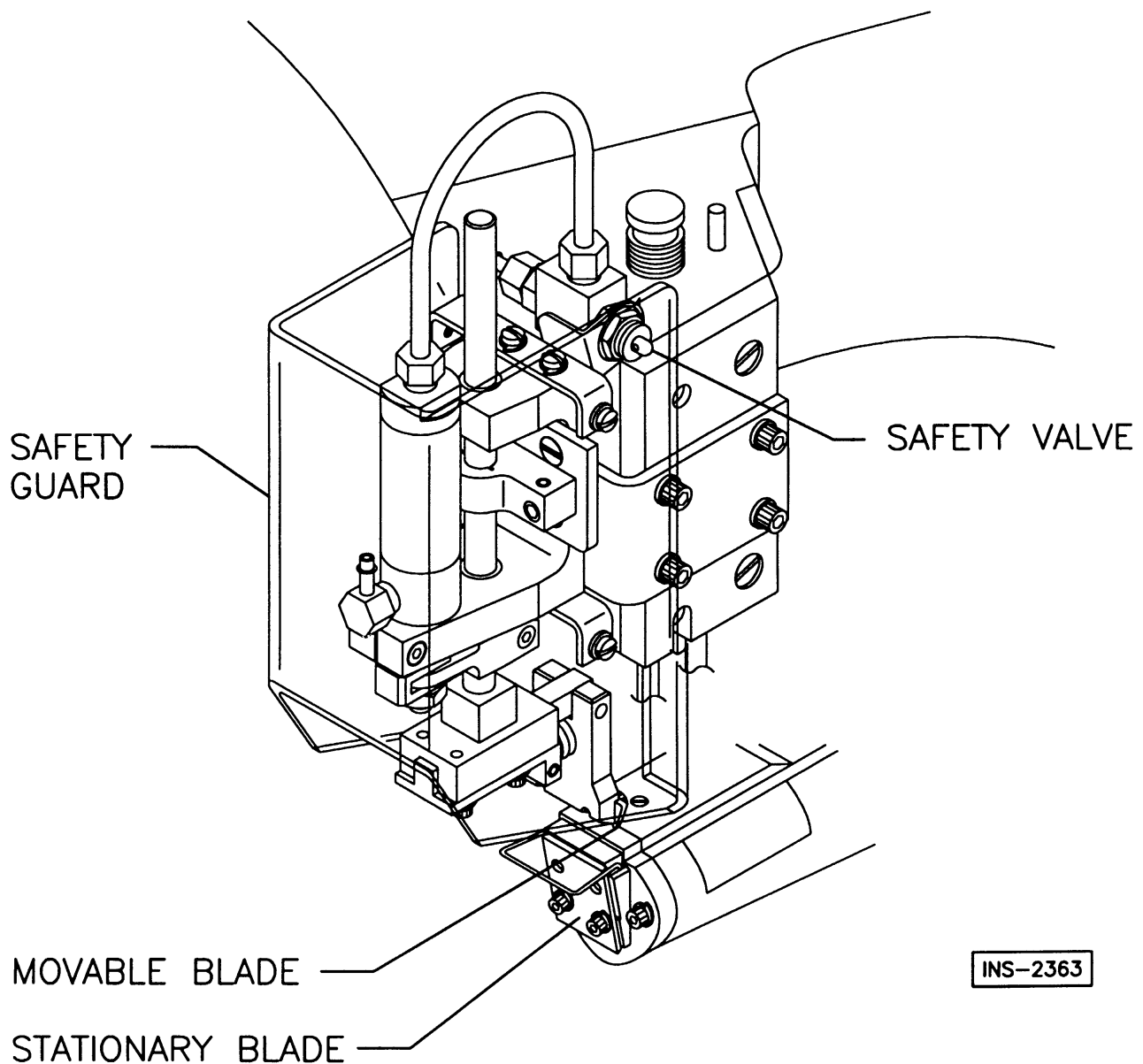


# CLINTON SERVICE GUIDE MODEL 115VS-FOTA FOR UNION SPECIAL 35700



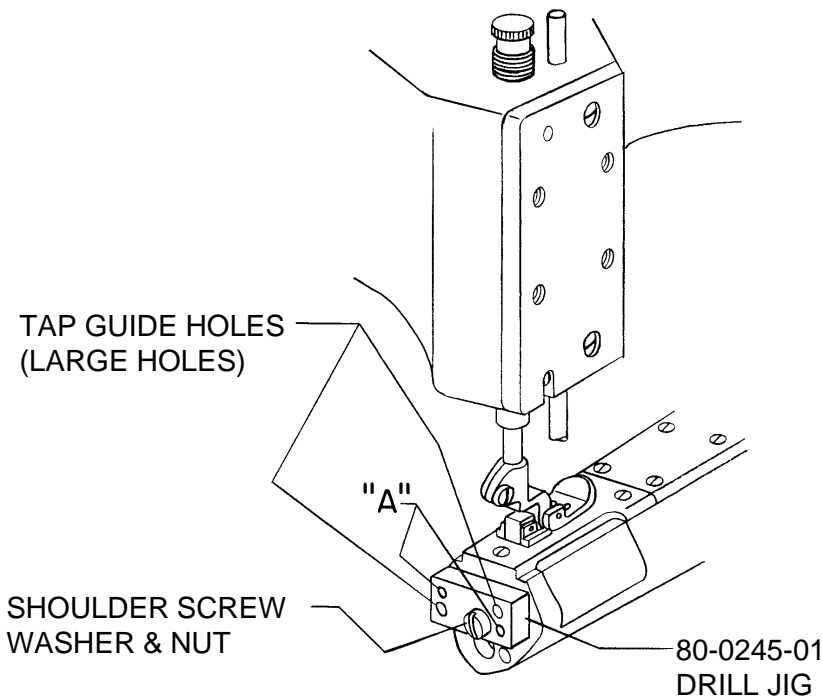
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Carlstadt, N.J. 07072  
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**DRILLING & INSTALLATION INSTRUCTIONS**

INS-2364

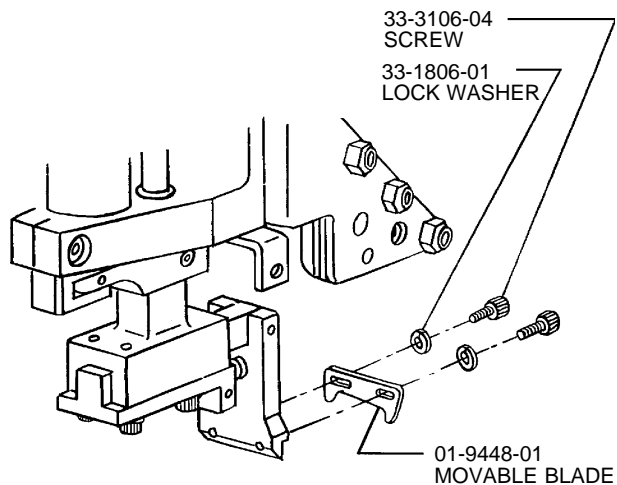
**DRILLING INSTRUCTIONS  
CHAIN CUTTER MODEL 115VS FOTA**

1. PLACE THE DRILL JIG ON THE MACHINE AS SHOWN.
2. ALIGN THE TOP OF THE DRILL JIG WITH THE TOP OF THE MACHINE BED.
3. TIGHTEN THE LOCKNUT ON END OF SHOULDER SCREW.
4. DRILL (2) TWO HOLES MARKED "A" WITH #29 DRILL (30-2130-29) SUPPLIED.
5. LOOSEN THE LOCKNUT AND REALIGN THE JIG SO THE TAPPING GUIDE HOLES WILL ALIGN WITH THE DRILLED HOLES.
6. TAP THE HOLES WITH AN 8-32 TAP (30-1266-01) USING THE TAP GUIDE HOLES TO GUIDE THE TAP STRAIGHT.
7. REMOVE THE DRILL JIG.



**MOVABLE BLADE**

INS-2297

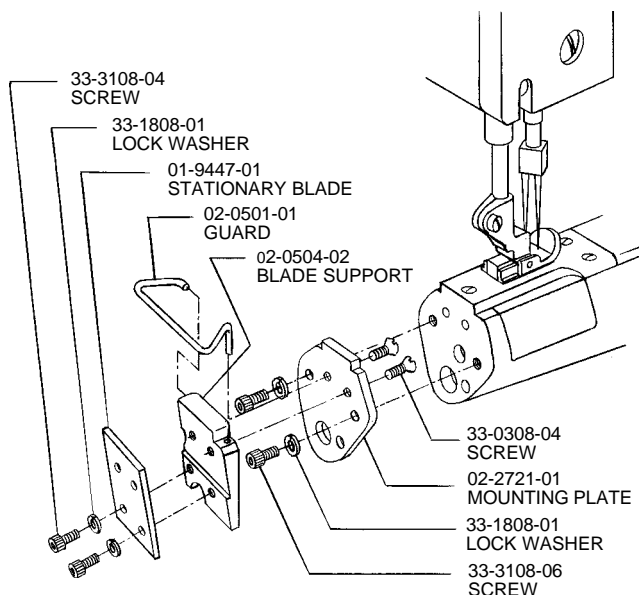


**NOTES:**

1. ASSEMBLE MOVABLE BLADE 01-9448-01 WITH SCREWS (2) 33-3106-04 AND LOCK WASHERS (2) 33-1806-01.
2. DO NOT TIGHTEN MOVABLE BLADE SCREWS AT THIS TIME. REFER TO ALIGNMENT ADJUSTMENT.

**STATIONARY BLADE**

INS-2365



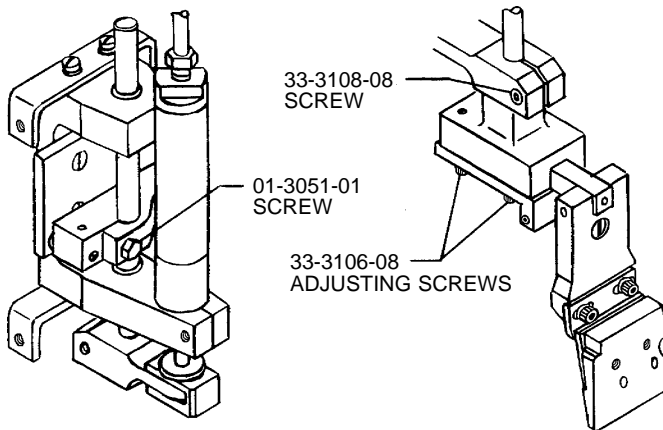
NOTE:  
ASSEMBLE STATIONARY BLADE AS SHOWN

**ADJUSTMENTS**

**WARNING!! TO PREVENT SERIOUS INJURY, DISCONNECT AIR SUPPLY BEFORE MAKING ANY ADJUSTMENTS.**

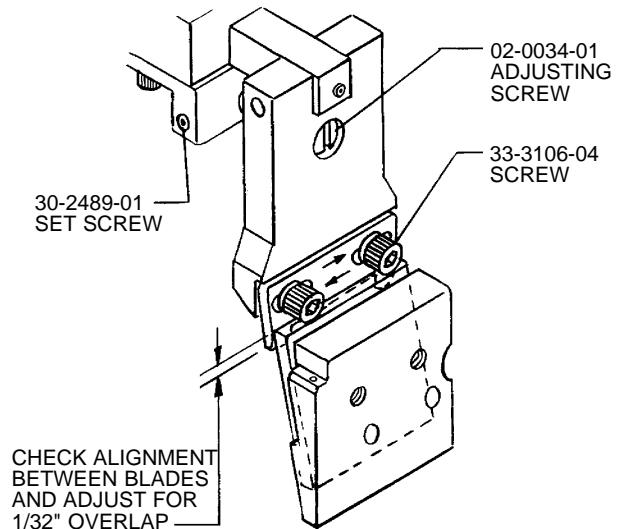
**RADIAL**

INS-2298



**ALIGNMENT**

INS-2299



**NOTES:**

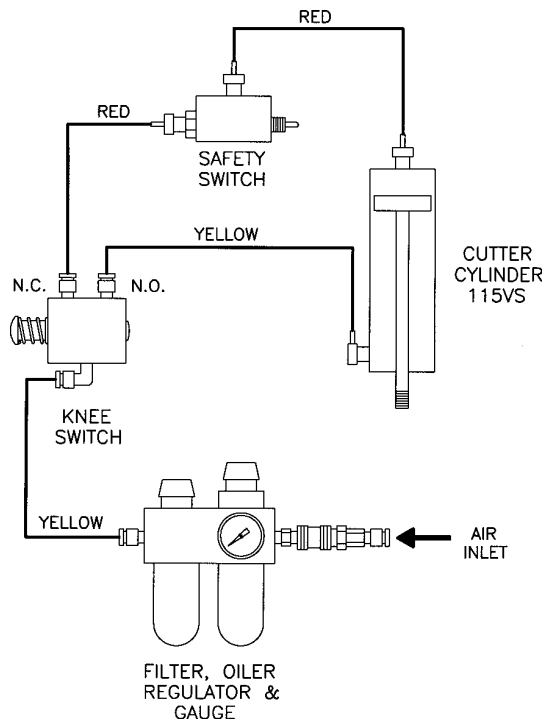
1. LOOSEN SCREW 01-3051-01 AND 33-3108-08 AND ROTATE ASSEMBLY FOR PROPER ENGAGEMENT.
2. LOOSEN SCREWS 33-3106-08 AND ADJUST MOVABLE BLADE AGAINST STATIONARY BLADE AND LOCK IN PLACE.

**NOTE:**

LOOSEN SET SCREW 30-2489-01 AND ADJUST SCREW 02-0034-01 COUNTER-CLOCKWISE FOR MORE CUTTING EDGE ENGAGEMENT.

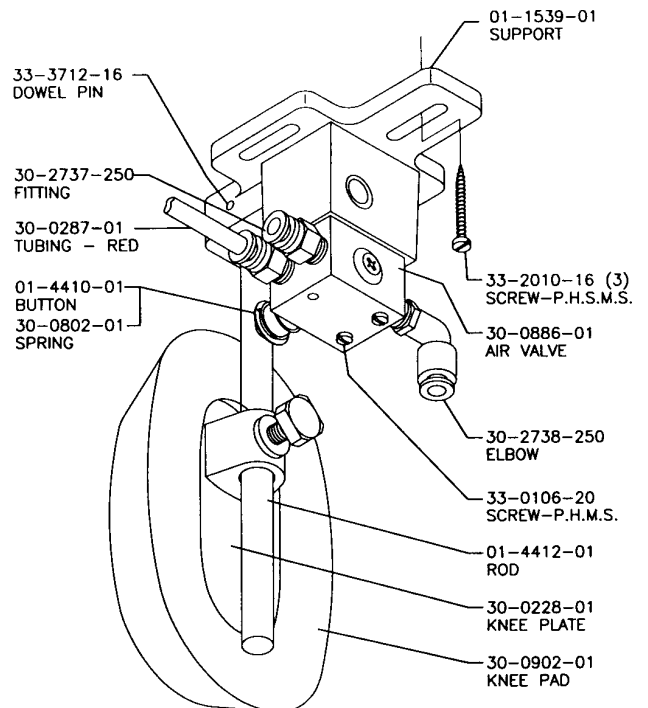
**AIR CIRCUIT DIAGRAM  
MODEL 115VS KS  
MODEL 115VS F.O.R.G.-KS**

INS-2664

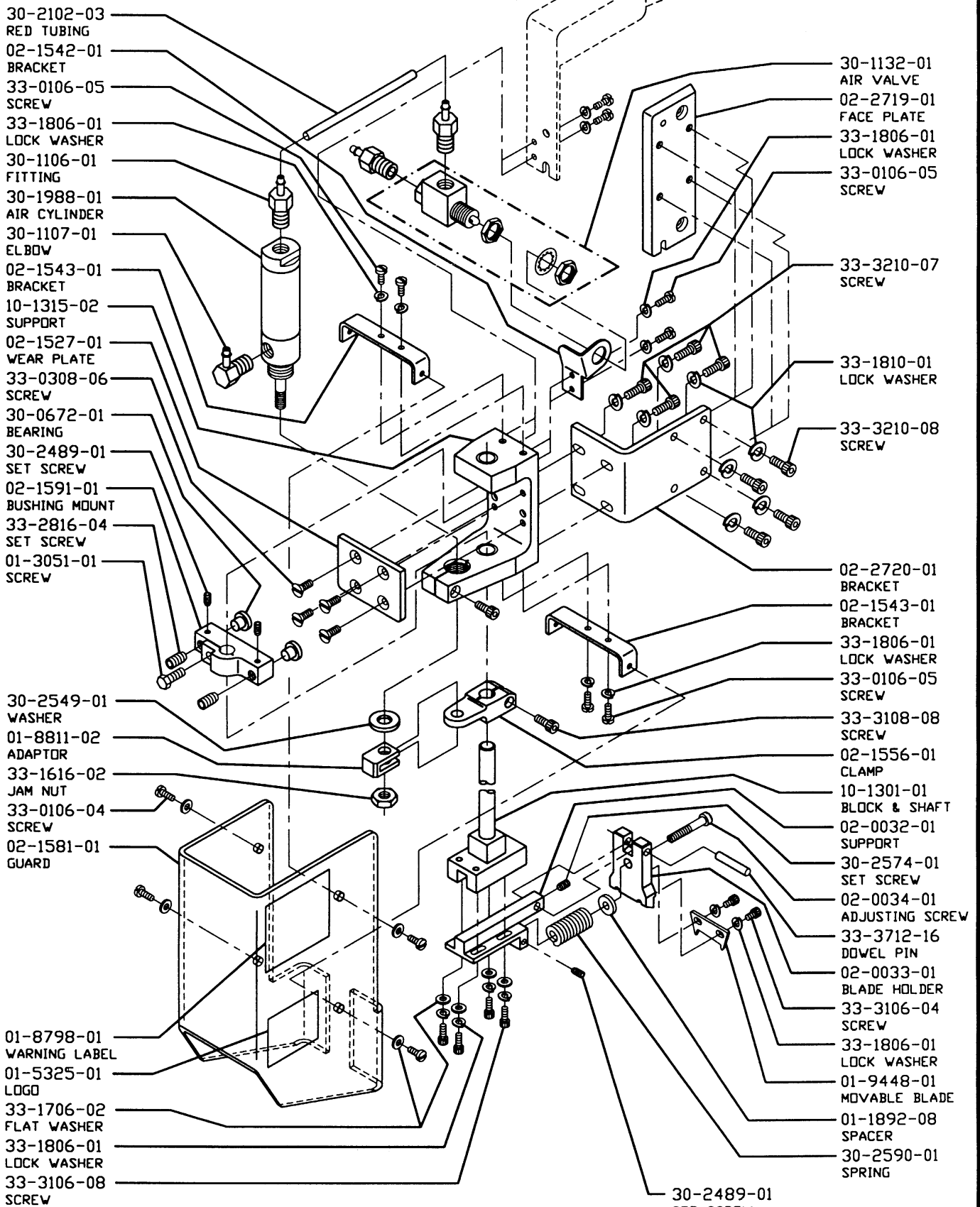


**4 WAY AIR VALVE, KNEE OPERATED  
80-0185-01**

INS-619-1A



**PARTS LIST**  
**MODEL 115VS-FDTA**  
**U.S. 35700**  
**80-0486-04**



\* 11-0429-02 SWITCH ASS'Y

\* NOT PART OF 80-0486-04 ASSEMBLY