

ASSEMBLY AND OPERATION INSTRUCTIONS FOR MODEL 281 FOLEY SETTER

I. Assembly

Place setter on work bench about 26" in height. This will enable you to operate setter while seated. Be sure that lighting conditions are good. The front of setter should be even with edge of bench. Drill two holes in bench so that the trip will extend through one and the spring tube will extend through the other. Fasten setter on bench by two screws extending through the base. Attach foot pedal to floor directly below setter. Then connect foot pedal to setter with adjustable rod. See that rod is long enough so that foot pedal just clears floor when setter hammer is tripped.

II. Operation

The setter is designed so that both sides of saw can be set while in hand saw carrier of Foley Filer. Place saw on setter's table rest, press down on foot pedal and raise hammer. Then place tooth of saw, which is to be set, directly under the center of the hammer. Loosen thumb screw on back of table rest and adjust indicator so that point fits into V of second tooth away from hammer. Then tighten thumb screw to hold indicator in position.

The force of the hammer blow is controlled by adjusting the wing screw at the bottom of spring tube under the bench. Setting heavier gauge saws is done by turning wing screw up (which increases hammer impact). For lighter gauge saws turn wing screw down (reduces hammer impact).

Be sure to set the top portion of tooth only. This is very important. Set should never go deeper than half the tooth length, even on fine toothed saws. Too deep a set is likely to crack or break teeth. The amount of set is controlled by moving saw table rest forward for heavier set and back for lighter set. Slotted screws at each end of saw rest must be loosened in order to get necessary back and forward movement.

Start at handle end of saw and set first tooth. Proceed across with saw so as to set every other tooth. The tooth indicator is used as an aid for proper feeding. Then turn saw over, adjust tooth indicator if necessary, and set opposite teeth of saw in the same manner.

This setter enables you to obtain a positive set, insuring a smooth cutting saw, one on which the cutting edge of teeth will stay sharp longer. Always use feed indicator for it will help in obtaining speed and accuracy. As soon as you have become familiar with this machine, you will be able to set saws more quickly and efficiently than by any other method.

III. Suggested Methods

In order to obtain the perfect job of saw filing demanded for quality workmanship, we suggest as follows:

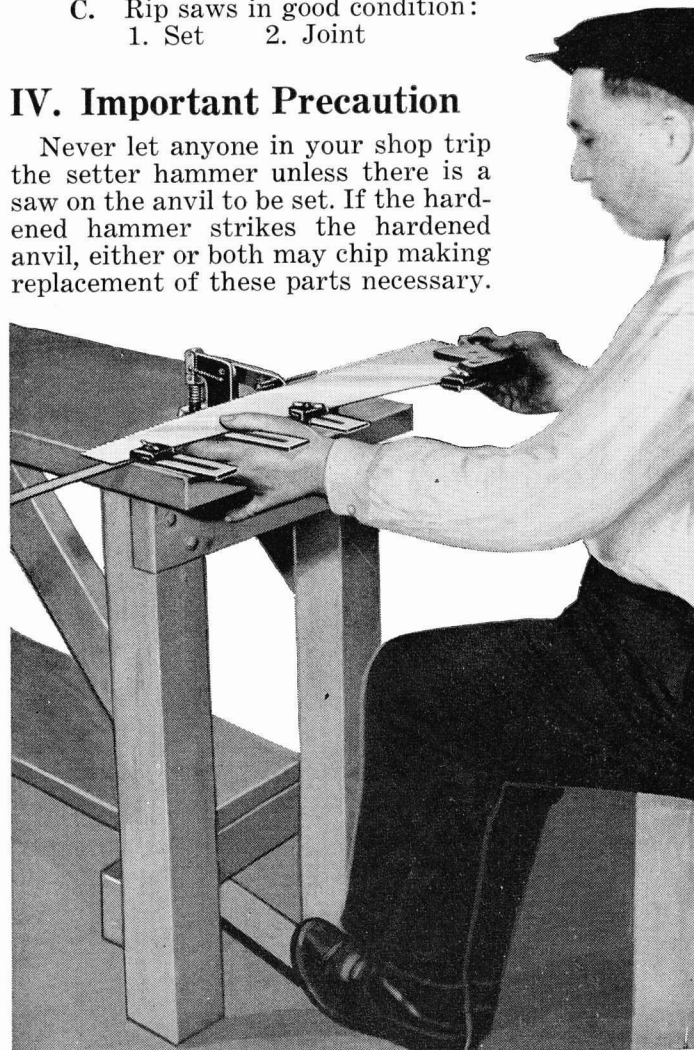
- A. With crosscut saws:
 - 1. Joint
 - 2. Bevel
 - 3. Set
 - 4. Go over again with light bevel for finished edge
- B. With rip saws:
 - 1. Joint
 - 2. Set
 - 3. Joint over lightly for razor edge

A quick method that can be used on saws that don't require this perfection edge is as follows:

- A. Crosscut saws:
 - 1. Joint 2. Set 3. Bevel
- B. When crosscut saw is in good condition:
 - 1. Set 2. Bevel
- C. Rip saws in good condition:
 - 1. Set 2. Joint

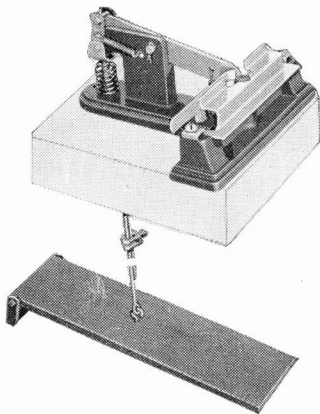
IV. Important Precaution

Never let anyone in your shop trip the setter hammer unless there is a saw on the anvil to be set. If the hardened hammer strikes the hardened anvil, either or both may chip making replacement of these parts necessary.



FOLEY SAW SETTERS

It is not practical to file and set a saw in the one operation. For this reason we manufacture separate machines for filing saws and separate machines for setting saws.



Model 281

CATALOG No. 38101

Foley Hand Saw Setter

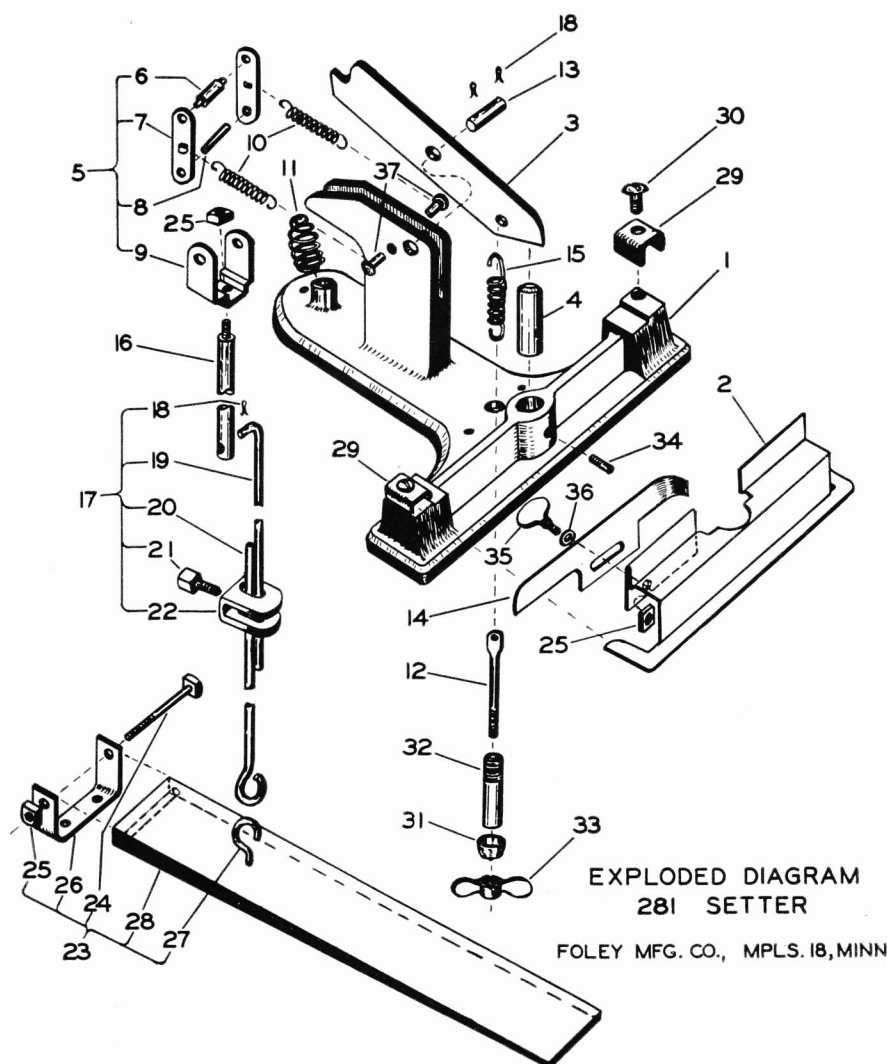
BENCH TYPE

Shipping Weight, 14 Lbs.

This is a hand-feed, hammer setter, operated by foot pedal with a positive hammer action on anvil, producing uniform set. Force of hammer blow is adjustable quickly for any amount of set or size of teeth. It is equipped with indicator, enabling operator to feed the saw by hand, one side at a time. It is not so apt to break teeth of saws as the ordinary push type setter. Teeth can be set while saw is in hand saw carrier used on Foley Filer, thus saving time for both operations

FOLEY MANUFACTURING CO.

**3300 FIFTH STREET N. E.
MINNEAPOLIS 18, MINN.**



EXPLODED DIAGRAM
281 SETTER
FOLEY MFG. CO., MPLS. 18, MINN.

DRAWING No. 22

MODEL 281 SAW SETTER

For machines manufactured after November, 1946 (with Adjusting Wing Nut under Bench)
(SEE EXPLODED VIEW DRAWING No. 22)

Diagram Number	Part Number	Part Name or Description	Price	Diagram Number	Part Number	Part Name or Description	Price
1	81001	Base Casting	\$ 7.20	24	511-4	1/4" x 4" Square Head Machine Bolt	.25
2	81003	Table	1.25	25	411	1/4" Square Nut	.05
3	81004	Hammer (Clipless type)	1.80	26	81022	Pedal Board Bracket	.95
4	81005	Anvil (3/8" diameter — new style)	1.45	27	852	No. 9 Screw Eye	.05
5	81506	Bracket Assembly	2.50	28	81018	Pedal Board	.75
6	81021	Pin for 81506	.40	29	81030	Table Clip	.10
7	81014	Side Bracket (2 required)	.50	30	310-1/2	1/4" x 1/2" Round Head Machine Screw	.10
8	81020	Bracket Pin	.25	31	81032	Tube Cap	.05
9	81016	End Rod Bracket Clip	.90	32	81033	Spring Tube	.30
10	81007	Trip Bracket Spring	.30	33	81038	Tension Wing Nut	.10
11	81008	Trip Spring	.40	34	145-1/4	1/4" x 1/4" Headless Set Screw	.10
12	81009	Hammer Adjustment Hook Bolt	.50	35	752-1/2	1/4" x 1/2" Thumb Screw	.10
13	81010	Hammer Pin	.40	36	451	3/8" Cut Washer	.05
14	81012	Pawl or Tooth Indicator	.75	37	779-1/4	1/8" x 1/4" Button Head Rivet	.05
15	81013	Hammer Tension Spring—2 for	.30	NOTE: In ordering replacement parts for Model 281 Setters built prior to 1946 (those having adjusting wing nut on top of hammer), please be sure to state —			
16	81015	End Rod	.40				
17	81517	Trip Rod Assembly	1.65	1.	Diagram Number		
18	772-1/2	Cotter Key	.05	2.	Part Name		
19	81036	Upper Rod	.50	3.	Date Purchased		
20	81037	Lower Rod	.50	This complete information must be given, to insure delivery of correct parts.			
21	106-5/8	1/4 x 5/8 Square Head Set Screw	.10				
22	81019	Trip Rod Clip	\$.60				
23	81518	Pedal Board Assembly	2.00				