Oregon® Maintenance and Safety Manual

Saw chain, Guide Bar and Drive Sprocket


OREGON
You've got work to do, we've got you covered.
If you have questions about your saw or cutting system, our technical support team is ready to help.
Oregon Products.com
OregonProductsSupport@Blount.com
800-223-5168

Table of Contents

Chainsaw Safety & Tips

Saw Chain

Table of Contents

Guide Bar

Drive Sprocket

Quick Reference

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Safety & Maintenance Manual

Chainsaw Safety & Tips

Page

- 3 -

Chainsaw Safety

Your chainsaw is only as good as your cutting system — saw chain, guide bar, and drive sprocket. They function as a team while doing the actual work of cutting wood and therefore must be maintained as a complete system.

A properly maintained saw chain, guide bar, and drive sprocket will provide excellent cutting performance and prevent damage. Equipment that has not been maintained will cut poorly and may create safety hazards.

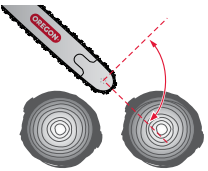
This manual addresses the maintenance of only Oregon® manufactured saw chains, guide bars, and drive sprockets. For information on maintenance and operation of your chainsaw, refer to your chainsaw's operator's manual or contact your local chainsaw dealer.

Important Safety Message

⚠ Safety Symbol

This safety symbol is used to highlight safety messages. When you see this symbol, read and follow the safety message to avoid severe personal injury.

Kickback Awareness



Potential kickback situation

⚠ **WARNING**: All saw chain can kickback, which can lead to dangerous loss of control of the chainsaw and result in serious injury to the chainsaw operator or bystanders. Follow all instructions in your chainsaw operator's manual and in this booklet for proper use and maintenance of your chainsaw's cutting chain, guide bar, and drive sprocket.

Guard Against Chainsaw Kickback

- Know your personal level of chainsaw experience.
- Know your saw chain.

If you do not have experience and specialized training for dealing with chainsaw kickback, then Oregon® urges you to use only low kickback saw chains.

What is Kickback?

Kickback is the violent backward and/or upward motion of the chainsaw guide bar occurring when the saw chain near the nose or tip of the guide bar contacts any object, such as another log or branch, or when the wood closes in and pinches the saw chain in the cut.

Avoiding Kickback Injury

- Be alert at all times to guard against a possible kickback reaction. Always be aware of the position of your guide bar's nose.
- Different models of saw chain are available for most cutting tasks. Use the saw chain, suitable for your type of cutting, with the lowest kickback potential.
- Narrow-nose guide bars such as our ControlCut™ guide

bars are recommended for maximum kickback safety.

ANSI Safety Rating

If you do not have experience and specialized training for dealing with chainsaw kickback, then we urge you to use only low-kickback saw chains which have this green* label: Part numbers of Oregon® saw chain that follow the ANSI low kickback standard (paragraph 5.11.2.4) are highlighted in green. Packages of Oregon low kickback saw chain carry this authorized UL® Classification Marking:

CLASSIFIED C UL US 17R2

LOW KICKBACK SAW CHAIN IN ACCORDANCE WITH ANSI/OPEI B175.1-2012, PARAGRAPH 5.11.2.4 AND WITH CSA Z62.3

This saw chain met the kickback performance requirements of ANSI-B175.1-2012 when tested according to the provisions of ANSI B175.1-2012. Low-kickback saw chain meets the kickback performance requirements of CSA Standard Z62.3.

Chain Pitch	Part Numbers by Gauge .043"	.050"	.058"	.063"
.325 Low Profile	80TXL	—	—	—
3/8 Low Profile	90PX *90SG*	91P 91PS 91PX 91PXL	—	—
.325	—	20BPX	21BPX	22BPX
.325	—	M20BPX	M21BPX	M22BPX
.325	—	*95VPX*	—	—
3/8	—	72V	73V	75V

*Some older Oregon packaging may have low-kickback saw chain identified with a blue label. Part numbers printed in *red* have been obsoleted. Contact your authorized Oregon distributor for availability.

Part number of Oregon® chains that do not meet ANSI low kickback performance requirements are highlighted in yellow. The chains below should be used only by those with experience and specialized training for dealing with kickback.

Chain Pitch	Part Numbers by Gauge		
	.050"	.058"	.063"
1/4	25AP *25A* 25F	—	—
3/8 Low Profile	91VXL M91VXL	—	—
.325	20LPX 20LGX M20LPX 95TXL	21LPX 21LGX M21LPX	22LPX 22LGX M22LPX
3/8	72APX 72DPX 72LGX 72JGX 72LPX 72JPX M72DPX M72LPX 72RD 72CJ 72CK 72CL 72EXL 72EXJ	73DPX 73JGX 73LGX 73LPX M73DPX M73LPX 73RD 73EXL 73EXJ	75DPX 75JGX 75LGX 75LPX M75DPX M75LPX 75RD 75CJ 75CK 75CL 75EXL 75EXJ
.404	—	58L	27X 27AX 59J 59L 68LX 68JX 27R 27RA 68CL 68CJ

Recommended Personal Protective Equipment

HEAD
- Hard hat
- Safety goggles/ glasses
- Ear plugs/muffs

HANDS
Gloves add grip and general protection.

LEGS
Chainsaw pants or chaps protect against saw strikes.

FEET
Safety boots and gaiters protect against saw strikes and add support on unstable terrain.

Dress Properly: Avoid clothing that is too tight or too loose.

Create a Safe Work Space

⚠ Caution

- Plan a clear escape route away from cutting zone.
- Scan worksite hazards: Check for limbs, power lines, dead trees, etc.
- Calculate how the object being cut will fall.
- Determine if the chainsaw may be thrown unexpectedly by the movement of the cut material.

Body Positioning

- If possible, position yourself away from the natural lead of the tree to avoid injury.
- Never cut above shoulder level.
- Never cut while in a tree or while on a ladder.
- Use only a right-hand grip to hold your chainsaw (right hand on the trigger, left hand on the front handle).
- Keep your left arm straight for better control.
- Hold chainsaw firmly with both hands. Keep thumb firmly wrapped around front handle.
- Stand to the side of the chainsaw, never behind it.
- Stand with feet well braced and your body balanced.
- Keep others a minimum of two tree lengths away from the cutting area.
- Do not allow others to hold wood during cutting.

Saw Operation

- Run engine at full throttle.
- Use low-kickback saw chain and a reduced-kickback guide bar whenever possible.
- Keep the chainsaw, saw chain, guide bar and drive sprocket properly maintained.
- Cut only wood with your chainsaw. Do not cut any other material.

Cutting Tips

Tension

Keep your saw chain correctly tensioned. Check and adjust often.

Cutters

Keep cutters sharp. Touch up the cutting edge with a file every hour, more often if needed. Do not force dull saw chain to cut.

Depth Gauges

Check and adjust your cutter's depth gauges every 3 – 4 sharpenings or more often as needed.

Guide Bar

Keep the guide bar groove clean and the oil hole open. Turn symmetrical* guide bars over to equalize rail wear.

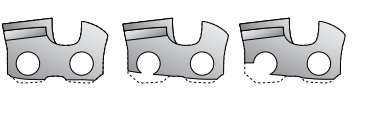
*Do not turn Guard Tip® guide bars over.

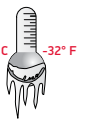
Drive Sprocket

Replace the drive sprocket after every two saw chains, or sooner.

Cutting in Cold Weather

Cutting frozen wood will cause rapid wear and possible breakage around the rear rivet hole of cutters. Follow the steps below to keep cold-weather wear to a minimum.



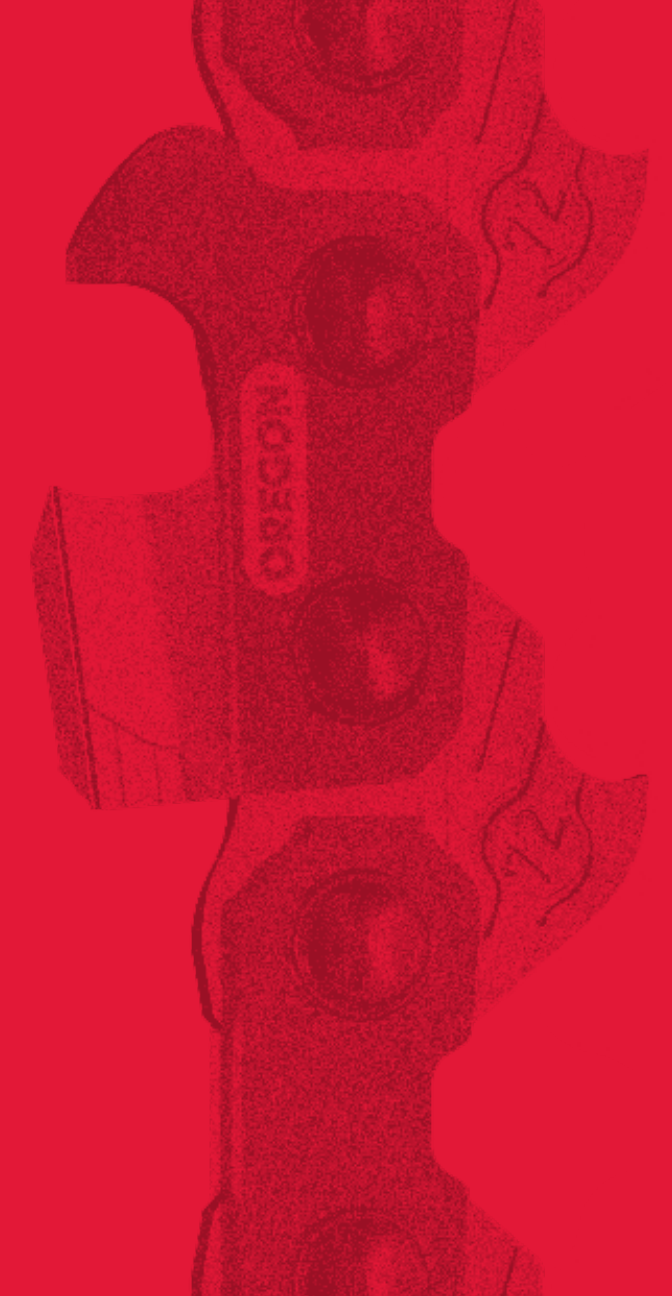


Oil in Cold Weather

Dilute guide bar chain oil 25 percent with clean kerosene or diesel oil. Use twice as much of this diluted oil during operation, and be certain your saw chain is receiving oil from the chainsaw.

Best Practices

1. Saw chain is made to cut only one thing: wood. Do not use saw chain to cut other materials.
2. Never let your saw chain contact rocks or dirt during operation. Dirt may seem soft. In fact, dirt is extremely abrasive and will wear away your saw chain's vital chrome plating in less than a second.
3. Never force dull saw chain to cut. When it is sharp, saw chain is designed to feed itself into the wood, and needs only light pressure to cut efficiently.
4. Cutting efficiency may be determined by the type of sawdust your chainsaw is producing. Dull saw chain produces fine wood dust, which can clog your chainsaw's air filter. Sharp saw chain produces larger wood chips.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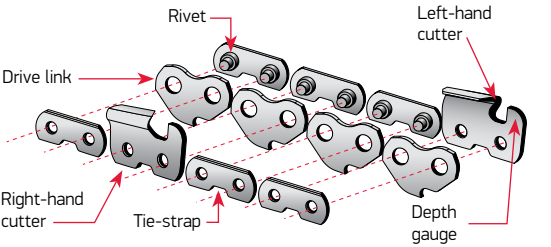
Safety & Maintenance Manual

Saw Chain

Saw Chain Terms

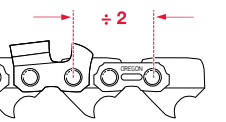
Parts of a Saw Chain



Saw Chain Pitch

Saw chain pitch is the distance between any three consecutive rivets, divided by two. Oregon® saw chain pitches are:

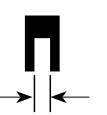
1/4"
.325" Low Profile
3/8" Low Profile
.325"
3/8"
.404"



Saw Chain Gauge

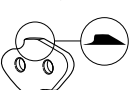
Saw chain gauge is the drive link's thickness where it fits into the guide bar groove. The industry standard for saw chain gauges are:

.043" (1.1 mm)
.050" (1.3 mm)
.058" (1.5 mm)
.063" (1.6 mm)



Kickback-Reducing Features

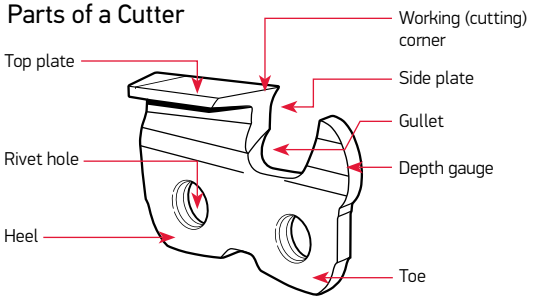
Bumper Drive Link



Ramped Depth Gauge

Wide-Track Depth Gauge

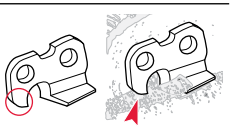
Parts of a Cutter



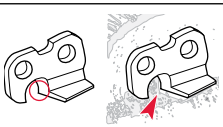
How a Cutter Works

Understanding how cutters work can help you see why proper saw chain maintenance is so important.

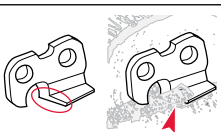
1. The depth gauge rides on the wood and controls the depth at which the working corner bites in.



2. The working corner and side plate sever the wood fibers across the grain. This is the hardest part of the work.



3. The top plate cutting angle chisels out the severed wood fibers, lifting them up and out of the kerf.



Saw Chain Cutter Sequence Terms

Four Basic Saw Chain Rules

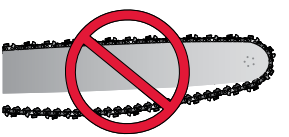
Oregon® urges you to become familiar with the four basic saw chain rules. Users who know and follow these rules can count on superior performance from their saw chain, guide bar, and drive sprocket — and reduce safety hazards at the same time.

Rule Number 1

Your saw chain must be correctly tensioned

More saw chain and guide bar problems are caused by incorrect saw chain tension than by any other single factor.

• See "How to Tension your Saw Chain" on page 22.



Rule Number 2

Your saw chain must be well lubricated

A constant supply of oil to your chainsaw's guide bar, saw chain and drive sprocket is vital. Without it, excessive friction, wear, and damage will occur.

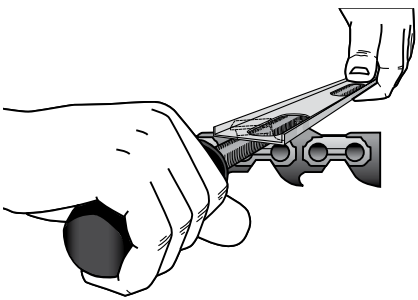
• See "How to Lubricate your Saw Chain" on page 21

Rule Number 3

Your saw chain must be sharp

When your saw chain is sharp, it does the work. When it's not, you do the work — and your guide bar and drive sprocket will wear more rapidly.

- See "How to Sharpen Cutters" on page 23.
- See "Filing Angles" on page 30 to find specifications for Oregon saw chain type.

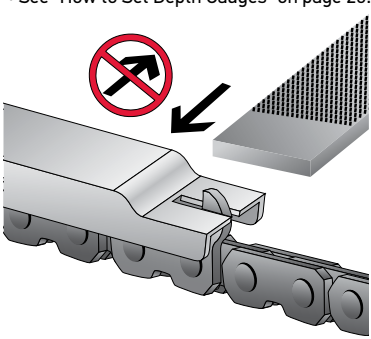


Rule Number 4

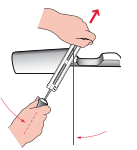
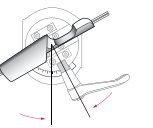
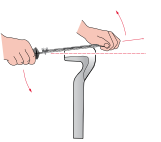
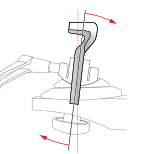
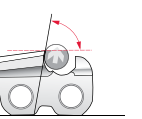
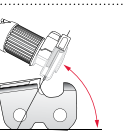
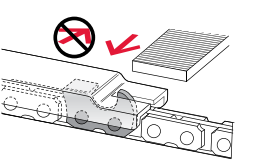
Your saw chain's depth gauges must be set correctly

Depth gauge setting and depth gauge shape are critical to performance and safety.

- See "How to Set Depth Gauges" on page 25.



Cutter Maintenance Terminology

	Filing	Grinding
A Top-Plate Angle		
B Down Angle		
C Side-Plate Angle		
D Depth Gauge Setting		

Filing Tools

Assembled Filing Guide

Round File

Flat File

File Handle

Sharpening Kit

Guide Bar-mounted Filing Guide

Filing Vise

Depth Gauge Tool

Grinders

Bench-model Chain Grinder

Mini Grinder

Sure Sharp® 12-Volt Grinder

Grinding Wheels

Saw Chain Repair Tools

Saw Chain Breaker

Rivet Spinner

Pocket Saw Chain Breaker

Operation & Handling Care

ATTENTION: DEALERS, CHAINSAW USERS, AND ANYONE WHO SERVICES SAW CHAIN. IMPORTANT SAFETY INFORMATION.

Oregon® urges you to become familiar with proper saw chain maintenance techniques, and the possible dangers which can result if saw chain is not properly maintained.

> ⚠ **WARNING**: Failure to follow the instructions below can result in severe injury to the chainsaw operator, bystanders, or the person performing maintenance.

⚠ Always turn off your chainsaw before performing any type of maintenance.

⚠ Any one of the following conditions can increase a saw chain's potential kickback energy, increase the risk of a saw chain throwing itself off the guide bar, or increase the risk of other hazards associated with chainsaw use.

1. Incorrect sharpening of angles.
2. Dull cutter teeth.
3. Alteration of kickback-reducing features.
4. Excessive depth gauge settings.
5. Incorrect depth gauge shapes.
6. Loose saw chain tension.
7. Incorrectly installed parts.
8. Loose rivets, cracks or breaks in any saw chain component.

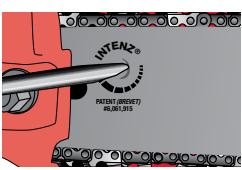
How to Lubricate your Saw Chain

1. Keep your chainsaw's saw chain oiling system filled with clean guide bar-and-saw chain oil.
2. Never put used oil or old motor oil in your chainsaw or on your saw chain. These oils have acids and grit that will shorten the life of your cutting system.
3. Be sure your saw chain, guide bar, and drive sprocket are always receiving oil from the chainsaw during operation.
4. Fill your oil reservoir each time you fill your chainsaw's gas tank.

How to Tension your Saw Chain with Intenz®

> ⚠ **WARNING:** Always wear protective gloves. Read operation and handling warnings on previous page.

1. Turn the engine off.
2. Loosen the guide bar mounting nuts on the side of the chainsaw.
3. Insert a screwdriver or Scrench in the Intenz® slot of the guide bar.
4. Turn the screwdriver or Scrench to move the guide bar forward, away from the chainsaw as far as possible.
5. Tighten the back guide bar mounting nut, then tighten the front nut.



Saw Chain Maintenance

How to Tension your Saw Chain

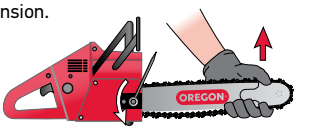
(without Intenz®)

> ⚠ **WARNING:** Always wear protective gloves. Read "Operation & Handling Care" on page 20.

1. Turn the engine off.

   Note: Never tension your saw chain right after cutting when the saw chain has expanded in length from the heat. Saw chain tensioned while hot will contract when it cools, and can damage your guide bar and saw chain. ONLY TENSION SAW CHAIN WHEN THE SAW CHAIN HAS COOLED.

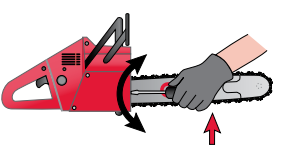
2. Loosen guide bar mounting nuts on the side of your chainsaw.
3. Pull the guide bar nose up, and keep it up as you adjust tension.



4. Adjust tension as follows:

   For Solid-Nose Guide Bars

   Turn your chainsaw's tension-adjustment screw until the bottoms of the lowest tie-straps and cutters come up and just touch the bottom of the guide bar rail.



   For Sprocket-Nose Guide Bar

   Tension must be tighter than on a solid-nose guide bar. Turn your chainsaw's tension adjustment screw until the bottoms of the lowest tie-straps and cutters come up and solidly contact the bottom of the guide bar rail.

5. With either type of guide bar, hold the nose up and tighten your chainsaw's rear guide bar mounting nut first, then tighten the front nut.

6. Pull the saw chain by hand along the top of the guide bar several times, from the engine to the guide bar's tip. Saw chain should feel snug but still pull freely.

   Note: If you have a sprocket-nose guide bar you should now perform the snap test. Grasp the saw chain along the bottom of the guide bar, pull down, and let go. Saw chain should snap back to its original position, solidly contacting the bottom of the guide bar.

7. Check tension often during operation, especially during the first half-hour. If saw chain loosens: stop, let your chainsaw cool, and readjust tension.

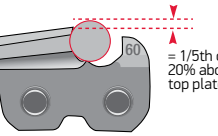
How to Sharpen Cutters

⚠ Read "Operation & Handling Care" on page 20.

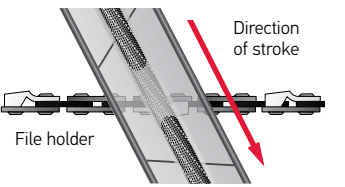
Note:

- On-chainsaw sharpening requires proper saw chain tension.
- See "Filing Angles" on page 30 for the correct maintenance specifications for each Oregon saw chain.
- To find your Oregon saw chain type, use the "Saw Chain Drive Link Number Identification" on page 48
- If unsure of your saw chain's type, part number or filing specification, ask your Oregon saw chain dealer.
- Check and adjust depth gauges.

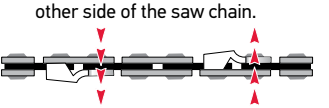
Round-File Cutter Sharpening

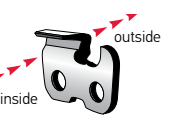


1. Be sure 1/5th, or 20%, of the file's diameter is always held above the cutter's top plate. Using the correct file guide is the easiest way to hold the file in this position.
2. Keep the correct Top-Plate Filing Angle line on your file guide parallel with your saw chain.

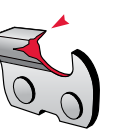


3. Sharpen cutters on one side of the saw chain first. File from the inside of each cutter to the outside. Then turn your chainsaw around and repeat the process for cutters on the other side of the saw chain.

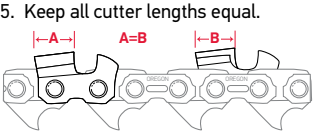




4. If damage is present on the chrome surface of top plates or side plates, file back until such damage is removed.



5. Keep all cutter lengths equal.



6. Recheck depth gauges. If resetting of the depth gauges is necessary. See "How to Set Depth Gauges" on page 25.

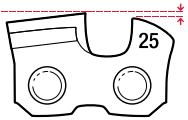
   Note: Do not file or alter the tops of kickback-reducing bumper tie-straps or bumper drive links.

How to Set Depth Gauges

⚠ Read "Operation & Handling Care" on page 20.

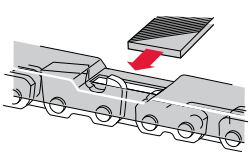
Note:

- On-chainsaw depth gauge setting requires proper saw chain tension ("How to Tension your Saw Chain" on page 22) prior to filing.
- "Filing Angles" on page 30 (column D) shows the correct depth gauge setting for each of the different saw chain types.
- To find your Oregon® saw chain type, use the Saw Chain Identification Chart on pages 47–55.
- If unsure of your saw chain's type or part number, ask your Oregon saw chain dealer.
- Most Oregon saw chains have a number stamped on each depth gauge indicating the correct depth gauge setting.



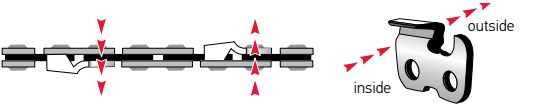
Example: 025" .025" (0.64 mm) Depth Gauge Setting

1. Use a depth gauge tool with the correct built-in setting for your saw chain and check your depth gauges every three or four sharpenings.
2. Place the tool on top of your saw chain so one depth gauge protrudes through the slot in the tool.
3. If the depth gauge extends above the slot, file the depth gauge down level with the top of the tool using a flat file. Never file the depth gauge down enough to exceed the depth gauge setting specified in this manual for your Oregon saw chain.

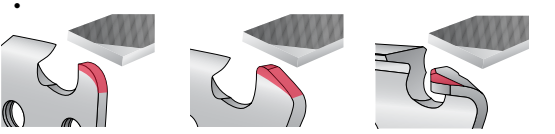


Note: Do not file or alter the tops of kickback-reducing bumper tie-straps or bumper drive links.

4. File from the inside of the round ground saw chain cutters to the outside. (For square ground saw chain, file from the outside of the cutter to the inside.)



5. After lowering, always file off the front corner of each depth gauge parallel to its original rounded or ramped shape.



Wide track bent over depth gauge is only filed from top down. No reshaping is necessary.

Note: On many saw chains, it may be helpful to tip the depth gauge tool on end and place it in front of the working corner in order to protect the cutting surfaces when reshaping depth gauges.

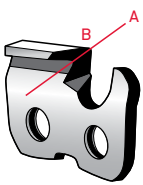
Square Filing

Who Should Perform Square Filing?

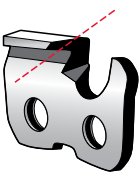
Most chainsaw users will probably never need to use square saw chain, nor learn to perform square filing. But in areas where the timber is larger and the guide bars used are longer, the performance advantages of square saw chain can outweigh the fact that square filing is more difficult and much less forgiving of filing errors.

File Positioning

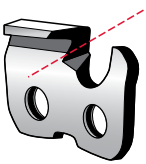
The file will sharpen the top plate, and the side plate, simultaneously. This creates a line, (A), where the top-plate cutting angle meets the side-plate angle. For best results, file so that the line intersects the cutting corner (B).



Correctly
Filed Corner

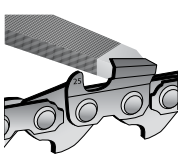


Incorrect
TOO HIGH

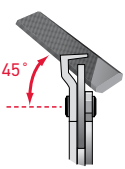


Incorrect
TOO LOW

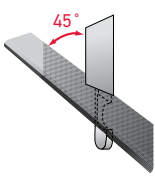
To properly sharpen the cutter, use the correct filing position, as shown here from three different points of view:



Side View

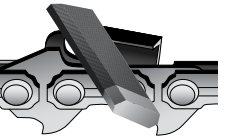


End View



Top View

File Direction



We recommend that square saw chain be filed from the outside in (in a downward direction). This leaves a better edge on the chromed cutting surfaces and makes it easier to keep the file's position, and the resulting cutting edges, in correct alignment as shown in the preceding File Positioning section. However, filing from the outside in will wear out your file faster.

Some square saw chain users may prefer to file from the inside out (in an upward direction). You should be aware that inside-out filing is much more difficult.

But whichever direction you choose, be sure your file and your cutting edges stay positioned as shown in the preceding File Positioning section. File all cutters on one side of the saw chain, then reverse the saw chain and repeat the process. Use the same file positions for cutters on the opposite side of the saw chain.

Tools

Only use files specially designed for square chisel cutters, available from your chainsaw dealer.

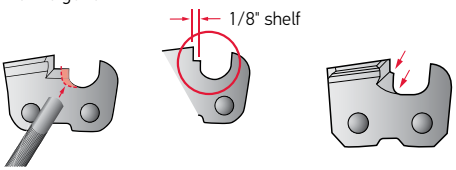
Double Bevel

Hexagon

"Goofy"

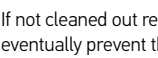
Gullet Filing

Approximately every fifth sharpening, clean out gullets by filing them back with a 7/32" round file. File gullets from the inside out (the side opposite from sharpening). Always leave a 1/8" shelf behind the gullet.

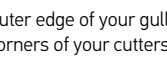


Before After

If not cleaned out regularly, the outer edge of your gullets will eventually prevent the working corners of your cutters from getting an adequate bite into the wood.

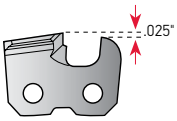


Wrong
Little or no clearance between the working corner and the gullet's outer edge.



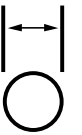
Right
Clearance is maintained between the working corner and the gullet's outer edge.

Depth Gauge Setting



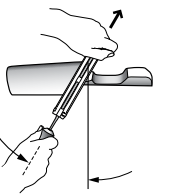
NOTE: The depth gauge setting for all square-ground chisel saw chain is .025".

Filing Angles

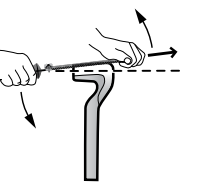


File Diameter

A

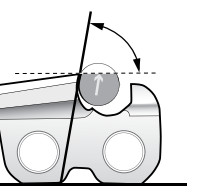


B

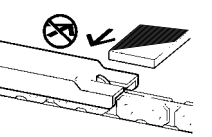


Note: When using the Oregon® file guide, always hold the file perpendicular to the center line of the chain.

C



D



	OREGON	A	B	C	D	
1/4"	25AP	30°	10°	85°	.025"	5/32"
.325" Low Profile™	80TXL	25°	10°	70°	.025"	5/32"
3/8" Low Profile™	90PX, *90SG*	30°	0°	75°	.025"	4.5 mm
	91P, 91PX, 91PXL	30°	0°	80°	.025"	5/32"
	91VXL, M91VXL	30°	0°	80°	.025"	5/32"
.325"	95VPX	30°	10°	70°	.025"	3/16"
	20, 21, 22BPX, M20, M21, M22BPX	30°	10°	70°	.025"	3/16"
	95TXL	30°	10°	70°	.025"	3/16"
	20, 21, 22LPX, LGX, *M20*, *M21*, *M22LPX*	25°	10°	60°	.025"	3/16"
3/8"	72, 73, 75V	25°	10°	60°	.025"	7/32"
	72, 75CJ, CK, CL	45°	45°	90°	.025"	❀
	72APX, 72, 73, 75DPX, M72, M73, M75DPX	30°	10°	80°	.025"	7/32"
	72, 73, 75EXL, EXJ, *LGX*, *JGX*, LPX, JPX	25°	10°	60°	.025"	7/32"
	M72, *M73*, *M75LPX*	25°	10°	60°	.025"	7/32"
	72, 73, 75RD	10°	10°	75°	.025"	7/32"
.404"	27X, 27AX	30°	10°	65°	.030"	7/32"
	27R, RX, *RA*	10°	10°	75°	.030"	7/32"
	58CJ, CL, 59CJ, CK, CL	45°	45°	85°	.025"	❀
	58, 59J, L	25°	10°	60°	.025"	7/32"
	68LX, JX	25°	10°	60°	.030"	7/32"
	68CJ, CL	45°	45°	—	.030"	❀

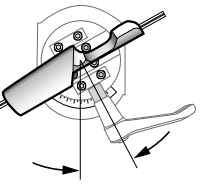
❀ Square-Ground Filing: A 15° cutting edge is the result when the file is held at 45° top-plate angle and 45° down angle.

Chains in *red* indicate items that are scheduled to be discontinued.

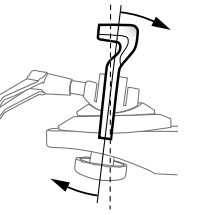
Grinding Angles

Wheel Thickness

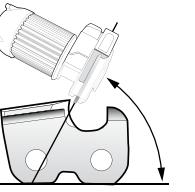
A



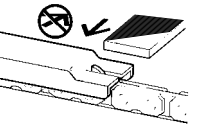
B



C



D



	OREGON	A	B	C	D	
1/4"	25AP	30°	10°	55°	.025"	1/8"
.325" Low Profile™	80TXL	25°	10°	70°	.025"	1/8"
3/8" Low Profile™	90PX, *90SG*	30°	0°	55°	.025"	1/8"
	91P, 91PX, 91PXL	30°	0°	55°	.025"	1/8"
	91VXL, M91VXL	30°	0°	55°	.025"	1/8"
.325"	*95VPX*	30°	10°	55°	.025"	3/16"
	20, 21, 22BPX, M20, M21, M22BPX	30°	10°	55°	.025"	3/16"
	95TXL	30°	10°	55°	.025"	3/16"
	20, 21, 22LPX, LGX, *M20*, *M21*, *M22LPX*	25°	10°	55°	.025"	3/16"
3/8"	72, 73, 75V	25°	10°	55°	.025"	3/16"
	72, 75CJ, CK, CL	15°	45°	–	.025"	–
	72APX, 72, 73, 75DPX, M72, M73, M75DPX	30°	10°	55°	.025"	3/16"
	72, 73, 75EXL, EXJ, *LGX*, *JGX*, LPX, JPX	25°	10°	55°	.025"	3/16"
	M72, *M73*, *M75LPX*	25°	10°	55°	.025"	3/16"
	72, 73, 75RD	10°	10°	50°	.025"	3/16"
.404"	27X, 27AX	30°	10°	55°	.030"	3/16"
	27R, RX, *RA*	10°	10°	50°	.030"	3/16"
	58CJ, CL, 59CJ, CK, CL	15°	45°	–	.025"	–
	58, 59J, L	25°	10°	55°	.025"	3/16"
	68LX, JX	25°	10°	55°	.030"	3/16"
	68CJ, CL	15°	45°	–	.030"	–

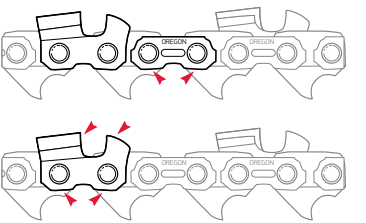
Chains in *red* indicate items that are scheduled to be discontinued.

How to Install New Saw Chain Parts

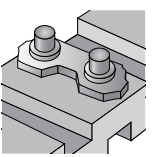
⚠ Read "Operation & Handling Care" on page 20.

Note: Use only Oregon® parts to repair Oregon saw chain, and only use parts which are the correct size and type for your saw chain.

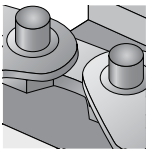
1. Remove rivets, and parts to be replaced, as shown under "How to Break Out Rivets" on page 36. Never reassemble a saw chain with old preset tie-straps — always use new preset tie-straps.
2. If needed, file off bottom of new parts to match existing worn parts. File new cutters back to match worn cutters. Do not file the tops of kickback-reducing bumper tie-straps or bumper drive links.



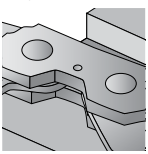
3. Place the preset tie-strap on a flat outer surface of a saw chain breaker anvil. Be sure the rivets are pointing up.



4. Assemble saw chain to the preset tie-strap.



5. Assemble tie-strap with brandmark, dot face up, and the notch toward the drive link tangs. Assemble bumper tie-strap in the correct direction, with the notch toward the drive link tangs.



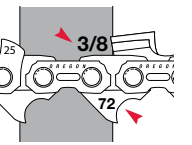
6. Be sure parts are assembled in the correct location, sequence and direction. Check "Parts of a Saw Chain" on page 14. If unsure, ask your Oregon® dealer.
7. To form rivet heads, use an Oregon rivet spinner. Follow the instructions packaged with the rivet spinner.

> ⚠ **WARNING:** Rivet heads must be snug and secure while still allowing all joined parts to move freely. Rapid wear leading to possible saw chain breakage and personal injury can be caused by rivet heads that are either too tight or too loose.

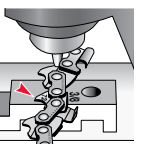
Note: New rivet heads may be smaller and shaped differently than factory-spun heads.

How to Break Out Rivets

⚠ **WARNING:** Always wear approved safety accessories for hands and face when breaking out rivets.

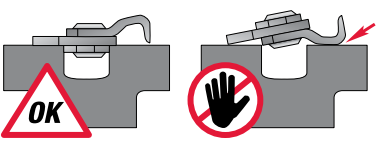


1. Select proper anvil slot number on saw chain breaker anvil which matches the drive link number on the saw chain to be broken (see "Saw Chain Drive Link Number Identification" on page 48).



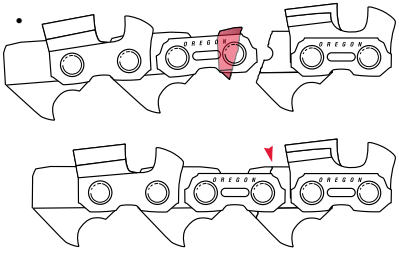
2. Insert saw chain portion for breaking into the proper slot of the saw chain anvil and push saw chain forward until bottom tie-strap is flush with the far side of slot. (Drive link is then supported on both sides of slot.)
3. Position rivet head directly under punch. Pull handle down if using a bench saw chain breaker, or hammer out rivet if using a handheld punch. Do not use excessive force.

   Note: Important — when breaking saw chain at cutter, make sure cutter is in the top position.



Removing Rivets from Broken Drive Links

1. When removing rivets from broken drive links, hold the two broken segments together in their original (unbroken) positions as you tighten the saw chain link in the adjustable anvil.



2. See steps 1 – 3 from “How to Break Out Rivets” on the previous page.

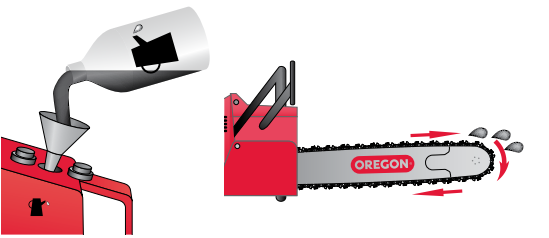
Saw Chain Drive Link Number Chart

Anvil Slot Number	1/4	.325" Low Profile™	.325"	3/8" Low Profile™	3/8"	.404"
Drive Link Number	25	80	95	90	72	27
			20	91	73	58
			21		75	59
			22			68

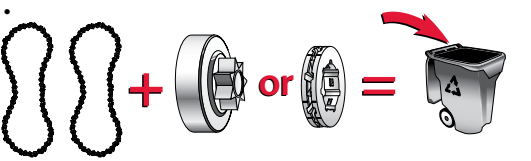
How to Break in a New Saw Chain

The life of your new saw chain can be extended by taking these few simple steps before using it.

1. Oil your saw chain prior to use.



2. Never run any saw chain on a worn drive sprocket rim or spur system, especially a new saw chain. Replace your rim or spur system after every two saw chains, or sooner.



3. Run new saw chain at half throttle for several minutes before doing any cutting in order to allow oil to reach all parts of the guide bar and saw chain. Allow the chainsaw and the cutting system to warm up fully.

   Also recommended: Dipping the saw chain in guide bar oil or drizzling oil down the length of the saw chain on the guide before running it. This gives the saw chain maximum lubrication at the bearing surfaces and rivets.

4. Stop, check saw chain tension, let saw chain cool, and adjust tension often during operation, as shown on "How to Tension your Saw Chain" on page 22

5. Keep the first several cuts light. Keep extra oil on the cutting system during these first cuts, and do not apply heavy pressure.

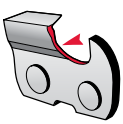
Most Saw Chain Problems are Caused by Four Things:

1. Incorrect saw chain tension
2. Incorrect filing
3. Lack of lubrication
4. Cutting any material other than wood.

Here are the things you should look for, and the corrective actions you should take:

Problem: Cuts Slow/Rough or Won't Hold Edge

Look closely at your saw chain's cutters and compare them to the following illustrations.



1. Light abrasive damage on side plates.

Cause: Cutters came in contact with light abrasive materials.

Symptoms: Very slow cutting

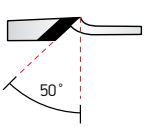
Remedy: File cutters back until all damage is removed.

2. Severe abrasive damage on side and/or top-plates.

Cause: Cutters hit or cut material other than wood, such as rock, dirt, or sand. This type of damage typically occurs when cutting close to the ground.

Symptoms: Saw chain won't cut or cuts crookedly if the damage is to one side of saw chain. Possible guide bar rail damage.

Remedy: File cutters back until all damage is removed.

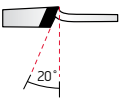


3. Too much top-plate filing angle.

Cause: Excessive top-plate angle while filing or grinding.

Symptoms: Cutting angle is very sharp, but dulls fast. Cutting action rough and erratic.

Remedy: Resharpen cutters while holding the file at the correct top-plate filing angle for the saw chain. Be sure the file guide is stamped with the saw chain's correct top-plate angle.

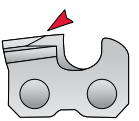


4. Too little top-plate filing angle.

Cause: Filed or ground at less than the recommended angle.

Symptoms: Slow cutting. Requires extra effort to cut. Possible binding in cut.

Remedy: Resharpen cutters while holding the file at the correct top-plate filing angle for the saw chain. Be sure the file guide is stamped with the saw chain's correct top-plate angle.

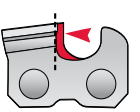


5. Too much top-plate cutting angle.

Cause: File held too low or file is too small. Grinders: Saw chain ground at the wrong top-plate cutting angle or using an incorrectly-sized grinding wheel.

Symptom: Poor stay-sharp. Rapid dulling. Cuts fast for a short time, then dulls.

Remedy: Resharpen cutters with the correct file in the right size, held in the correct position. Use correct file guide.



6. Too little top-plate cutting angle.

Cause: File held too high or file is too large. Grinders: Saw chain ground at the wrong top plate cutting angle or an incorrectly sized grinding wheel.

Symptoms: Slow cutting. Premature wear to saw chain and guide bar rails.

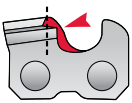
Remedy: Resharpen cutters using the correct file guide that is the right size and in the correct position.

7. Too much hook in the side plate.

Cause: File held too low or the file is too small. Grinders: Saw chain ground at the wrong top-plate cutting angle, grinding wheel is too small or is grinding too deep into the body of cutter.

Symptoms: Rough cutting. Saw chain grabs. Cutters dull quickly or won't hold cutting edge. Top plate breakage and/or saw chain stretch.

Remedy: Resharpen cutters using the correct file in the right size held in the correct position.

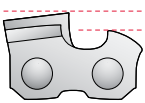


8. Backslope on the side plate.

Cause: File held too high or the file is too large. Grinders: Saw chain ground at the wrong top-plate cutting angle, grinding wheel is too large, or the grinding wheel is not grinding deep enough into the body of cutter.

Symptoms: Slow cutting. Premature wear to saw chain and guide bar rails.

Remedy: Resharpen cutters using the correct file guide in the right size held in the correct position.

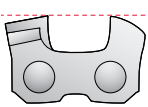


9. Low depth gauges.

Cause: Too much depth gauge removed; depth gauge damaged in use.

Symptoms: Rough cutting. Saw chain grabs. Excessive wear to the heel of cutters, opposing tie-straps, guide bar rails. Top-plate breakage and/or saw chain stretch.

Remedy: In most cases, cutters cannot be filed back enough to correct for depth gauges that are too low. Replace the saw chain.



10. High depth gauges.

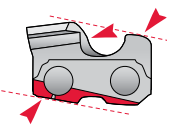
Cause: Depth gauge never lowered.

Symptoms: Slow cutting. Excessive wear to the saw chain and guide bar rails.

Remedy: File depth gauges down to their correct height.

NOTE: Refer to "How to Sharpen Cutters" on page 23 when performing the remedies above.

Problem: Cutters & Tie-Straps Wear Heavily or Break



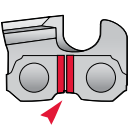
11. Excessive heel wear on cutters and opposite tie-straps; cracks under rear rivet holes.

Cause: Forcing dull saw chain to cut. Low depth gauge settings. Lack of lubrication. Loose saw chain tension.

Symptoms: Excessive heel wear on cutters. Saw chain breakage. Excessive saw chain stretch.

Remedy: Replace worn or cracked cutters and/or tie-straps.

NOTE: One or more of the following may be required to prevent future wear and / or cracks: (1) Refile cutters using the correct angles. (2) Keep more lubrication on the saw chain and guide bar. (3) Reduce the amount of depth gauge setting (may require replacement of the saw chain). (4) Do not force dull saw chain to cut. (5) Do not force saw chain through frozen wood. (6) Keep cutters sharp. (7) Always maintain proper tension.

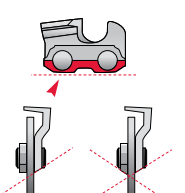


12. Tie-straps or cutters, broken in the center.

Cause: Incorrect field assembly of saw chain components.

Symptoms: Broken tie-straps or cutters.

Remedy: Replace broken components.



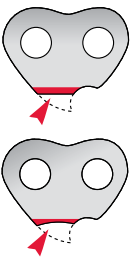
13. Bottoms of tie-straps and cutters worn out of square.

Cause: Worn guide bar rails.

Symptoms: Bottoms of tie-straps and cutters worn out of square.

Remedy: Dress the tops of the guide bar's rails square. If wear is minor, file the bottoms of tie-straps and cutters square. If wear is extensive, replace the saw chain.

Problem: Drive Links Wear Heavily or Break

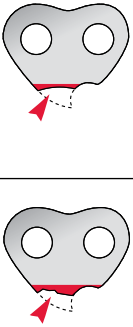


14. Straight or concave bottoms.

Cause: Straight bottoms are due to shallow guide bar body groove. Concave bottoms are due to shallow guide bar nose groove.

Symptoms: Drive link tangs worn straight or concave. Drive links can't clean guide bar groove. Tendency to throw saw chain from guide bar.

Remedy: Replace guide bar, drive sprocket, or both. Sharpen drive link tangs, as shown in the "Sharpening Drive Link Tangs" on page 44, if possible. If not, replace the saw chain.

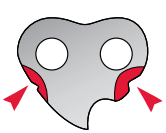


15. Battered and broken bottoms.

Cause: Worn or broken drive sprocket. Loose saw chain tension or saw chain jumping from guide bar groove. Results in damage from revolving drive sprocket.

Symptoms: Drive links are burred or nicked. Drive links may not fit in guide bar groove. Drive links can't clean the guide bar groove.

Remedy: Maintain proper tension to prevent saw chain from climbing out of spur drive sprocket. Replace drive links or replace entire saw chain if many drive links are damaged.

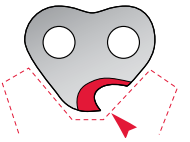


16. Peening in front or back.

Cause: Worn drive sprocket. Pin sprocket systems are known to concentrate load to the back of drive link, causing premature wear.

Symptoms: Change in drive link shape. Tight joints in the saw chain. Saw chain stretch. Shortened saw chain life.

Remedy: Replace the drive sprocket and/or pins. Replace saw chain. Do not attempt to run a new saw chain on an old drive sprocket, or an old saw chain on a new drive sprocket.

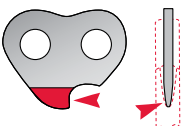


17. Drive link tang turned up.

Cause: Worn drive sprocket.

Symptoms: Drive link tangs hit the bottom.

Remedy: Replace drive sprocket. Sharpen drive link tangs as shown in the illustration below, if possible. If not, replace the saw chain.



18. Sides worn round or thin at bottoms.

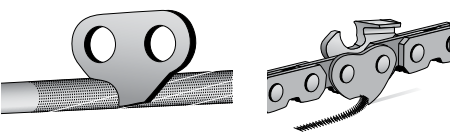
Cause: Guide bar rails have spread, or one rail has worn low, allowing saw chain to lean over.

Symptoms: Saw chain cuts crookedly. Accelerated guide bar rail and saw chain wear.

Remedy: Have guide bar rails serviced by a dealer, otherwise replace guide bar. Replace saw chain if wear is extensive or if problem persists.

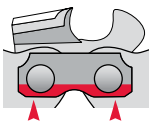
NOTE: Also check bottoms of tie-straps and tops of guide bar rails for damage.

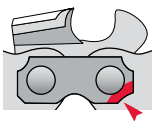
Sharpening Drive Link Tangs



Pointed drive link tangs help remove chips and debris from your guide bar groove. Sharpen damaged tangs back to their original shape with a round file.

Problem: Saw Chain Has Tight Joints



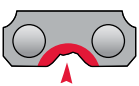


19. Peening on bottom or front of cutters and tie-straps.

Cause: Improper saw chain tension or a worn out drive sprocket.

Symptoms: Saw chain stretch or saw chain breakage.

Remedy: Saw chain with tight joints cannot be repaired. Replace the saw chain and maintain proper tension. Replace the rim drive sprocket if worn.



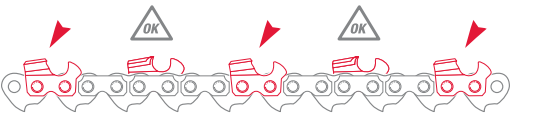
20. Peening in notches of cutters and tie-straps.

Cause: Worn spur drive sprocket.

Symptoms: Saw chain stretch or saw chain breakage.

Remedy: Replace the spur drive sprocket. Replace the saw chain. Always maintain proper tension and do not run saw chain on a worn drive sprocket.

Problem: Cuts Crooked / Leans to One Side / Cuts Unevenly

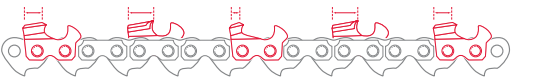


21. Damage to cutters on one side of saw chain.

Cause: Cutters on one side of saw chain are damaged by hitting the saw box or the ground/debris.

Symptoms: Guide bar and saw chain bind in the cut. Could result in guide bar and saw chain breakage when removing the guide bar from tree. Uneven guide bar rail wear.

Remedy: File cutters back enough to remove all damage. Square up guide bar rails if uneven.



22. Different cutter top-plate lengths

Cause: Inconsistent sharpening.

Symptoms: Guide bar and saw chain bind in the cut. Could result in guide bar and saw chain breakage when removing the guide bar from tree. Uneven guide bar rail wear.

Remedy: File cutters back to even cutter top-plate lengths. Square up guide bar rails if uneven.

Oregon® Families

To help easily identify our tiers of products, packaging is differentiated by color. Product within families meeting the needs of occasional users will be indicated by gray packaging. Product families targeted at demanding professional users will be indicated by black packaging.

PowerCut™

The ultimate saw chain for loggers and skilled forest workers. Full chisel cutters power through timber with speed, efficiency, and precision.

SpeedCut™

Faster, cutting performance for wood-cutting professionals and experienced homeowners alike. Narrow kerf system requires less power to cut through high volumes of wood quickly and easily.

VersaCut™

Designed for tree-cutting professionals who require high performance from their saw chain. Uses cutters designed for maximum durability and versatility.

ControlCut™

Ideal for property owners and professionals looking for additional control, delivering a smooth cut every single time. Easy to maintain, with a forgiving sharpening profile.

DuraCut™

Made for woodcutters working in abrasive and tough environments. Advanced plating process with extra layers of chrome. Cut up to three times longer than conventional saw chain.

RipCut™

Created specifically for chain-type sawmills. Produces smooth ripping cuts with supreme efficiency to make precise boards and planks.

AdvanceCut™

Perfect for homeowners cutting trees on their property and for tree-cutting professionals who only need to occasionally cut wood. User-friendly because of the low kickback design.

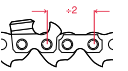
Saw Chain Identification

Saw Chain Drive Link Number Identification

Nearly all Oregon® saw chains are named by a part number made up of a number (see below), followed by one, two or three letters (see next page). Part number Examples: 72LPX, 91PX

The Numbers: 72 LPX, 91 PX

The numbers are stamped on the saw chain's drive links and indicate the physical size of the saw chain (pitch and gauge).

 Chain Number	 Pitch	 Gauge in.	mm
25	1/4"	.050"	1.3
80	.325" Low Profile™	.043"	1.1
90	3/8" Low Profile™	.043"	1.1
91	3/8" Low Profile™	.050"	1.3
20	.325"	.050"	1.3
95	.325"	.050"	1.3
21	.325"	.058"	1.5
22	.325"	.063"	1.6
72	3/8"	.050"	1.3
73	3/8"	.058"	1.5
75	3/8"	.063"	1.6
26, 58	.404"	.058"	1.5
27, 59, 68	.404"	.063"	1.6

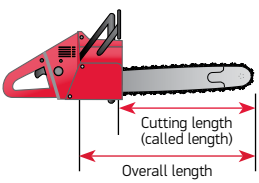
How to Order Replacement Saw Chain

For the best possible service, have the following chainsaw information ready for your Oregon® dealer.

1. Make and model

SAW MAN 1100-A

2. Guide bar's cutting length



NOTE: Your guide bar's called length is different from its overall length. The called length is the distance from the front of the chainsaw to the tip of the guide bar.

3. Saw chain part number and drive link count for saw chain length.

EXAMPLE:

Oregon®
saw chain 72LGX-068G

Part Number — Drive Link Count

Saw Chain Identification

Round Ground

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
1/4"							
25AP	ControlCut™	.050"	1.3	Micro Chisel®		Standard	
.325" Low Profile™							
80TXL	SpeedCut™	.043"	1.1	Micro Chisel		Standard	
3/8" Low Profile™							
90PX	AdvanceCut™	.043"	1.1	Chamfer Chisel®		Standard	
91PX	AdvanceCut	.043"	1.3	Chamfer Chisel		Standard	
91PXL	ControlCut	.043"	1.3	Semi-Chisel		Standard	
91VXL	VersaCut™	.050"	1.3	Semi-Chisel		Standard	
M91VXL	DuraCut™	.050"	1.3	Semi-Chisel		Standard	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

Round Ground

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
.325"							
20BPX 21BPX 22BPX	ControlCut™	.050" .058" .063"	1.3 1.5 1.6	Micro Chisel®		Standard	
95TXL *95VPX*	SpeedCut™	.050"	1.3	Micro Chisel		Standard	
20LPX 21LPX 22LPX	PowerCut™	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
20LGX 21LGX 22LGX	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
M20BPX M21BPX M22BPX	DuraCut™	.050" .058" .063"	1.3 1.5 1.6	Micro Chisel		Standard	
M20LPX *M21LPX* *M22LPX*	DuraCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

Saw Chain Identification

Round Ground

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
3/8"							
72V 73V 75V	AdvanceCut™	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
72DPX 73DPX 75DPX	VersaCut™	.050" .058" .063"	1.3 1.5 1.6	Semi-Chisel		Standard	
72APX	VersaCut	.050"	1.3	Semi-Chisel		Skip	
72EXL 73EXL 75EXL	PowerCut™	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
72EXJ 73EXJ 75EXJ	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Skip	
72LGX *73LGX* *75LGX*	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
72JGX *73JGX* *75JGX*	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Skip	
72LPX 73LPX 75LPX	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

Round Ground

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
3/8"							
72JPX 73JPX 75JPX	PowerCut™	.050" .058" .063"	1.3 1.5 1.6	Chisel		Skip	
M72DPX M73DPX M75DPX	DuraCut™	.050" .058" .063"	1.3 1.5 1.6	Semi-Chisel		Standard	
M72LPX *M73LPX* *M75LPX*	DuraCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
.404"							
27X	VersaCut™	.063"	1.6	Micro Chisel®		Standard	
27AX	VersaCut	.063"	1.6	Micro Chisel		Skip	
59L	PowerCut™	.058" .063"	1.5 1.6	Chisel		Standard	
59J	PowerCut	.058" .063"	1.5 1.6	Chisel		Skip	
68LX	PowerCut	.063"	1.6	Chisel		Standard	
68JX	PowerCut	.063"	1.6	Chisel		Skip	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

Saw Chain Identification

Square Ground

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
3/8"							
72CL 73CL 75CL	PowerCut™	.050" .058" .063"	1.3 1.5 1.6	Chisel		Standard	
72CK 73CK 75CK	PowerCut	.050" .058" .063"	1.3 1.5 1.6	Chisel		Semi-Skip	
72CJ 75CJ	PowerCut	.050" .063"	1.3 1.6	Chisel		Skip	
.404"							
68CL	PowerCut	.063"	1.6	Chisel		Standard	
68CJ	PowerCut	.063"	1.6	Chisel		Skip	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

Specialty

Part	Type	Gauge		Cutter Type		Cutter Sequence	Kickback-Reducing Features (if any)*
		in.	mm	End View	Side View		
1/4"							
25A	Sculptor™	.050"	1.3	Micro Chisel		Standard	
25F	Sculptor	.050"	1.3	Micro Chisel		Full-House Sequence	
3/8"							
72RD 73RD 75RD	3/8" RipCut™	.050" .058" .063"	1.3 1.5 1.6	Micro Chisel		Standard	
.404"							
27R	RipCut	.063"	1.6	Micro Chisel		Standard	
27RA	RipCut	.063"	1.6	Micro Chisel		Skip	
27RX	RipCut	.063"	1.6	Micro Chisel		Super Skip	

*Refer to the "Kickback-Reducing Features" on page 14 for all kickback icons.
Chains in *red* indicate items that are scheduled to be discontinued.

High-Performance Chain

PowerCut™

20, 21, 22 LPX

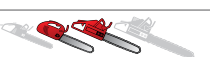
An ideal chain for professional woodcutters who use .325" pitch saws. Low-vibration, full chisel cutters offer top performance. Offset depth gauges prevent cutters from driving into the sidewall of the cut, offering a smoother cut.

Features and Benefits

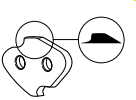
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
20LPX	.050"	1.3 mm
21LPX	.058"	1.5 mm
22LPX	.063"	1.6 mm

.325"

Saw Size 38–62 cc	
Bar Lengths 13–20" (32–50 cm)	
Chisel	Kickback Safety

7



PowerCut™

20, 21, 22 LGX

The all-new 20-Series LGX has been engineered to harness the power of today's high-performance saws. Blued, full-chisel cutters and advanced LubriTec™ oiling features mean this chain is ready to work as hard as you are.

Features and Benefits

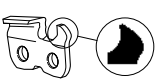
- LubriTec keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
20LGX	.050"	1.3 mm
21LGX	.058"	1.5 mm
22LGX	.063"	1.6 mm

.325"

Saw Size 38–62 cc	
Bar Lengths 13–20" (32–50 cm)	
Chisel	Kickback Safety

7



High-Performance Chain

PowerCut™

72, 73, 75 EXL/EXJ

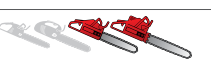
With a reshaped cutter and multi-axis grind technology for superior performance, sharpness and consistency; now the top option for professional woodcutters who use 3/8" pitch saws (replaces 72, 73, 75LGX & JPX). This low-vibration, full chisel cutter chain is engineered to utilize the power of today's professional saws and reduce the force applied by the operator. Designed to maximize every cut, our proprietary cutter technology gives users a sharper, more durable cutting edge that provides increased cutting performance with less effort.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Expanded Top-Plate Filing Indicators and depth gauge Filing Indicators area make accurate sharpening easier
- Gold Loop Start Indicator makes sharpening easier with start and stop identification
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72EXL/EXJ	.050"	1.3 mm
73EXL/EXJ	.058"	1.5 mm
75EXL/EXJ	.063"	1.6 mm

3/8"

Saw Size 50–100 cc	
Bar Lengths 16–36" (40–90 cm)	
Chisel	Kickback Safety

7

PowerCut™

72, 73, 75 LGX/JGX

An ideal chain for professional woodcutters who use 3/8" pitch saws. Low-vibration, full chisel cutters offer top performance. Offset depth gauges prevent cutters from driving into the sidewall of the cut, offering a smoother cut.

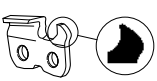
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72LGX/JGX	.050"	1.3 mm
73LGX/JGX	.058"	1.5 mm
75LGX/JGX	.063"	1.6 mm

3/8"

Saw Size 50–100 cc	
Bar Lengths 16–36" (40–90 cm)	
Chisel	Kickback Safety



High-Performance Chain

PowerCut™

72, 73, 75 CL/CK
72, 75 CJ

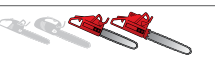
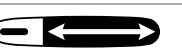
Work more efficiently with 72, 73, 75 CL & CK — 72, 75 CJ chains. Ideal for high-production cutting with long bars and 3/8" pitch saws. This is the square ground version of our LGX series chain.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72CL/CK/CJ	.050"	1.3 mm
73CL/CK	.058"	1.5 mm
75CL/CK/CJ	.063"	1.6 mm

3/8"

Saw Size	
50–100 cc	
Bar Lengths	
16–36" (40–90 cm)	
Chisel	Kickback Safety

7

PowerCut™

72, 73, 75 LPX
72 JPX

An ideal chain for professional woodcutters who use 3/8" pitch saws. Low-vibration, full chisel cutters offer top performance. Offset depth gauges prevent cutters from driving into the sidewall of the cut, offering a smoother cut.

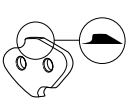
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72LPX/JPX	.050"	1.3 mm
73LPX	.058"	1.5 mm
75LPX	.063"	1.6 mm

3/8"

Saw Size 50–100 cc	
Bar Lengths 16–36" (40–90 cm)	
Semi-Chisel	Kickback Safety



High-Performance Chain

PowerCut™

68 LX/JX

A top performing, heavy-duty, big-timber chain, for professionals who use large saws. Full chisel cutters offer top performance.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
68LX/JX	.063"	1.6 mm

.404"

Saw Size 65 cc & Larger	
Bar Lengths 20" (50 cm) & Larger	
Chisel	Kickback Safety

7

PowerCut™

68 CL/CJ

68 CL & CJ helps you get more done. Ideal for high-production cutting with long bars and .404"- pitch saws. This is the square ground version of our 68LX.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
68CL/CJ	.063"	1.6 mm

.404"

Saw Size 65 cc & Larger	
Bar Lengths 20" (50 cm) & Larger	
Chisel	Kickback Safety

7

High-Performance Chain

PowerCut™

59 L/J

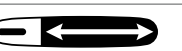
A big-timber, heavy-duty chain for professionals who use large saws. Full chisel cutters offer top performance. Get less kickback without the added weight or bulk of other methods because of the depth gauge design.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
59L/J	.063"	1.6 mm

.404"

Saw Size 65 cc & Larger	
Bar Lengths 20" (50 cm) & Larger	
Chisel	Kickback Safety

7

SpeedCut™

95 TXL

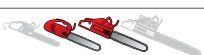
Ideal for arborists and property owners who want top performance. 95TXL is for saws up to 55 cc. (Replaces 95VPX.) Oregon® SpeedCut 95TXL narrow kerf cutting systems are more efficient, needing less power from the saw than standard cutting systems. Low-vibration, Micro Chisel® cutters have small-radius working corners for excellent performance and easy maintenance.

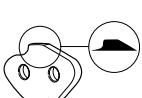
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Expanded Top-Plate Filing Indicators and depth gauge Filing Indicators area make accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
95TXL	.050"	1.3 mm

.325"

Saw Size 38–55 cc	
Bar Lengths 13–20" (32–50 cm)	
Micro Chisel	Kickback Safety



Always use SpeedCut narrow kerf chain in combination with SpeedCut or other narrow kerf bars.

High-Performance Chain

SpeedCut™ Nano

80 TXL

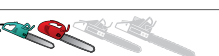
SpeedCut Nano has been engineered from the ground up with maximum efficiency in mind. Built to optimize saw performance, SpeedCut Nano meets the demands of tree care professionals like no other system on the market. SpeedCut Nano is the first ever .325" Low Profile™ cutting system. By sizing the chain to better match the specific power range of battery-powered and compact light-weight gas-powered saws, we've maximized the chain's efficiency for improved performance.

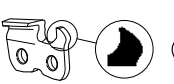
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Expanded Top-Plate Filing Indicators and depth gauge Filing Indicators area make accurate sharpening easier
- Gold Loop Start Indicator makes sharpening easier with start and stop identification
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
80TXL	.043"	1.1 mm

.325" Low Profile™

Saw Size 20–38 cc	
Bar Lengths 10–16" (25–40 cm)	
Micro-Chisel	Kickback Safety



VersaCut™

91 VXL

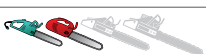
91VXL is a high-performance, Low Profile™ chain. It's ideal for professional arborists and orchardists who use light-weight chainsaws. Cutter top-plates are 33% longer than standard 91 cutters. Low vibration, semi-chisel cutters provide an aggressive cutting edge with a forgiving sharpening profile and good stay-sharp.

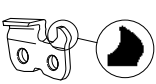
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion

No.	Gauge
91VXL	.050" 1.3 mm

3/8" Low Profile

Saw Size Up to 42 cc	
Bar Lengths Up to 18" (45cm)	
Semi-Chisel	Kickback Safety



High-Performance Chain

VersaCut™

72, 73, 75 DPX

72 APX

An ideal choice for professional users who cut in a variety of conditions. Easy to maintain. Low-vibration, semi-chisel cutter designs work fast. This design is typically more tolerant of sharpening errors than chisel cutters.

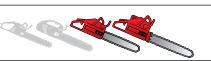
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72DPX	.050"	1.3 mm
73DPX	.058"	1.5 mm
75DPX	.063"	1.6 mm
72APX	.050"	1.3 mm

3/8"

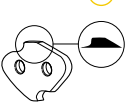
Saw Size
50–100 cc



Bar Lengths
16–36" (40–90 cm)

Semi-Chisel

Kickback Safety



Note: DPX is standard sequence and APX is skip sequence.

VersaCut™

27X/AX

This is a heavy-duty, high-performance chain for professionals using large saws. Ideal for those who prefer the durability and easy maintenance of Micro Chisel® cutters. Micro Chisel cutters have small-radius working corners for excellent performance and easy maintenance.

Features and Benefits

- LubriTec keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
27X/AX	.063"	1.6 mm

.404"

Saw Size 65 cc & Larger	
Bar Lengths 20" (50 cm) & Larger	
Micro Chisel	Kickback Safety

7

High-Performance Chain

ControlCut™

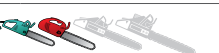
25 AP

25AP is light-weight, smooth chain, ideal for pruning — our Micro Chisel® cutters have small-radius working corners for excellent performance, and they are easy to maintain. The 25AP is small and light-weight, making it easy to use and maneuver.

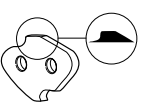
- Available in Sculptor™ chain version — see page 78.

No.	Gauge	
25AP	.050"	1.3 mm

1/4"

Saw Size Up to 38 cc	
Bar Lengths Up to 16" (40 cm)	
Micro Chisel	Kickback Safety

7



ControlCut™

91 PXL

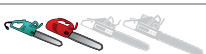
A high-performance Low Profile chain, 91PXL is ideal for property owner or professionals using light-weight chainsaws, who prefer low kickback. Cutter top-plates are 33% longer than standard 91 cutters. The low vibration, low kickback semi-chisel cutters give you an aggressive cutting edge. 91PXL also offers a forgiving sharpening profile and good stay-sharp. Bumper drive link paired with depth gauge design offers reduced kickback with strong performance.

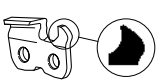
Features and Benefits

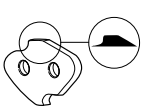
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion

No.	Gauge	
91PXL	.050"	1.3 mm

3/8" Low Profile™

Saw Size Up to 42 cc	
Bar Lengths Up to 18" (45 cm)	
Semi-Chisel	Kickback Safety





High-Performance Chain

ControlCut™

20, 21, 22 BPX

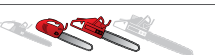
An ideal choice for regular users of saws such as property owners and landscapers. The low-vibration, Micro Chisel® cutters have small-radius working corners for excellent performance and easy maintenance. Low kickback design.

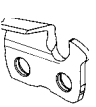
Features and Benefits

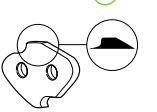
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
20BPX	.050"	1.3 mm
21BPX	.058"	1.5 mm
22BPX	.063"	1.6 mm

.325"

Saw Size 38–62 cc	
Bar Lengths 13–20" (32–50 cm)	
Micro Chisel	Kickback Safety





DuraCut™

M91 VXL

Formerly named MultiCut™

Work longer in dirty conditions with this more durable version of our aggressive 91VXL chain; cuts up to 3 times longer. Maintain with standard maintenance tools.

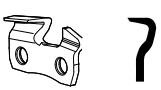
Features and Benefits

- Multiple layers of chrome keeps chain sharp longer
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion

No.	Gauge	
M91VXL	.050"	1.3 mm

3/8" Low Profile™

Saw Size Up to 42 cc	
Bar Lengths Up to 18" (32–50 cm)	
Semi-Chisel	Kickback Safety



High-Performance Chain

DuraCut™

M20, 21, 22 BPX

Formerly named MultiCut™

Cut effectively in dirty and abrasive conditions with this more durable version of our high performing .325" pitch BPX chain; cuts up to 3 times longer. The low-vibration, Micro Chisel® cutters have small-radius working corners for excellent performance and easy maintenance. Low kickback design. Maintain with standard maintenance tools.

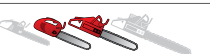
Features and Benefits

- Multiple layers of chrome keeps chain sharp longer
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
M20BPX	.050"	1.3 mm
M21BPX	.058"	1.5 mm
M22BPX	.063"	1.6 mm

.325"

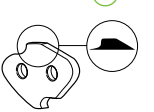
Saw Size
38–62 cc



Bar Lengths
13–20" (32–50 cm)

Micro-Chisel

Kickback Safety



DuraCut™

M72, 73, 75 DPX

Formerly named MultiCut™

Cut more between sharpenings in the toughest, dirtiest, or most abrasive conditions with this more durable version of our high-performing 3/8" pitch DPX chain; cuts up to 3 times longer. Easy to maintain. Low-vibration, semi-chisel cutter designs work fast. Maintain with standard maintenance tools.

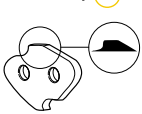
Features and Benefits

- Multiple layers of chrome keeps chain sharp longer
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Blued Cutters deliver high-quality protection against corrosion
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
M72DPX	.050"	1.3 mm
M73DPX	.058"	1.5 mm
M75DPX	.063"	1.6 mm

3/8"

Saw Size 50–100 cc	
Bar Lengths 16–36" (40–90 cm)	
Semi-Chisel	Kickback Safety



RipCut™

72, 72, 75 RD

Specially made for ripping — making cuts parallel to the wood grain. 72, 73, 75 RD has a special ripping application grind for making dimensional boards and planks from larger timbers. For use on chain-type sawmills. Not recommended for hand-held use.

Features and Benefits

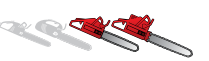
- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72RD	.050"	1.3 mm
73RD	.058"	1.5 mm
75RD	.063"	1.6 mm

3/8"

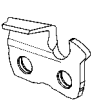
Saw Size

For ripping cuts only. Do not use these chains for any type of cutting other than ripping.



Micro Chisel®

Kickback Safety



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RipCut™

27 R/RX

Specially made for ripping — making cuts parallel to the wood grain. 27R, RX has a special ripping application grind for making dimensional boards and planks from larger timbers. The 27RX is a super-skip sequence to allow greater chip clearance when making extra wide cuts. For use on chain-type sawmills. Not recommended for hand-held use.

Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
27R/RX	.063"	1.6 mm

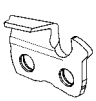
.404"

Saw Size

For ripping cuts only. Do not use these chains for any type of cutting other than ripping.

Micro Chisel®

Kickback Safety



7

High-Performance Chain

Sculptor™

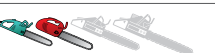
25 F

25F –For users with bars with a nose radius of 12 mm or less designed for carving. The "full-house" sequencing makes 25F the preferred chain of some carvers cutting fine detail and finishing work. Micro Chisel® cutters have small-radius working corners to give you excellent performance with easy maintenance. Small size and light weight make the 25F easy to use and maneuver.

No.	Gauge	
25F	.050"	1.3 mm

1/4"

Saw Size
Up to 38 cc



Bar Lengths
Sculptor Bar Only.

Micro Chisel

7

Kickback Safety

WARNING: Failure to use this chain on bars with nose radii of 12 mm or smaller can result in severe kickback

Notes

Reliable Performance Chain

AdvanceCut™

90 PX

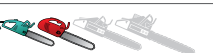
90PX offers higher chain efficiency, ideal for small, low-powered saws great for homeowners and landscapers (replaces 90SG). They need less power from the saw than standard cutting systems. The narrow .043" gauge reduces the weight of the bar and chain by roughly 15%. Low-vibration, low kickback Chamfer Chisel™ cutters' twin cutting corners offer outstanding performance.

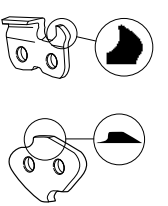
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Top-Plate Filing Indicators makes accurate sharpening easier

No.	Gauge	
90PX	.043"	1.1 mm

3/8" Low Profile™

Saw Size Up to 42 cc	
Bar Lengths Up to 16" (40 cm)	
Chamfer Chisel	Kickback Safety



Always use with guide bars designed for narrow kerf saw chain.

AdvanceCut™

91 PX

91PX is for homeowners and occasional users who want a low-vibration and low kickback saw chain. The Chamfer Chisel™ cutters' twin cutting corners offer outstanding performance. They are durable, easy to maintain and forgiving, comparable to round-cornered chains. Bumper drive link paired with depth gauge design, offers reduced kickback with strong performance.

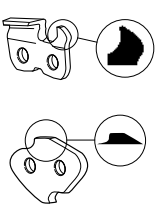
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life

No.	Gauge	
91PX	.050"	1.3 mm

3/8" Low Profile™

Saw Size Up to 42 cc	
Bar Lengths Up to 18" (45 cm)	
Chamfer Chisel	Kickback Safety



Reliable Performance Chain

AdvanceCut™

72, 73, 75 V

An ideal, low kickback chain for homeowners and occasional users. The low-vibration, full chisel cutters offer reliable performance. Smooth cutting and low kickback performance via our unique, patented, bent-over depth gauges.

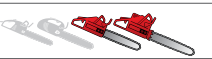
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life
- Top-Plate Filing Indicators makes accurate sharpening easier
- Our exclusive OCS-01 Steel delivers greater durability

No.	Gauge	
72V	.050"	1.3 mm
73V	.058"	1.5 mm
75V	.063"	1.6 mm

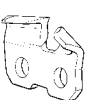
3/8"

Saw Size
50 – 100 cc



Bar Lengths
16 – 32" (40–80 cm)

Chisel



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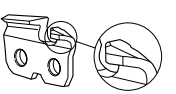
Kickback Safety



PowerSharp®

91 PS

Now you can sharpen fast, easy, and on the saw with the PowerSharp system. Includes the 91PS PowerSharp saw chain; a guide bar designed for PowerSharp; and the PowerSharp bar-mount sharpener. Sharpen the 91PS chain in a flash. Go from dull to sharp in just three seconds with this easy-to-use, precision sharpening system. Stays sharp three times longer than 91PX saw chain.

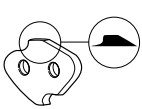
Features and Benefits

- LubriTec™ keeps your saw chain and guide bar oiled, for less friction and longer life

No.	Gauge	
91PS	.050"	1.3 mm

3/8" Low Profile™

Saw Size Up to 42 cc	
Bar Lengths Up to 18" (45 cm)	
PowerSharp	Kickback Safety




PowerCut™
OREGON®

OREGON®

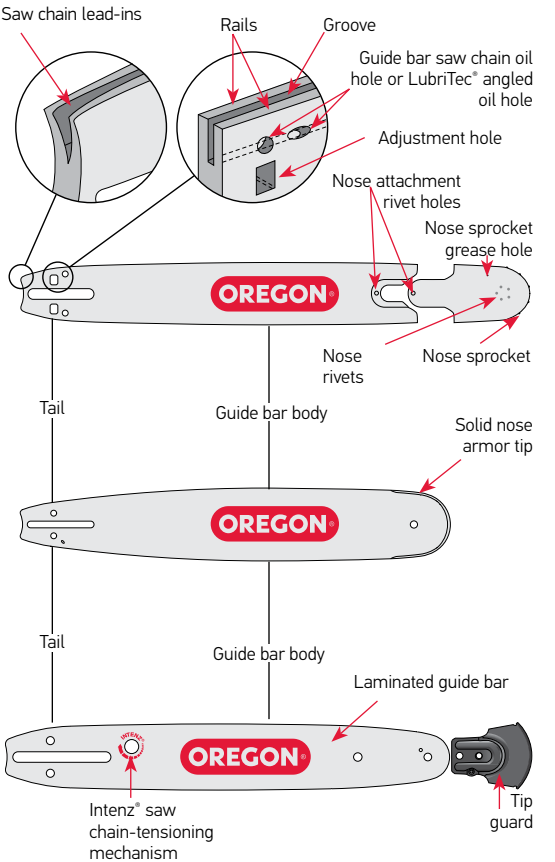
Safety & Maintenance Manual

Guide Bar

Page

- 85 -

Guide Bar Terms



Spanner Wrench "Scrench"

Flat File with Handle

Grease Gun

Guide Bar Groove Cleaner

Bar Rail Dresser

ATTENTION: DEALERS, CHAINSAW USERS, AND ANYONE WHO SERVICES SAW CHAIN. IMPORTANT SAFETY INFORMATION.

⚠ **WARNING:** Always turn off your chainsaw's engine before handling the guide bar. Failure to do so can result in severe injury.

For proper mounting of your guide bar, refer to the chainsaw operator's manual.

Note:

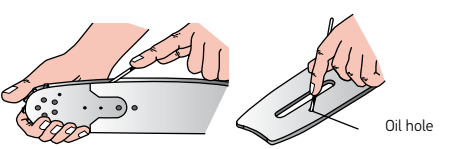
- Never use guide bar as a lever to lift, twist, or pry.
- A guide bar requires constant supply of oil during operation.

Basic Guide Bar Maintenance Tasks

▲ Before each use	● Daily
■ Often (Hourly, or at refueling)	◆ Weekly, periodically

1. ▲ ■ Saw chain tensioning
   See "How to Tension your Saw Chain" on page 22

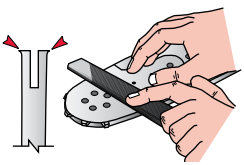
2. ● Inspect for damage and component wear; ("Problem: Guide Bar Rail Conditions" on page 94) replace as needed. Check bar groove depth after dressing by using our Multi-Purpose tool.
3. ◆ Clean guide bar grooves and oil holes.



4. ◆ Turn your guide bar over to equalize bar wear.

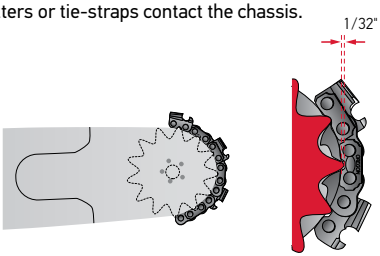
5. ◆ Dress the rail, always dressing from the bar tip to the bar mount.

   Note: If using a grinding wheel, direct debris towards tail, then clean out grooves. Grinding debris can cause the nose components to wear quickly or jam.



Bar Rail Dresser, p/n 111589 makes it easy to remove effects of normal wear and remove minor damage.

6. ◆ On sprocket-nose guide bars, check for clearance around the guide bar's tip between the tops of rails and the chassis. Replace nose sprockets before cutters or tie-straps contact the chassis.

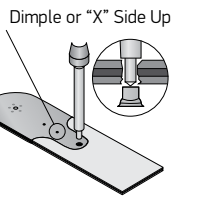


Replacing Oregon® PowerCut™ Guide Bar Noses

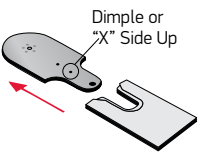
(formerly Power Match®)

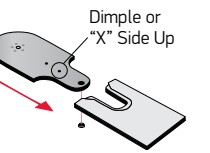
NOTE: Select a new PowerCut nose with the correct pitch for your guide bar and saw chain. Reduced-kickback Double Guard® replacement noses can be installed on any PowerCut guide bar and can be used with the same drive link count loop of saw chain.

1. Your Oregon PowerCut guide bar nose is marked, on one side only, with dimple or "X". Always strike on this side of PowerCut guide bar noses. Striking on the wrong side will damage the nose and guide bar body. Use the PowerCut nose rivet punch (part no. 102623si) to drive out the single attaching rivet.



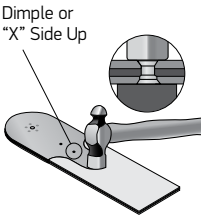
2. Remove the old nose. Clean the guide bar's attachment area.
3. Insert the new nose into the guide bar body. Insert the Power Match rivet (included with replaceable sprocket nose kit) ßthrough the underside of the nose, opposite the "X" mark.



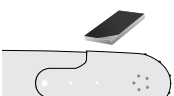


NOTE: The rivet will not fit, and cannot be secured, if inserted through the "X" side.

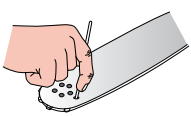
4. With the guide bar body, nose, and rivet solidly supported on a strong flat metal surface, peen the PowerCut™ rivet's head down with the flat end of a hammer. Do not hit the guide bar body, hit only the rivet head. Strike only on the "X" side; To check installation, grip the guide bar body in one hand, and twist. Nose and body should feel like a single, solid piece. If not (if any movement in the nose guide bar joint area is felt, or if any clicking sound from the same area is heard), tighten the rivet with a few more hammer strokes.

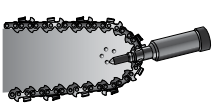


5. File down the rails of new noses to align with the rails of old guide bar bodies.



6. Grease the new nose sprocket. Clean out guide bar grease hole before using lubricant. Pump grease into hole until excess grease appears around the nose sprocket teeth of the guide bar.





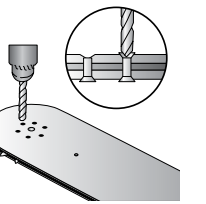
NOTE: Select a new nose sprocket with the correct pitch for your guide bar and saw chain.

Replace Nose Sprocket

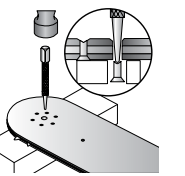
Pro-Lite® *(discontinued, no inventory available)*

⚠ **WARNING:** Wear eye protection and gloves.

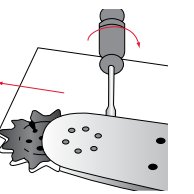
1. Using a 1/4" drill bit, drill out head from each of the nose sprocket rivets.



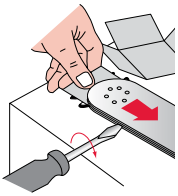
2. Punch out the remainder of the rivets. Use a punch narrow enough to keep from damaging the rivet holes in the nose of the guide bar.



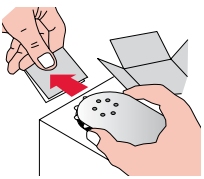
3. Use a small screwdriver to spread the guide bar nose rails just enough to remove the old nose sprocket. Clean debris from the sprocket area.



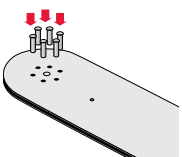
4. Inside the nose sprocket package, you'll find the new sprocket wrapped in a tissue. Be careful to keep the sprocket inside the tissue as you remove it from the package — bearings are easily lost. Slide the tissue and the new sprocket, together, into the guide bar's nose.



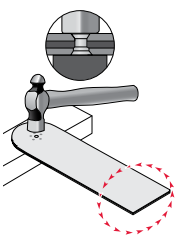
5. Once fully inside the nose, hold the nose sprocket in place, then remove the tissue.



6. Align the sprocket's inner race holes with the holes in the guide bar nose. Insert rivets into each hole through the guide bar. On used guide bars the nose rails could be spread apart. Use a small clamp to hold the nose rails together when inserting and securing the rivets.



7. With the guide bar and rivets solidly supported on a strong, flat metal surface, carefully peen the rivet heads down with the flat end of a hammer. Be careful to hit only the rivet head. Do not hit the guide bar body — this will pinch the nose sprocket. Rivet heads must be snug and secure while still allowing the drive sprocket to turn freely.



Guide Bar Troubleshooting

Most guide bar problems occur in the guide bar rails, and are caused by four things: lack of lubrication, incorrect saw chain tension, and accidents or irregular operating techniques which pinch the rails or push the drive links sideways against the guide bar rails.

Problem: Guide Bar Rail Conditions

1. Rails are worn down, groove becomes shallow.

Cause: Normal wear on rails.

Symptoms: Chain rides on groove bottom causing drive link damage, chain leans during cutting.

Remedy: Guide bar is at end of life, replace guide bar. If wear occurs too quickly, check for proper lubrication, chain sharpness, guide bar feed load.

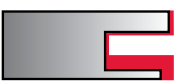
2. Outside edge of rails develop wire edges.

Cause: Normal wear on rails.

Symptoms: Left alone, wire edges can break off and chip away rail material.

Remedy: Use flat file or grinder to square up guide bar's rails and remove wire edges. If wire edges develop too quickly, check for proper lubrication, saw chain sharpness and guide bar feed load.

Note: If using a grinding wheel, direct debris towards tail, then clean out grooves. Grinding debris can cause nose components to wear quickly or jam.

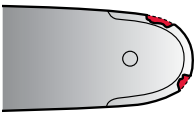


3. Rail on one side is worn thin.

Cause: Damaged or dull cutters on one side (see saw chain section). Saw chain leaning over in a worn groove or using a .063" gauge saw chain in a .080" gauge guide bar.

Symptoms: Incomplete cuts, leading cuts, guide bar bound in the cut.

Remedy: Replace guide bar, check for correct saw chain gauge, replace saw chain if it continues to cut crooked after sharpening (see "How to Sharpen Cutters" on page 23).

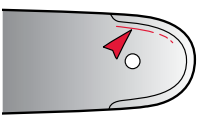


4. Rails around tip of solid-nose guide bars show small cracks or broken-out sections.

Cause: Accidents or irregular operating techniques, which push drive links sideways or place excessive pressure on the nose, can cause breaks or cracks.

Symptoms: Damage to tie-straps and cutters, saw chain throws, short guide bar life.

Remedy: Your dealer may be able to repair minor damage on a relatively new guide bar.

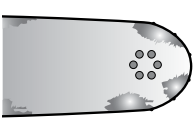


5. Rails around the tip of solid-nose guide bars are split at the bottom of the guide bar groove.

Cause: Accidents or irregular operating techniques which push drive links sideways or place excessive pressure on side of nose can cause breaks or cracks.

Symptoms: Rails spread and chain rides on groove bottom causing drive link damage and saw chain leans during cutting.

Remedy: Your dealer may be able to repair minor damage on a relatively new guide bar.



6. Rails along the guide bar body or around the tip of sprocket nose guide bars show blue discoloration.

Cause: Pinched rails, lack of lubrication, or accidents and improper cutting techniques. These actions can push drive links sideways in the groove, creating extreme friction-generated heat.

Symptoms: Blue spots on rails indicate temperatures reaching 600° F (315° C) and rail softening. Rails wear quickly. Saw chain drive link damage.

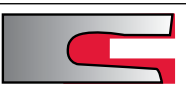
Remedy: Replace guide bar and saw chain.

7. Spread rails.

Cause: (1) Saw chain was struck broadside by tree, log, or branch stub. (2) Saw chain was pushed sideways, forcing drive links to pry guide bar rails apart.

Symptoms: Guide bar will not enter log during cut or cannot make complete cut.

Remedy: (1) Hammer rails together with a drive link in groove as spacer. Adjust saw return to allow guide bar to go farther into saw box. Sharpen delimbing knives. Avoid moving tree/log when guide bar and saw chain are out of saw box. (2) Reduce guide bar feed speed.



8. Rail on one side worn low.

Cause: Damaged or dull cutters on one side, or saw chain leaning over in a worn groove, or using .063" saw chain in .080" guide bar. Most often one short rail is caused by cutters contacting rocks on one side of saw chain, usually the cutters closest to the ground.

Symptoms: Incomplete cuts, leading cuts, guide bar bound in the cut.

Remedy: Replace guide bar. Replace saw chainsaw continues to cut crookedly after sharpening (see "How to Sharpen Cutters" on page 23).

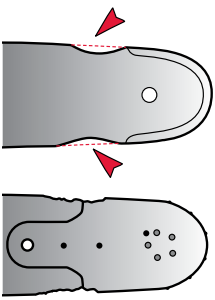
9. Rail chipping in middle of guide bar.

Cause: Excessive pressure on guide bar, excessive guide bar feed speed, cold conditions, lack of lubrication, aggressive saw chain cutting in frozen wood.

Symptoms: Damage to saw chain and reduced guide bar life.

Remedy: Replace guide bar if rail wear is extensive. Decreased guide bar feed force when cutting consists mostly of small-diameter trees. Increase lubrication, especially in cold conditions. Reduce aggressiveness of saw chain when cutting frozen wood.

Problem: Guide Bar Nose Conditions



10. Chipped rails or excessive rail wear just behind hard steel on solid nose guide bars, or near the nose on sprocket nose guide bars.

Cause: Loose saw chain tension.

Symptoms: Saw chain damage, saw chain throwing, shortened guide bar life.

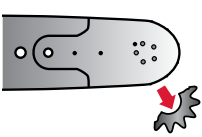
Remedy: Use proper saw chain tension ad invert guide bar on saw periodically to distribute wear.

11. Rails in tip of sprocket-nose guide bar spread, allowing loss of bearings.

Cause: Accidents or irregular operating techniques twist the nose or push drive links sideways against the nose's rails.

Symptoms: Sprocket breakage.

Remedy: Replace sprocket components. Keep guide bar nose away from objects not intended for cutting.

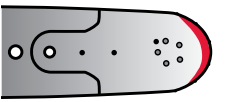


12. Sprocket in sprocket nose guide bar breaks.

Cause: High saw chain tension, accidents, saw chain broadsided by log pulling saw chain out of guide bar rails.

Symptoms: Guide bar nose sprocket no longer functions.

Remedy: Replace sprocket components. Use proper saw chain tension.

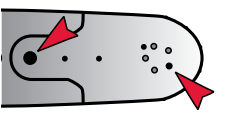


13. Nose burned at tip from saw chain sliding on rails of sprocket nose guide bar, or from the sprocket being recessed into the tip.

Cause: High saw chain tension from automatic saw chain tensioners.

Symptoms: Nose breakage from bearings wearing quickly and jamming.

Remedy: Decrease the tension applied by automatic saw chain tensioner.



14. Loose or missing nose/ attachment rivets.

Cause: Guide bar tip flexing during operation from difficult cutting conditions or accidents.

Symptoms: Rivets continue to loosen until laminates spread and bearings are lost.

Remedy: Check rivets every 100 machine hours. Rehammer loose rivets and replace rivets if rivet head is missing. Always use new rivets.

Professional

For loggers, arborists, orchardists, millwrights, forestry workers, and other highly skilled woodcutters.

LIGHT-WEIGHT PROFESSIONAL

SpeedCut™

For professionals who cut high volumes of wood. Narrow kerf. Durable and efficient. The lighter weight helps reduce operator fatigue.

VersaCut™

For professionals (like arborists) who cut with a variety of applications. Versatile and durable. The lighter weight helps reduce operator fatigue.

ControlCut™

For users who require smooth and controlled cuts. Smaller radius nose reduces kickback. The lighter weight helps reduce operator fatigue.

PROFESSIONAL

PowerCut™

For loggers and other users who require a tough, heavy-use tool. The chrome-moly body helps reduce wear and promotes a longer lifespan.

DuraCut™

Made for challenging cutting environments. Stellite nose and chrome-moly body promotes ultra high-wear resistance.

Occasional User

For homeowners and other occasional users who prize simplicity and reliability for yard work.

AdvanceCut™

For experienced homeowners, as well as farmers and firewood cutters. Multi-rivet nose, light-weight, and maneuverable.

Single Rivet

For homeowners who only have an occasional need to use a chainsaw. The single-rivet, smaller-radius noses helps reduce kickback.

Choosing the Right Guide Bar

For safety and performance, it's essential that you choose the right guide bar. From electric and small gas to the largest professional powerheads, Oregon® has the bar you need - beginning with 8" up to 42". Oregon offers you the broadest selection of guide bars in the industry. Use the chart below to help you choose the right guide bar for your saw.

GOOD

Single Rivet

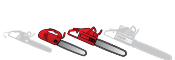
BETTER

AdvanceCut™

BEST

Light-Weight Professional Guide Bars

SpeedCut™ Nano



SpeedCut™ / ControlCut™ / VersaCut™

PowerCut™

DuraCut™

4				0					8			3				
																
.043"				.050"					.058"			.063"				
325"	3/8"	1/4"	3/8"	325"			3/8"		325"	3/8"	.404"	325"	3/8"		.404"	
	90	25	91													
			91	95	20		72		21	73		22	75			
80																
				95	20		72		21	73		22	75			
					20		72		21	73	58	22	75	59	27	68
							72			73	58		75	59	27	68

Using the Guide Bar Number System

Our 10 or 11-digit guide bar part numbers are printed on the guide bar package and etched on the guide bar body. Here's what each digit means:

18 0 EXL D K095

Length		Gauge
8"	24"	4 = .043"
10"	25"	0 = .050"
11"	26"	8 = .058"
12"	27"	3 = .063"
13"	28"	
14"	30"	
15"	32"	
16"	33"	
18"	34"	
20"	36"	
21"	37"	
22"	42"	

Type

SpeedCut™ Nano

TXL	SpeedCut Nano

SpeedCut™, ControlCut™, VersaCut™

TXL	SpeedCut
PXL	ControlCut
VXL	VersaCut

PowerCut™

EXL	Replaceable sprocket-nose
RN	Replaceable sprocket-nose
PM	Replaceable sprocket-nose
RW	Replaceable sprocket-nose

DuraCut™

DXL	Solid nose, laser welded tip with wear-resistant alloy
AT	Solid nose, laser welded tip with wear-resistant alloy

AdvanceCut™

SX	Sprocket-nose
PX	Sprocket-nose
GD	Sprocket-nose with Guard Mate® holes
ML	Narrow kerf sprocket-nose
SF	Sprocket-nose

Single Rivet

SD	Sprocket-nose
DG	Sprocket-nose with Guard Mate holes
ML	Narrow kerf sprocket-nose

In a few cases where two guide bars would have the same length in their part numbers but different drive link counts, the letter Z will be used in the guide bar mount description to distinguish between them (K095 and Z095 for example).

Chainsaws originally equipped with an Intenz® guide bar, and chainsaws adapted to take an Intenz guide bar, do not have a "guide bar-adjustment pin" for tensioning the saw chain. Use ONLY an Intenz guide bar when replacing the guide bar on these chainsaws. See page 21 for important information on Intenz guide bars.

Sprocket Nose			
Pitch		Tooth Count	Bar Mount
A	1/4"	10	A041
B	.325"	10 or 12	A061
D	**3/8"**	9 or 11	A074
E	3/8"	7 or 9	A089
F	.404"	10	A095
G	.325"	12	A218
H	3/8"	11	A318
N	.325"		D009
			D024
Solid Nose Code			D025
M	Medium (1.33")		D033
			D096
			D176
			D196
			E031
			K041
			K095
			K216
			Z095
			Intenz®
			T041
			T095
			T218
			T318

PowerCut™ solid body guide bars may be stamped with XXX, ZZZ or other letters as they can have different noses installed on the body, thereby changing the part number.

Guard Mate® holes are built into the noses of certain types of Oregon® guide bars and allow the attachment of a Guard Mate tip guard to help reduce the risk of kickback.

Oregon Sculptor™ carving bar part numbers do not follow the Oregon bar part numbering system.

Guide Bars – Light-Weight Professional

SpeedCut™, VersaCut™, ControlCut™

16 0 TXL B K095

Lengths (in)
13
15
16
18
20

SpeedCut Guide Bar Code
TXL = SpeedCut, Narrow Kerf, Sprocket-Nose

Gauge
0 = .050"

Nose Alpha Code & Sprocket Tooth Counts

B	G
10	12

Chain Type by Pitch
.325"
95TXL

Tail Mounts
A074
D025
K095

18 0 VXL G K095

Lengths (in)
13
15
16
18
20
24

VersaCut & ConrolCut Guide Bar Codes
VXL = VersaCut, Sprocket-Nose
PXL = ControlCut, Sprocket-Nose

Gauges

	.325"	3/8"
0 = .050"	20	72
8 = .058"	21	73
3 = .063"	22	75

Nose Alpha Code & Sprocket Tooth Counts

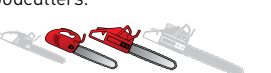
B	**G**	H
10	12	11

Chain Types by Pitch

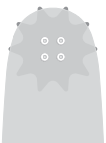
Tail Mounts
A041
A074
D009
D024
D025
D176
K041
K095
K216

These completely re-designed light-weight professional guide bars are lighter, stronger and longer lasting. Designed for top performance for professional woodcutters.

Recommended Saw Sizes –
Up to 2.3 – 4.0 cu. in (38 – 65 cc)

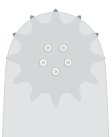


TXLB SpeedCut™ • 325" Pitch



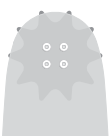
Tooth Count	10				
Motor Mount	A074	D025	K041	K095	K216
Bar Length	16–18"	13"	16–18"	13–20"	14–18"

TXLG SpeedCut • 325" Pitch



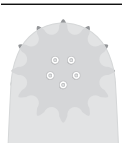
Tooth Count	12			
Motor Mount	D025	K041	K095	K216
Bar Length	15–20"	16–18"	15–20"	16–20"

PXLB ControlCut™ • 325" Pitch



Tooth Count	10			
Motor Mount	A074	D025	K041	K095
Bar Length	16–18"	13"	13, 15"	13–18"

VXLG VersaCut™ • 325" Pitch



Tooth Count	12			
Motor Mount	D025	K041	K095	K216
Bar Length	15–20"	15–18"	15–20"	16–20"

VXLH VersaCut • 3/8" Pitch

Tooth Count	11				
Motor Mount	D009	D024	D025	D176	K095/ Z095
Bar Length	15–24"	16–20"	15–24"	16–20"	15–20"

SpeedCut™ Nano

16 4 TXL N A074

Lengths (in)	Gauges	SpeedCut Nano Guide Bar Codes	Nose Alpha Code & Sprocket Tooth Counts	Tail Mounts
10 12 14 **16**	**4** = .043"	**TXL** = SpeedCut Nano, System Guide Bar	**N** 7	**A074** A095
		Chain Types by Pitch	.325" Low Profile	
			80	

Power through the day with a guide bar engineered specifically for 80TXL saw chain. Designed for professionals, the high-strength body and performance-driven nose components are constructed to exacting tolerances. When the job demands accurate cuts with unmatched speed and endurance to run all-day without downtime, professionals choose SpeedCut Nano.

SpeedCut Nano guide bars must be used together with the corresponding 80TXL saw chain and sprocket and are not compatible with other existing cutting systems.

Recommended Saw Sizes – 2.3 cu. in (38 cc) and larger

SpeedCut™ Nano • 80TXL • Conversion Chart

Drive Links	Guide Bar Length & P/N		Sprocket 7T	Conversion Kit
Stihl®				
MS201T, 200, 193T, 192				
46	10"	**104TXLNA074**	**610725**	**614379**
51	12"	**124TXLNA074**	**610725**	**614380**
59	14"	**144TXLNA074**	**610725**	**614377**
64	16"	**164TXLNA074**	**610725**	**614381**
MS180, 170, 171				
59	14"	**144TXLNA074**	**610726**	**614384**
64	16"	**164TXLNA074**	**610726**	**614385**
MS150				
51	12"	**124TXLNA074**	**610727**	**614383**
59	14"	**144TXLNA074**	**610727**	**614382**
Husqvarna®				
540				
46	10"	**104TXLNA095**	**610728**	**614387**
51	12"	**124TXLNA095**	**610728**	**614390**
59	14"	**144TXLNA095**	**610728**	**614393**
64	16"	**164TXLNA095**	**610728**	**614397**
T435				
46	10"	**104TXLNA095**	**610729**	**614388**
51	12"	**124TXLNA095**	**610729**	**614391**
59	14"	**144TXLNA095**	**610729**	**614395**
64	16"	**164TXLNA095**	**610729**	**614398**
T536LiXP				
46	10"	**104TXLNA095**	**610730**	**614389**
51	12"	**124TXLNA095**	**610730**	**614392**
59	14"	**144TXLNA095**	**610730**	**614396**
64	16"	**164TXLNA095**	**610730**	**614399**

PowerCut™

18 0 EXL D K095

Lengths (in)

13, 15
16, 17
18, 20
21, 22
24, 25
26, 28
30, 32
33, 34
36, 37
42

PowerCut Guide Bar Codes

EXL = Replaceable Sprocket-Nose

RN = Replaceable Sprocket-Nose

Nose Alpha Code & Sprocket Tooth Counts

B	**D**	F
12	11	10

Tail Mounts

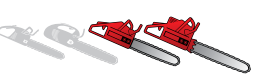
D009
D024
D025
D033
D176
D196
E031
K041
K095
Z095

Chain Types by Pitch

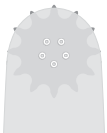
Gauges	.325"	3/8"	.404"
0 = .050"	20	**72**	
8 = .058"	21	73	58
3 = .063"	22	75	27, 59, 68

For loggers and other tree-cutting professionals that need heavy-use guide bars. PowerCut's chrome-moly steel body is tough and powerful, enabling you to cut through timber precisely and efficiently. The replaceable sprocket nose reduces the need for new guide bars, giving the PowerCut bar a longer life and greater durability.

Recommended Saw Sizes – 3.5 cu. in (58 cc) and larger



RNB • .325" Pitch

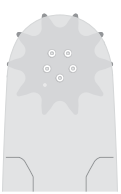


Tooth Count	12		
Motor Mount	D025	K041	K095
Bar Length	16–18"	16–18"	15–20"

RND / RWD / PMD • 3/8" Pitch

Tooth Count	11				
Motor Mount	D009	D025	D033	D176 K095	D196
Bar Length	13–42"	16–42"	20"	16–28"	16–24"

RNF / PMF • .404" Pitch



Tooth Count	10		
Motor Mount	D009	D025	E031
Bar Length	16–18"	13"	13, 15"

DuraCut™

20 0 DXL M K095

Lengths (in)

16
18
20
24

DuraCut Guide Bar Code

DXL = Solid Nose, Laser Welded Tip with Wear-Resistant Alloy

Solid Nose Alpha Code

M = Medium (1.33")

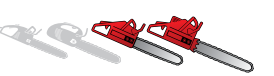
Tail Mounts

D009
D025
D176
K095
Z095

Gauges	Chain Types by Pitch .325"	3/8"	.404"
0 = .050"	20	**72**	
8 = .058"	21	73	58
3 = .063"	22	75	27, 59, 68

Created for all challenging and abrasive environments, including fire-damaged forests, deserts, or sandy environments, and areas where the wood is unstable and requires extra care. DuraCut has an ultra high-wear resistant stellite nose and chrome-moly steel body to give you a longer-lasting tool for the most punishing environments.

Recommended Saw Sizes – 2.3 cu. in (38 cc) and larger



ATM

Tooth Count	—			
Motor Mount	D009	D025	D176	K095/ Z095
Bar Length	16–24"	16–24"	20, 24"	16–20"

AdvanceCut™

15 0 ML B K095

Lengths (in)

12
13
14
15
16
18
20
24

AdvanceCut Guide Bar Codes

SX = Sprocket-Nose
PS = Sprocket-Nose
GD = Sprocket-Nose with Guard Mate® Holes
ML = Narrow Kerf Sprocket-Nose
SF = Sprocket-Nose

Nose Alpha Code & Sprocket Tooth Counts

E	B	**G**	D	H
9	10	12	9	11

Tail Mounts

A041
A074
A095
A318
D009
D025
D096
D176
K041
K095

Intenz
T041

Gauges	Chain Types by Pitch 3/8 LP	.325"	3/8"
0 = .050"	91	**20,95**	72
8 = .058"		21	73
3 = .063"		22	75

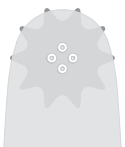
Exceptional tool for homeowners who regularly cut trees on their properties or yards, as well as farmers and firewood cutters. AdvanceCut is for experienced users who need power and reliability in challenging yard conditions. The multi-rivet nose gives you durability, and AdvanceCut's maneuverability and light-weight help you get the job done quickly.

Recommended Saw Sizes –
Up to 3.5 cu. in (57 cc)

SXE • .3/8"Low Profile Pitch

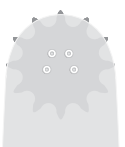
Tooth Count	9			
Motor Mount	A041	A074	A095	A318
Bar Length	10–16"	12–16"	12–16"	14, 16"

PXB / MLB / GDB • .325" Pitch



Tooth Count	10		
Motor Mount	A074	K041	K095
Bar Length	16, 18"	13–20"	13–20"

SFG • .325" Pitch

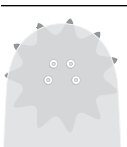


Tooth Count	12		
Motor Mount	D025	K041	K095
Bar Length	16–20"	16–18"	16–20"

PXD / GDD • 3/8" Pitch

Tooth Count	9			
Motor Mount	D096	D176	K041	K095
Bar Length	16, 20"	16–20"	20"	16"

SFH / GDH • 3/8" Pitch



Tooth Count	11		
Motor Mount	D009	D025	K095
Bar Length	16–24"	16–24"	16–20"

Single Rivet

16 0 SD E A041

Lengths (in)

8
10
12
14
16
18

Gauge

4 = .043"
0 = .050"

Single Rivet Guide Bar Codes

SD = Sprocket-Nose
DG = Sprocket-Nose with Guard Mate® Holes
ML = Narrow Kerf Sprocket-Nose

Nose Alpha Code & Sprocket Tooth Counts

A	**E**
10	7

Chain Type by Pitch

1/4"	3/8 LP
	90
25	**91**

Tail Mounts

A041
A061
A074
A095
A218
A318
Z041
Z095

Intenz®
T041
T218

For homeowners who only have an occasional need to use a chainsaw. You value quality and reliability, and you're willing to do the tougher yardwork yourself. Single rivet guide bars are safe and maneuverable, with less kickback. They make working on your property quick and easy.

Recommended Saw Sizes –
Electric or gas up to 2.5 cu. in (41 cc)

SDA • 1-4" Pitch

Tooth Count	10		
Motor Mount	A041	K041	K095
Bar Length	8–14"	16–18"	15–20"

MLE • 3/8" Low Profile Pitch

Tooth Count	7		
Motor Mount	A041	A074	A218
Bar Length	8–16"	12–16"	10–12"

SDE / DGE • 3/8" Low Profile Pitch

Tooth Count	7				
Motor Mount	A041	A061 A074 A318	A095	A108	A218
Bar Length	8–18"	12–16"	12–18"	10	10–12

Guide Bars – Carving

Sculptor™

Lengths (in)		Solid Nose and Saw Chain Dime Tip (10mm) Quarter Tip (12mm)		Tail Mounts
10 12 14		Chain Types		Multi-Mount: A041 A074 A095
	Gauge	1/4"	3/8 LP	
	0 = .050"	25A (25F)	91VXL	

An essential tool for chainsaw artists seeking long-lasting performance and versatility.

- Manufactured with high-quality steel
- Precision gas-welded high cobalt/chrome alloy hard-facing material for better nose performance and life
- Clear-coated, brushed steel for distinctive and durable appearance and finish

Recommended Saw Sizes –
Up to 2.3 – 4.0 cu. in (38 – 65 cc)

Dime Tip

	Motor Mount	041 / 095			074		
	Bar Length	10" 25 cm	12" 30 cm	14" 35 cm	10" 25 cm	12" 30 cm	14" 35 cm
Drive Link Count:	25A 25F	60	68	76	60	68	75

Quarter Tip

	Motor Mount	041 / 095		074	
	Bar Length	12" 30 cm	14" 35 cm	12" 30 cm	14" 35 cm
Drive Link Count:	25A & 25F	68	76	68	75
	91VXL	47	52	47	51

A041

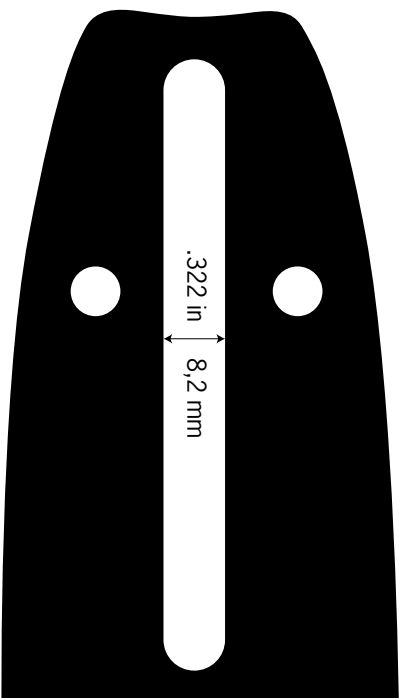
OEM Applications

Craftsman®, Cub Cadet®, Dolmar®, Homelite®, Husqvarna®, John Deere, Jonsered®, Makita®, McCulloch®, Poulan®/Poulan Pro®, Redmax®, Sears®, Shindaiwa®, Skil®, Snapper®, Tanaka®, Toro®, and others

A041

T041	Intenz® mount

- Carlton® mount – 10
- Windsor® mount – PKU



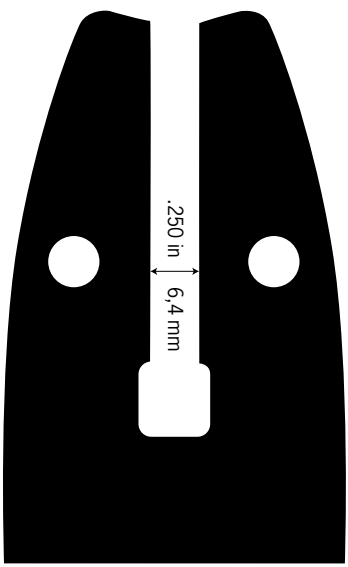
A061

OEM Applications

Homelite®

A061

- Carlton® mount – 28
- Windsor® mount – MXL



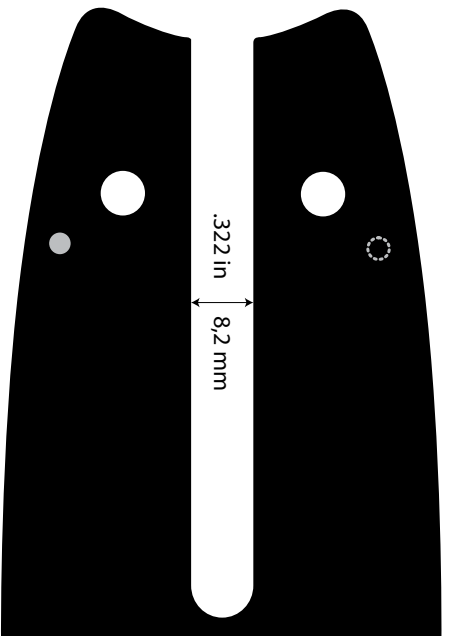
A074

OEM Applications

Stihl®, Olympyk (Oleo-Mac®)

A074

- Carlton® mount – 26
- Windsor® mount – ST



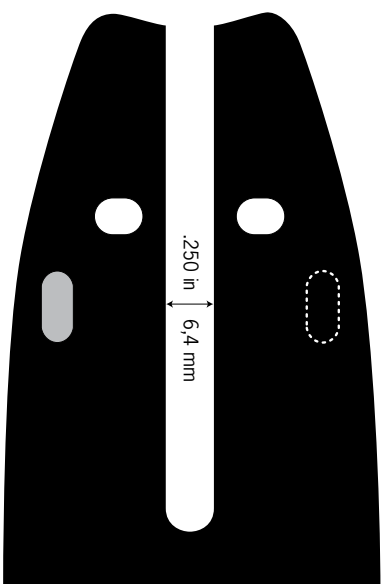
A089

OEM Applications

Remington®

A089

- Carlton® mount – 39



A095

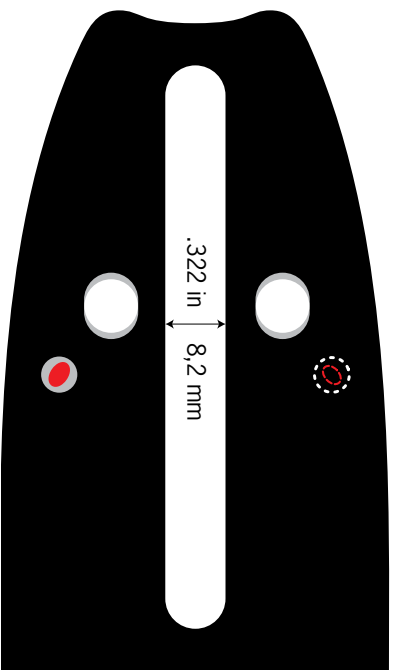
OEM Applications

Cub Cadet®, Dolmar®, Homelite®, Husqvarna®, John Deere, Jonsered,® Makita®, Maruyama pole saws, McCulloch®, Olympyk (Oleo-Mac®) Partner, Pioneer, Poulan®/Poulan Pro®, Redmax®, Sears®, Solo®, Stanley®, and others

A095

T095 Intenz® mount

- Carlton® mount – 01
- Windsor® mount – CJL



A218

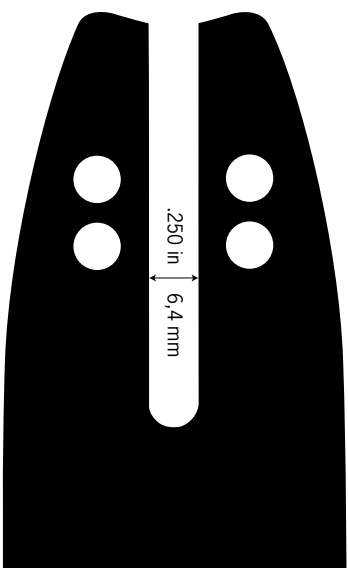
OEM Applications

Black+Decker®, Maruyama pole saws, Power Pruner/Echo® Power Pruner, Redmax® pole saws

A218

T218 Intenz® mount

- Carlton® mount – 29



A318

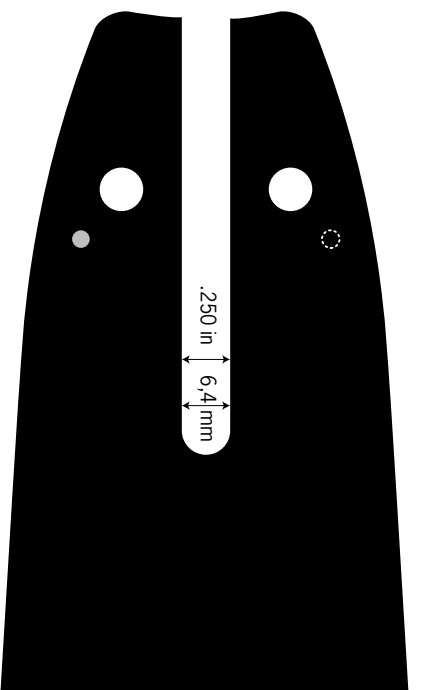
OEM Applications

McCulloch®, Remington®

A318

T318 Intenz® mount

- Carlton® mount – 38
- Windsor® mount – MC



K041

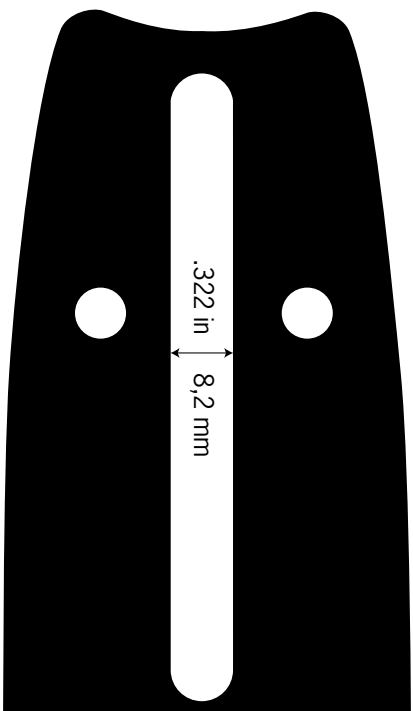
OEM Applications

Craftsman®, Cub Cadet®, Dolmar®, Homelite®, Husqvarna®, John Deere, Jonsered®, Makita®, McCulloch®, Poulan®/Poulan Pro®, Redmax®, Sears®, Shindaiwa®, Skil®, Snapper®, Tanaka®, Toro®, and others

K041

T041 Intenz® mount

- Carlton® mount – 10W
- Windsor® mount – PKU



K095

OEM Applications

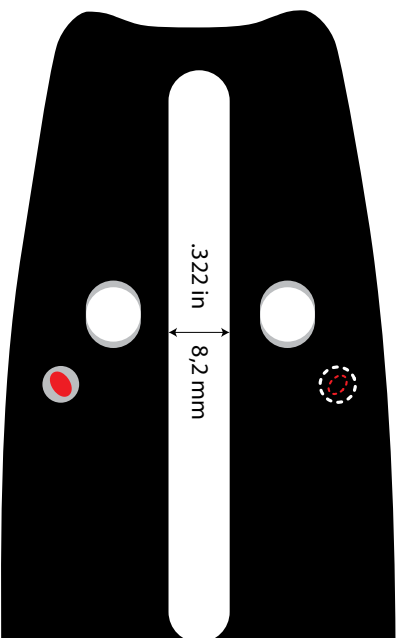
Cub Cadet®, Dolmar®, Homelite®, Husqvarna®, John Deere, Jonsered®, Makita®, Maruyama pole saws, McCulloch®, Olympyk (Oleo-Mac®) Partner, Pioneer, Poulan®/Poulan Pro®, Redmax®, Sears®, Solo®, Stanley®, and others

K095*

Z095*

- Carlton® mount – 01W
- Windsor® mount – CJL

***Note**: In a few cases where two bars would have the same called length but different drive-link counts, the letter Z will be used in the motor-mount description to distinguish between them (K095 and Z095 for example)

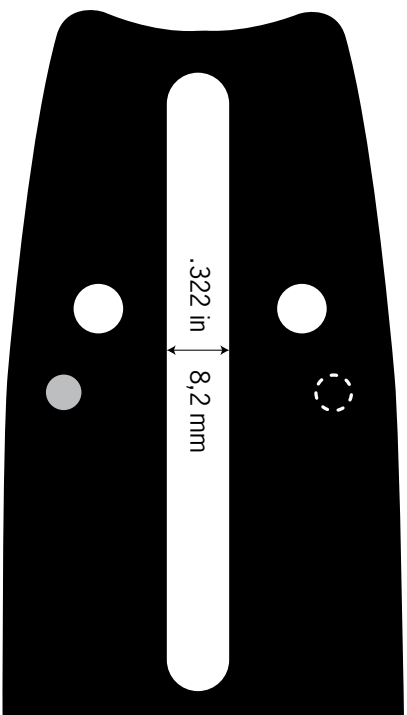


K216

OEM Applications

Echo®

K216



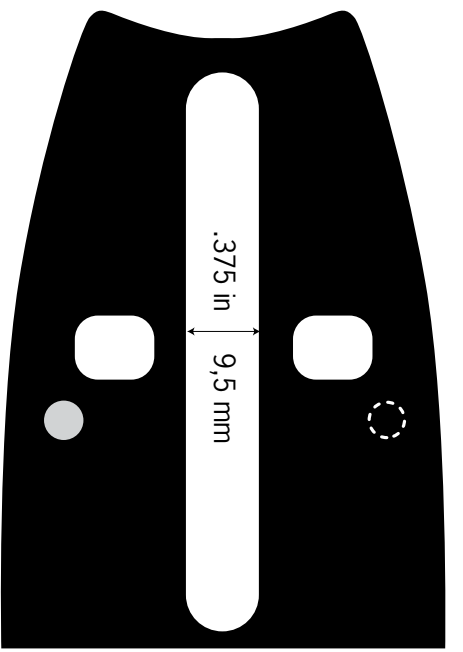
D007

OEM Applications

Pioneer, Poulan®/Poulan Pro®

D007

- Carlton® mount – 21
- Windsor® mount – PP



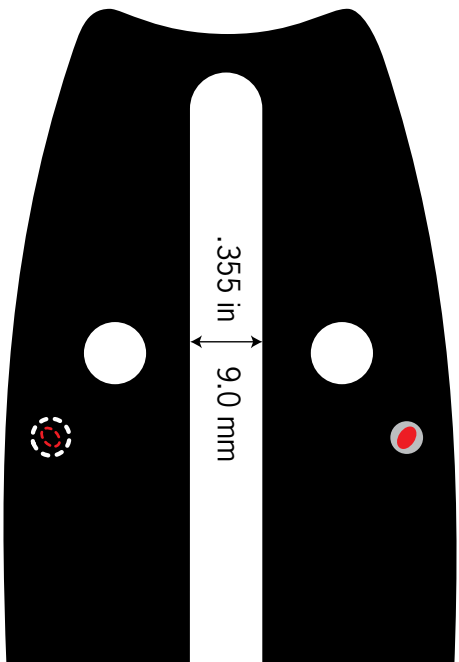
D009

OEM Applications

Dolmar®, Husqvarna®, Jonsered®, Makita®, Partner, Shindaiwa®, Solo®

D009

- Carlton® mount – 81
- Windsor® mount – EM



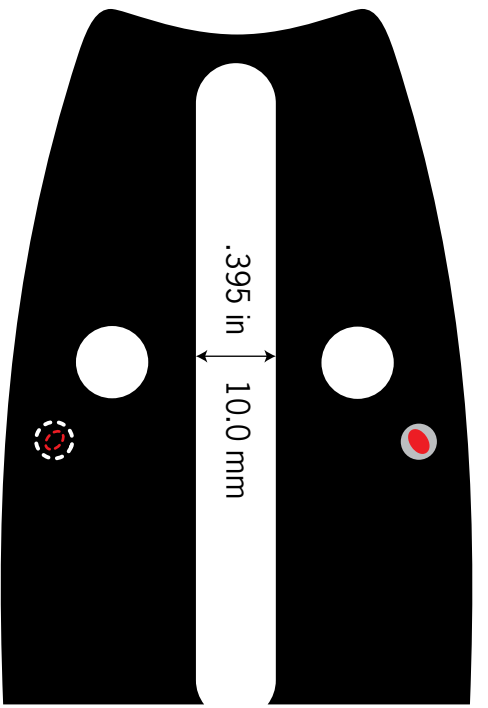
D024

OEM Applications

Jonsered®, Olympyk (Oleo-Mac®)

D024

- Carlton® mount – 71
- Windsor® mount – JR



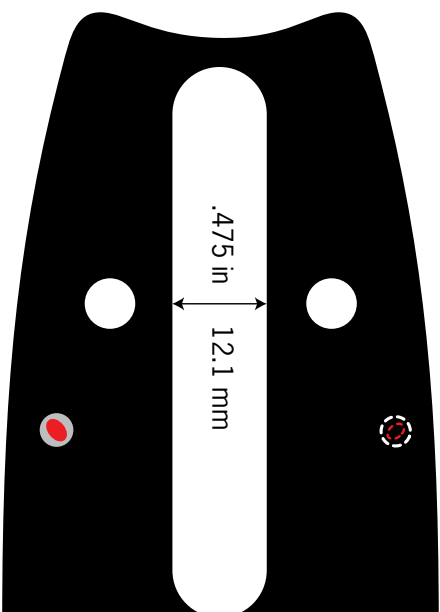
D025

OEM Applications

Stihl®

D025

- Carlton® mount – 42
- Windsor® mount – 40



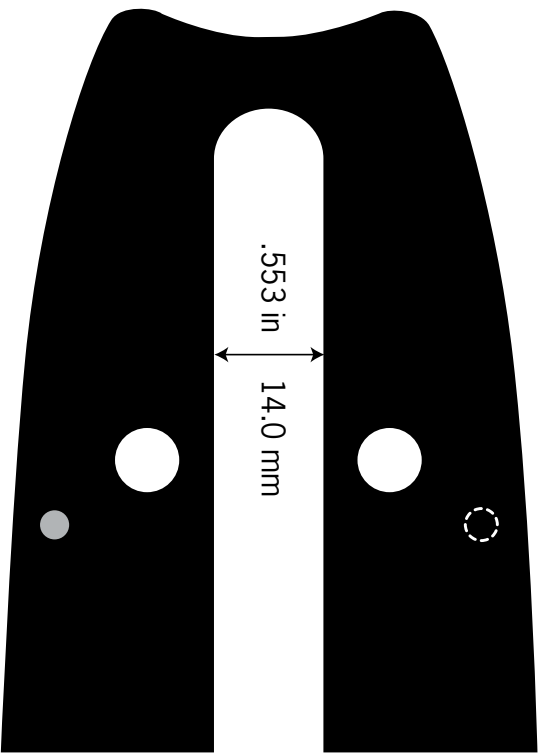
D033

OEM Applications

Dolmar®

D033

- Carlton® mount – 55



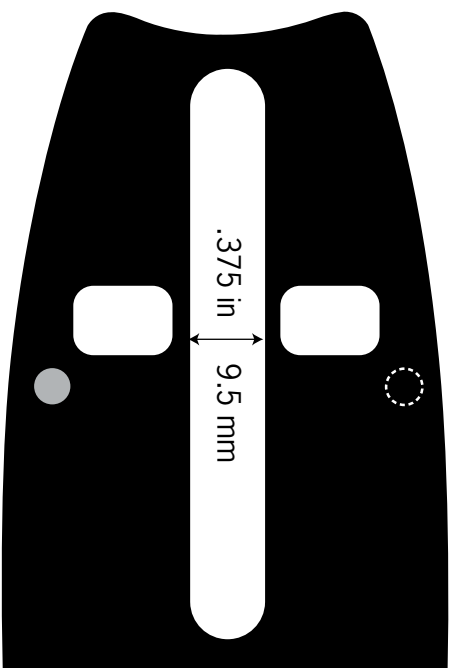
D096

OEM Applications

Echo®, Homelite®, John Deere, Jonsered®, Olympyk (Oleo-Mac®), Poulan®/Poulan Pro®, Remington®

D096

- Carlton® mount – 21
- Windsor® mount – HL



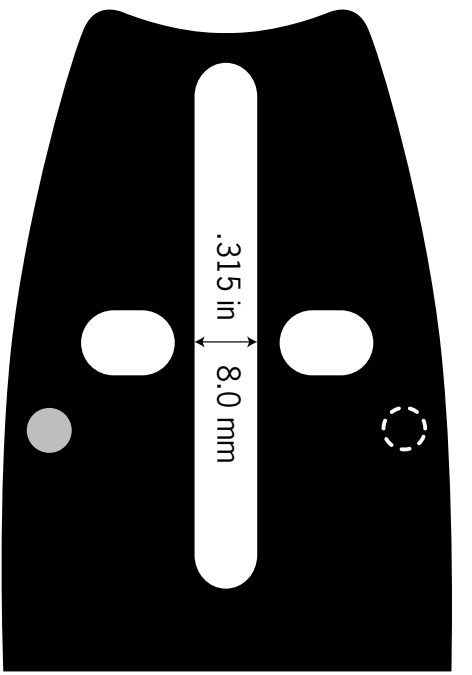
D176

OEM Applications

Echo®, Fairmont®, John Deere, McCulloch®, Poulan®/Poulan Pro®, Redmax®, Sears®, Skil®, Tanaka®

D176

- Carlton® mount – 41
- Windsor® mount – UXL



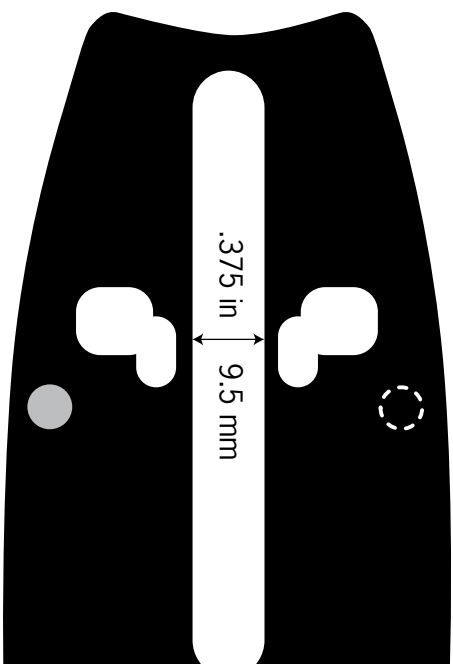
D196

OEM Applications

Echo®, Homelite®, John Deere, Jonsered®, Olympyk (Oleo-Mac®), Poulan®/Poulan Pro®, Remington®, Stanley®

D196

- Carlton® mount – 21
- Windsor® mount – HL



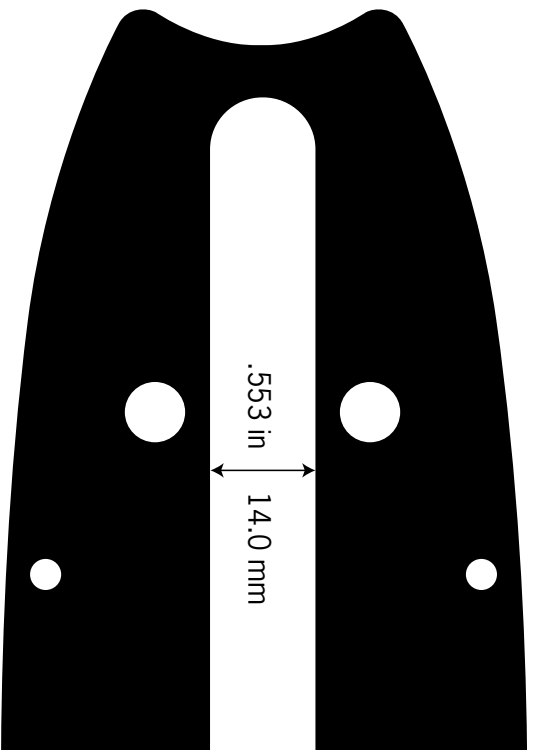
E031

OEM Applications

Stihl®

D176

- Carlton® mount – 55
- Windsor® mount – 07



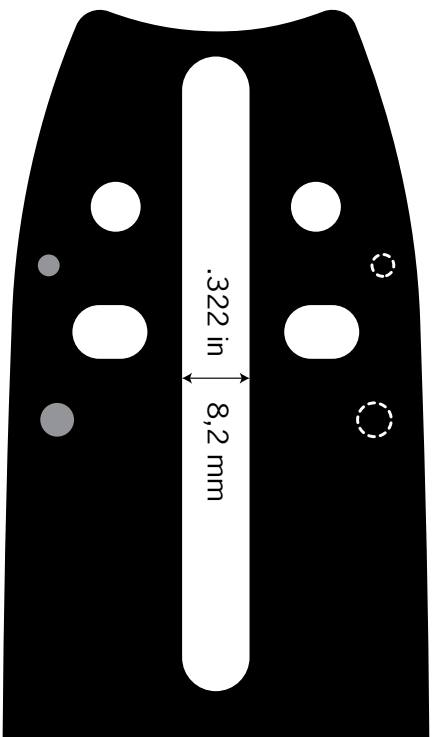
A041 / A074 / A095

Sculptor™ Specialty Mount

OEM Applications

Multi-mount fits most popular chainsaws used for carving
Echo®, Husqvarna®, Stihl® and others

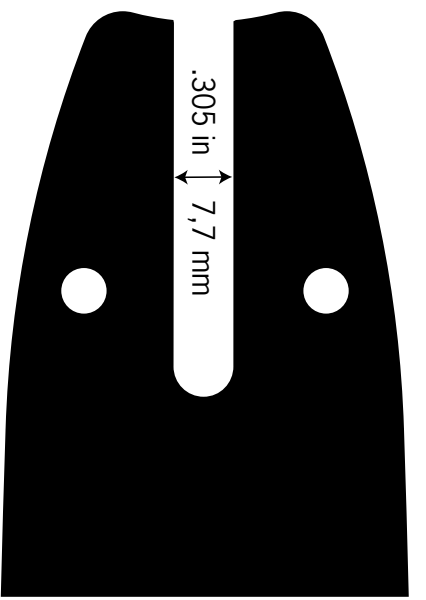
SCULPTOR mount **A041 / A095**



A108

OEM Applications

Unitec and Cob Industry Hydraulic saws



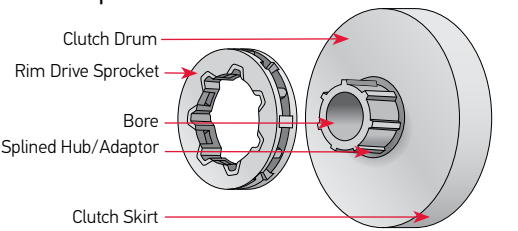
OREGON®

Safety & Maintenance Manual

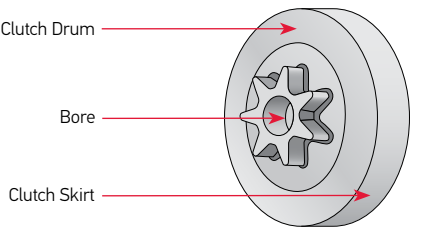
Drive Sprockets

Drive Sprocket Terms

Rim Drive Sprocket

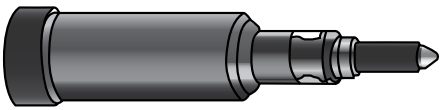


Spur Drive Sprocket



Drive Sprocket Maintenance Tools

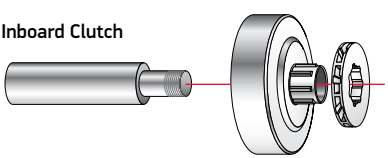
Grease Gun



Installing Drive Sprockets

Oregon® drive sprockets can be installed on chainsaws having either inboard-clutch or outboard-clutch assemblies. Follow instructions in the operator's manual provided by your chainsaw's manufacturer for correct drive sprocket installation. The illustrations below are for general reference only. Do not use them as instructions for drive sprocket or clutch assembly.

Inboard Clutch



Outboard Clutch

Drive Sprocket Maintenance

ATTENTION: DEALERS, CHAINSAW USERS, AND ANYONE WHO SERVICES SAW CHAIN. IMPORTANT SAFETY INFORMATION.

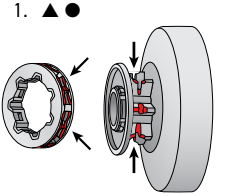
⚠ **WARNING:** Always turn off your chainsaw's engine before handling the drive sprocket. Failure to do so can result in severe injury.

Your drive sprocket, the third member of the cutting team, deserves regular attention and maintenance just like your guide bar and saw chain. A misused drive sprocket will cause patterns of saw chain wear which can damage the guide bar and reduce the life of all three components. A damaged drive sprocket cannot be repaired, it can only be inspected and replaced. Here are the things to look for, and the steps to take.

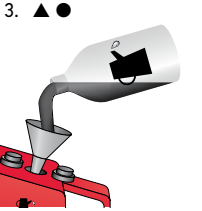
Basic Drive Sprocket Maintenance Tasks

▲ Before each use	● Daily
■ Often (Hourly, or at refueling)	◆ Weekly, periodically

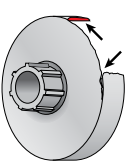
1. ▲ ●



3. ▲ ●



2. ▲ ●



4. ▲ ■

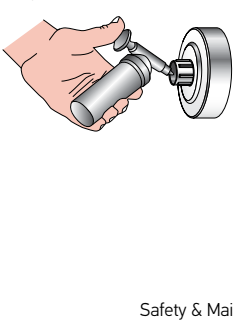
5. ▲ ■ Saw chain tension is especially important when the chainsaw is tipped on its side during felling cuts. Loose saw chain (and rim-type drive sprocket, if used), will slide down and out of alignment with the guide bar. Loose saw chain tension is the leading cause of drive sprocket problems.

Note: If your chainsaw has a saw chain brake, check the saw chain brake's action according to the instructions in your chainsaw operator's manual. Be sure the saw chain brake strap around your clutch skirt is not too tight, which can lead to clutch drum overheating and failure.

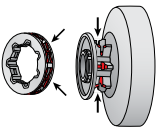
6. ● Clean any build-up of sap or debris from splined hub so rim drive sprocket can float freely.

7. ◆ Do not run old saw chain on a new drive sprocket, or a new saw chain on an old drive sprocket*. Use two new saw chains in rotation with each new drive sprocket so all can wear together. Replace drive sprocket every two saw chains, or sooner.

8. ◆ Apply clean lithium-based grease to the clutch drum's bearings each time the drive sprocket is removed.

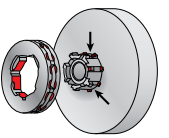


Drive Sprocket Troubleshooting



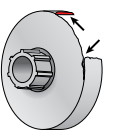
Worn outer surfaces on rim drive sprockets or spur drive sprockets.

Remedy: Such outer surface wear is normal over time. Replace rim drive sprockets and spur drive sprockets when wear is 1/64" (0.4 mm) deep. Never run saw chain on severely worn drive sprockets. Severely worn drive sprockets could break during operation.



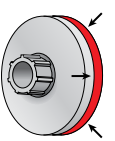
Worn inner surface on rim drive sprockets or wear on the adaptor's splines.

Remedy: Such wear indicates that saw chain drive links are bottoming out on the adaptor's splines. Replace the clutch drum. Replace the rim drive sprocket..



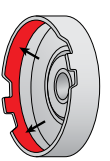
Cracks or breakage on the clutch drum.

Remedy: Do not attempt to repair cracked or broken clutch drums. Replace the drum.



Obvious wear or discoloration around the outer circumference of the drum skirt.

Remedy: Replace the drum. Have your chainsaw dealer adjust the saw chain brake strap.



Excessive wear on the inside surface of the drum skirt.

Remedy: Replace the drum. Have your chainsaw dealer service the chainsaw's clutch.

Notes

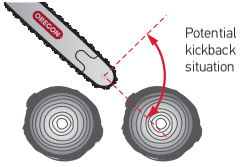
Filing & Grinding Angles

*When using an Oregon® Filing Guide, ALWAYS hold it level, 0°, flat on the top plate. Part numbers printed in red have been obsoleted. Contact your authorized Oregon distributor for availability. ❀ Square Ground Filing: A 15° cutting edge is the result when the file is held at 45° top-plate angle and 45° down angle.

For filing and grinding terminology, visit page 18.

		Pro Code	Retail Code	X Filing | X Grinding	A	B*	C	D
1/4	.050"	25AP	A	5/32" 4.0 mm | 1/8"	30°	10°	55°	.025" .65 mm
	.043"	90PX, 90SG	R	4.5 mm | 1/8"	30°	0°	55°	.025" .65 mm
3/8 Low Profile	.050"	91P, 91PX, 91PXL,	S	5/32" 4.0 mm | 1/8"	30°	0°	55°	.025" .65 mm
	.050"	91VXL, M91VXL	T	5/32" 4.0 mm | 1/8"	30°	0°	55°	.025" .65 mm
.325 Low Profile	.043"	80TXL	—	5/32" 4.0 mm | 1/8"	25°	10°	70°	.025" .65 mm
.325	.050"	95VPX, 95TXL	G, M	3/16" 4.8 mm | 3/16"	30°	10°	55°	.025" .65 mm
	.050"-.058"-.063"	20-21-22BPX, M20-21-22BPX	H, J, L	3/16" 4.8 mm | 3/16"	30°	10°	55°	.025" .65 mm
	.050"-.058"-.063"	20-21-22LPX, M20-21-22LPX	Q, V	3/16" 4.8 mm | 3/16"	25°	10°	55°	.025" .65 mm
3/8	.050"-.058"-.063"	72-73-75V	D, P	7/32" 5.5 mm | 3/16"	25°	10°	55°	.025" .65 mm
	.050"-.058"-.063"	72-73-75CJ, CK, CL, CJK, CKX, CLX	—	❀	45°	45°	—	.025" .65 mm
	.050"-.058"-.063"	72APX, 72-73-75DPX, M72-73-75DPX	—	7/32" 5.5 mm | 3/16"	30°	10°	55°	.025" .65 mm
	.050"-.058"-.063"	72-73-75EXL, EXJ, LGX, JGX, LPX, JPX, M72-73-75LPX	E, B	7/32" 5.5 mm | 3/16"	25°	10°	55°	.025" .65 mm
	.050"-.058"-.063"	72-73-75RD	—	7/32" 5.5 mm | 3/16"	10°	10°	50°	.025" .65 mm
.404	.063"	27X, 27AX	—	7/32" 5.5 mm | 3/16"	30°	10°	55°	.030" .75 mm
	.063"	27R, RA, 27RX	—	7/32" 5.5 mm | 3/16"	10°	10°	50°	.030" .75 mm
	.058", .063"	58CJ, CL, 59CJ, CK, CL	—	❀	45°	45°	—	.025" .65 mm
	058"-.063"	58-59J, L	—	7/32" 5.5 mm | 3/16"	25°	10°	55°	.025" .65 mm
	.063"	68LX, JX	—	7/32" 5.5 mm | 3/16"	25°	10°	55°	.030" .75 mm
	.063"	68CJ, CL	—	❀	45°	45°	—	.030" .75 mm

Avoiding Kickback Injury



- Be alert at all times to guard against a possible kickback reaction. Always be aware of the position of your guide bar's nose.
- Different models of saw chain are available for most cutting tasks. Use the saw chain, suitable for your type of cutting, with the lowest kickback potential.
- Small radius tip guide bars such as our ControlCut® guide bars are recommended for maximum kickback safety.

Four Basic Saw chain Rules

Rule Number 1
Ensure Correct Tension

More saw chain and guide bar problems are caused by incorrect saw chain tension than by any other single factor.

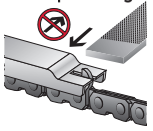
Rule Number 2
Keep Your Saw lubricated

A constant supply of oil to your chainsaw's guide bar, saw chain and drive sprocket is vital. Without it, excessive friction, wear, and damage will occur.

Rule Number 3
Keep Your Saw Sharp

When your saw chain is sharp, it does the work. When it's not, you do the work — your guide bar and sprocket will wear more rapidly.

Rule Number 4
Set Depth Gauges Correctly



Depth gauge setting and depth gauge shape are critical to performance and safety.

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