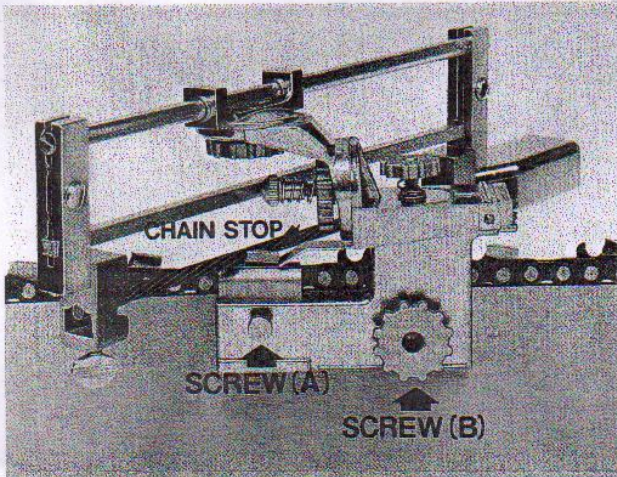
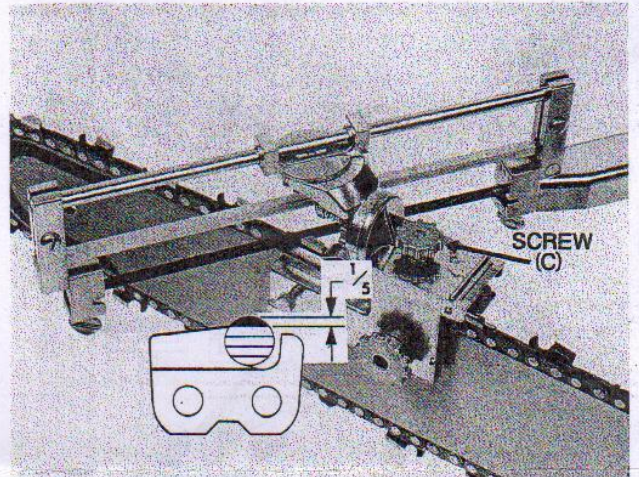


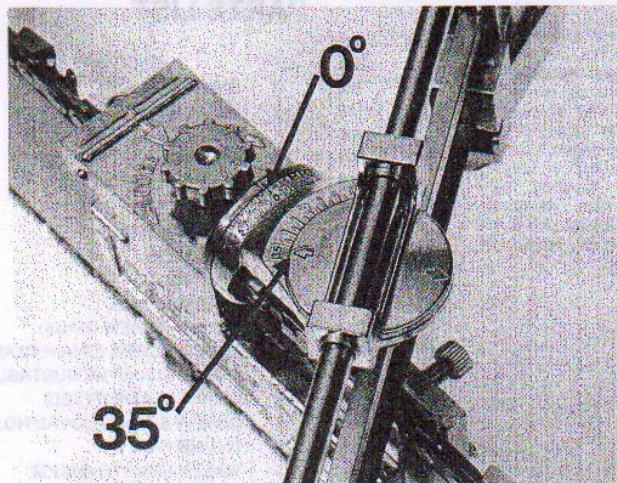
File-N-Joint® Instructions



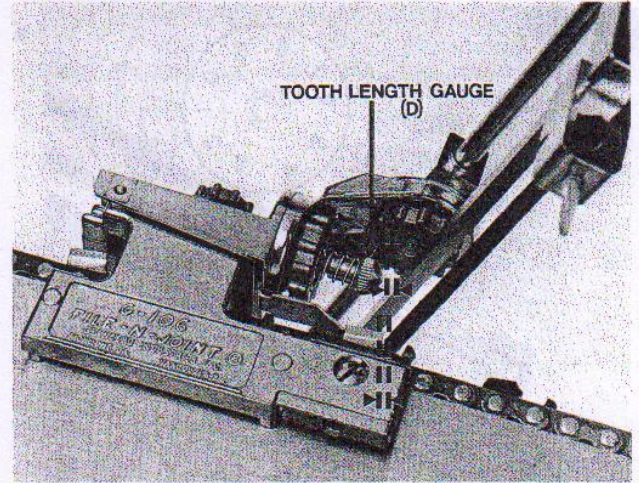
1. Position File-N-Joint® on bar...tighten screws (A) to lock chain clamp over chain rivets. Hold File-N-Joint® parallel to bar; tighten screw (B). Back off screws (A) slightly to allow chain to move through snugly but freely. Position back of cutter against chain stop.



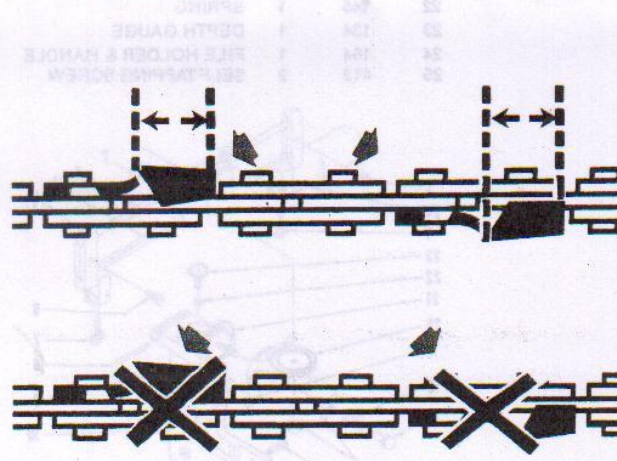
2. Set file height by turning screw (C). File should show approximately 1/5 to 1/10 of its diameter above the cutter. See manufacturer's filing instructions.



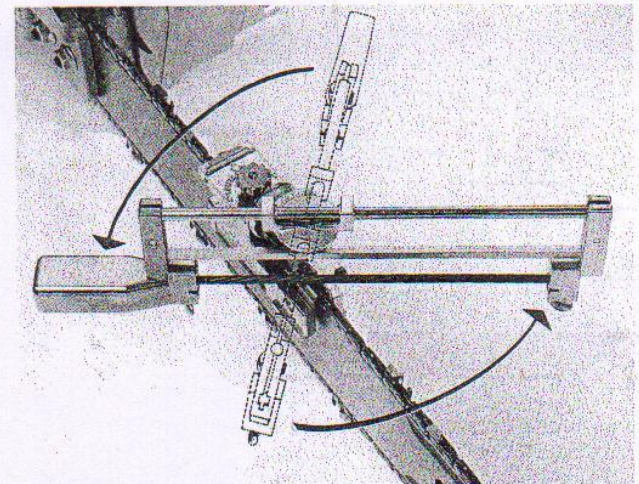
3. Set tilt dial at 0°. Set filing angles according to manufacturer's instructions on horizontal scale (eg. 35° for chain with round cutters).



4. Adjust tooth length gauge (D) to control amount of cutter to be filed back.

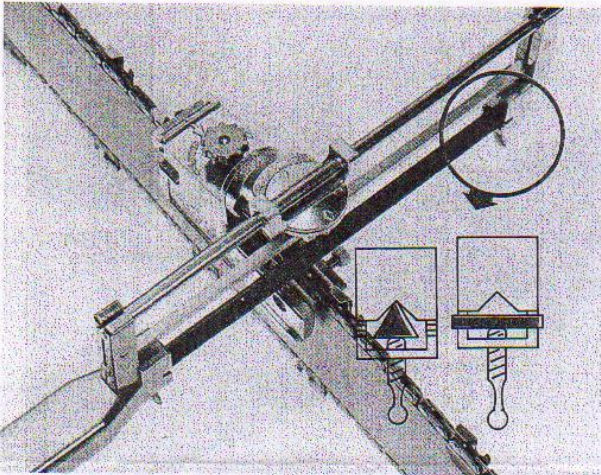


5. Start with shortest cutter and file all cutters on both sides to same length.

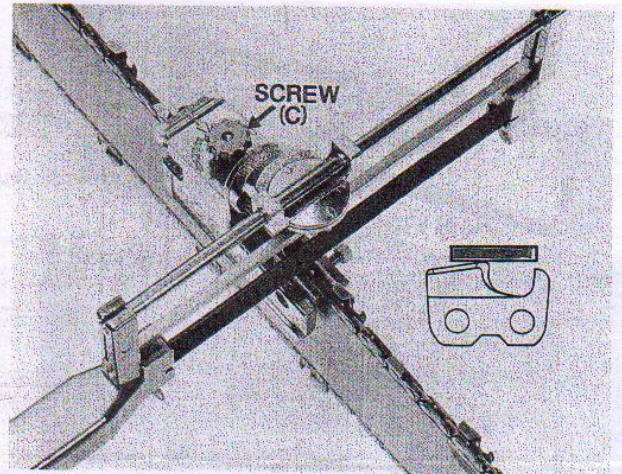


6. When filing cutters on the other side of chain, reset filing angle on opposite side of horizontal scale. Check tooth length. Adjust tooth length gauge (D) if necessary. See manufacturer's filing instructions

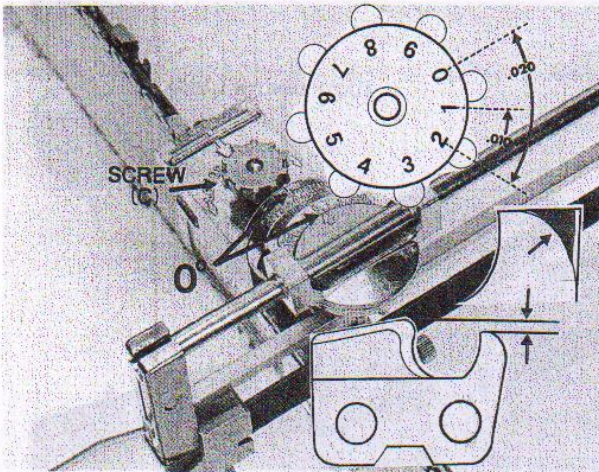
G-106 File-N-Joint®



7. Use a flat or triangular file to lower depth gauges.



8. Adjust screw (C) until file rests on top of cutter.



9. Set tilt dial and angle dial at 0°. Adjust file height to depth gauge setting as recommended by manufacturer by turning screw (C). Each number indicated on screw (C) corresponds to approximately .010". If setting of .025" is required, turn screw (C) 2½ numbers counter-clockwise. After filing depth gauge, round off front corner.

PARTS LIST

ITEM NO.	PART NO.	QTY.	DESCRIPTION
1	130	1	SWIVEL GUIDE
2	142	2	BUSHING
3	140	1	FILE FRAME SLIDE ROD
4	141	1	FILE FRAME STOP BAR
5	160	1	FILE HOLDER FRAME
6	165	2	SCREW 8-32 x 7/16
7	21	2	THUMB SCREW
8	138	1	HINGE PIN
9	32	1	SPRING
10	124	1	ANCHOR BASE
11	306	1	THUMB SCREW (BASE)
12	453	1	THUMB SCREW (CHAIN CLAMP)
13	135-1	1	CHAIN CLAMP (ADJUSTABLE)
14	135-2	1	CHAIN CLAMP (FIXED)
15	453	1	SCREW 8-32 x ¼ (OVAL HD.)
16	925	2	THUMB NUT
17	154	1	TOOTH LENGTH GAUGE
18	137	1	SPRING
19	136	1	CHAIN STOP
20	126	1	TILT & SWIVEL BASE
21	125	1	ADJUSTMENT BASE
22	145	1	SPRING
23	134	1	DEPTH GAUGE
24	164	1	FILE HOLDER & HANDLE
25	412	2	SELF-TAPPING SCREW

