



NOTICE TO EMPLOYER AND SAFETY DIRECTOR
AVOID INJURY

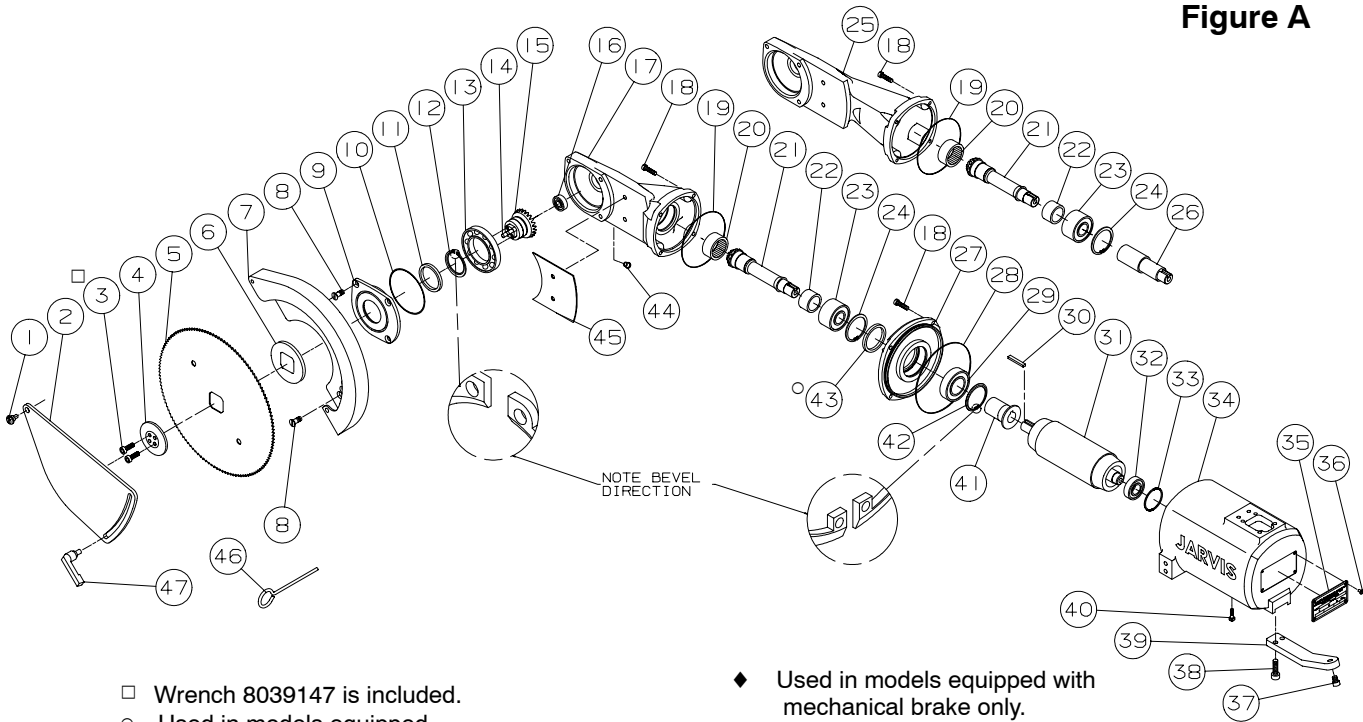
1. **Remove** and **repair** any tool that malfunctions. All personnel must be instructed to remove any malfunctioning equipment.
2. **Ensure** that all employees who use this tool are trained in the proper use of this tool and are aware of the dangers that may arise if they do not follow procedures outlined in this brochure.
3. **Ensure** that all employees are instructed not to walk in front of the tool during its use.
4. **Enclosed** are four (4) copies of “**NOTICE TO OPERATORS, MAINTENANCE AND CLEANUP PERSONNEL.**” Post one copy on the employees’ bulletin board; give one copy to the operator(s); give one copy to the maintenance foreman; and give one copy to the sub-contract cleanup / internal cleanup foreman. *Additional copies will be provided upon request.*
5. The tool is designed and intended to be powerful. This fact should be obvious to your employees, but you must emphasize it to them.
6. **Ensure** that eye protection is worn in accordance with OSHA’s eye and face protection requirements (29 CFR 1910.133) when operating the tool.
7. **Never** make modifications or alterations to the tool. *Replace any missing or illegible labels.*
8. **Ensure** that proper procedures are established in accordance with OSHA’s lockout/tagout procedures (29 CFR 1910.147) to prevent accidental startup or release of stored energy.
9. **Follow** our installation and maintenance instructions for proper installation and care of the tool.
10. **Avoid** injury. Do not permit the tool to be misused.
11. **If you resell or distribute** a Jarvis product, you must provide the purchaser with the appropriate safety sheets and tool brochure. *Additional copies of safety sheets and tool brochures will be provided upon request.*



NOTICE TO OPERATORS, MAINTENANCE AND CLEANUP PERSONNEL
REMOVE ANY MALFUNCTIONING TOOL FROM SERVICE
REPORT ANY PROBLEMS TO YOUR SUPERVISOR

1. **Disconnect** the power supply in accordance with OSHA's lockout/tagout procedures (29 CFR 1910.147) before making any blade changes.
2. **Disconnect** the power supply in accordance with OSHA's lockout/tagout procedures (29 CFR 1910.147) before performing any repair or maintenance.
3. **Disconnect** the power supply - or have the power supply disconnected - in accordance with OSHA's lockout/tagout procedures (29 CFR 1910.147) before performing any cleanup.
4. **Disconnect** the power supply when the tool is not being used.
5. **Always** wear eye protection in accordance with OSHA's eye and face protection requirements (29 CFR 1910.133) when operating the tool.
6. **Never** put fingers, hands or other parts of the body on the cutting edge or within the cutting path of the tool.
7. **Never** allow people to walk in front of the tool during its use.
8. **Never** allow people to hold / restrain the carcass while operating the tool.
9. **Test** the **tool** prior to use or daily. For models with **dual** anti-tie-down control handles: **Depress** each trigger separately and the tool should not start. **Depress** one trigger, then pause one second and depress the other trigger and the tool should not start. **Repeat** this procedure reversing the triggers. **Depress** both triggers simultaneously and the tool should start. With the tool running, release one trigger and the tool should stop. **Continue** holding the depressed trigger and then depress the other trigger. The tool should not start. **Repeat** this procedure holding the other trigger. *If the tool malfunctions, remove it from service and report or repair it immediately.* For models with single trigger: **Depress** the trigger and the tool should start. **Release** the trigger and the tool should stop. *If the tool malfunctions, remove it from service and report or repair it immediately.*
10. **Test** the **brake** prior to use or daily. After releasing either or both triggers, the tool should stop within 2.5 seconds. *If the tool malfunctions, remove it from service and report or repair it immediately.*
11. **Never** depress the trigger(s) unless you want to use or test the tool.
12. **Never** make modifications or alterations to the tool. *Replace any missing or illegible labels.*
13. **Always** use both hands when starting and operating the tool to avoid the risk of possible "kick back" or "recoil". **Continue** holding the tool with both hands until the saw blade comes to a complete stop.

Figure A



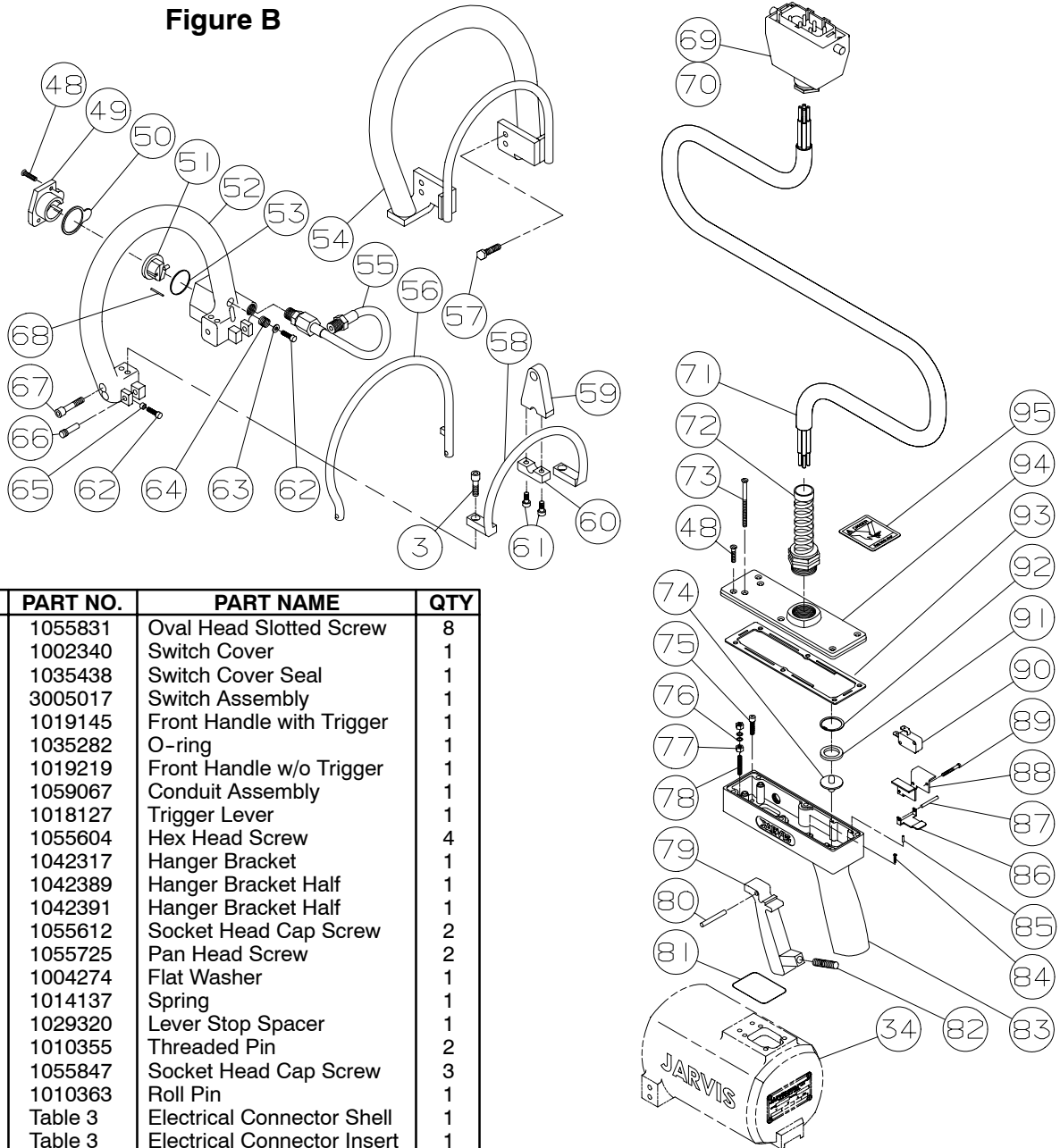
- Wrench 8039147 is included.
- Used in models equipped with DC brake only.

- ◆ Used in models equipped with mechanical brake only.
- ** Used in LN models only

ITEM	PART NO.	PART NAME	QTY
1	1054134	Depth Gage Screw	1
2	1032359	Depth Gage Plate	1
3	1055746	Socket Head Cap Screw (SEC 230-4 LN models)	2
4	1004330	Blade Washer	7
5	1023286	Standard Blade, 130 teeth	1
	1023387	Skip Tooth Blade, 72 teeth	
	1023299	Noise Reduction Blade	
	1023348	Noise Red. Blade, 60 teeth	
6	1004268	Flinger	1
7	1024129	Blade Guard	1
8	1055835	Flat Head Slotted Screw	5
9	1002393	Gear Head Cover	1
10	1035435	O-ring	1
11	1035544	Oil Seal	1
12	1013247	External Retaining Ring	1
13	1021350	Ball Bearing	1
14	1010432	Blade Retaining Pin	2
15	1026195	Crown Gear with item 14	1
16	1021351	Ball Bearing	1
17	3016244	Right Angle Gear Housing (includes items 20 and 44)	1
18	1055833	Cheese Head Slotted Screw	8
19	1035437	O-ring	1
20	1021352	Needle Bearing	1
21	1026160	Pinion gear	1
22	1009127	Bearing Inner Race	1
23	1021238	Ball Bearing, 2 Row	1
24	1013219	Internal Retaining Ring	1
25	3016251**	Rt. Angle Gear Hsg. LN (includes items 20 and 44)	1
26	3020039**	Shaft Assembly 230-LN	

ITEM	PART NO.	PART NAME	QTY
27	1002332○	Motor Front Cover	1
	1002417◆	Motor Front Cover	
28	1035461	O-ring	1
29	1021513	Ball Bearing	1
30	1030058	Square Key	1
31	1064034	Rotor Assembly	1
32	1021306	Ball Bearing	1
33	1035296	O-ring	1
34	Table 3	Housing & Stator Assembly	1
35	1017188	Name and Info Label	1
36	1055590	Pan Head Slotted Screw	4
37	1055829○	Socket Head Cap Screw	1
	1055020◆	Socket Head Cap Screw	
38	1055894	Socket Head Cap Screw	2
39	1042316○	Rear Handle Bracket.	1
	1042414◆	Rear Handle Bracket	
40	1055828	Oval Head Slotted Screw	1
41	1011269○	Shaft Coupling	1
	1011355◆	Shaft Coupling	
42	1013309	Internal Retaining Ring	1
43	1035474○	Oil Seal	1
44	1038006	Grease Fitting	1
45	1061575	Damper	1
46	8039099	Blade Locking Pin	1
47	1018128	Gage Locking Lever	1
	3026063	Spiral Bevel Gear Set (incls item 14, 15, 21 and 22)	1
	3016248	Housing and Gear Assy (includes items 3, 4, 6, 8-17, 20-24 and 44)	
	3016252**	Housing and Gear Assy. LN (includes items 3, 4, 6, 8-16, 20-25 and 44)	

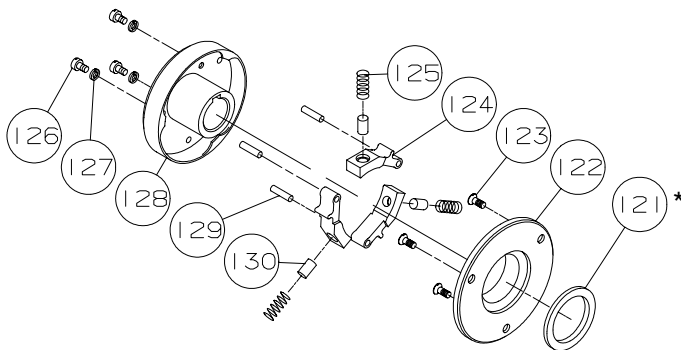
Figure B



ITEM	PART NO.	PART NAME	QTY
48	1055831	Oval Head Slotted Screw	8
49	1002340	Switch Cover	1
50	1035438	Switch Cover Seal	1
51	3005017	Switch Assembly	1
52	1019145	Front Handle with Trigger	1
53	1035282	O-ring	1
54	1019219	Front Handle w/o Trigger	1
55	1059067	Conduit Assembly	1
56	1018127	Trigger Lever	1
57	1055604	Hex Head Screw	4
58	1042317	Hanger Bracket	1
59	1042389	Hanger Bracket Half	1
60	1042391	Hanger Bracket Half	1
61	1055612	Socket Head Cap Screw	2
62	1055725	Pan Head Screw	2
63	1004274	Flat Washer	1
64	1014137	Spring	1
65	1029320	Lever Stop Spacer	1
66	1010355	Threaded Pin	2
67	1055847	Socket Head Cap Screw	3
68	1010363	Roll Pin	1
69	Table 3	Electrical Connector Shell	1
70	Table 3	Electrical Connector Insert	1
71	Table 3	Electric Cord	1
72	Table 3	Strain Relief Connector	1
73	1055832	Oval Head Slotted Screw	2
74	1035413	Diaphragm Seal	1
75	1055777	Cheese Head Screw	4
76	1004227	Internal Tooth Lock Washer	2
77	1007283	Hex Jam Nut	2
78	1055848	Cup Point Set Screw	1
79	1018162	Trigger Lever with item 82	1
80	1010362	Dowel Pin	1
81	1035439	O-ring	1
82	1014097	Spring	1
83	1019144	Rear Handle, Dual Triggers	1
84	1055913	Self-Tapping Screw	2

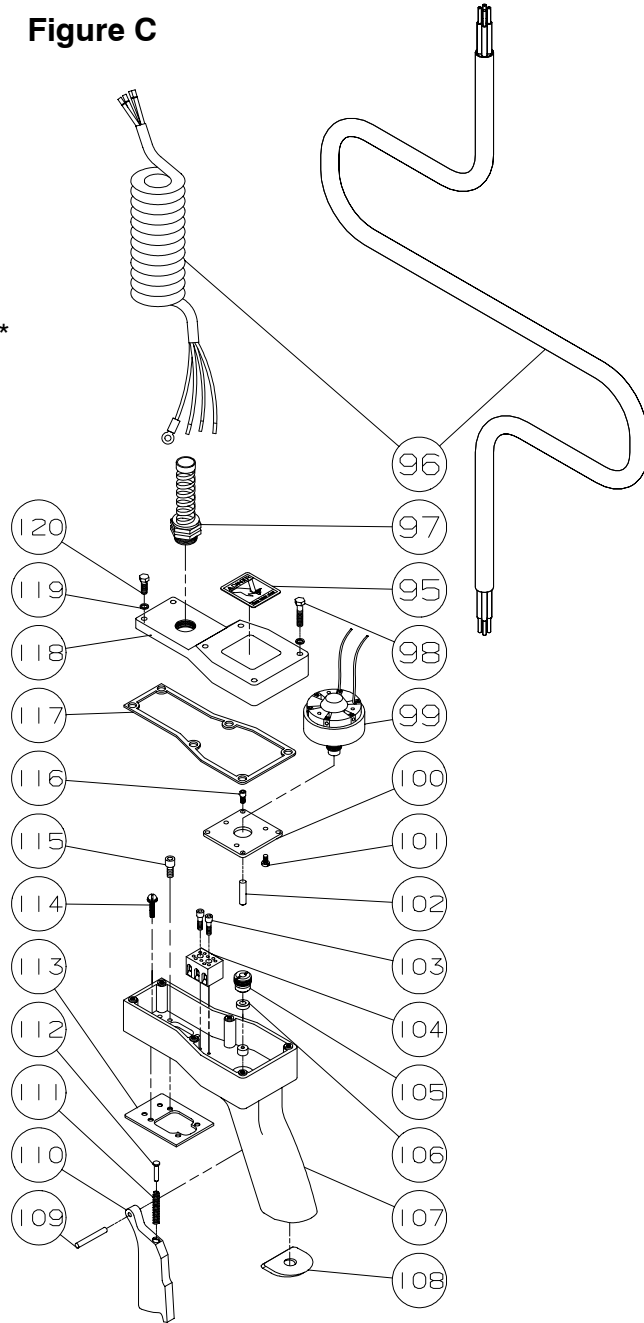
ITEM	PART NO.	PART NAME	QTY
85	1010167	Roll Pin	2
86	1018126	Switch Actuating Lever	1
87	1010356	Dowel Pin	1
88	1042282	Switch Holder	1
89	1055834	Pan Head Slotted Screw	1
90	1005104	Electric Switch	2
91	1004257	Ring Washer	1
92	1013220	Internal Retaining Ring	1
93	1035414	Rear Handle Cover Gasket	1
94	1002349	Rear Handle Cover with item 95	1
95	1017083	Danger Label	1

Mechanical Brake



* Install with open end facing away from motor
 ** Not used in current tools

Figure C

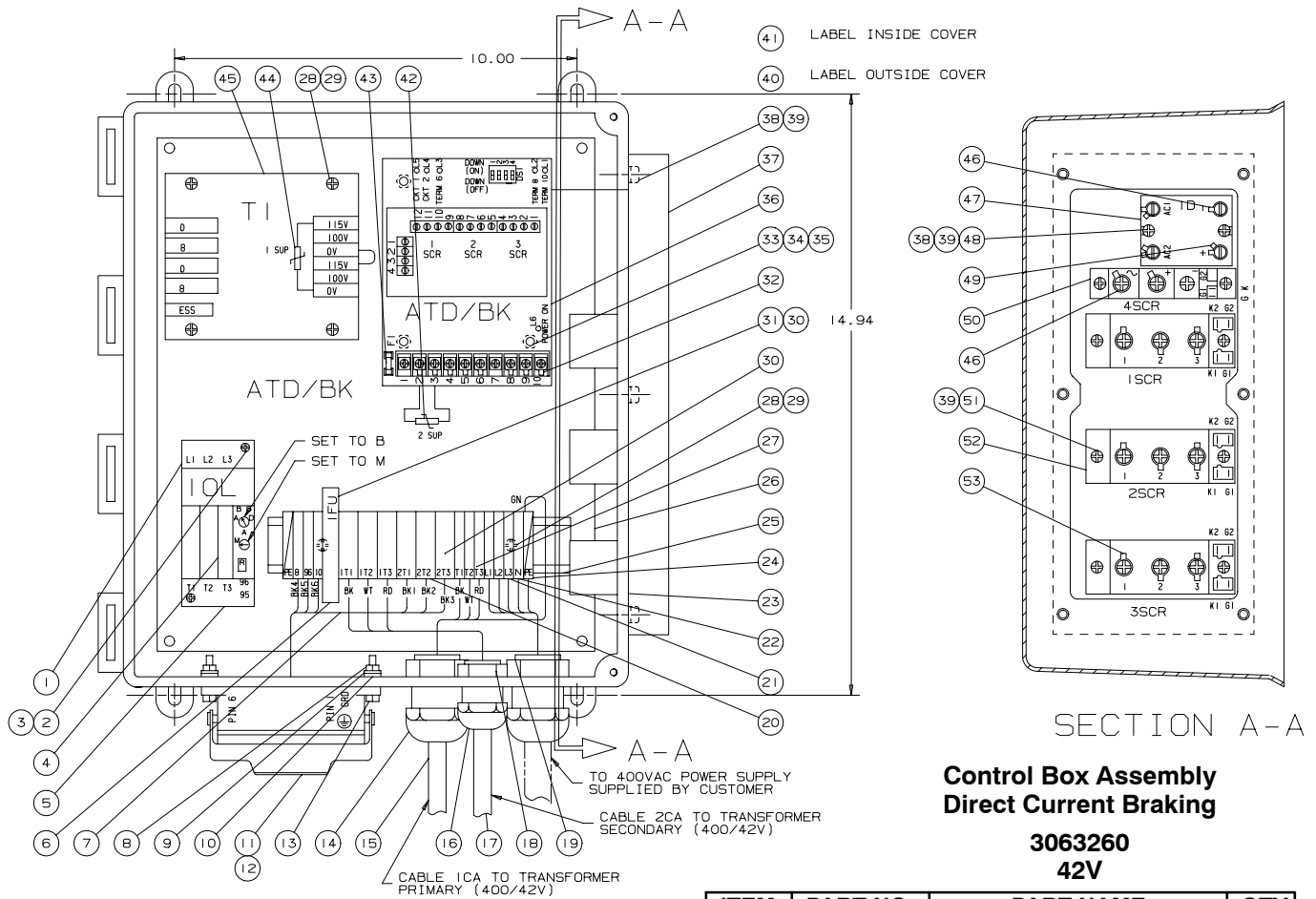


Rear Handle Assembly
for 42V Mechanical Brake

ITEM	PART NO.	PART NAME	QTY
96	Table 3	Electric Cord	1
97	Table 3	Strain Relief Connector	1
98	1055055	Hex Head Screw	4
99	1005143	Push Button Switch	1
100	1032529	Switch Mounting Plate	1
101	1055915	Cheese Head Screw	3
102	1010457	Dowel Pin	1
103	1055744	Socket Head Cap Screw	2
104	1063860	Terminal Block	1
105	1036260	Trigger Bushing	1
106	1035395	U-cup Seal	1
107	1019195	Rear Handle	1
108	1035596	Bottom Handle Gasket	1
109	1010456	Dowel Pin	1
110	1018153	Trigger Lever	1
111	1014208	Spring	1
112	1039077	Spring Plunger	1
113	1035595	Rear Handle Gasket	1
114	1055150	Pan Hd Screw, Lock Washer	1
115	1055617	Socket Head Cap Screw	6
116	1055960	Socket Head Cap Screw	4
117	1035563	Handle Cover Gasket	1
118	1002418	Handle Cover, 42v	1
	1002415	Handle Cover, 115-575v with item 95	
119	1004361	Plain Washer	6
120	1055872	Hex Head Screw	2
121	1035354	Oil Seal (24 mm)	1
	1035486**	Oil Seal (22 mm)	1
122	1071071	Brake Drum	1
	1061801**	Brake Drum	
123	1055918	Flat Head Screw	3
124	1061800	Brake Shoe	3
125	1014066	Compression Spring (50Hz)	3
	1014171	Compression Spring (60Hz)	3
126	1055616	Cheese Head Screw	3
127	1004360	Split Lock Washer	3
128	1031041	Brake Hub	1
	1031029**	Brake Hub	

ITEM	PART NO.	PART NAME	QTY
129	1010455	Dowel Pin	3
130	1010454	Dowel Pin	3
	3019219	Rear Handle Assy, 115-380v	
	3019221	Rear Handle Assy, 42v (includes items 95, 98-107, 109-113 and 116-120)	

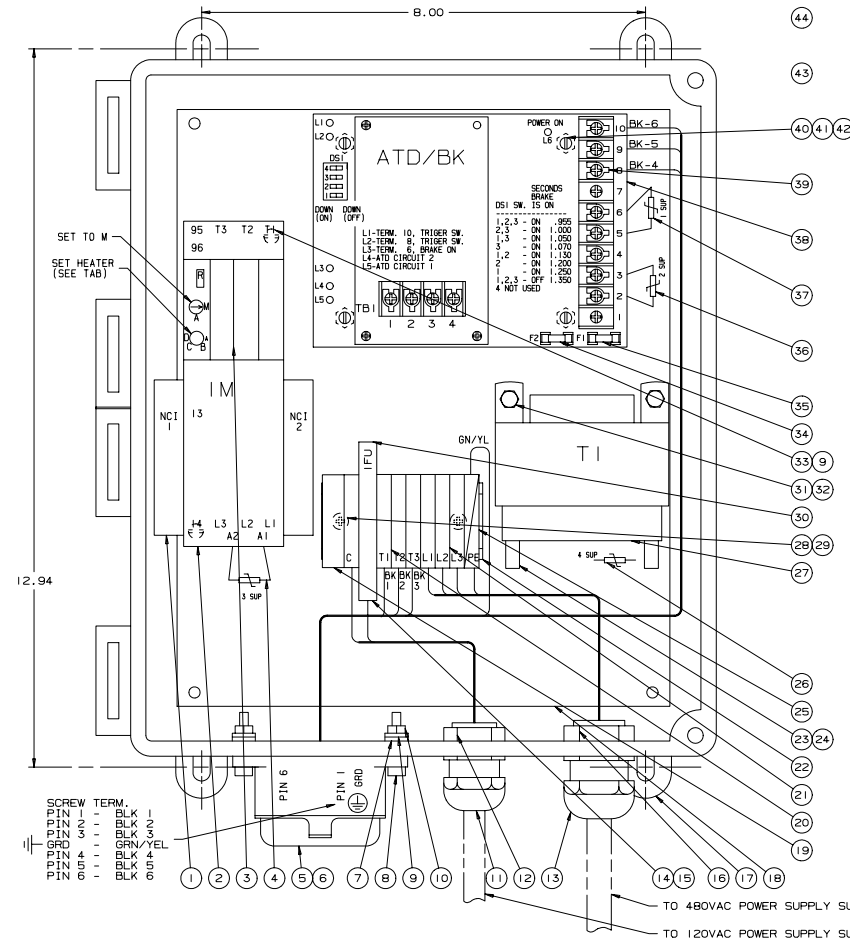
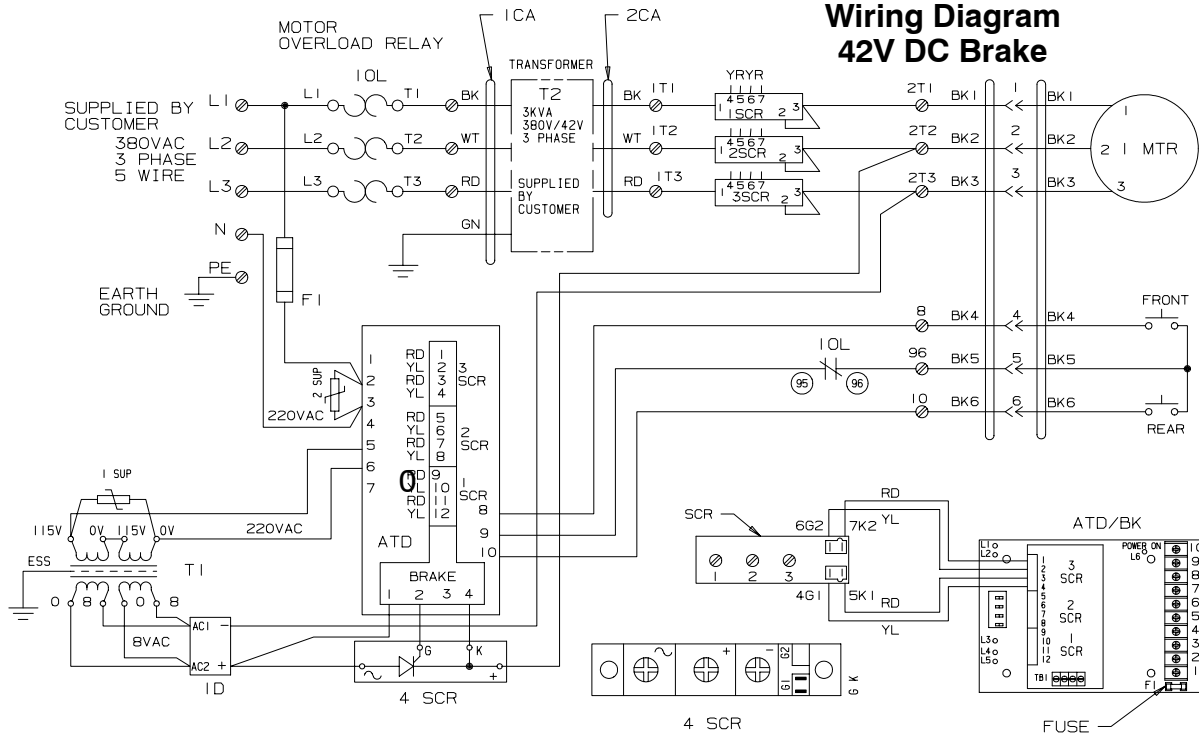
Figure D



**Control Box Assembly
Direct Current Braking
3063260
42V**

ITEM	PART NO.	PART NAME	QTY
1	1063632	Overload Mtg. Adapter	1
2	1055863	Pan Head Screw	2
3	1004242	Split Lock Washer	2
4	1063631	Overload Relay	1
5	1063656	Heater Pack	1
6	1063455	Fuse Terminal Block	1
7	1001159	Cord, Seven Conductor	2 ft
8	1007318	Hex Nut	4
9	1004227	Internal Lock Washer	4
10	1004226	Washer	4
11	1063629	Base Connector w/Gasket	1
12	1063627	Female Insert, 6 pole	1
13	1055979	Hex Head Screw	4
14	1011262	Cord Connector	2
15	1001119	Yellow Cord, 4 ft	1
16	1011249	Cord Connector	1
17	1001107	Black Cord, 4 ft	1
18	1007256	Locking Nut	1
19	1007266	Locking Nut	2
20	1063520	Gray Terminal Block	6
21	1063494	Gray Terminal Block	9
22	1063495	Blue Terminal Block	1
23	1016572	Electrical Enclosure	1
24	1063496	Yel/Grn Terminal Block	2
25	1042300	Terminal Rail	1
26	1032386	Mounting Plate	1

ITEM	PART NO.	PART NAME	QTY
27	1063363	Terminal Marker	11
28	1055803	Pan Head Screw	6
29	1004247	External Lock Washer	6
30	1063456	Terminal Marker	7
31	1063570	Fuse	1
32	1063502	Fork Terminal	9
33	1029445	Hex Spacer	4
34	1004244	Internal Lock Washer	4
35	1073072	Plastic Screw	4
36	1063571	Circuit Board	1
37	1061617	Heatsink	1
38	1055741	Cheese Head Screw	8
39	1004230	Split Lock Washer	16
40	1017085	Danger Label	1
41	1017339	Connection Diagram	1
42	1063702	Interference Suppressor	1
43	1063862	Cylindrical Fuse	1
44	1063757	Transient Suppressor	1
45	1063607	Transformer	1
46	1063446	Terminal Ring	4
47	1063605	Bridge Rectifier	1
48	1004216	Washer	2
49	1063079	Terminal Ring	5
50	1063759	SCR Rectifier	1
51	1055845	Pan Head Screw	8
52	1072186	Dual SCR Rectifier	3
53	1063633	Terminal Ring	12



- 44 PLACE LABEL 1017344 ON INSIDE OF COVER.
- 43 PLACE LABEL 1017085 ON OUTSIDE OF COVER CENTER.

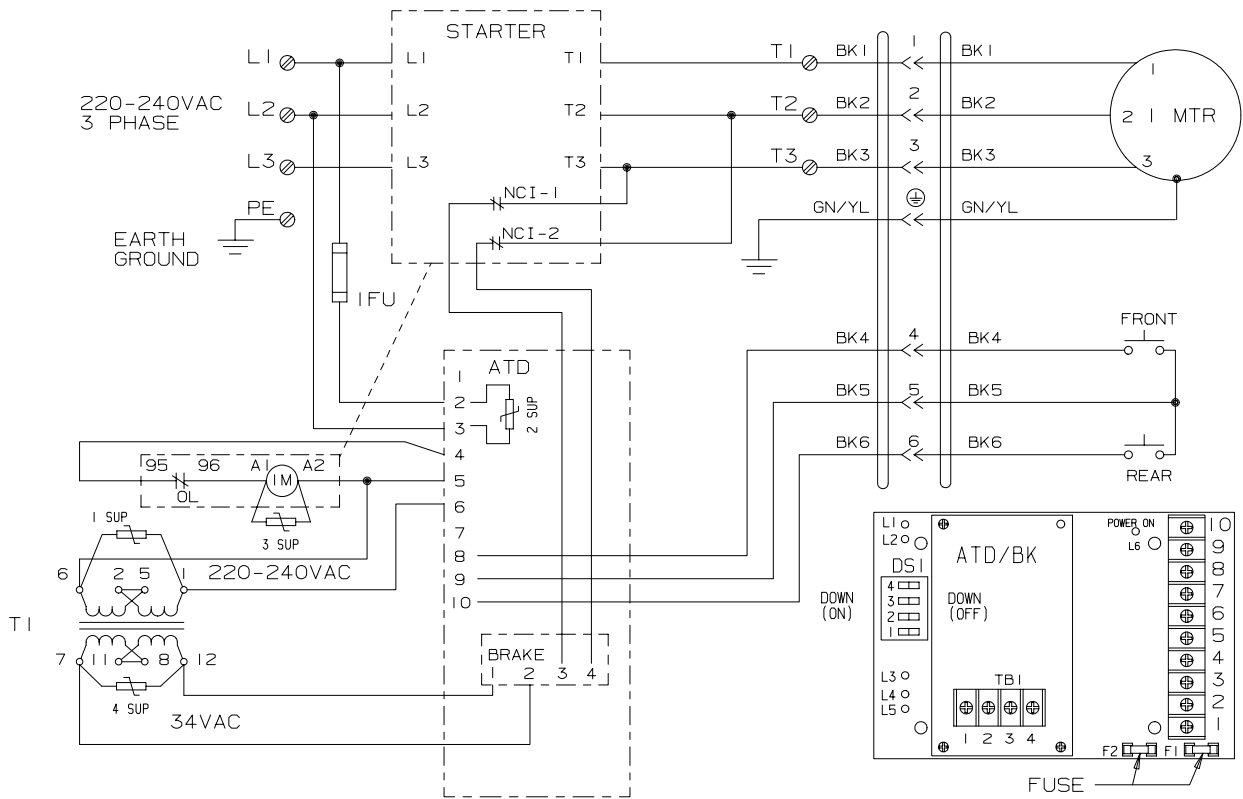
Figure E
Control Box Assy
DC Braking
(see Table 2)

SCREW TERM.

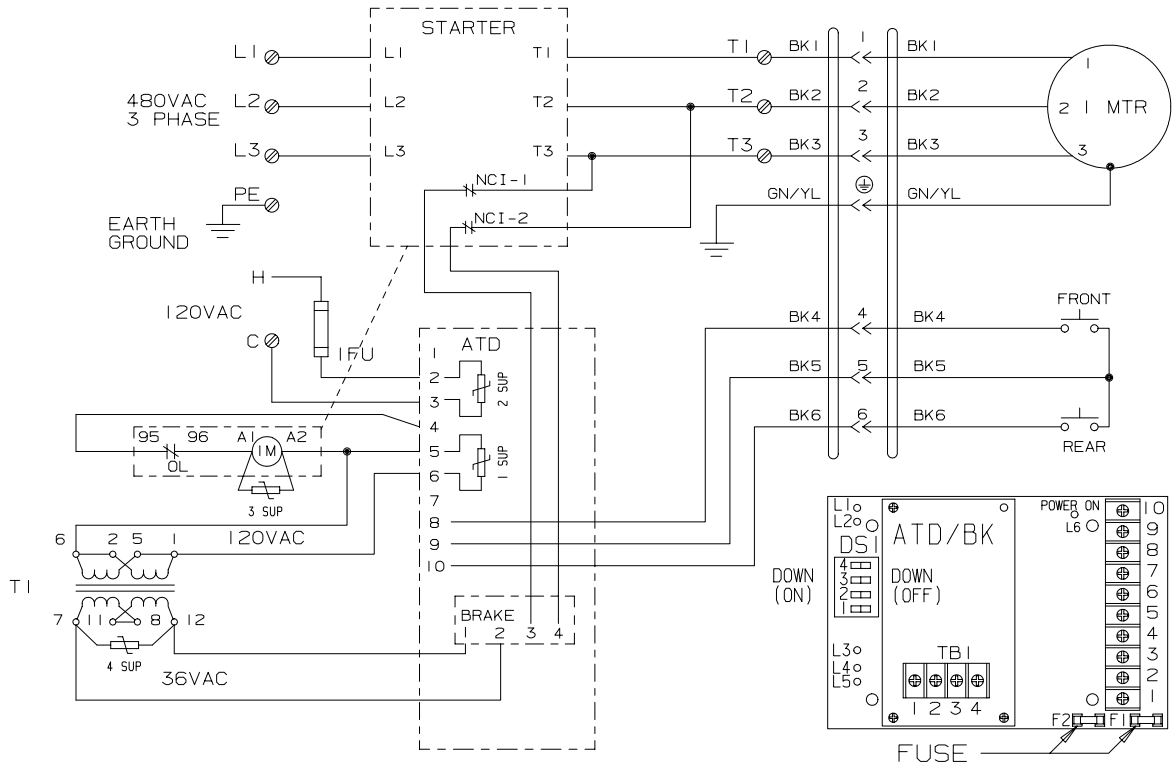
PIN 1	-	BLK 1
PIN 2	-	BLK 2
PIN 3	-	BLK 3
GRD	-	GRN/YEL 4
PIN 4	-	BLK 4
PIN 5	-	BLK 4
PIN 6	-	BLK 6

TO 480VAC POWER SUPPLY SUPPLIED BY CUSTOMER.
TO 120VAC POWER SUPPLY SUPPLIED BY CUSTOMER.

Wiring Diagram 220-240V DC Brake



Wiring Diagram 480V DC Brake



Models SEC 230-4 and 230-4LN

TABLE 1 - COMPLETE TOOL PART NUMBERS

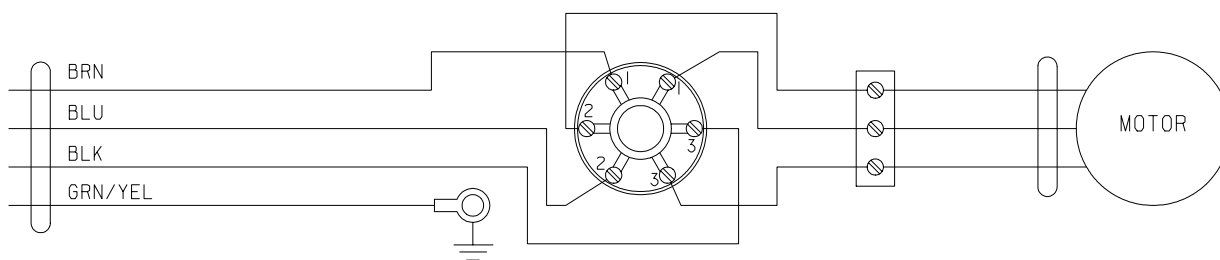
Saw Voltage/Hz	42v/50	115v/50	208v/60	230v/50	240v/60	380v/50	400v/50	415v/50	480v/60	575v/60
SEC 230-4, 2 Triggers, DC Brake	4004218				4004217				4004216	
SEC 230-4LN, 2 Triggers, DC Brake	4004221				4004220				4004219	
SEC 230-4, 1 Trigger, Mech Brake	4004206	4004246		4004207	4004215	4004205			4004214	
SEC 230-4LN 1Trigger, Mech Brake	4004224				4004223				4004222	

TABLE 2 - DC BRAKE (See Figure E)

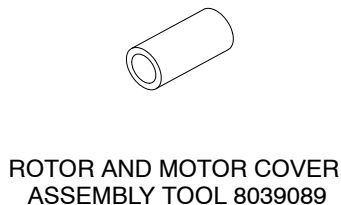
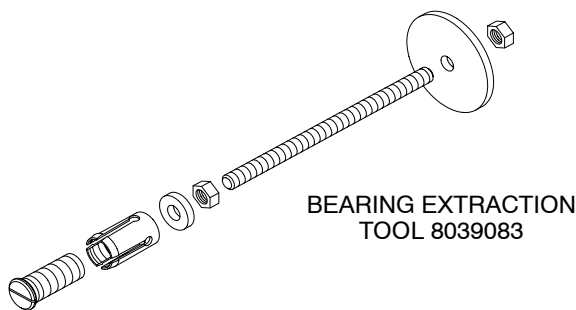
Item	Name	Part Numbers									
	Control Box, 2 Triggers, DC Brake	3063260	3063261	3063262	3063263	3063263	3063206	3063206	3063264	3063265	3063266
1	Auxiliary Contacts		1063528		1063528	1063528	1063528			1063528	
2	Magnetic Starter		1063557		1063527	1063527	1063527			1063544	
3	Heater Pack		1063659		1063657	1063657	1063656			1063655	
4	Suppressor 3		1063709		1063703	1063703	1063703			1063709	
5	Connector Base with Cover		1063810		1063810	1063810	1063810			1063810	
6	Connector Insert, Female		1063808		1063808	1063808	1063808			1063808	
7	Washer		1004226		1004226	1004226	1004226			1004320	
8	Pan Head Screw		1055970		1055970	1055970	1055970			1055484	
9	Internal Lock Washer		1004227		1004227	1004227	1004227			1004006	
10	Hex Nut		1007318		1007318	1007318	1007318			1007192	
11	Cord Connector		N/A		N/A	N/A	N/A			1011248	
12	Locking Nut		N/A		N/A	N/A	N/A			1007249	
13	Cord Connector		1011249		1011249	1011249	1011249			1011249	
14	Fuse Terminal Block		1063390		1063390	1063390	1063390			1063455	
15	Fuse		1063781		1063537	1063537	1063559			1063348	
16	Locking Nut		1007256		1007256	1007256	1007256			1007256	
17	Electrical Enclosure		1016512		1016512	1016512	1016512			1016573	
18	Mounting Plate		1032371		1032371	1032371	1032371			1032474	
19	Terminal End Clamp		1063362		1063362	1063362	1063362			1063362	
20	Terminal Marker		1063363		1063363	1063363	1063363			1063363	
21	Grey Terminal Block		1063494		1063494	1063464	1063494			1063494	
22	Terminal Rail		1063393		1063393	1063393	1063393			1063393	
23	Female Disconnect Term		1063533		1063533	1063533	1063533			1063533	
24	Male/Fem Piggyback Term		1063402		1063402	1063402	1063402			1063402	
25	Yellow/Green Terminal Block		1063496		1063496	1063496	1063496			1063496	
26	Suppressor 4		1063708		1063708	1063708	1063708			1063708	
27	Transformer		1063598		1063598	1063598	1063598			1063598	
28	Pan Head Screw		1055803		1055803	1055803	1055803			1055010	
29	External Lock Washer		1004247		1004247	1004247	1004247			1004022	
30	Terminal Marker		N/A		N/A	N/A	N/A			1063456	
31	Hex Head Screw		1055754		1055754	1055754	1055754			1055477	
32	Internal Lock Washer		1004227		1004227	1004227	1004227			1004244	
33	Pan Head Screw		1055910		1055910	1055910	1055910			1055490	
34	Fuse F2		1072310		1072310	1072310	1072310			1072310	
35	Fuse F1		1072091		1063862	1063862	1063862			1072091	
36	Suppressor 2		1063702		1063702	1063702	1063702			1063702	
37	Suppressor 1		1063709		N/A	N/A	1063701			1063709	
38	Circuit Board		1063556		1063530	1063530	1063530			1063556	
39	Terminal Fork		1063502		1063502	1063502	1063502			1063502	
40	Internal Lock Washer		1002244		1002244	1004244	1004244			1004244	
41	Hex Spacer		1029445		1029445	1029445	1029445			1029445	
42	Plastic Screw		1073072		1073072	1073072	1073072			1073072	
43	Danger Label		1017085		1017085	1017085	1017085			1017085	
44	Wiring Diagram Label		1017340		1017342	1017342	1017294			1017344	

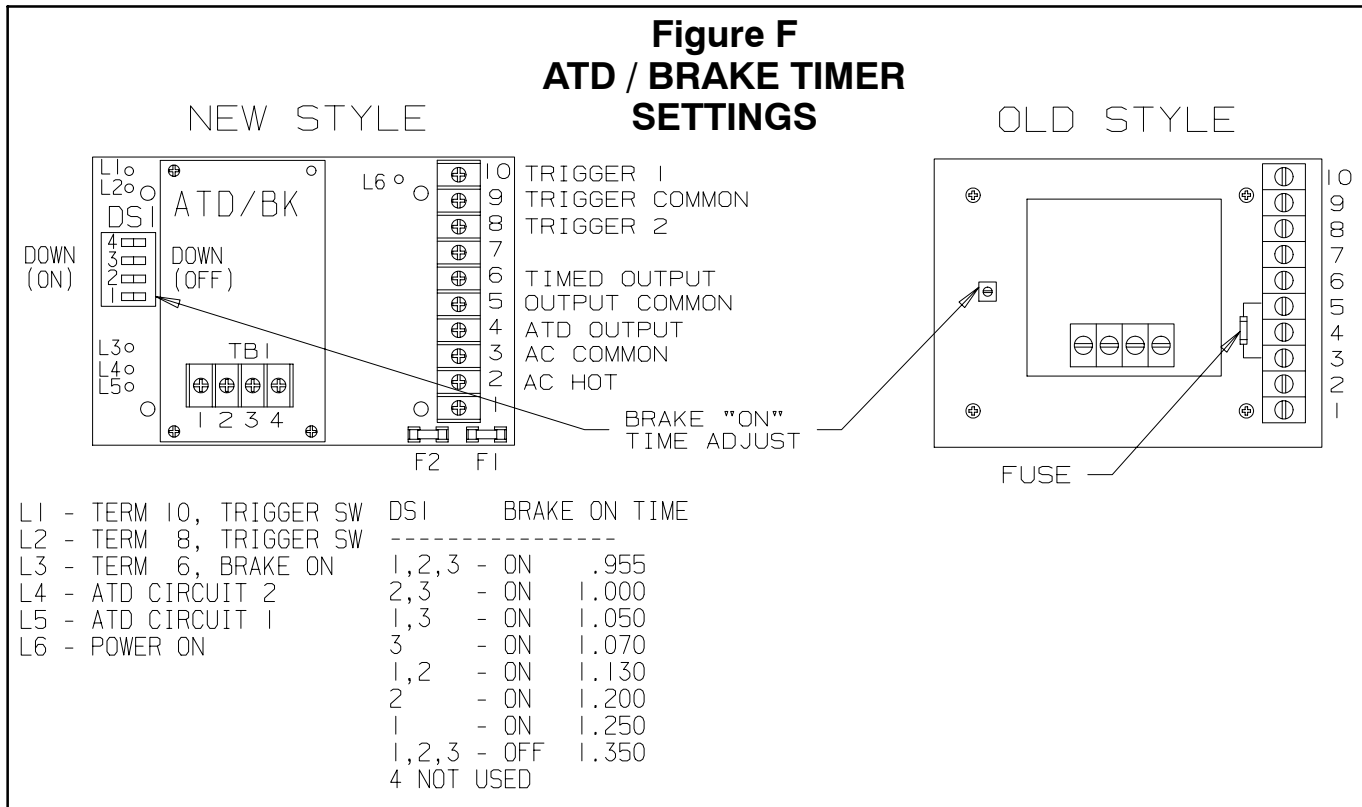
TABLE 3- MISCELLANEOUS COMPONENTS											
N/A indicates item is not applicable.											
Saw Voltage/Hz		42v/50	115v/50	208v/60	230v/50	240v/60	380v/50	400v/50	415v/50	480v/60	575v/60
Item 34, pg 4	Housing and Stator Assembly w/o Cords	3016370	3016371	3016372	3016373	3016374	3016376	3016375	3016377	3016378	3016379
Item 69, pg 5	Connector Shell	1063628								1063809	
Item 70, pg 5	Connector Insert	1063626								1063807	
Item 71, pg 5	Electric Cord	1001159								1001143	
Item 96, pg 6	Electric Cord	1001157			1001095		1001095			1001095	
Item 97, pg 6	Strain Relief Connector	1011328			1011260		1011260			1011260	
"X", pg 8	Overload Setting	"B"	"C"		"C"		"B"			"C"	

Wiring Diagram Mechanical Brake



THE FOLLOWING TOOLS ARE RECOMMENDED FOR PROPER AND EFFECTIVE ASSEMBLY AND DISASSEMBLY OF THE JARVIS SEC 230-4 CIRCULAR BREAKING SAWS.





SPECIFICATIONS

Motor Power	2.25 hp	1700 W
Operating Voltages	42V, 115V, 230V, 400V, 415V, 3 phase, 50 Hz 208V, 240V, 380V, 480V, 575V, 3 phase, 60 Hz	
Blade Speed	1350 rpm at 50 Hz 1650 rpm at 60 Hz	
Control Handle	Electric Dual Anti-tie-down or One Trigger (CE)	
Brake	Electric (DC) or Mechanical	
Blade Diameter	9.1 in	230 mm
Cutting Depth (max.)	3.0 in	75 mm
Overall Length	24 in	610 mm
Weight	40 lbs	18.1 kg
Vibration	less than 108 dB	< 0.25 m/sec ²
Noise (one meter from tool)	less than 80 dB	

INSTALLATION INSTRUCTIONS

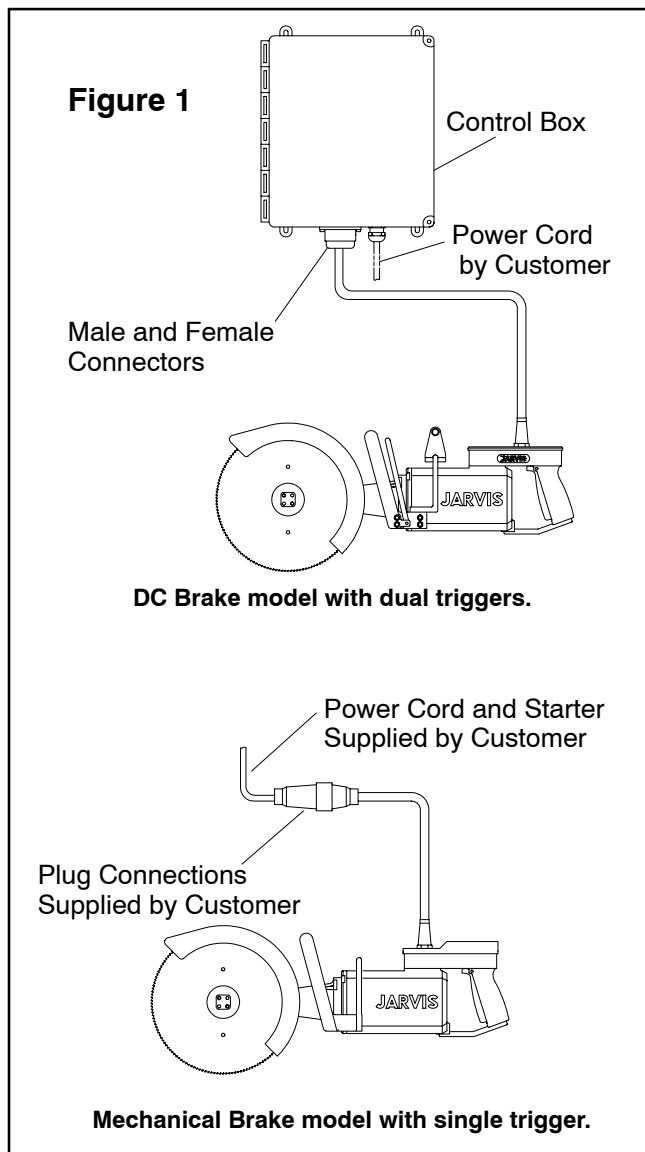
IMPORTANT: ALWAYS DISCONNECT THE POWER SUPPLY IN ACCORDANCE WITH OSHA'S LOCKOUT/TAGOUT PROCEDURES (29 CFR 1910.147) BEFORE PERFORMING ANY REPAIRS OR MAINTENANCE. ALL WIRING MUST BE DONE IN ACCORDANCE WITH NATIONAL, STATE AND LOCAL ELECTRICAL CODES.

- 1 Install the electrical control box (DC brake models) in a convenient location.
- 2 Wire the electrical control box. *Note: Electrical control boxes are different for different power supplies. You must have the proper control box for your power supply. Refer to Table 2, page 10 for control box numbers.*
 - 2.1 Attach terminals to the appropriately rated power supply. *See wiring diagram inside control box cover.*
- 3 For mechanical brake models, wire electrical cord (item 96) to appropriately rated power supply. *Refer to Wiring Diagrams on page 11 as a guide. Note: plug connections and starter are supplied by customer.*

- 4 Install a balancer above the work station on a trolley.
Jarvis part number 4042035 is available.

Note: The trolley should have sufficient travel to allow the operator to reach the entire work area.

- 5 Suspend the tool from the balancer.
 - 5.1 Adjust the balancer to the operator's preference.
- 6 Plug the tool into the control box outlet (DC brake models) or power supply outlet (mechanical brake models) as applicable. *Refer to Figure 1, below, as a guide.*



OPERATION INSTRUCTIONS

- 1 Plug in the tool.
- 2 *Each day*, before you begin operation, perform the following:
 - 2.1 Make sure that tool moves freely on its balancer.
 - 2.2 Make sure that the saw is working correctly. Check for the correct operation of the trigger(s) prior to use or daily.

Always use two hands when starting and stopping the tool. Continue holding the tool with two hands until the saw blade comes to a complete stop.

- 2.2.1 For models equipped with a single trigger, depress the rear trigger and the tool should start. Release the trigger and the tool should stop within 2.5 seconds. *If the tool malfunctions, remove it from service and report the problem to your supervisor immediately.*
- 2.2.2 For dual anti-tie-down control handles (front and rear handles), **depress** each trigger separately and the tool should not start. **Depress** one trigger, then pause one second and depress the other trigger and the tool should not start. **Repeat** this procedure reversing the triggers. **Depress both** triggers simultaneously (within one half second of each other) and the tool should start. With the tool running, **release one** trigger and the tool should stop within 2.5 seconds. **Continue** holding the depressed trigger and then depress the other trigger. The tool should not start. **Repeat** this procedure holding the other trigger. *If the tool malfunctions, remove it from service and report the problem to your supervisor immediately.*
- 3 Make the cut:
 - 3.1 Position the saw.
 - 3.2 **Depress** the rear trigger or **both** triggers simultaneously (within one half second of each other), *as applicable*, and make the cut.
 - 3.3 When the desired length of cut is reached, release the trigger or triggers. This will stop the blade from rotating. **Continue holding the tool with two hands until the saw blade comes to a complete stop.**
 - 3.4 Withdraw the saw from the carcass.
- 4 Unplug the tool.

MAINTENANCE INSTRUCTIONS

ALWAYS DISCONNECT THE POWER SUPPLY IN ACCORDANCE WITH OSHA'S LOCKOUT/TAGOUT PROCEDURES (29 CFR 1910.147) BEFORE INSTALLING OR REMOVING A BLADE. ALWAYS DISCONNECT THE POWER SUPPLY IN ACCORDANCE WITH OSHA'S LOCKOUT/TAGOUT PROCEDURES (29 CFR 1910.147) BEFORE PERFORMING ANY REPAIRS OR MAINTENANCE.

1 PRIOR TO USE OR DAILY:

- 1.1 Add **Jarvis 1315 White Grease** to grease fitting (item 44) on the right angle gear housing (item 17 or 25).
- 1.2 Make sure that the saw is working correctly. Check for the correct operation of the trigger(s) prior to use or daily:

Always use two hands when starting and stopping the tool. Continue holding the tool with two hands until the saw blade comes to a complete stop.

- 1.2.1 For models equipped with a single trigger, depress the rear trigger and the tool should start. Release the trigger and the tool should stop within 2.5 seconds. *If the tool malfunctions, repair or remove it from service immediately.*
- 1.2.2 For dual anti-tie-down control handles (front and rear handles), **depress** each trigger separately and the tool should not start. **Depress** one trigger, then pause one second and depress the other trigger and the tool should not start. **Repeat** this procedure reversing the triggers. **Depress both** triggers simultaneously (within one half second of each other) and the tool should start. With the tool running, **release one** trigger and the tool should stop within 2.5 seconds. **Continue** holding the depressed trigger and then depress the other trigger. The tool should not start. **Repeat** this procedure holding the other trigger. *If the tool malfunctions, repair or remove it from service immediately.*
- 1.2.3 On DC brake models, to adjust the blade stopping time, use rocker switch settings as shown on Figure F, page 12.

2 CIRCULAR BLADE REMOVAL:

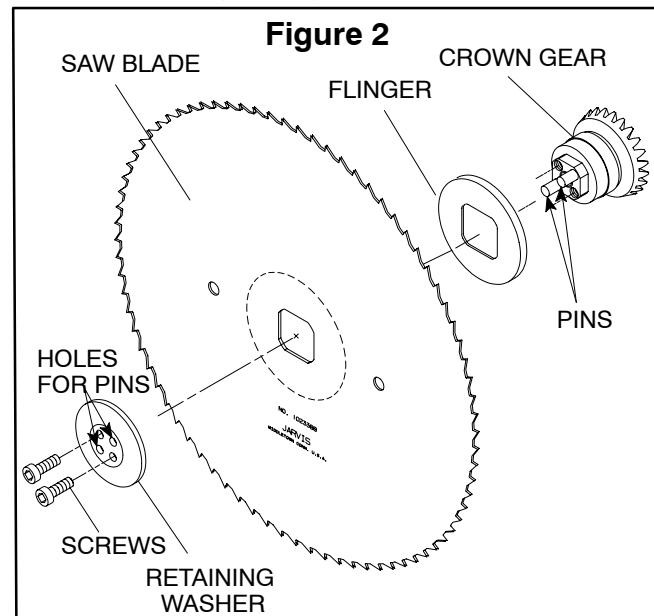
- 2.1 Remove depth gage locking lever (item 47) and

rotate depth gage plate (item 2) out of the way to access blade retaining screws and washer (items 3 and 4).

- 2.2 Remove blade retaining screws (item 3). **Jarvis** wrench, part number 8039147 is supplied. *Prevent blade from turning by inserting blade locking pin (item 46) through hole in blade.*
- 2.3 Remove blade retaining washer (item 4).
- 2.4 Remove circular blade (item 5).
- 2.5 Inspect all parts for wear and replace or sharpen if necessary.

3 CIRCULAR BLADE INSTALLATION:

- 3.1 Reverse steps and procedures outlined in section 2. *See notes below.*
 - 3.1.1 To ensure proper fit and safe operation, the flinger (item 6) and saw blade (item 5) must fit securely on the crown gear (item 15). The hub on the saw blade must be facing the crown gear.
 - 3.1.2 The holes in blade washer (item 4) must align with the pins (item 14) of the crown gear (item 15). *See Figure 2 below.*

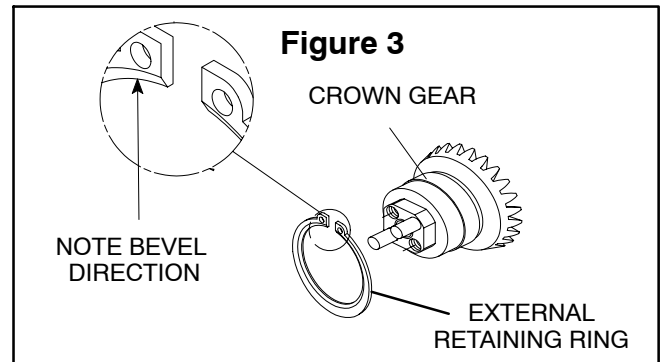


4 RIGHT ANGLE GEAR HOUSING DISASSEMBLY:

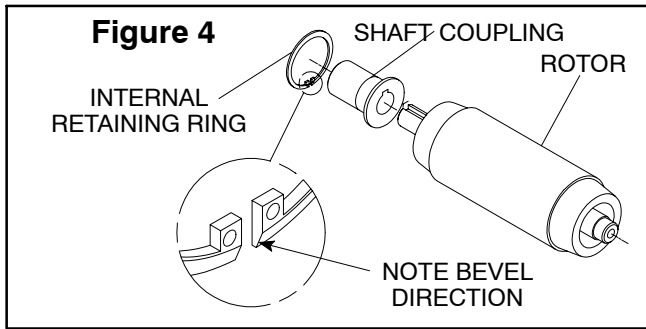
- 4.1 Remove blade as described in section 2.
- 4.2 Remove (2) flat head screws (item 8) and remove blade guard (item 7).
- 4.3 Remove (4) cheese head screws (item 18) and remove gear head assembly from saw.

- 4.4 Remove (3) flat head screws (item 8) and remove gear head cover (item 9), o-ring (item 10) and oil seal (item 11) from right angle gear housing (item 17 or 25).
- 4.5 Lightly tap right angle gear housing in guard mounting area with a nylon mallet until bearing assembly (items 12-16) slides out of right angle gear housing.
- 4.6 Remove external retaining ring (item 12).
- 4.7 Place crown gear (item 15) in arbor press and remove ball bearing (item 13). Using a 7 mm pin, press ball bearing (item 16) from crown gear (item 15).
- 4.8 Remove internal retaining ring (item 24) from right angle gear housing (item 17 or 25).
- 4.9 Lightly tap end of right angle gear housing (item 17 or 25) with a nylon mallet until pinion gear (item 21), inner race (item 22) and bearing (item 23) come out of right angle gear housing.
- 4.10 Place pinion gear (item 21) in arbor press and remove ball bearing (item 23). If necessary, also remove inner race (item 22).
- 4.11 Remove needle bearing (item 20) from right angle gear housing (item 17 or 25). **Jarvis** bearing extraction tool, part number 8039083, is available.
- 4.12 Remove o-ring (item 19).
- 4.13 Inspect all parts for wear and replace if necessary.
- 5 RIGHT ANGLE GEAR HOUSING ASSEMBLY:
 - 5.1 Reverse steps and procedures outlined in section 4. *See special notes below.*
 - 5.1.1 **Jarvis** needle bearing assembly tool, part number 8039091, is available to insert needle bearing (item 20) into right angle gear housing (item 17 or 25).
 - 5.1.2 **Jarvis** inner ring assembly tool, part number 8039090, is available to assemble inner race (item 22) onto pinion gear (item 21).
 - 5.1.3 Make sure the bevel end of external retaining ring (item 12) is facing away from crown gear teeth (item 15). *See Figure 3.*
- 6 MOTOR DISASSEMBLY:
 - 6.1 Remove blade as described in section 2.
 - 6.2 Remove right angle gear housing as described in section 4.
 - 6.3 Remove (4) cheese head screws (item 18), mo-

tor front cover (item 27), o-ring (item 28) and rotor assembly (items 29-32, 39 and 40) from housing (item 34).



- 6.4 Place front cover and rotor assembly in arbor press and press rotor (item 31) and shaft coupling (item 41) from motor front cover (item 27).
- 6.5 Remove internal retaining ring (item 42).
- 6.6 Press ball bearing (item 29) from front motor cover (item 27).
- 6.7 Place rotor (item 31) in arbor press and press shaft coupling (item 41) and square key (item 30) from rotor.
- 6.8 Turn rotor around and press bearing (item 32) from rotor (item 31).
- 6.9 Remove o-ring (item 33) from bottom of housing (item 34).
- 6.10 Inspect all parts for wear and replace if necessary.
- 7 MOTOR ASSEMBLY:
 - 7.1 Reverse steps and procedures outline in section 6. *See special notes below.*
 - 7.1.1 **Jarvis** rotor and motor cover assembly tool, part number 8039089, is available to assemble rotor and shaft coupling (items 31 and 41) into motor front cover and ball bearing (items 27 and 29).
 - 7.1.2 Make sure the bevel end of internal retaining ring (item 42) is facing toward rotor and shaft coupling (items 31 and 41). *See Figure 4.*
- 8 REAR HANDLE DISASSEMBLY FOR DC BRAKE MODELS:
 - 8.1 Remove screws (items 48 and 73).
 - 8.2 Remove rear handle cover (item 94) and gasket (item 93).



- 8.3 Disconnect input wiring from terminals on electric switches (item 90). *Make note of wiring connection locations for re-assembly.*
- 8.4 Remove switch and lever assembly (items 86-90).
 - 8.4.1 Remove dowel pin (item 87).
 - 8.4.2 Remove pan head screw (item 89).
 - 8.4.3 Remove switch actuating lever (item 86) and electric switches (item 90) from switch holder (item 88).
- 8.5 Remove socket head screw (item 37) and remove rear handle (item 83).
- 8.6 Remove internal retaining ring (item 92), ring washer (item 91) and diaphragm seal (item 74).
- 8.7 Press dowel pin (item 80) from handle and remove trigger lever (item 79).
- 8.8 Remove spring (item 82).
- 8.9 Inspect parts for wear and replace if necessary.
- 9 REAR HANDLE ASSEMBLY FOR DC BRAKE MODELS:
 - 9.1 Reverse steps and procedures described in section 8. *Connect wiring to noted locations from step 8.3.*
- 10 REAR HANDLE DISASSEMBLY FOR MECHANICAL BRAKE MODELS:
 - 10.1 Remove hex head screws (items 98 and 120).
 - 10.2 Remove handle cover (item 118) and gasket (item 117).
 - 10.3 Disconnect input wiring from terminals on push button switch (item 99). *Make note of wiring connection locations for re-assembly.*
 - 10.4 Remove socket head screws (item 116) and switch mounting plate (item 100).
 - 10.5 Remove cheese head screws (item 101) and push button switch (item 99) from switch mounting plate (item 100).
 - 10.6 Remove socket head screws (items 37 and 115), handle gaskets (items 108 and 113) and rear handle (item 107).
 - 10.7 Remove trigger bushing (item 105), dowel pin (item 102) and u-cup seal (item 106) from rear handle (item 107).
 - 10.8 Press dowel pin (item 109) from rear handle (item 107) and remove trigger lever (item 110), spring (item 111) and spring plunger (item 112).
 - 10.9 Inspect all parts for wear and replace if necessary.
- 11 REAR HANDLE ASSEMBLY FOR MECHANICAL BRAKE MODELS:
 - 11.1 Reverse steps and procedures outlined in section 10. *Connect wiring to noted locations from step 10.3.*
- 12 FRONT HANDLE TRIGGER DISASSEMBLY:
 - 12.1 Remove rear handle cover as described in section 8, steps 8.1 and 8.2.
 - 12.2 Disconnect wiring from front handle switch assembly (item 51) at terminal block located inside rear handle assembly. *Make note of wiring connection locations for re-assembly.*
 - 12.3 Remove conduit assembly (item 55).
 - 12.4 Remove (3) socket head screws (item 67).
 - 12.5 Remove front handle assembly.
 - 12.6 Remove oval head screws (item 48), front handle switch cover (item 49) and switch cover seal (item 50).
 - 12.7 Pull out switch assembly (item 51) and o-ring (item 53).
 - 12.8 Remove socket head screws (item 3) and hanger bracket (item 58).
 - 12.9 Remove socket head screws (item 61) and hanger bracket halves (items 59 and 60).
 - 12.10 Remove (2) threaded pins (item 66) and trigger lever (item 56).
 - 12.11 Remove pan head screws (item 62), flat washer (item 63) and spring (item 64).
 - 12.12 Inspect parts for wear and replace if necessary.
- 13 FRONT HANDLE TRIGGER ASSEMBLY:
 - 13.1 Reverse steps and procedures outlined in section 12. *Connect wiring to noted locations from step 12.2.*