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 OR ANY DEWALT TOOL, CALL US TOLL FREE AT:  
**1-800-4-DEWALT (1-800-433-9258)**

DW321

DeWalt

Jig Saw

VS orbital

**DEWALT... BUILT JOBSITE TOUGH**

DeWalt high performance industrial tools are made for America's toughest industrial and construction applications. The design of every tool in the line—from drills to sanders to grinders—is the result of rigorous use on jobsites and throughout industry. Each tool is produced with painstaking precision using advanced manufacturing systems and intense quality control. Every tool is checked before it leaves the factory to make sure that it meets your standards for durability, reliability and power.

**DEWALT** Built Jobsite Tough.....WE GUARANTEE IT.

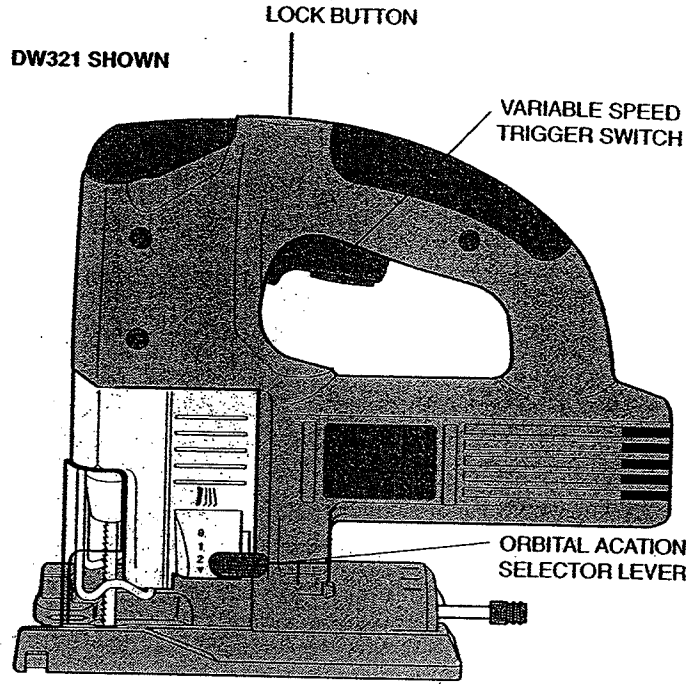


FIG. 1 DW321 B

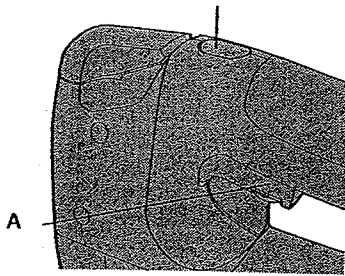
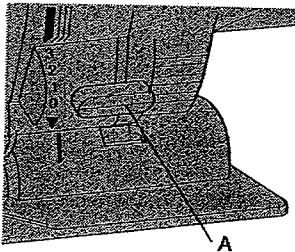


FIG. 2



**Motor**

Our DEWALT tool is powered by a DeWALT-built motor. Be sure your power supply agrees with the nameplate markings.

Volts 50/60 Hz or "AC only" means your tool must be operated only with alternating current and never with direct current. Volts DC-60 Hz or AC/DC means your tool may be operated with either alternating or direct current.

Voltage decrease of more than 10% will cause loss of power and

overheating. All DeWALT tools are factory tested; if this tool does not operate, check the power supply.

**Variable Speed Switch (Fig. 1)**

This switch has a button "A", mounted in the trigger, which can be rotated to vary the blade stroke speed.

- (a) For "Free Hand" speed control (the further the trigger is pulled, the higher the S.P.M.) rotate the button to the 7 position (clockwise).
- (b) To set the trigger switch to produce a selected speed each time the trigger is squeezed, first rotate the button toward 7 until it stops. Then fully depress the trigger, press the locking button "B", and release the trigger. The tool will stay ON. Now, rotate the button "A" toward the 1 and you will notice a decrease in speed. Continue rotating the button until the desired speed is reached. Pull the trigger and release to turn the tool OFF. At this setting the saw will run at the selected speed each time the trigger is pulled and the trigger may be locked ON at the selected speed.

**Straight Line or Orbital Cutting Action**

For cutting softer materials your jig saw features orbital cutting action. Soft materials, like wood and plastic, permit deep penetration of individual saw teeth. The orbital action thrusts the blade forward on the cutting stroke and greatly increases cutting speed over conventional jig saws. Harder materials like metal should be cut using the straight line cutting action or a very low orbital setting. To select straight line or orbital cutting adjust the lever (A) on the saw as shown in Figure 2.

**Bevel Cutting Adjustment (Fig. 6 & 7)**

Bevel cuts may be made at any angle between 0° and 45°.

**TO ADJUST THE SHOE:**

- a. Lift the shoe lever on the bottom of the tool (A).
- b. Align the arrow on the housing with the line on the shoe Fig. 7.
- c. Rotate the shoe to the desired angle.

er setting the shoe, tighten it by returning the shoe lever to its original position.

**NOTE:** The shoe will be difficult to bevel at first. Ensure the shoe lever is up and the two arrows shown are aligned. Gently rock the shoe from side to side to loosen.

When the shoe lever is down, the shoe may slide back to allow for cutting in tight work areas. To lock the shoe lever, slide the shoe back and depress the lever to lock. To lock the shoe lever, slide the shoe back and depress the lever to lock. To lock the shoe lever, slide the shoe back and depress the lever to lock. To lock the shoe lever, slide the shoe back and depress the lever to lock.

### Attaching Blades (Fig. 4 & 5)

**PLUG TOOL.** To remove the blade, lift the knob on the top of the saw approximately 1/2". Rotate the knob counterclockwise until the knob is open (Figure 4a). Do not force the knob once it stops. Insert blade as shown. Make sure the back edge of the blade fits into the support roller. Tighten clamp by turning top knob clockwise until you hear a click. Push knob down.

For "T" shank blades, insert blade to the shoulder of the shank, positions C and D.

### Pocket Cutting (Fig. 5 & 6)

Pocket cut is an easy method of making an inside cut. The saw can be inserted directly into a panel or board without first drilling a lead or pilot hole. In pocket cutting measure the surface to be cut and mark carefully with a pencil. Be sure the shoe is extended forward. Next tip the saw forward until the front end of the shoe sits firmly on the work surface. Switch the tool on and allow it to attain maximum speed. Grip the saw firmly and lower the back edge of tool slowly until the blade reaches its complete depth. Hold the shoe flat against the wood and begin cutting. Do not remove blade from cut while it is still moving. The blade must come to a complete stop.

### Wood Cutting

Ensure board is firmly positioned. Don't attempt to turn on when blade is against material to be cut. This could stall the motor. Place

FIG. 3

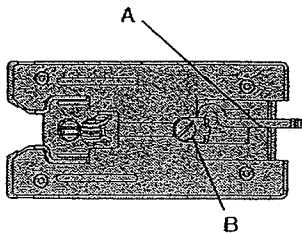


FIG. 4

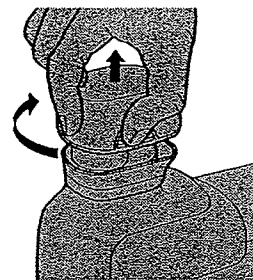


FIG. 5

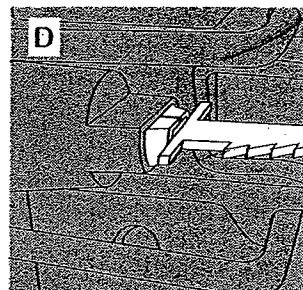
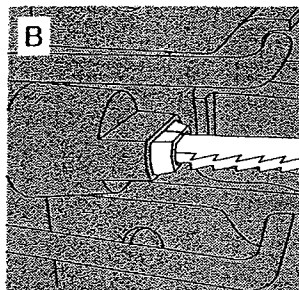
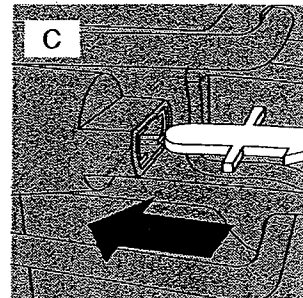
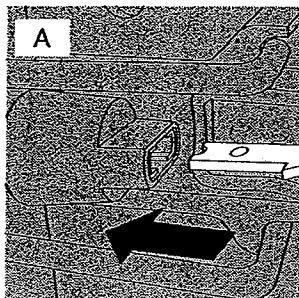


FIG. 5

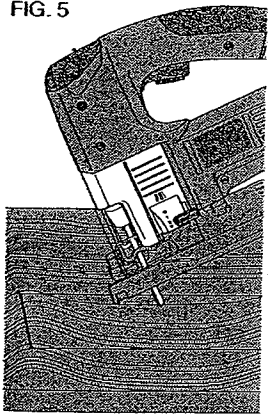
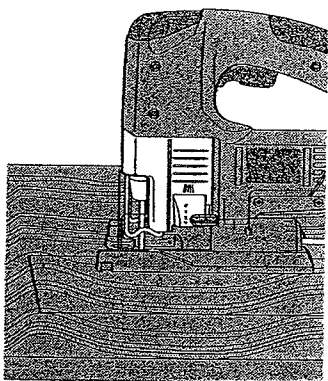


FIG. 6



the front of shoe on material to be cut and hold jig saw shoe firmly against the wood while cutting. Don't force the tool; let the blade cut at its own speed. Whenever possible, clamp or support work close to the line of cut; when the cut is completed, shut off power, let blade come to a complete stop and then lay the saw aside before loosening the work. Use the higher speed setting for cutting wood.

### Rip & Circle Cutting

Ripping and circle cutting without a pencil line are easily done with an accessory Rip Fence and Circle Guide (available at small extra cost). When using the Rip Fence and Circle Guide, the shoe must be in the Anti-Splintering position. When ripping: insert rip fence in either side of saw with cross bar facing down; adjust to width of cut and tighten screw. When circle cutting: Insert rip fence from either side with cross bar facing up; adjust rip fence so that distance from blade to hole in cross bar is the desired radius and tighten screw; place saw so that center of hole in cross bar is over center of circle to be cut (make pocket cut, drill hole for blade or cut inward from edge of material to move blade into position). When saw is properly positioned, drive a

small nail through hole in cross bar into exact center of circle to be cut. Using rip fence as a pivot arm, begin cutting circle.

### Metal Cutting

In cutting thin gauge sheet metals, it is best to clamp wood or plywood to the bottom of sheet metal; this will insure a clean cut without the danger of vibration or tearing of metal. Always remember to use a finer blade for ferrous metals (for those that have a high iron content); and use a coarser blade for non-ferrous metals (those that do not have an iron content). Use a high speed setting for cutting soft metals (aluminum, copper, brass, mild steel, galvanized pipe, conduit sheet metal, etc.). Use lower speed to cut plastics, tile, Formica, hard metals, cast iron.

### Rip Fence & Circle Guide

(AVAILABLE AT EXTRA COST)

Permits ripping without a penciled line and circle cutting with jig saws.

**CAUTION:** Recommended saw blades and accessories for your saw are listed in this manual. The use of any other type of blade or accessory might be hazardous.

### Lubrication

It is recommended that, at least once a year, you take or send the tool to a service center for a thorough cleaning, inspection and lubrication of the gear case.

### Accessories

Recommended accessories for use with your tool are available at extra cost from your local service center.

**CAUTION:** The use of any non-recommended accessory may be hazardous.

If you need assistance in locating any accessory, please contact DeWALT Industrial Tool Company, P.O. Box 158, 626 Hanover Pike, Hampstead, MD 21074 or call 1-800-4-DeWALT (1-800-433-9258).

FIG. 1

DW 318

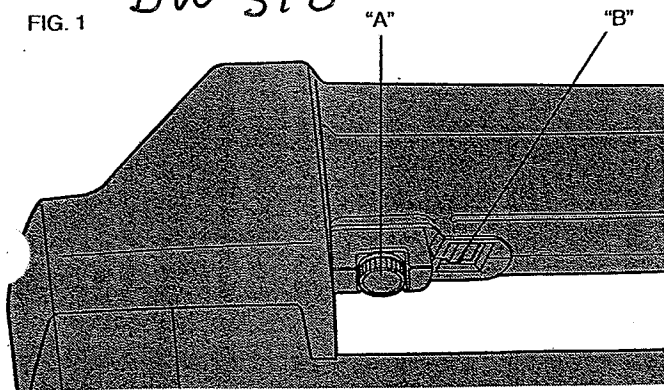
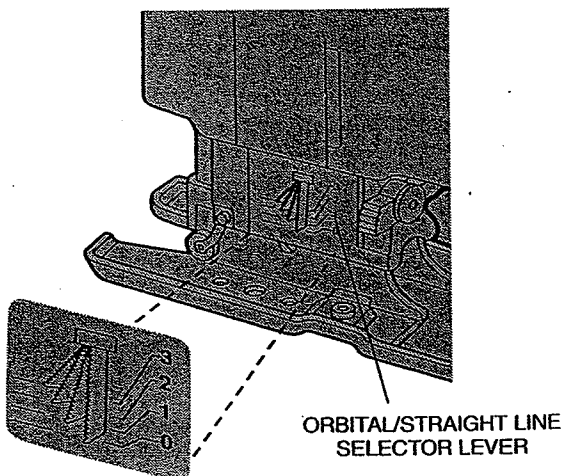


FIG. 2



3

using the straight line cutting action or a very low orbital setting. To select straight line or orbital cutting adjust the lever on the saw as shown in Figure 2.

### Bevel Cutting Adjustment

Bevel cuts may be made at any angle between 0° and 45°. The shoe is adjusted by loosening the screw on the bottom of the tool (Fig. 3) and rotating the shoe to the desired angle. After setting the shoe, tighten the screw firmly and use saw in the normal manner.

**NOTE:** One hand on the saw body and the other on the edge of the saw shoe, well back from the blade, may be necessary to maintain accurate cutting.

### Adjustment For 90° Cuts

1. Disconnect plug from power supply.
2. Place a right angle against the blade and the shoe and adjust the shoe to 90°.
3. The 0° mark on the quadrant plate should line up with mark on shoe. If adjustment is necessary, loosen screw on quadrant plate and adjust as necessary.

### Attaching Blades (Fig. 4)

Cycle the tool on and off as necessary to make the blade clamp stop in a position where you can reach the blade clamping screw. **NEVER REMOVE THE BLADE CLAMP GUIDE.**

Disconnect tool from extension cord or wall receptacle. Loosen screw at side of blade clamp. Insert blade in blade clamp as far as it will go (about 13 mm). Make sure the back edge of the blade fits into the support roller as shown in Fig. 4 and tighten the screw against the blade.

### Anti-Splintering Shoe (Fig. 5)

This jig saw has a special double-ended shoe with a wide opening at one end for general cutting and bevel cutting and a very narrow

### Motor

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### Variable Speed Switch (Fig. 1)

This switch has a button "A", mounted in the trigger, which can be rotated to vary the blade strokes-per-minute (S.P.M.).

- a. For "Free Hand" speed control (the further the trigger is depressed, the higher the S.P.M.), rotate the button in the "HI" direction (clockwise) until it stops.
- b. To set the trigger switch to produce a selected speed each time the trigger is squeezed, first rotate the button toward "HI" until it stops. Then fully depress the trigger, press in the locking button "B", and release the trigger. The tool will stay "ON". Now, rotate the button "A" toward "LO" and you will notice a decrease in speed. Continue rotating the button until desired speed is obtained. Pull trigger and release to turn the tool "OFF". At this setting the saw will run at the selected speed each time the trigger is pulled and the trigger may be locked "ON" at the selected speed.

### Straight Line or Orbital Cutting Action (DW318, DW318G, DW318-220)

For cutting softer materials your saw features orbital cutting action. Soft materials, like wood and plastic, permit deep penetration of individual saw teeth. The orbital action thrusts the blade forward on the cutting stroke and greatly increases cutting speed over conventional jig saws. Harder materials like metal should be cut

FIG. 3

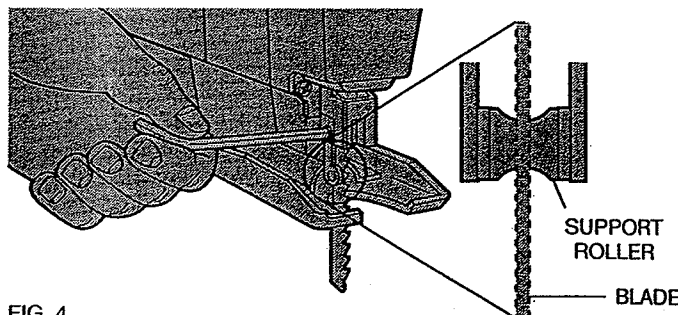
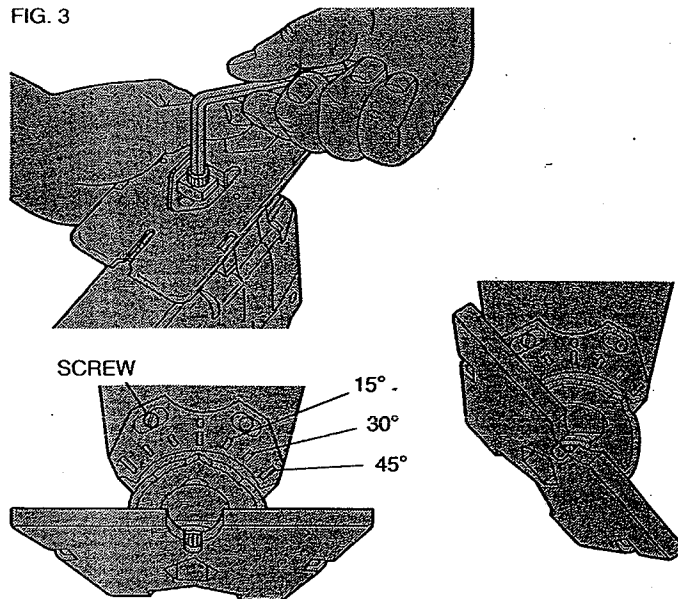


FIG. 4

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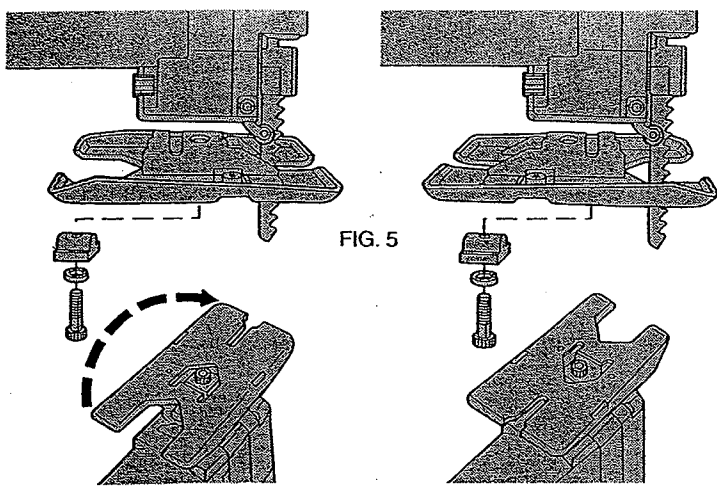


FIG. 5

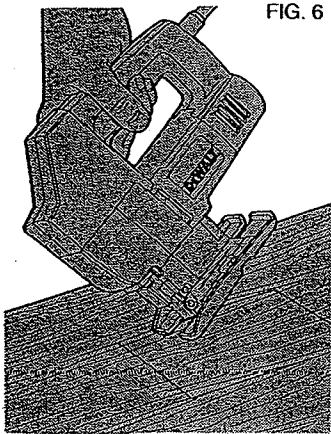


FIG. 6

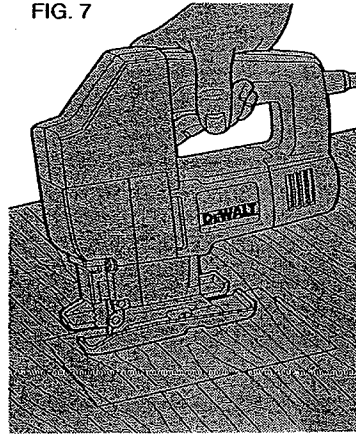


FIG. 7

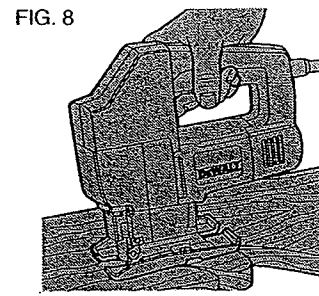


FIG. 8

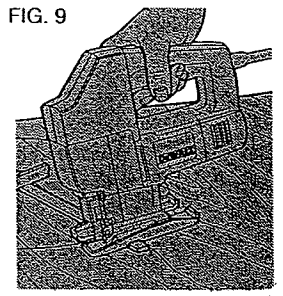


FIG. 9

slot at the other end for use only with hollow ground blades. This narrow slot acts as an anti-splintering device particularly useful when cutting plywood.

**NOTE:** Use only hollow ground blades in the slotted end of the shoe. Use of any other blades will damage the shoe. The anti-splintering feature should be used only when making straight cuts or circle cuts with a rip fence & circle guide, not for bevel cutting, pocket cutting or metal cutting.

### Reversing Shoe Position (UNPLUG TOOL)

To reverse the shoe position remove the screw from the bottom of the tool, as shown in Figure 5, and remove the shoe from the jig saw. (Be careful to note the position of the clamp. This clamp must be re-installed the same way or the shoe will not fit properly.) Turn the shoe around and re-install noting carefully that, when the slot is forward, the screw goes through the hole in the shoe and when the wide opening is forward, the screw passes through the slot in the shoe.

**NOTE:** Study Figure 5 before attempting to reverse shoe.

### Pocket Cutting (Figs. 6 & 7)

A pocket cut is an easy method of making an inside cut. The saw can be inserted directly into a panel or board without first drilling a lead

5

English

or pilot hole. In pocket cutting measure the surface to be cut and mark clearly with a pencil. Next tip the saw forward until the front end of the shoe sits firmly on the work surface. Switch the tool on and allow it to attain maximum speed. Grip the saw firmly and lower the back edge of tool slowly until the blade reaches its complete depth. Hold the shoe flat against the wood and begin cutting. Do not remove blade from cut while it is still moving. Blade must come to a complete stop.

### Wood Cutting (Fig. 8)

Be sure board is firmly positioned. Don't attempt to turn on when blade is against material to be cut. This could stall the motor. Place front of shoe on material to be cut and hold jig saw shoe firmly against the wood while cutting. Don't force the tool; let the blade cut at its own speed. Whenever possible, clamp or support work close to the line of cut; when the cut is completed, shut off power, let blade come to a complete stop and then lay the saw aside before loosening the work. Use the higher speed setting for cutting wood.

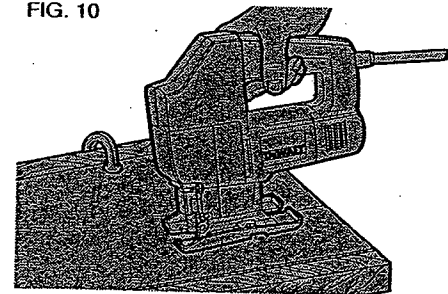
### Rip & Circle Cutting (Fig. 9)

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### Metal Cutting (Fig. 10)

In cutting thin gauge sheet metals, it is best to clamp wood or plywood to

FIG. 10



the bottom of sheet metal; this will insure a clean cut without the danger of vibration or tearing of metal. Always remember to use a finer blade for ferrous metals (for those that have a high iron content); and use a coarse blade for non-ferrous metals (those that do not have an iron content). Use a high speed setting for cutting soft metals (aluminum, copper, brass, mild steel, galv. pipe, conduit sheet metal, etc.). Use lower speed to cut plastics, tile, formica, hard metals, cast iron.

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6