

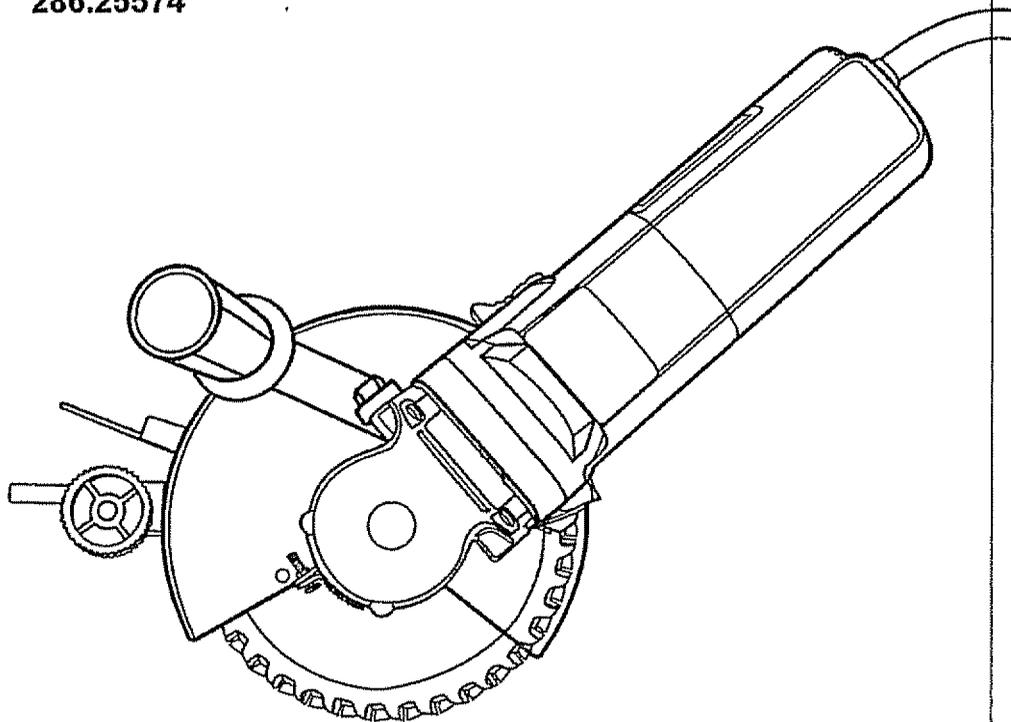
Owner's Manual

CRAFTSMAN®

PROFESSIONAL

6 1/8-in. TWIN CUTTER SAW

Model No.
286.25574



⚠ CAUTION: Read, understand and follow all Safety Rules and Operating Instructions in this manual before using this product.

- SAFETY
- OPERATION
- MAINTENANCE
- ESPAÑOL

Sears, Roebuck and Co., Hoffman Estates, IL 60179 U.S.A.
Visit our Craftsman® website: www.sears.com/craftsman

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ONE FULL YEAR WARRANTY ON CRAFTSMAN® PROFESSIONAL TOOL

If this Craftsman Professional tool fails to give complete satisfaction within 90 days from the date of purchase, return it to any Sears Store or other Craftsman Outlet in the United States for free replacement.

After 90 days and through one year from the date of purchase, if this Craftsman Professional tool fails to give complete satisfaction, return it to any Sears store or Parts & Repair Center or other Craftsman Outlet for free repair (or replacement if repair proves impossible.)

This warranty gives you specific legal rights, and you may also have other rights, which vary, from state to state.

Sears, Roebuck and Co., Hoffman Estates, IL 60179

**SAVE THESE INSTRUCTIONS!
READ ALL INSTRUCTIONS!**

SAFETY INSTRUCTIONS



WARNING: BE SURE to read and understand all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious personal injury.

WORK AREA SAFETY

1. **ALWAYS** keep your work area clean and well lit. Cluttered benches and dark areas invite accidents.
2. **DO NOT** operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases, or dust. Power tools create sparks which may ignite the dust or fumes.
3. **ALWAYS** keep bystanders, children, and visitors away while operating a power tool. Distractions can cause you to lose control

ELECTRICAL SAFETY

1. Double insulated tools are equipped with a polarized plug (one blade is wider than the other.) This plug will fit in a polarized outlet only one way. If the plug does not fit fully in the outlet, reverse the plug. If it still does not fit, contact a qualified electrician to install a polarized outlet. Do not change the plug in any way.
2. Double insulation eliminates the need for the three-wire grounded power cord and grounded power supply system. Applicable only to Class II (double insulated) tools.
3. Before plugging in the tool, **BE SURE** that the outlet voltage supplied is within the voltage marked on the tool's data plate. **DO NOT** use "AC only" rated tools with a DC power supply.
4. **ALWAYS** avoid body contact with grounded surfaces, such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is grounded.
5. If operating the power tool in damp locations is unavoidable, **ALWAYS** use a Ground Fault Circuit Interrupter to supply power to your tool. **ALWAYS** wear electrician's rubber gloves and footwear in damp conditions.
6. **DO NOT** expose power tools to rain or wet conditions. Water entering a power tool will increase the risk of electric shock.
7. **DO NOT** abuse the cord. **NEVER** use the cord to carry the tools or pull the plug from the outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock.
8. When operating a power tool outside, **ALWAYS** use an outdoor extension cord marked "W-A" or "W". These cords are rated for outdoor use and reduce the risk of electric shock.

NOTE: The extension cord must have adequate wire size AWG (American Wire Gauge) for safe, efficient use. Smaller gauge wires, have greater capacity (16 gauge wire has more capacity than 18 gauge wire).

SAFETY INSTRUCTIONS cont.

PERSONAL SAFETY

- 1. ALWAYS stay alert, watch what you are doing and use common sense when operating a power tool. DO NOT use tool while tired or under the influence of drugs, alcohol, or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- 2. ALWAYS dress properly. DO NOT wear loose clothing or jewelry. Pull back long hair. Keep your hair, clothing, and gloves away from moving parts.** Loose clothes, jewelry, or long hair can be caught in moving parts.
- 3. ALWAYS avoid accidental starting. BE SURE switch is in the "Off" position before plugging in. DO NOT carry tools with your finger on the switch.** Carrying tools with your finger on the switch or plugging in tools that have the switch in the "On" position invites accidents.
- 4. ALWAYS remove adjusting keys or wrenches before turning the tool "On".** A wrench or a key that is left attached to a rotating part of the tool may result in personal injury.
- 5. DO NOT overreach. ALWAYS keep proper footing and balance at all times.** Proper footing and balance enables better control of the tool in unexpected situations.
- 6. ALWAYS use safety equipment. Always wear eye protection.** Dust mask, non-skid safety shoes, hardhat, or hearing protection must be used for appropriate conditions.

TOOL USE AND CARE SAFETY

- 1. ALWAYS use clamps or other practical ways to secure and support the workpiece to a stable platform.** Holding the work by hand or against your body is unstable and may lead to loss of control.
- 2. DO NOT force the tool. Use the correct tool for your application.** The correct tool will do the job better and safer at the rate for which it is designed.
- 3. DO NOT use the tool if the switch does not turn it "On" or "Off".** Any tool that cannot be controlled with the switch is dangerous and must be repaired.
- 4. ALWAYS disconnect the plug from the power source before making any adjustments, changing accessories or storing the tool.** Such preventive safety measures reduce the risk of starting the tool accidentally.
- 5. ALWAYS store idle tools out of the reach of children and other untrained persons.** Tools are dangerous in the hands of untrained users.
- 6. ALWAYS maintain tools with care. Keep cutting tools sharp and clean.** Properly maintained tools with sharp cutting edges are less likely to bind and are easier to control.
- 7. ALWAYS check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tool's operation. If damaged, have the tool serviced before using.** Many accidents are caused by poorly maintained tools.

⚠ WARNING: USE OF ACCESSORIES THAT ARE NOT RECOMMENDED FOR USE WITH THIS TOOL MAY CREATE A HAZARDOUS CONDITION

- 8. ALWAYS use only accessories that are recommended for this tool.** Accessories that may be suitable for one tool can become hazardous when used on another tool.

SAFETY INSTRUCTIONS cont.

SERVICE SAFETY

1. If any part of this saw is missing or should break, bend, or fail in any way; or should any electrical component fail to perform properly: **ALWAYS** shut off the power switch and remove the saw plug from the power source and have the missing, damaged or failed parts replaced **BEFORE** resuming operation.
2. **Tool service must be performed only at a Sears Parts and Repair Center.** Service or maintenance performed by unqualified personnel could result in a risk of injury.

SAFETY RULES FOR SAWS

⚠ DANGER! Keep hands away from cutting area and blades. Keep your second hand on the auxiliary handle or motor housing. If both hands are holding the saw, they cannot be cut by the blades.

1. **ALWAYS** keep your body positioned to either side of the saw blades, but not in line with the saw blades.
2. **DO NOT** reach underneath the work. The guard cannot protect you from the blades beneath the work.
3. **ALWAYS** check guard for proper closing **BEFORE** each use. **DO NOT** operate the saw if the guard does not move freely and close instantly. Never clamp or tie the blade guard in the open position. If the saw is accidentally dropped, the guard may be bent. Raise the guard and make sure that it moves freely and does not touch the blades or any other part.
4. **ALWAYS** check the operation and condition of the guard spring. If the guard and the spring are not operating properly, they **MUST** be serviced before use. The blade guard may operate sluggishly, due to damaged parts, gummy deposits, or a buildup of debris.
5. The guard should be retracted manually **ONLY** for making special cuts, such as pocket or compound cuts. **ALWAYS** raise the guard by retracting the handle. As soon as the blade enters the material, the guard **MUST** be released. For all other sawing, the guard should operate automatically.
6. **ALWAYS** make sure that the guard is covering the blades **BEFORE** placing the saw down on a work bench or floor. An unprotected moving blade will cause the saw to walk backwards, cutting whatever is in its path. Make note of the time it takes for the blades to stop spinning after the switch is released.
7. **NEVER** hold the piece being cut in your hands or across your legs. It is important to support the work properly in order to minimize body exposure, blade binding, or loss of control.
8. **ALWAYS** hold tool by insulated gripping surfaces when performing an operation where the cutting tool may contact hidden wiring or its own cord. Contact with a "live" wire will make the exposed metal parts of the tool "live" and shock the operator.
9. **DO NOT** leave the saw running when carrying it in your hand. The lower blade guard may be opened by contact with your clothing. Accidental contact with the spinning saw blades could result in serious personal injury.
10. **DO NOT** use the tool if the switch does not turn "On" or "Off". Any tool that cannot be controlled with the switch is dangerous and must be repaired.

SAFETY INSTRUCTIONS cont.

SAFETY RULES FOR SAW cont.

11. When removing the blades from the tool, **ALWAYS** wear protective gloves when grasping the blades or accessory. Accessories may be hot after prolonged use.

KICKBACK...WHAT CAUSES IT AND WAYS TO PREVENT IT

The Causes of Kickback

1. Kickback is a sudden reaction to a pinched, bound or misaligned saw blades, which cause the uncontrolled saw to lift up and out of the workpiece and towards the operator.
2. When the blades are pinched or bound tightly by the kerf closing down, the blades stall and the motor reaction drives the unit rapidly back towards the operator.
3. If the blades become twisted or misaligned in the cut, the teeth at the back edges of the blades can dig into the top surface of the wood. This causes the blades to climb out of the kerf and jump back towards the operator.
4. Kickback is a result of tool misuse and/or incorrect operating procedures or conditions. It can be avoided by taking the proper precautions, as listed below.

Ways to Prevent Kickback

1. **ALWAYS** maintain a firm grip with both hands on the saw and position your body and arms to allow you to resist **KICKBACK** forces. **KICKBACK** forces can be controlled by the operator, if the proper precautions are taken.
2. If the blades are binding, or when you are interrupting a cut for any reason, **ALWAYS** turn off the saw and hold the saw motionless in the material until the blades come to a complete stop. **NEVER** attempt to remove the saw from the work or pull the saw backward while the blades are in motion or **KICKBACK** may occur. **ALWAYS** check and be ready to take corrective action to eliminate the cause of blade binding.
3. When restarting the saw in the workpiece, **ALWAYS** center the blades in the kerf and check to be sure that the saw teeth are not engaged into the material. If the saw blades are binding, they may walk up or **KICKBACK** from the workpiece when the saw is restarted.
4. **ALWAYS** support large panels to minimize the risk of blades pinching and **KICKBACK**. Large panels tend to sag under their own weight. Supports **MUST** be placed under the panel on both sides, near the line of cut and near the edge of the panel.
5. **DO NOT** use a dull or damaged blades. Unsharpened or improperly set blades produce narrow kerf which causes excessive friction, blade binding and **KICKBACK**.
6. **ALWAYS** use extra caution when making a "Pocket Cut" into existing walls or other blind areas. The protruding blades may cut objects that can cause **KICKBACK**.
7. **ALWAYS** have the saw blades at full speed before contacting workpiece
8. **ALWAYS** keep your body positioned to either side of the saw blades, but not in line with the saw blades. **KICKBACK** could cause the saw to jump backwards towards the operator. **KICKBACK** forces can be controlled by the operator, if proper precautions are taken.

ALWAYS hold tool by insulated gripping surfaces when performing an operation where the cutting tool may contact hidden wiring or its own cord. Contact with a "live" wire will make the exposed metal parts of the tool "live" and shock the operator.

SAFETY INSTRUCTIONS cont.

ADDITIONAL RULES FOR SAFE OPERATION

 **WARNING: BE SURE** to read and understand all instructions. Failure to follow all instructions listed below may result in electric shock, fire and/or serious personal injury.

1. **Know your power tool.** Read operator's manual carefully. Learn the applications and limitations, as well as the specific potential hazards related to this tool. Following this rule will reduce the risk of electric shock, fire or serious injury.
2. **ALWAYS wear safety glasses or eye shields when using this saw.** Everyday eyeglasses have only impact-resistant lenses; they are NOT safety glasses. Following this rule will reduce the risk of serious personal injury.
3. **ALWAYS protect your lungs.** Wear a face mask or dust mask if the operation is dusty. Following this rule will reduce the risk of serious personal injury.
4. **ALWAYS protect your hearing.** Wear hearing protection during extended periods of operation. Following this rule will reduce the risk of serious personal injury.
5. **ALWAYS inspect the tool cords periodically and if damaged have them repaired at your nearest Sears Service Center or other Authorized Service Facility.** ALWAYS be aware of the cord location. Following this rule will reduce the risk of electric shock or fire.
6. **ALWAYS check for damaged parts.** Before further use of the tool, a guard or other part that is damaged should be carefully checked to determine if it will operate properly and perform its intended function. Check for misalignment or binding of moving parts, breakage of parts, and any other condition that may affect the tool's operation. A guard or other part that is damaged, should be properly repaired or replaced at a Sears Service Center. Following this rule will reduce the risk of electric shock, fire or serious injury.
7. **DO NOT abuse the cord.** NEVER use the cord to carry the tool or pull the plug from the outlet. Keep cord away from heat, oil, sharp edges or moving parts. Replace damaged cords immediately. Damaged cords increase the risk of electric shock. Following this rule will reduce the risk of electric shock or fire.
8. **ALWAYS make sure that your extension cord is in good condition.** When using an extension cord be sure to use one that is heavy enough to carry the current that your tool will draw. A wire gauge size (A.W.G.) of at least 16 is recommended for an extension 100 feet or less in length. Using an extension cord that is over 100 feet in length is not recommended. If in doubt, use the next heavier gauge. Smaller gauge wires, have greater capacity (16 gauge wire has more capacity than 18 gauge wire). An undersized cord will cause a drop in line voltage, resulting in loss of power and overheating.
9. **DO NOT use the tool while tired or under the influence of drugs, alcohol or any medication.** Following this rule will reduce the risk of electric shock, fire or serious personal injury.
10. **SAVE THESE INSTRUCTIONS.** Refer to them frequently and use them to instruct others who may use this tool. If someone borrows this tool, make sure they have these instructions also.

SAFETY INSTRUCTIONS cont.

ADDITIONAL RULES FOR SAFE OPERATION cont.

⚠ WARNING: Some dust particles created by power sanding, sawing, grinding, drilling and other construction jobs contains chemicals known 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.
- Arsenic and chromium from chemically-treated lumber.

Your risk from these exposures varies, depending upon how often you do this type of work. To reduce your exposure to these chemicals:

- Work in a well-ventilated area.
- Work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.



⚠ WARNING: The operation of any saw can result in foreign objects being thrown into your eyes, which can result in severe eye damage. Before beginning power tool operation, **ALWAYS** wear safety goggles or safety glasses with side shield and a full face shield when needed. We recommend A Wide Vision Safety Mask for use over eyeglasses or standard safety glasses with side shield, available at Sears Retail Stores.

SAFETY SYMBOLS

The label on your tool may include the following symbols.

V	Volts
A	Amperes
Hz	Hertz
W	Watts
min	Minutes
~	Alternating current
—	Direct current
n o	No-load speed
□	Class II construction
/min	Revolutions or Strokes per minute
⚠	Indicates danger, warning or caution. It means attention! Your safety is involved.

IMPORTANT! READ ALL INSTRUCTIONS

DESCRIPTION

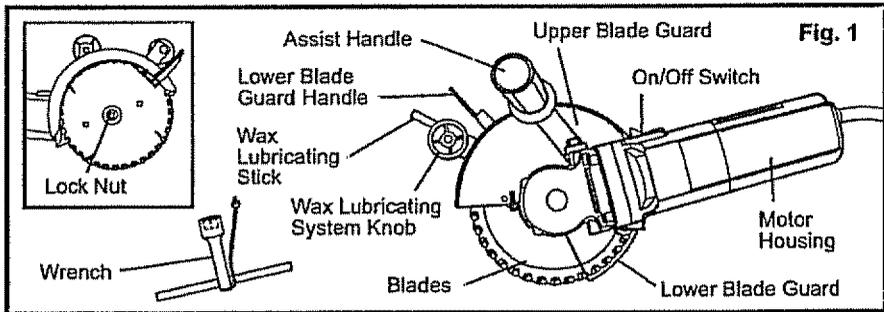
Before attempting to use any tool, be sure to familiarize with all the operating features and safety instructions.

⚠ WARNING: DO NOT let familiarity with your saw make you careless. Remember that a careless fraction of a second is sufficient to cause severe injury.

KNOW YOUR SAW (SEE Fig. 1)

Your Twin Cutter saw has many built-in convenience features for fast, efficient cutting. These features include a innovative 2-blade system with special blades that spin in opposite directions to provide smooth, clean cuts. It also includes a pre-installed blade lubricating system for use when cutting aluminum, copper, stainless steel and cast iron. The auxiliary handle mounts on the top of the saw to provide maximum support and ease of handling.

For your convenience, there is no assembly required for your Twin Cutter Saw. The special 2-blade cutting system and the wax lubricating system are already installed.



PRODUCT SPECIFICATIONS

Input	7.8 Amps
Output	1.25-Peak HP
Blade Diameter	6 1/8 in. (155mm)
Rating	120 volts, 60 Hz AC
No-load Speed	4600 RPM
Maximum Depth of Cut	wood (1 1/2 in.) metal (with a wall or sheet thickness of 1/8 in.)
Duty Cycle	30 minutes on 10 minutes off (see page 12)

ASSEMBLY

UNPACKING

Your Twin Cutter Saw has been shipped completely assembled. Inspect the saw carefully to make sure that no breakage or damage has occurred during shipping. If any parts are damaged or missing return the saw to your nearest Sears Store to have it replaced.

⚠ WARNING: If any parts are missing, **DO NOT** operate this saw until the missing parts are replaced. Failure to do so could result in possible serious personal injury

OPERATION

SAW BLADES

Even the best saw blades will not cut efficiently if they are not kept clean and sharp. Using dull blades will place a heavy load on your saw and increase the danger of kickback. Keep extra blades on hand, so sharp blades are always available.

Gum and wood pitch hardened on your blades will slow your saw down. Use gum and pitch remover, hot water or kerosene to remove these accumulations.

DO NOT use gasoline.

⚠ WARNING: This Twin Cutter saw uses specially designed 6 1/8-in. blades and no other types or sizes of blades should ever be used. Other types and sizes of blades will not operate safely in this saw and could result in serious personal injury.

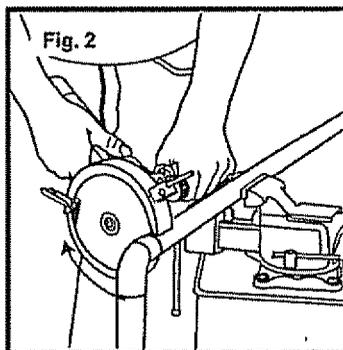
To order extra blades or to replace the blades that came with the saw, see page 21 of this manual for ordering instructions. To install new blades onto to your saw see the special instructions on pages 17 to 19 of this manual for proper removal and installation of blades.

BLADE GUARD SYSTEM

The lower blade guard, attached to your saw, is there for your protection and safety. It should **NEVER** be altered for any reason. If it becomes damaged or begins to return slowly or sluggishly, **DO NOT** operate your saw until the problem has been corrected or the damaged part has been replaced. **ALWAYS** leave the guard in its correct operating position when using the saw.

⚠ DANGER: When sawing through a workpiece, the lower blade guard does not cover the blade on the underside of the workpiece. Since the blade is exposed on the underside of the workpiece, **ALWAYS** keep your hands and fingers away from the cutting area (see Fig. 2). Any part of your body coming in contact with the moving blade will result in serious injury.

Lower Blade Guard is in UP position when making a cut. Blades are exposed on underside of workpiece.



⚠ WARNING: **NEVER** use the saw when the guard is not operating properly. The guard should be checked for correct operation before each use. If you drop your saw, check the lower blade guard for damage before using.

NOTE: The guard is operating properly when it moves freely and then readily returns to the closed position. If, for any reason, your lower blade guard does not close freely, take it to your nearest Sears Repair Center for service before using it.

OPERATION cont.

KICKBACK

Kickback occurs when the blades stall rapidly and the saw is driven back towards you. Blade stalling is caused by any action which pinches the blade in the material being cut.

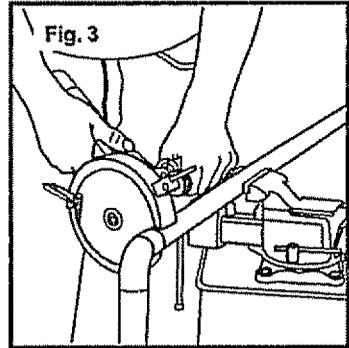
IMPORTANT: The best guard against kickback is to avoid dangerous practices.

⚠ DANGER: ALWAYS turn OFF power to saw immediately if the blades bind or the saw stalls. Kickback could cause you to lose control of the saw. Loss of control can lead to serious injury.

ALWAYS provide proper support for the workpiece and hold the saw with both hands

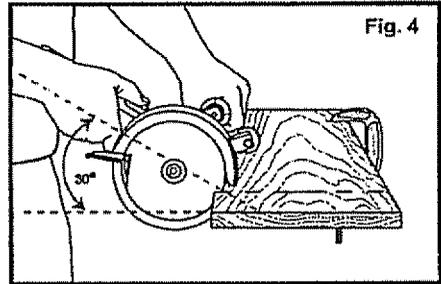
Kickback is Caused By:

1. Twisting the blades while making a cut.
2. Making a cut with a dull, gummed up, or improperly set blades.
3. Not providing proper support for workpiece. **ALWAYS** provide proper support as shown in Fig. 3.
4. Forcing a cut.
5. Cutting warped or wet lumber.
6. Tool misuse or incorrect operating procedures.
7. Contacting the workpiece with blades at less than full speed.



To Lessen the Chance of Kickback

1. **ALWAYS** approach the workpiece with the saw at an angle of approximately 30° to the workpiece. (see Fig. 4.)
2. **ALWAYS** make straight cuts. This will help prevent twisting the blade in the cut.
3. **ALWAYS** use clean, sharp and properly set blades. **NEVER** make cuts with dull blades.
4. **ALWAYS** properly support the workpiece before beginning a cut. This will help you avoid pinching the blades (see Fig. 3).
5. **ALWAYS** use steady, even pressure when making a cut. **NEVER** force the cut.
6. **DO NOT** cut wet or warped lumber.
7. **ALWAYS** hold the saw firmly with both hands and keep your body in a balanced position. **ALWAYS** keep your body positioned to either side of the saw blades, but not in line with the saw blades. This will help you resist the forces of kickback, should it occur.



IMPORTANT: When using your saw, **ALWAYS** stay alert and exercise control. **DO NOT** remove your saw from the workpiece, while the blade is moving.

OPERATION cont.

STARTING A CUT

IMPORTANT:

BEFORE using the Twin Cutter Saw for the first time, **ALWAYS** familiarize yourself with the saw by making practice cuts in scrap materials.

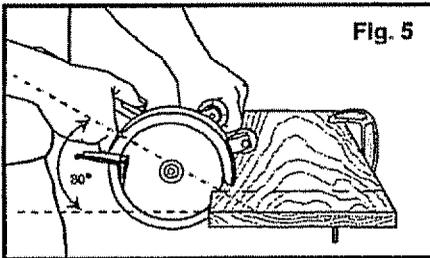
The weight of this saw helps to make the cuts smoother. Learn how to safely handle and control the weight of the saw.

ALWAYS be sure that you position the blades perpendicular to the plane of the workpiece. Make the cut at an approximate 30° angle to the workpiece surface. (See Fig. 5).

Practice the proper feed speed rate for the materials being cut.

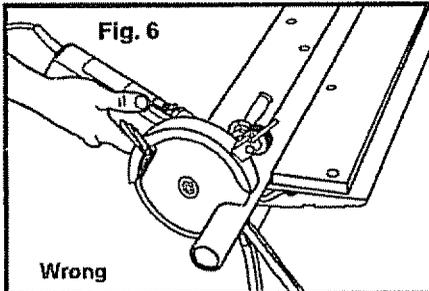
Engage the on/off switch to start the saw. **ALWAYS** let the blades reach full speed before you begin the cut into the workpiece.

IMPORTANT: When using your saw, **ALWAYS** stay alert and exercise control. **DO NOT** remove your saw from the workpiece, while the blade is moving.

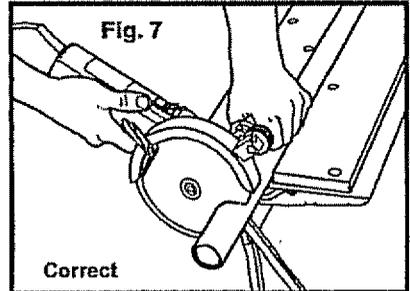


Blades perpendicular to workpiece
Approximately 30°

⚠ WARNING: **ALWAYS** maintain proper control of the saw to make sawing safer and easier. Loss of control of the saw could cause an accident resulting in possible serious injury.



NEVER hold the saw with just one hand (see Fig. 6).



ALWAYS hold saw by motor body and assist handle (see Fig. 7).

DUTY CYCLE

30 minutes on 10 minutes off duty cycle refers to **short-time operation**. Short time operation denotes operation under normal load for a specified period and material, starting cold, the interval between each period of operation being sufficient to allow the tool to cool down approximately to room temperature.

OPERATION cont.

TO HELP MAINTAIN CONTROL

1. **ALWAYS** support the workpiece near the cut.
2. **ALWAYS** support the workpiece so the cut will be on your right.
3. **ALWAYS** clamp the workpiece so it will not move during the cut.

Place the workpiece with the good side down. **NOTE:** The good side is the side where appearance is important.

Before starting a cut, draw a guideline along the desired line of cut. Then place the front edge of the saw blades on the part of the workpiece that is solidly supported.

4. **ALWAYS** keep the cord away from the cutting area. **ALWAYS** place the cord so it does not hang up on the workpiece when making a cut.

⚠ DANGER: If the cord hangs up on the workpiece during a cut, release the on/off switch immediately. Unplug the saw and move the cord to prevent it from hanging up again.

⚠ DANGER: Using the saw with a damaged cord could result in serious injury or death. If the cord has been damaged, have it replaced before using the saw again.

⚠ WARNING: If the blades come in contact with the workpiece before they reach full speed, it could cause the saw to kickback towards you, resulting in serious injury.

When making a cut, **ALWAYS** use steady, even pressure. Forcing the saw causes rough cuts and could shorten the life of the saw or cause kickback.

⚠ DANGER: When sawing through the workpiece, the lower blade guard does not cover the blades. The blades are exposed on the under side of the workpiece. **ALWAYS** keep your hands and fingers away from the cutting area. Any part of your body coming in contact with the moving blades will result in serious injury.

After completing your cut, release the on/off switch and allow the blades to come to a complete stop. **DO NOT** remove the saw from the workpiece while the blades are moving.

⚠ CAUTION: Whenever you lift your saw from the workpiece, the blades are exposed on the under side of the saw until the lower blade guard closes. **ALWAYS MAKE SURE** that the lower blade guard is closed before setting the saw down on work surface.

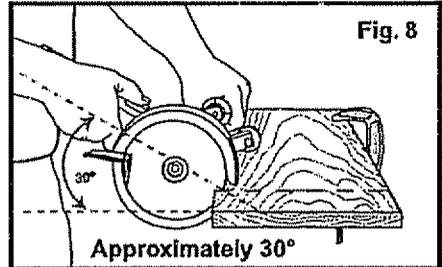
OPERATION cont.

CUTTING INSTRUCTIONS

NOTE: The life span of the blades on your Twin Cutter saw and the quality of the cutting edges is dependent on keeping vibrations to a minimum.

ALWAYS securely clamp the workpiece **BEFORE** beginning a cut. Then feed the blade through the material at an angle of approximately 30° (see Fig. 8).

This saw produces hot chips, not sparks, when cutting metal. It is recommended that you wear a face shield over safety glasses to protect your face.



FEED SPEED

Feed speed is how quickly you push the saw blades through the material being cut. The correct feed speed is totally determined by the hardness and the thickness of the material being cut.

IMPORTANT: Feeding must **ALWAYS** be done with the blades perpendicular to the plane of the workpiece (See Fig. A). Feeding at an angle can burn the blade and damage the blade teeth (See Fig. B).

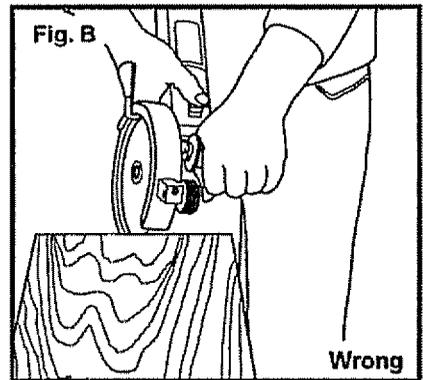
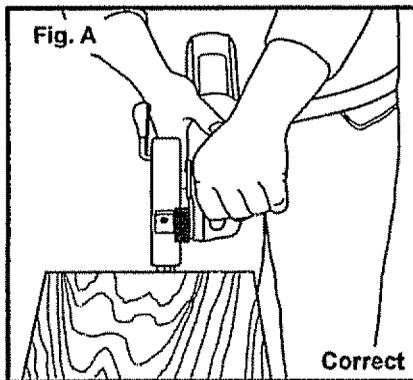
Selecting the correct feed speed is important.

If the feed speed is too slow:

1. The blades will only press down on the material rather than cutting it.
2. The blade edges glide and wear down the material.
3. A poor cut will result and cause excessive wear on the blades

If the feed speed is too fast:

1. There is a definite risk that the cut might split and the splintered opening of the cut will not be sufficient to divert the wood shavings.
2. A poor cut will result with a significant discharge of wood shavings on the lower side of the cut.



OPERATION cont.

CUTTING INSTRUCTIONS cont.

WHAT IT CUTS

The blades supplied with the saw are universal in application and will give clean, smooth cuts in:

- Wood up to a maximum depth of 1½ Inch.
- Mild steel tubing or sheets with a maximum wall or sheet thickness of 1/8 inch.
- Copper, stainless steel, aluminum, cast iron tubing or sheets with a wall thickness of 1/8 inch. When cutting these materials, the wax lubricating sticks **MUST BE USED**.
- Plastic pipe or sheets of a wall thickness of 1/8 inch.

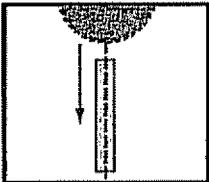
IMPORTANT: The Twin Cutter **WILL NOT CUT** masonry, cement or brick material.

IMPORTANT: Once the blades become worn, chipped or dull, they **MUST BE** replaced immediately.

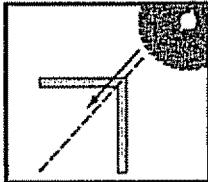
CUTTING ALL MATERIALS

1. **ALWAYS** have the saw blades at full speed before contacting workpiece.
2. **ALWAYS** hold the saw so the blades feed perpendicularly into the workpiece. Hold the saw at an approximate 30° angle.
3. **ALWAYS** keep your body positioned to either side of the saw blades, but not in line with the saw blades.
4. Feed the blades into the workpiece until the desired cut is made.
5. The kerf (width of the cut) of the twin blades is approximately 1/8th of an inch. Always be sure to allow for this kerf width.

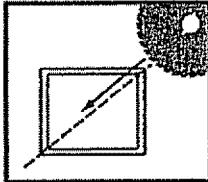
This Twin Cutter Saw with its special blades and cutting action is a highly versatile tool that quickly and efficiently provides smooth, efficient cuts a wide variety of materials:



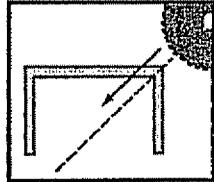
Flat Iron Bar



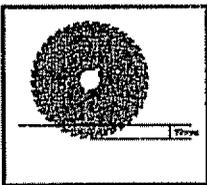
Corner Piece



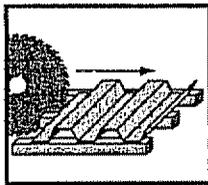
Rectangular Pipe



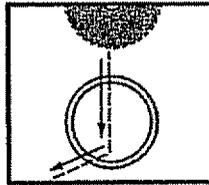
U-Section



Thin Plate



Shaped Plate



Pipes

OPERATION cont.

CUTTING ALL MATERIALS cont.

MAXIMUM STOCK SIZE AND FEED RATES

C/S TYPE	MATERIALS	MAX. SIZE (CROSS SECTION)	MAX THICKNESS	AVERAGE BLADE LIFE	AVERAGE TIME OR FEED
Hollow Pipe 	Galvanized Iron	1 1/2-in.	1/8-in.	285 cuts	26 Sec
Square Channel 	M.S.	1 1/2-in.	1/8-in.	105 cuts	30 Sec
	Aluminum	1 1/2-in.	1/8-in.	4000 cuts	5 Sec
Channel 	M.S.	1 1/2-in.	1/8-in.	95 cuts	30 Sec
Sheet Metal 	M.S.	-	1/8-in.	60 feet	4.3 Inch/min
	Aluminum	-	1/8-in.	85 feet	102 Inch/min
Stud	Wood (Pine)	2 x 4-in.	1 1/2-in.	4500 cuts	11 Sec
Pipe	Plastic (PVC)	1 1/2-in.	3/8-in.	6000 cuts	6 Sec

P.S. Average blade life indicates results of performance test in particular type of test material as per the above table. However the results may vary if the same blade is used on a combination of listed materials.

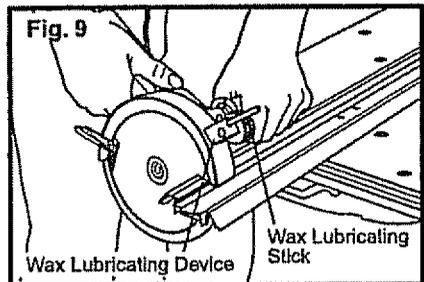
DUTY CYCLE

30 minutes on 10 minutes off duty cycle refers to **short-time operation**. Short time operation denotes operation under normal load for a specified period and material, starting cold, the interval between each period of operation being sufficient to allow the tool to cool down approximately to room temperature.

Cutting other materials may require even more special handling. These include cutting aluminum, copper, stainless steel and cast iron or shaped plates

Cutting Aluminum, Copper, Stainless Steel and Cast Iron up to 1/8-in. thick.
(See Fig. 9).

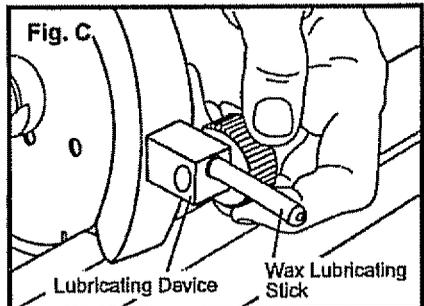
- 1. ALWAYS** use the wax lubricating device (included) when cutting these materials because they have a tendency to soften and adhere to the blades.



LUBRICATING INSTRUCTIONS (See Figure C)

The blades of your Twin Cutter saw are equipped with "dry cut teeth" that under normal cutting conditions do not need to be lubricated. However, in extreme cutting conditions, such as when you are sawing into aluminum, copper, stainless steel and cast iron, the wax lubricating device should be used.

1. Insert wax lubricating stick into wax lubricating device.
2. Turn feeder wheel to apply lubricant to blade. A 1/4 turn should provide adequate lubrication.

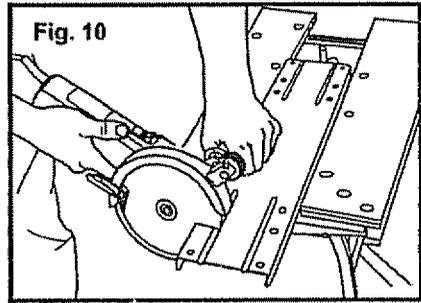


OPERATION cont.

CUTTING INSTRUCTIONS cont.

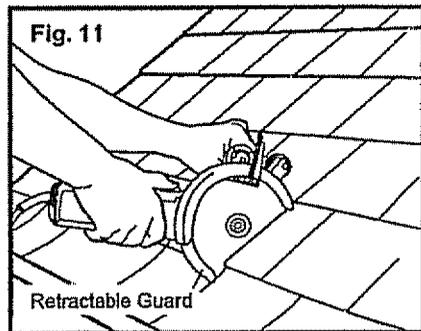
Cutting Shaped Plates up to 1/8-in. thick (See Fig. 10)

1. When cutting shaped metal plate **ALWAYS** support the plate evenly on both sides and in the middle with support blocks. This will keep it from flexing when cutting. This should be done, whether you're using a clamping table, or using adjustable clamps on a flat work table.



PLUNGE CUTTING (See Figure 11)

1. Raise the retractable guard into the open position with your left hand.
2. Use the thumb of your left hand to hold the guard in the open position while gripping the saw's assist handle.
3. Turn on the saw and plunge the blades into the material to be cut.
4. Push the saw forward to complete the cut.
5. Turn off saw, allow blades to stop completely, then remove saw from workpiece.
6. Clean out the corners of the cut with a hand saw or sabre saw, depending on project.



NOTE: When cutting roofing materials, blades must be kept clean with a tar and pitch blade cleaning solvent

REMOVING BLADES FROM SAW (See Figs. 12 - 15)

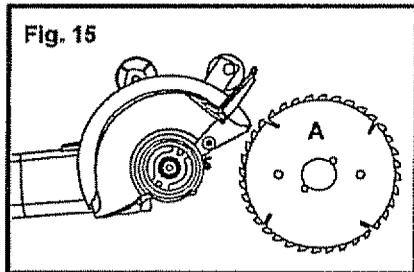
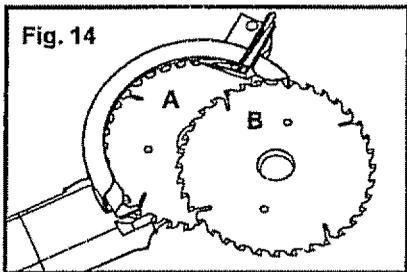
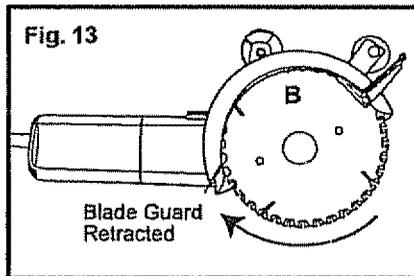
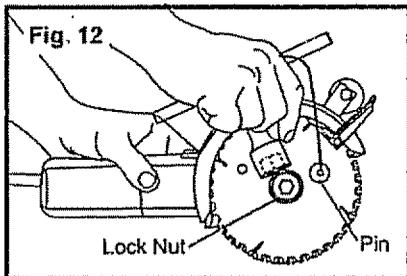
1. Unplug the saw and allow blades to cool.

⚠ WARNING: Failure to unplug the saw could result in accidental starting causing possible serious personal injury.

2. Rotate the blades until the holes in both blades are aligned. Then place pin attached to the wrench through holes in blades. Unscrew Lock Nut counterclockwise and remove (see Fig. 12).
3. Open the retractable guard (see Fig. 13).
4. Lift up and remove Blade "B" (see Fig. 14).
5. Lift up and remove Blade "A" (see Fig. 15).

OPERATION cont.

REMOVING BLADES FROM SAW cont. (See Figs. 12 - 15)



ATTACHING REPLACEMENT BLADES TO THE SAW (See Figs. 16 - 19)

⚠ WARNING: This Twin Cutter saw uses specially designed 6 $\frac{1}{8}$ -in. blades and no other types or sizes of blades should ever be used. Other types and sizes of blades will not operate safely in this saw and could result in serious personal injury.

See the accessories section of this manual for the proper replacement blades that are needed for this saw.

1. Unplug the saw.

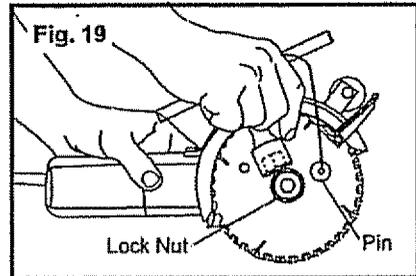
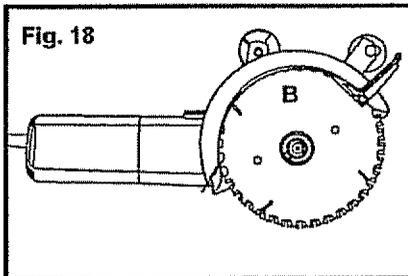
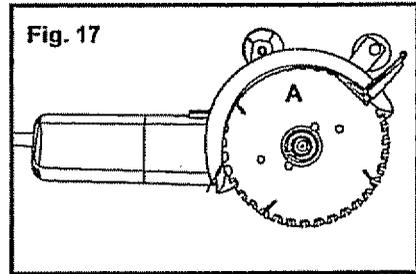
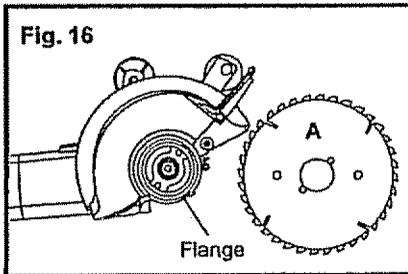
⚠ WARNING: Failure to unplug the saw could result in accidental starting causing possible serious personal injury.

2. Lay the saw down with the blade arbor pointing upward.
3. Place blade "A" onto the blade flange with the "A" clearly visible (see Fig. 16).
4. Align the holes on the blade with the pins on the flange and securely fit the blade on the flange (see Fig. 17).
5. Place blade "B" onto the arbor with the "B" easily visible, then thread lock nut onto shaft. DO NOT tighten, (see Fig. 18).
6. Turn the blades so that the holes in both blades are lined up.

OPERATION cont.

ATTACHING REPLACEMENT BLADES TO THE SAW cont. (See Figs. 16 - 19)

7. Place the pin (included with the wrench) into the lined up holes.
8. Tighten the lock nut clockwise with the wrench and then remove the pin from the blades (see Fig. 19). This will allow the blades to turn freely.
9. Carefully turn blades with your hand to be sure they easily turn in opposite directions.



MAINTENANCE

GENERAL

⚠ WARNING: To avoid accidents, **ALWAYS** disconnect the tool from the power source **BEFORE** cleaning or performing any maintenance.

All parts represent an important part of the double insulation system and should be serviced only at a Sears Service Center.

Avoid using solvents when cleaning plastic parts. Most plastics are susceptible to damage from various types of commercial solvents and may be damaged by their use. Use clean cloths to remove dirt, carbon dust, etc.

⚠ WARNING: **DO NOT** at any time let brake fluids, gasoline, petroleum-based products, penetrating oils, etc. to come in contact with plastic parts. They contain chemicals that can damage, weaken or destroy plastic.

MAINTENANCE cont.

GENERAL cont.

It is a known fact that electric tools are subject to accelerated wear and possible premature failure when they are used to work on fiber glass boats and sports cars, wallboard, spackling compounds or plaster. The chips and grindings from these materials are highly abrasive to electrical tool parts, such as bearings, brushes, commutators, etc. Consequently, it is not recommended that this tool be used for extended work on any fiber glass material, wallboard, spackling compound, or plaster. During any use on these materials, it is extremely important that the tool is cleaned frequently by blowing with an air jet.

 **WARNING:** ALWAYS wear safety goggles or safety glasses with side shields or face shield when blowing dust from tool when cleaning it. If operation is dusty, also wear a dust mask.

LUBRICATION

All of the bearings in this tool are lubricated with a sufficient amount of high-grade lubricant for the life of the tool under normal operating conditions. Therefore, no further lubrication is required.

DOUBLE INSULATION

Double insulation is a concept in safety in electric power tools, which eliminates the need for the standard 3-wire grounded power cord. All exposed metal parts are isolated from the internal motor components with protective insulation. Double insulated tools do not need to be grounded.

IMPORTANT

The servicing of a tool with double insulation requires extreme care and knowledge of the system and should be performed only by a qualified service technician. For service, we recommend that you return the tool to your nearest Sears Service Center for repair. **ALWAYS** use original factory replacement parts when servicing.

EXTENSION CORDS

The use of any extension cord will cause some loss of power. To keep the loss at a minimum and to prevent overheating, use an extension cord that is heavy enough to carry the current that the tool will draw.

A wire gauge (AWG) of at least 16 is recommended for an extension cord 100 feet or less in length. When working outdoors **ALWAYS** use an extension cord that is suitable for outdoor use. The cord's jacket will be marked WA.

 **CAUTION:** Keep extension cords away from the cutting area, and position the cord so it will not get caught on lumber, tools, etc. during the cutting operation

 **DANGER:** Check extension cords before each use. If damaged, replace it immediately. **NEVER** use a tool with a damaged cord because touching the damaged area could cause electrical shock, resulting in serious injury.

Extension cords that are suitable for use with your saw are available at your nearest Sears Store.

TROUBLESHOOTING

PROBLEM	CAUSE	SOLUTION
An unusually large amount of sparks	<ol style="list-style-type: none"> 1. Damaged teeth 2. Feed speed is too slow 3. Blunt teeth 	<ol style="list-style-type: none"> 1. Replace blades 2. Increase feed speed 3. Replace blades
A lot of wear in sections	<ol style="list-style-type: none"> 1. Feed speed is too fast 2. Damaged teeth 3. Blunt teeth 4. Not cutting perpendicular to work surface 	<ol style="list-style-type: none"> 1. Reduce feed speed 2. Replace blades 3. Replace blades 4. Hold saw perpendicular to work surface
Blades are breaking	<ol style="list-style-type: none"> 1. Damaged teeth 2. Feed speed is too fast 3. Blunt teeth 4. Blades have buckled 5. Blades have burned out 	<ol style="list-style-type: none"> 1. Replace blades 2. Reduce feed speed 3. Replace blades 4. Replace blades 5. Replace blades
Possible causes of broken teeth	<ol style="list-style-type: none"> 1. Feed speed is too fast 2. The surface being cut is too hard 3. The teeth have been damaged by impact 4. Blades were not installed properly 5. Blades are burned out 6. Not cutting perpendicular to work surface 	<ol style="list-style-type: none"> 1. Reduce feed speed 2. Replace blades 3. Replace blades 4. Replace blades and follow the proper blade installation instructions 5. Replace blades 6. Replace blades and always hold saw perpendicular to work surface when cutting

ACCESSORIES

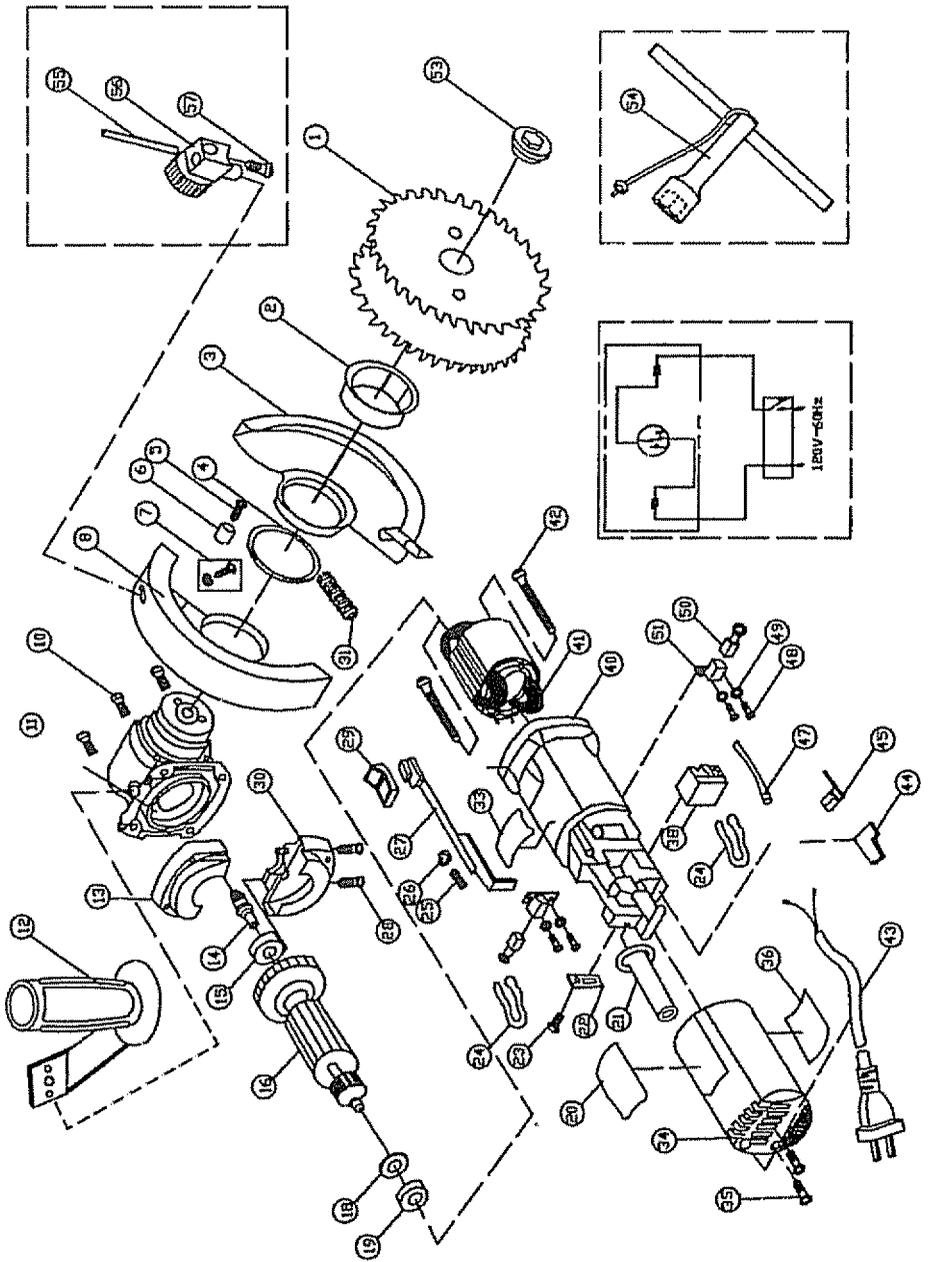
⚠ WARNING: This Twin Cutter saw uses specially designed 6 1/8-in. blades and no other types of blades should ever be used. Other blades will not operate safely in this saw and could result in serious personal injury.

The following accessories for your Twin Cutter saw are available at your local Sears store.

9-61131 — A packaged set of 2 Universal Twin Cutter Saw Blades

9 26678 — 6 Packaged Wax Lubricating Sticks

⚠ WARNING: The use of attachments or accessories that are not recommended might be dangerous.



TWIN-CUTTER SAW -- MODEL NUMBER 286.25574

The Model Number will be found on the Nameplate. Always mention the Model Number in all correspondence regarding your tool.

Item No.	Parts No.	Part Description	Qty.
1	PW001 -N	Blade	1 Set
2	PW002	Blade Guard	1
3	PW003 -N	Retractable Guard	1
4	PW004	Guard Washer	1
5	PW005	Screw M4 x 14	1
6	PW006	Rubber Pin	1
7	PW007 -N	Screw SA M4 x 12	1
8	PW008	Guard	1
10	PW010	Tapping Screw ST 4.2 x 35	4
11	PW011 -N	Gear Box SA	1
12	PW012 -N	Side Handle	1
13	PW013 -N	Cover	1
14	PW014 -N	Pinion	1
15	PW015	Bearing 6000	1
16	PW016	Armature	1
18	PW018	Rubber Ring	1
19	PW019	Bearing 607	1
20	PW020 -N	Lable	1
21	PW021	Cord Armor	1
22	PW022 -N	Cord Platen	1
23	PW023	Tapping Screw ST 4.2 x 12	1
24	PW024	Lable IV	2
25	PW025	Spring	1
26	PW026	Spring Washer	1
27	PW027 -N	Switch lever	1

Item No.	Parts No.	Part Description	Qty.
28	PW028	Tapping Screw ST 4.2 x 20	2
29	PW029 -N	Switch Button	1
30	PW030 -N	Cover	1
31	PW031	Spring	1
33	PW033 -N	Small Lable	1
34	PW034 -N	Back Cover	1
35	PW035	Tapping Screw ST 4.2 x 16	2
36	PW036 -N	Name Plate	1
38	PW038	Switch	1
40	PW040 -N	Housing	1
41	PW041	Stator	1
42	PW042	Tapping Screw ST 4.2 x 65	2
43	PW043 -N	Cord and Plug	1
44	PW044	Protector Washer	1
45	PW045	Lead I	1
47	PW047	Lead VII	1
48	PW048	Tapping Screw ST 2.2 x 8.5	4
49	PW049	Washer	4
50	PW050	Brush	2
51	PW051	Brush Holder	2
53	PW053 -N	Blade Lock Nut	1
54	PW054 -N	Wrench	1
55	PW055	Wax Tube	1
56	PW056	Lubrication Unit	1
57	PW057	Tapping Screw ST 4.8 x 10	1

SEE BACK PAGE FOR PARTS ORDERING INSTRUCTIONS

