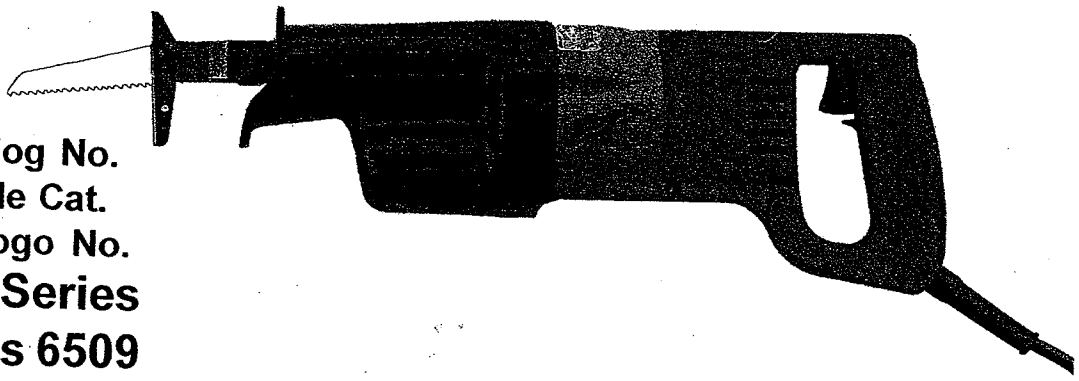
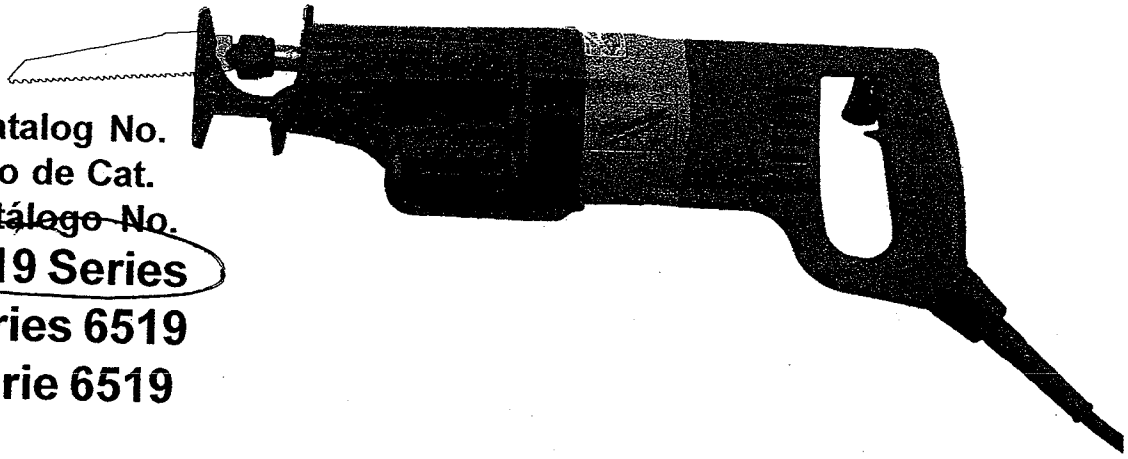
Milwaukee®

OPERATOR'S MANUAL
MANUEL de L'UTILISATEUR
MANUAL del OPERADOR



Catalog No.
No de Cat.
Catálogo No.
6509 Series
Séries 6509
Serie 6509



Catalog No.
No de Cat.
Catálogo No.
6519 Series
Séries 6519
Serie 6519

SAWZALL®
PASSE-PARTOUT SAWZALL®
SIERRAS SABLE SAWZALL®

TO REDUCE THE RISK OF INJURY, USER MUST READ AND UNDERSTAND OPERATOR'S MANUAL.
AFIN DE REDUIRE LE RISQUE DE BLESSURES, L'UTILISATEUR DOIT LIRE ET BIEN COMPRENDRE LE MANUEL DE L'UTILISATEUR.
PARA REDUCIR EL RIESGO DE LESIONES, EL USUARIO DEBE LEER Y ENTENDER EL MANUAL DEL OPERADOR.

SPECIFIC SAFETY RULES

1. **Hold power tools 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 exposed metal parts of the tool "live" and shock the operator.
2. **Use clamps or another practical way to secure and support the workpiece to a stable platform.** Holding the work by hand or against your body leaves it unstable and may lead to loss of control.
3. **Keep hands away from all cutting edges and moving parts.**
4. **Maintain labels and nameplates.** These carry important information. If unreadable or missing, contact a *MILWAUKEE* service facility for a free replacement.
5. **WARNING!** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
   - lead from lead-based paint
   - crystalline silica from bricks and cement and other masonry products, and
   - arsenic and chromium from chemically-treated lumber.

   Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specifically designed to filter out microscopic particles.

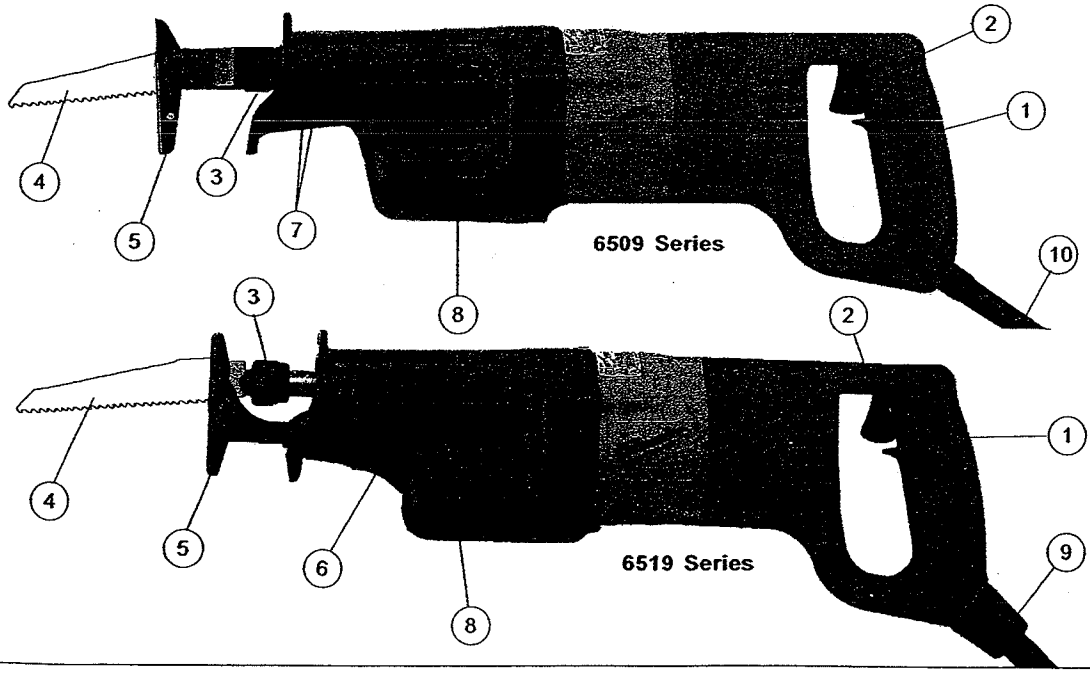
Symbology

⧈	Double Insulated	V~	Volts Alternating Current
SP	Canadian Standards Association	$n_{o\,\underline{xxxx}}$/min.	No Load Strokes per Minute (RPM)
UL	Underwriters Laboratories, Inc.	A	Amperes

Specifications

Cat. No.	Volts AC	Amps	RPM	Length of Stroke
6509 Series	120	10	0 - 2 800	3/4"
6519 Series	120	10	0 - 2 800	1-1/8"

FUNCTIONAL DESCRIPTION



1. Handle
2. Trigger
3. Quik-Lok® blade clamp
4. Blade
5. Adjustable pivot shoe
6. Shoe release lever
7. Pivot shoe access holes
8. Insulating boot
9. Quik-Lok® cord
10. Fixed cord

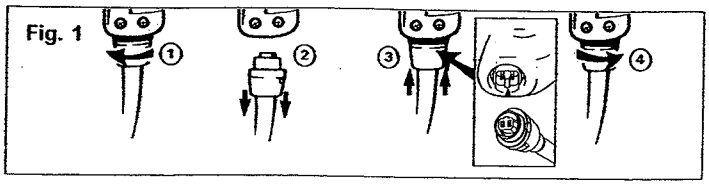
TOOL ASSEMBLY

WARNING!

To reduce the risk of injury, always unplug tool before attaching or removing accessories or making adjustments. Use only specifically recommended accessories. Others may be hazardous.

Removing and Replacing Quik-Lok® Cords (Fig. 1) (Select Models)

MILWAUKEE's exclusive Quik-Lok® Cords provide instant field replacement or substitution.



1. To remove the Quik-Lok® Cord, turn the cord nut 1/4 turn to the left and pull it out.
2. To replace the Quik-Lok® Cord, align the connector keyways and push the connector in as far as it will go. Turn the cord nut 1/4 turn to the right to lock.

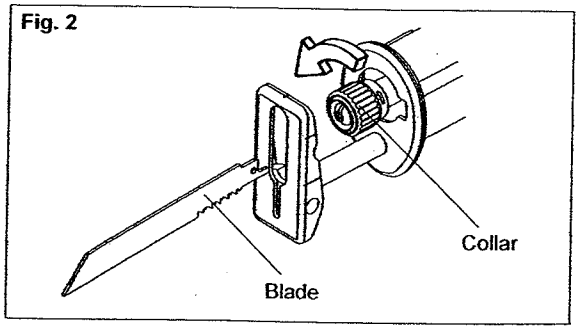
Selecting a Blade

Use *MILWAUKEE* Sawzall® Blades for best performance. When selecting a blade, choose the right type and length.

Many types of blades are available for a variety of applications: cutting metal, wood, nail-embedded wood, scroll cutting, roughing-in, and contours.

Many lengths are also available. Choose a length long enough to extend beyond the shoe and your work throughout the stroke. For best performance and longest life, see "Accessories" to select the best blade for the job.

Quik-Lok® Blade Clamp (Fig. 2) (Select Models)



1. Unplug the tool.
2. Be sure the spindle and blade clamp areas are clean. Metal chips and sawdust may prevent the Quik-Lok® Blade Clamp from clamping securely (see "Maintenance").
3. To **install** a blade, twist the collar in the direction of the arrow while inserting the blade into the clamp until the tang butts against the collar.

   Depending on the job, the blade may be inserted with the teeth facing upward or downward.
4. Release the collar and the spring loaded mechanism will clamp the blade firmly in place.

   Twist the collar in the opposite direction of the arrow to ensure that the blade is locked into the clamp.
6. Tug on blade to make sure it is securely locked in place.
7. To **remove** a blade, twist the collar in the direction of the arrow while pulling on the blade. Be careful when handling hot blades.

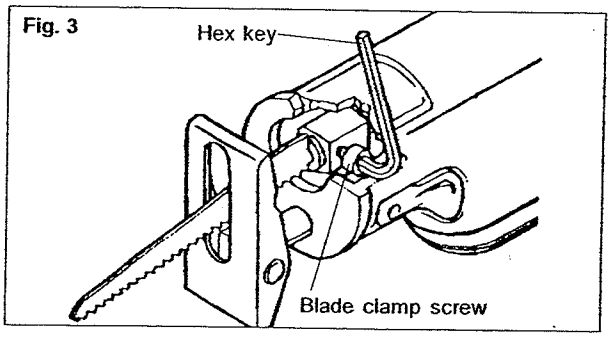
Removing Broken Blades from the Quik-Lok® Blade Clamp

1. Unplug the tool.
2. Broken blades can be removed by the following methods.

- Point the tool downward, twist the collar, and shake the tool up and down (**DO NOT** turn on the tool while your fingers are holding the blade clamp open). The shank of the broken blade should drop out of the clamp.
- If shaking the tool doesn't work...

  In most cases, a corner of the broken blade will extend beyond the blade clamp. Twist the collar and pull the broken blade out of the clamp by this corner.
- If the broken stub doesn't extend far enough to be grabbed by its corner, use a thin blade with small teeth (such as a metal cutting blade) to hook the blade that is jammed in the clamp while twisting the collar and pull it out.

Installing and Removing Blades
Blade Clamp (Available as accessory Cat. No. 49-22-5016 only) (Fig. 3)



1. Unplug the tool before changing blades.
2. Be sure the spindle and blade clamp area are clean. Metal chips and sawdust may prevent the blade clamp screw from clamping securely.
3. To **install** a blade, loosen the blade clamp screw, turning it counterclockwise. Insert the blade until the tang butts against the spindle.

   NOTE: The blade must be inserted all the way into the spindle so that the tang on the blade seats firmly in the blade clamp.

   Depending on the job, the blade may be inserted with the teeth facing upward or downward.
4. Insert the hex key into the blade clamp screw, turning it clockwise. Tighten securely.
5. To **remove** a blade, insert hex key into the blade clamp screw and turn it counterclockwise 1 full turn. Then slide the blade out of the spindle. Be careful when handling hot blades.

Adjustable Pivot Shoe

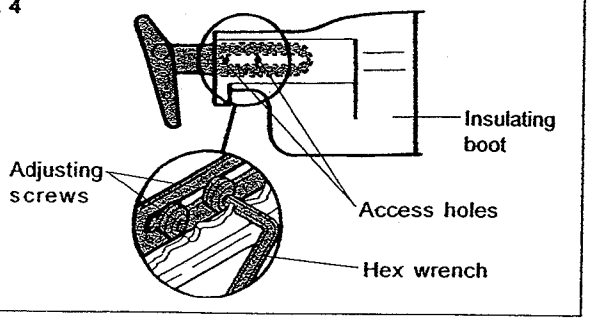
The shoe can be adjusted forward or backward to take advantage of the unused portion of the blade or for special jobs requiring low blade clearance.

WARNING!

Do not operate Sawzall without a shoe. Striking the spindle against the work may damage the reciprocating mechanism.

6509 Series (Fig. 4)

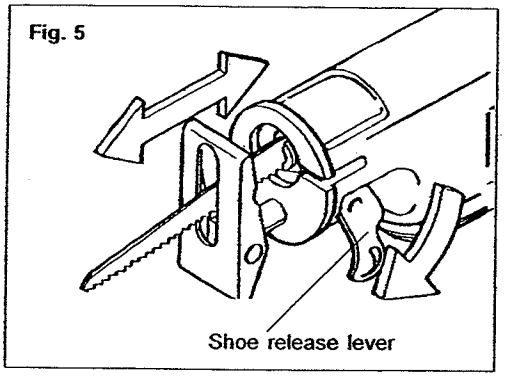
Fig. 4



1. To adjust the shoe, place hex wrench through access holes in insulating boot and loosen four (4) screws.
2. Move shoe to desired position
3. Tighten screws.
4. After adjusting the shoe, slowly pull the trigger to be sure the blade always extends beyond the shoe and your work throughout the stroke.

6519 Series (Fig. 5)

Fig. 5

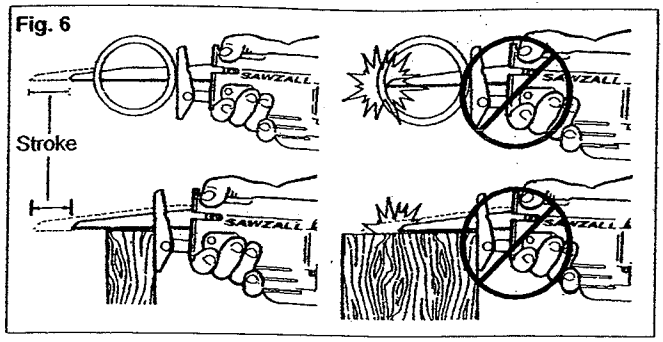


1. To adjust the shoe, pull out the shoe release lever 1/4 turn.
2. Slide the shoe forward or backward to the desired position.
3. To lock the shoe in position, push in the shoe release lever.
4. After adjusting the shoe, slowly pull the trigger to be sure the blade always extends beyond the shoe and your work throughout the stroke.

WARNING!

To reduce the risk of injury, be sure the blade always extends beyond the shoe and work throughout the stroke. Blades may shatter if they impact the work or shoe (Fig. 6).

Fig. 6



WARNING!

To reduce the risk of injury, wear safety goggles or glasses with side shields. Unplug the tool before changing accessories or making adjustments.

Impact Protection System (Select Models)

Select models are equipped with a unique patented gearing system that provides efficient power transmission and extended life in the most difficult cutting applications. This durable system will absorb impacts, blade lock ups, and motor stalls. These models can be used for extreme cutting applications such as large diameter pipe, thick metal, pallets, and heavy demolition and renovation work as well as for general purpose cutting.

Starting, Stopping and Controlling Speed

1. To **start** the tool, grasp the handle firmly and pull the trigger.
2. To **stop** the tool, release the trigger. Allow the tool to come to a complete stop before removing the blade from a partial cut or laying the tool down.

Trigger Speed Control Switch

MILWAUKEE Sawzalls® are equipped with a trigger speed control switch. It may be operated at any speed from zero strokes per minute to full speed. Always start tool before blade contacts the workpiece. To vary the speed, simply increase or decrease the pressure on the trigger. The further the trigger is pulled, the greater the speed. To stop the tool, release the trigger and allow the tool to stop completely before removing from a partial cut or before laying the tool down.

G[illegible]l Cutting

Fo[illegible]ight or contour cutting from an edge, line the blade up with your cutting line. Before the blade contacts the workpiece, grasp the handle firmly and pull the trigger. Then guide the tool along your cutting line. Always hold the shoe flat against the workpiece to avoid excessive vibration.

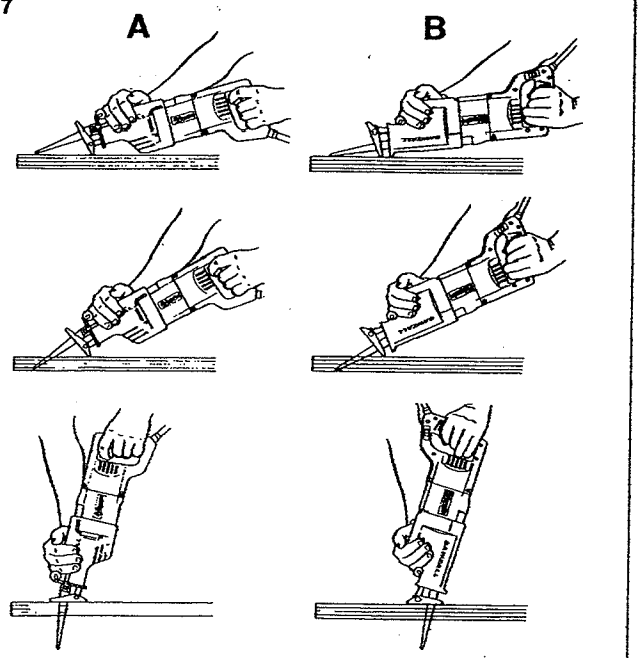
Cutting Metals

Begin cutting at a slow speed, gradually increasing speed as you cut. When cutting into metals or hard materials that can not be cut from an edge, drill a starting hole larger than the widest part of the blade. Extend blade life by using a solid blade cutting lubricant such as *MILWAUKEE* Band Saw Blade Lubricant Cat. No. 49-08-4206.

Plunge Cutting (Fig. 7)

Your *MILWAUKEE* Sawzall® is ideal for plunge cutting directly into surfaces that can not be cut from an edge, such as walls or floors. Plunge cutting may be done two ways depending on how the blade is inserted. Column A shows how to plunge cut with the teeth of the blade facing down. Column B shows how to plunge cut with the teeth of the blade facing up. Do not plunge cut into metal surfaces (see "Cutting Metals").

Fig. 7



WARNING!

To reduce the risk of explosion, electric shock and property damage, always check the work area for hidden gas pipes, electrical wires or water pipes when making blind or plunge cuts.

1. Insert the blade into the tool.

   If you inserted the blade with the teeth facing downward, hold the tool as shown in Column A, resting the edge of the shoe on the workpiece.

   If you inserted the blade with the teeth facing upward, hold the tool as shown in Column B, resting the edge of the shoe on the workpiece as shown.
2. With the blade just above the workpiece, pull the trigger. Using the edge of the shoe as a pivot, lower the blade into the workpiece as shown.
3. As the blade starts cutting, raise the handle of the tool slowly until the shoe rests firmly on the workpiece. Then guide the tool along your cutting line to acquire the desired cut.

   NOTE: To make plunge cutting easier, use a heavy gauge blade and install the blade with the teeth facing upward as shown in Column B.