen the bevel indicator screw (9) using a Phillips screwdriver.
9. Adjust the bevel indicator (10) to the “0” mark on the bevel scale and retighten the indicator screw (9).
10. Attach the blade guard foot (1) using the Phillips screwdriver, so the foot rests flat against the table and tighten.

Fig. L



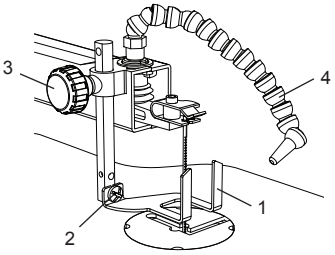
BLADE GUARD FOOT ADJUSTMENT (FIG. M)

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 screw (2) with the Phillips screwdriver, tilt the blade guard foot (1) 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. M)

The sawdust blower (4) 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.

BLADE SELECTION (FIG. N)

⚠ WARNING

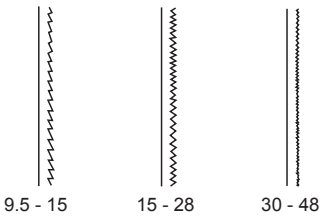
To avoid injury from accidental starting, always turn the switch OFF and unplug the scroll saw before moving, replacing the blade or making adjustments.

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. N



General Scroll Saw Blade Reference Guide		
Tooth Type	TPI ←Speed→ Faster Slower	Application
Standard	9.5 ~ 48	General cutting
Skip	9.5 ~ 33	Better chip removal. Smooth, splinterless finish
Double	10 ~ 37	Efficient chip removal. Clean edges
Reverse	9/5 ~ 28/21	Eliminates underside tearout. Smooth, splinterless finish
Spiral	36 ~ 46	All direction cutting

1. Hard, thicker wood - Coarse TPI, slower speed.
2. Soft, thinner wood - Fine TPI, faster speed.
3. Plastic materials - Slower speed.
4. Please use the blades for the applications recommended by the blade suppliers.

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.
- 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.**
- **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.**

VARIABLE SPEED CONTROL KNOB (FIG. O)

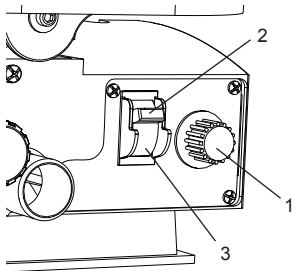
1. Your saw is equipped with a variable speed control knob (1). The blade stroke rate may be adjusted by simply rotating the variable speed control knob (1).
2. Turn the control knob clockwise to increase up to 1,600 strokes per minute (SPM). Turn the control knob counterclockwise to reduce, down to 550 strokes per minute (SPM).

ON/OFF SWITCH (FIG. O)

The ON/OFF switch has a removable, safety key (2). With the safety key removed from the switch, unauthorized and hazardous use by children and others is minimized.

1. To turn the scroll saw "ON", insert the safety key (2) into the slot of the switch (3). Move the switch upward to the "ON" position.
2. To turn the scroll saw "OFF", move the switch downward.
3. To lock the switch in the OFF position, grasp the sides of the safety key, and pull it out.
4. With the safety key removed, the switch will not turn the power tool on.
5. If the safety key is removed while the scroll saw is running, it can be turned "OFF" but cannot be restarted without inserting the safety key.

Fig. O



RECOMMENDATIONS FOR CUTTING

1. When feeding the workpiece into the blade do not force the leading edge of the workpiece into the blade because the 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. P)

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.

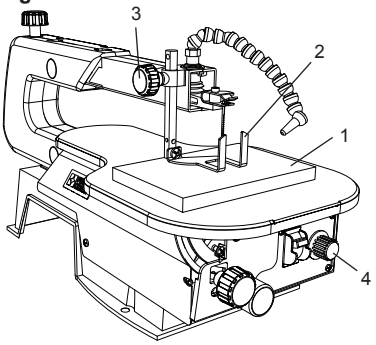
   ⚠ CAUTION

   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. P



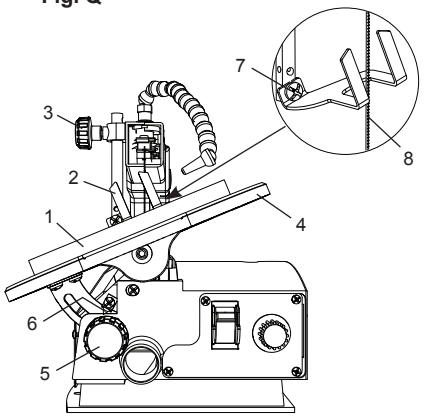
LEFT BEVEL CUTTING (MAXIMUM 45 DEGREES) (FIG. Q)

⚠ WARNING

- **To avoid injury from an accidental starting, make sure the switch is in the OFF position and the plug is not connected to the power source outlet before moving, replacing the blade or making adjustments.**
- **To avoid injury, always keep your hands off the underneath of the table during operating.**

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 (4) to the desired angle by loosening the table lock knob (5) and move the table to the proper angle, using the degree scale and the pointer (6).
4. Tighten the table lock knob (5).
5. Loosen the blade guard screw (7), and tilt the blade guard to the same angle as the table (4). Retighten the blade guard screw (7).
6. Position the workpiece on the left and right side of the blade (8). Lower the blade guard foot slightly above the surface by loosening the blade guard foot lock knob (3).
7. Follow items 4 - 8 under the section of **FREEHAND CUTTING**.

Fig. Q



RIP OR STRAIGHT LINE CUTTING (FIG. R)

⚠ WARNING

To avoid injury from an accidental starting, make sure the switch is in the OFF position and the plug is not connected to the power source outlet before moving, replacing the blade or making adjustments.

Tools Needed (Not Included)

Q'TY	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. 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.

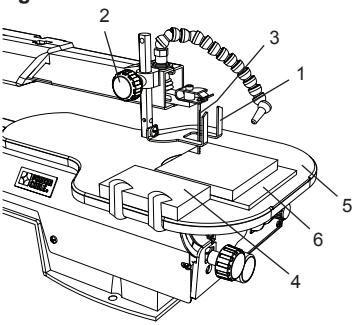
7. Position the workpiece against the straight edge (4) prior to touching the leading edge of the workpiece against the blade (3).
8. Slowly feed the workpiece into the blade, guiding the workpiece against the straight edge and press the workpiece down against the table while cutting.

⚠ 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.

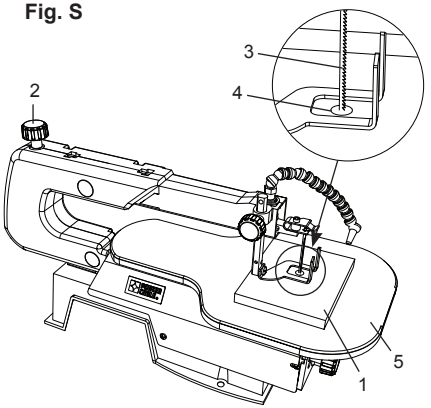
Fig. R



INTERIOR CUTTING (FIG. S)

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 knob (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 tighten the blade tension knob (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. S



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.

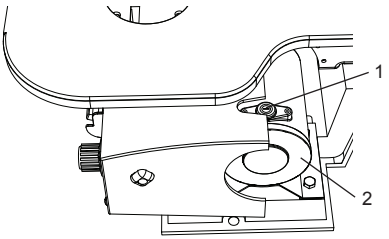
REPLACING CARBON BRUSHES (FIG. T)

Replace both carbon brushes when either has less than 1/4 in. length of carbon remaining, or if the spring or wire is damaged or burned. To inspect or replace brushes, first unplug the saw. Then remove the black plastic cap (1) on the side of the motor (2). Carefully remove the spring-loaded cap. Then pull out the brush and replace. Repeat for the other side. To reassemble reverse the procedure.

The ears on the metal end of the assembly go in the same hole the carbon part fits into. Tighten the cap snugly, but do not overtighten.

NOTE: When reinstalling the same brushes, put them back in the way they came out. This will avoid a break-in period that reduces motor performance and increases wear.

Fig. T



LUBRICATION

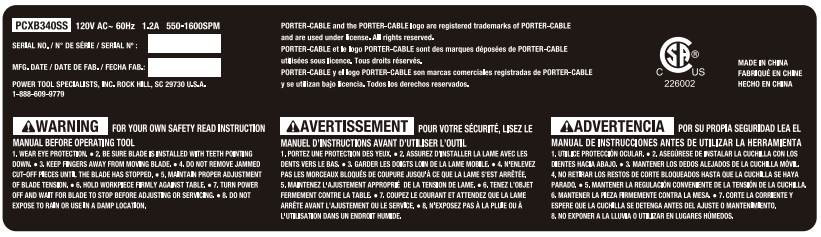
Ball bearings in the scroll saw are packed with grease at the factory and require no further lubrication.

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.

FREE WARNING LABEL REPLACEMENT:

If your warning labels become illegible or are missing, call 1-888-609-9779 for a free replacement.



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 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. 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 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 29730, - Attention: Product Service. Be sure to include all of the information shown on the nameplate of your tool (model number, type, serial number, etc.).

PLEASE READ THE FOLLOWING: The manufacturer and/or distributor is providing the buyer with a parts list and assembly diagram in this manual as a reference tool only. Neither the manufacturer nor distributor make any representation or warranty of any kind to the buyer regarding the accuracy of the list or diagram or that buyer is qualified and able to make any repairs or replace any parts of the product. The manufacturer and/or distributor expressly recommend: that all repairs and/or part replacements only be undertaken by a certified and licensed technician, and not by the buyer. The buyer assumes all risk and liability, including injuries to persons and damage to property, associated with and arising out of any attempt of the buyer at repairs or replacement of parts to the product.

PROBLEM	POSSIBLE CAUSES	CORRECTIVE ACTION
Breaking blades	1. Wrong tension. 2. Overworking blades. 3. Wrong blade application. 4. Twisting blade in wood.	1. Adjust blade tension. See BLADE REMOVAL AND INSTALLATION section. 2. Reduce feed rate. See BLADE REMOVAL AND INSTALLATION section. 3. Use narrow blade. See BLADE SELECTION section. 4. Avoid side pressure on blade. See BLADE REMOVAL AND INSTALLATION section.
Motor will not run.	1. Defective cord or plug. 2. Defective motor. 3. Blown overload breaker.	1. Replace defective parts before using saw again. See ELECTRICAL REQUIREMENTS AND SAFETY section. 2. Call Service Center. Any attempt to repair this motor may create a HAZARD unless the repair is done by a qualified technician. 3. Push the on/off switch to the OFF position. Let the motor cool.

PROBLEM	POSSIBLE CAUSES	CORRECTIVE ACTION
Excessive vibration. **NOTE**: There will always be some vibration present when the saw is running because of motor operation.	1. Improper mounting of saw. 2. Unsuitable mounting surface. 3. Loose table or table resting against motor. 4. Loose motor mounting.	1. See mounting instructions in this manual for proper mounting technique. 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. 3. Tighten the table lock knob. 4. Tighten motor mounting screw.
Blade run out. Blade not in line with arm motion.	1. Blade holders not aligned.	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.

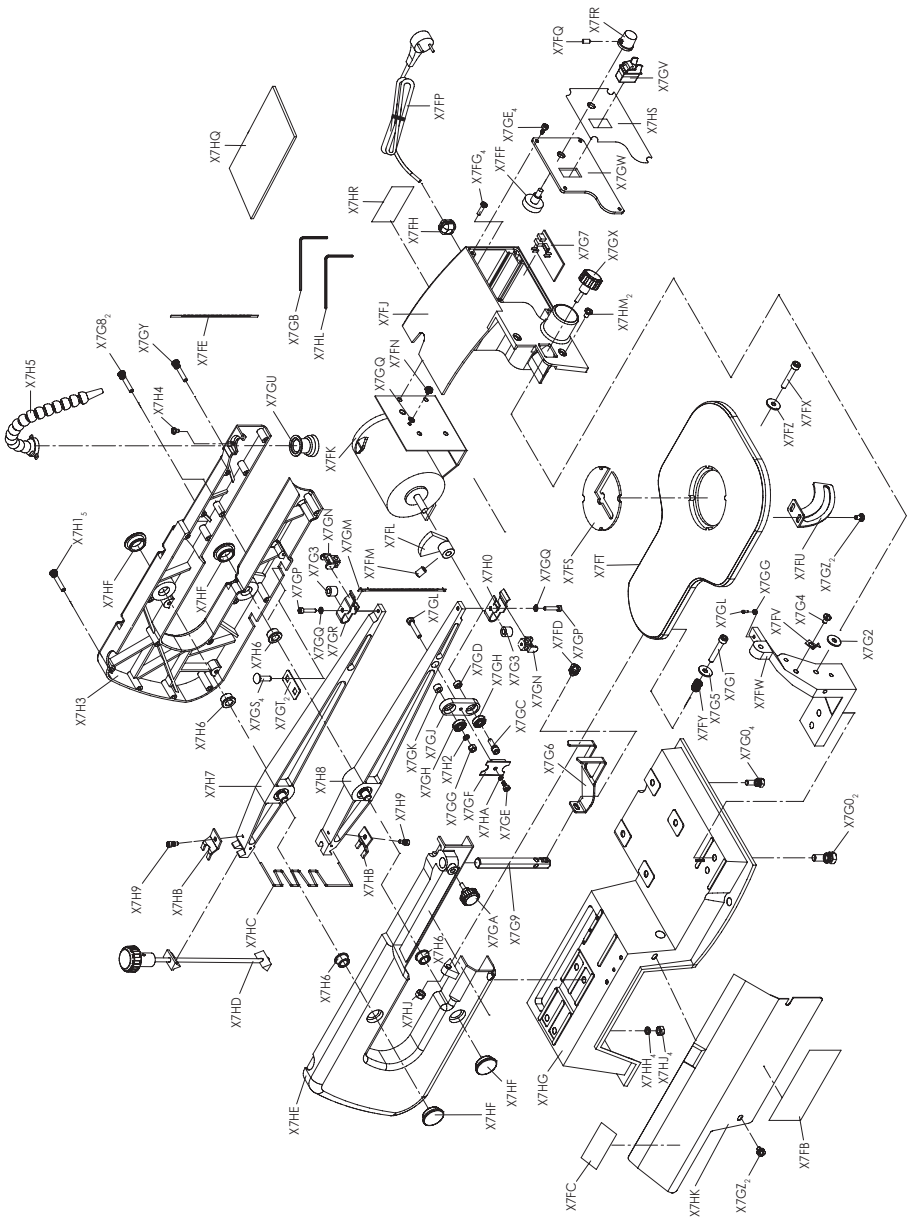
For assistance with your product, visit our website at www.portercable.com for a list of service centers, or call the Porter-Cable Customer Care Center at (888) 609-9779.

PARTS LIST

16 IN. (406 MM) VARIABLE SPEED SCROLL SAW
PARTS LIST

I.D. No.	Description	Size	Q'ty
X7FB	DATA LABEL		1
X7FC	TRADEMARK LABEL		1
X7FD	PHILLIPS SCREW	M6*10	1
X7FE	PLAIN-END BLADE		1
X7FF	POTENTIOMETER		1
X7FG	PHILLIPS SCREW	M4*10	4
X7FH	CORD CLIP		1
X7FJ	SWITCH BOX		1
X7FK	MOTOR		1
X7FL	ECCENTRICITY		1
X7FM	HEX. SOC. SCREW	M8*12	1
X7FN	PHILLIPS SCREW	M4*8	1
X7FP	POWER CORD		1
X7FQ	HEX. SOC. SCREW	M5*6	1
X7FR	VARIABLE SPEED CONTROL KNOB		1
X7FS	TABLE INSERT		1
X7FT	TABLE		1
X7FU	SCALE		1
X7FV	POINTER		1
X7FW	TABLE BRACKET		1
X7FX	HEX. SOC. SCREW	M6*20	1
X7FY	COMPRESSION SPRING		1
X7FZ	FLAT WASHER		1
X7G0	HEX. BOLT	M6*16	6
X7G1	HEX. SOC. SCREW	M6*40	1
X7G2	PVC WASHER		1
X7G3	BUSHING		2
X7G4	PHILLIPS SCREW	M6*10	1
X7G5	FLAT WASHER		1
X7G6	BLADE GUARD FOOT		1
X7G7	PC BOARD		1
X7G8	PHILLIPS SCREW	M5*30	2
X7G9	PRESSURE POLE		1
X7GA	PRESSURE POLE KNOB		1
X7GB	HEX. WRENCH	3MM	1
X7GC	HEX. SOC. SCREW	M5*16	1
X7GD	SMALL CUSHION		1
X7GE	PHILLIPS SCREW	ST4.2*9.5	5
X7GF	CONNECTOR PRESSURE PLATE		1
X7GG	HEX. NUT, TYPE I	M5	2
X7GH	BALL BEARING		2
X7GJ	ECCENTRICITY CONNECTOR ASS'Y		1
X7GK	BIG CUSHION		1
X7GL	HEX. SOC. SCREW	M5*25	2
X7GM	PIN-END BLADE		1
X7GN	BLADE ADAPTOR		2
X7GP	HEX. BOLT	M4*20	2
X7GQ	TOOTH WASHER		3
X7GR	UPPER BLADE SUPPORT		1
X7GS	DOME SCREW	M6*20	4
X7GT	FIXING PLATE		2
X7GU	BELLOW		1
X7GV	SWITCH		1
X7GW	SWITCH BOX COVER		1
X7GX	TABLE LOCK KNOB		1
X7GY	PHILLIPS SCREW	M5*28	1
X7GZ	PHILLIPS SCREW	M5*8	4
X7H0	LOWER BLADE SUPPORT		1
X7H1	PHILLIPS SCREW	M5*35	5
X7H2	STANDARD SPRING WASHER		1
X7H3	HOUSING SET (RIGHT)		1
X7H4	PHILLIPS SCREW	M4*8	1
X7H5	SAWDUST BLOWER		1
X7H6	ARM BEARING		4
X7H7	UPPER ARM		1
X7H8	LOWER ARM		1
X7H9	HEX. SOC. SCREW	M4*10	2
X7HA	STANDARD SPRING WASHER		1
X7HB	PRESSURE PLATE		2
X7HC	EXTENSION SPRING		1
X7HD	TENSION BOLT ASS'Y		1
X7HE	HOUSING SET (LEFT)		1
X7HF	OIL CAP		4
X7HG	BASE		1
X7HH	STANDARD SPRING WASHER		4
X7HJ	HEX. NUT, TYPE I	M6	5
X7HK	SIDE COVER		1
X7HL	HEX. WRENCH	2.5 MM	1
X7HM	PHILLIPS SCREW	M5*8	2
X7HQ	INSTRUCTION MANUAL		1
X7HR	WARNING LABEL		1
X7HS	VARIABLE SPEED LABEL		1

16 IN. (406 MM) VARIABLE SPEED SCROLL SAW
SCHEMATIC



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 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.

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

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