

PARTS LIST FOR

JIG SAW

24 INCH

MODEL NUMBERS

103.0403

103.0404

This is the model number of your Jig Saw. It will be found on a plate on the front of the base. Always mention this model number when communicating with us regarding your Jig Saw or when ordering parts.

ORDERING INFORMATION FOR RETAIL AND MAIL ORDER STORES

REFER TO THE PRICE LIST 103...
FOR CURRENT SELLING PRICES AND
ORDERING INFORMATION.

SEARS, ROEBUCK and CO.

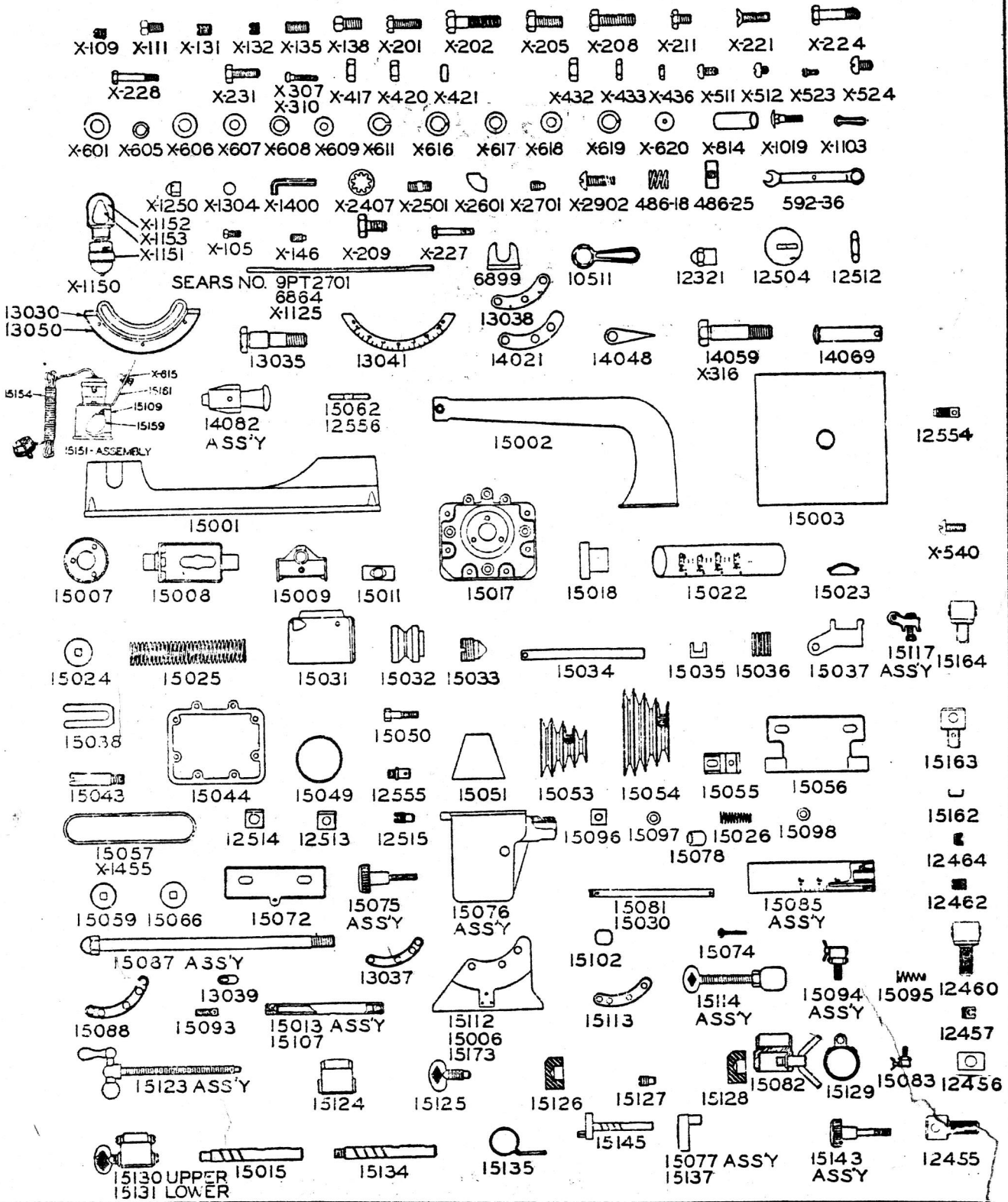
RR952 - Div. 9

(Revised)
SEPT. 1941

HOW TO ORDER PARTS FOR SEARS 24 INCH JIG SAW MODEL NUMBERS 103.0403 OR 103.0404

All parts listed here may be ordered through any Sears retail or mail order store. Parts are shipped prepaid. When ordering repair parts, always give the following information:

1. The Part Number in this List
2. The Part Name
3. The Model Number, which is 103.0403 or 103.0404 and will be found on a plate on the front of the base



PARTS LIST

All parts are shipped prepaid.
This sheet is intended for instruction and repair parts only and is not a packing slip. The parts shown and listed may include accessories not necessarily part of this tool.

Part Number	Name of Part	Part Number	Name of Part
486-18	Protractor Clamp Pin Spring	15095	Lower Guide Rod Spring Not Used
486-25	Shaft Collar Assembly	15096	Baffle Plate Not Used
592-36	Wrench	15097	Baffle Plate Washer Not Used
6864	Jig Saw Blade	15098	Lower Guide Rod Washer Not Used
6899	Motor Support Clip	15102	Thumb Screw Bumper Replaced by 15114
10511	Protractor Lock Wrench	15104	Pump Tube Assembly Complete Replaced by 15138
12321	Protractor Clamp Nut	15107	Lower Guide Rod Assembly
12455	Chuck Housing—Lower	15109	Lamp Shade
12456	Blade Centering Cover	15112	Table Support
12457	Socket Head Clamp Screw	15113	Protractor Guide—Front
12460	Chuck Assembly—Lower	15114	Motor Adjusting Bracket Thumb Screw Assembly
12462	Slotted Head Set Screw	15116	Crank Case Assembly Complete (Not Illus.)
12464	Threaded Plug		Replaced by 15139
12504	Table Insert	15117	Lower Roller Guide Assembly
12512	Chuck Jaw Housing Lock Nut	15123	Tensioner Screw Crank Assembly
12513	Chuck Jaw Stationary	15124	Chuck Jaw Housing—
	Upper		Replaced by 15172
	Lower		Replaced by 12460 plus 12464
12514	Chuck Jaw Movable	15125	Chuck Jaw Clamp Screw
	Upper		Replaced by 15172
	Lower		Replaced by 12460 plus 12464
12515	Chuck Jaw Pilot	15126	Chuck Jaw Stationary—
	Upper		Replaced by 15172
	Lower		Replaced by 12460 plus 12464
12554	Machine File Jaw Screw	15127	Chuck Jaw Pilot Screw—
12555	Chuck Jaw Clamp Screw		Replaced by 15172
	Upper		Replaced by 12460 plus 12464
	Lower		Replaced by 12460 plus 12464
12556	Jaw Clamp Screw Pin	15128	Chuck Jaw Movable—
	Upper		Replaced by 15172
	Lower		Replaced by 12460 plus 12464
13030	Protractor	15129	Tensioner Collar
13035	Table Protractor Guide Screw, Short	15130	Upper Chuck Jaw Assembly Includes 15124 (1), 15125 (1), 15126 (1), 15127 (1), 15128 (1), X-2902 (2)
13037	Protractor Guide—Front		Replaced by 15172
	Rear		Replaced by 15172
13038	Table Protractor Clamp	15131	Lower Chuck Jaw Assembly Includes 15124 (1), 15125 (1), 15126 (1), 15127 (1), 15128 (1), X-2902 (2)
13039	Table Stop Link		Replaced by 12460 plus 12464
13041	Protractor Scale	15134	Pulley Shaft Replaced by 15145
13050	Protractor Assembly	15135	Lamp Bracket Replaced by 15151
14021	Table Protractor Clamp	15137	Pulley Shaft Crank Assembly Replaced by 15145
14048	Mitre Gage Pointer	15138	Pump Tube Assembly Complete Includes 15023 (1), 15024 (1), 15025 (1), 15030 (1), 15066 (1), 15085 (1), 15162 (2), 15059 (1), 15164 (1), X-511 (1), X-540 (2), X-608 (1), X-620 (1)
14059	Table Protractor Lock Screw		Replaced by 15139
14069	Protractor Clamp Pin—Rear	15139	Crank Case Assembly Complete Includes Boot and Chuck Less Pulley
14082	Mitre Gage Plunger Assembly	15140	Lamp Assembly Replaced by 15151
15001	Base	15143	Pump Tube Clamp Knob Assembly
15002	Arm	15145	Pulley Shaft and Crank Assembly
15003	Table	15151	Lamp Assembly Complete
15006	Table Support	15154	Socket, Cord & Plug
15007	Boot Retainer	15155	Upper Head Assembly (Model 103.0404) Not Illus.
15008	Lower Guide Rod Bracket	15159	Lamp Bulb
15009	Yoke	15161	Lamp Bracket
15011	Yoke Pin	15162	Upper Guide Tube Spacer
15013	Lower Guide Rod	15163	Chuck Housing—Upper
15015	Pulley Shaft	15164	Chuck Assembly—Upper
15017	Crank Case Cover	15172	Upper Chuck Replacement for All Square Chucks—Not Illustrated
15018	Mounting Insulator	15173	Table Support Assembly
15022	Pump Tube	X-184	Pulley Shaft Bearing Replaced by X-814
15023	Pump Tube Cap	X-814	Pulley Shaft Bearing
15024	Pump Leather	X1125	Jig Saw Blade 3/8" Wide, 5" Long, 15 Teeth per inch. Purchase from Div. 9 in nearest retail store
15025	Pump Spring	X1150	Lamp Replaced by 15151
15026	Lower Guide Rod Spring	X1151	Lamp Socket Replaced by 15151
15030	Upper Guide Tube Assembly	X1152	Lamp Shade Replaced by 15151
15031	Pump Tube Support	X1153	Lamp Bulb Replaced by 15151
15032	Pump Tube Support Pilot	X1455	V Belt — 1/2"x32". Purchase from Div. 9 in nearest retail store
15033	Pump Tube Support Pilot Lock Screw	X2407	Shakeproof Lock Washer
15034	Saw Guide Rod	X2902	Chuck Screw Th'd Cutting—
15035	Thrust Roller Holder Guide		Replaced by 15172
15036	Saw Thrust Roller		Replaced by 12460 plus 12464
15037	Thrust Roller Holder		
15038	Hold Down Spring		
15043	Thrust Roller Pin		
15044	Crank Case Gasket		
15049	Boot Spring		
15050	Protractor Lock Plunger Housing Screw		
15051	Boot		
15053	Motor Pulley		
15054	Jig Saw Pulley		
15055	Thrust Roller Holder Support		
15056	Motor Support		
15057	V Belt 1/2"x32"		Replaced by X1455
15059	Pump Spring Guide		
15062	Jaw Clamp Screw Pin—Upper		Replaced by 15172
	Lower		Replaced by 12460 plus 12464
15066	Pump Leather Washer		
15072	Motor Adjustment Bracket		
15074	Motor Adj. Bracket Thumb Screw		Replaced by 15114
15075	Saw Guide Rod Lock Knob Assembly		
15076	Crank Case Assembly Includes 15004 (1) X-814 (1)		
15077	Pulley Shaft Crank Assembly		Replaced by 15145
15078	Motor Support Sleeve		
15081	Upper Guide Tube Assembly		Replaced by 15172
15082	Upper Chuck Jaw Assembly		Replaced by 15172
15083	Lower Chuck Jaw Assembly		Replaced by 12460 plus 12464
15085	Pump Tube Assembly includes 15022 (1) 15070 (1) 15071 (1) 15073 (1)		
15087	Arm Stud Assembly		
15094	Protractor Guide—Rear		
15093	Chuck Stem—Lower		Replaced by 12460 plus 12464
15094	Lower Chuck Jaw Housing Assembly		Replaced by 12460 plus 12464

THE FOLLOWING PARTS ARE STANDARD AND CAN BE PURCHASED LOCALLY

X-105	Yoke Set Screw	Replaced by X-138
X-109	Tensioner Collar Set Screw 3/16-24x 1/4	
X-111	Collar Set Screw 1/4-20x 3/4	
X-131	Motor Pulley Set Screw 1/4-20x 3/4 sq. hd.	
X-132	Jig Saw Pulley Set Screw 5/16-18x 3/4	
X-135	Jig Saw Pulley Set Screw 5/16-18x 3/4	
X-138	Yoke Screw 5/16-18 1/2 sq. hd.	
X-146	Crank Disc Set Screw 5/16-18x 3/4	
X-201	Crank Case and Guide Rod Bracket Screw 1/4-20-3/4	
X-202	Thrust Roller Guide Support Screw 1/4-20-1 1/4	
X-205	Table Mounting Screw 5/16-18-3/4	
X-208	Table Support Mounting Screw 5/16-18-1	
X-209	Table Stop Link Screw	Not Used
X-211	Hold Down Spring Screw 1/4-20-3/4	
X-221	Motor Rail Clin Screw 1/4-20-3/4	
X-224	Thrust Roller Holder Guide Screw 1/4-20-1 1/4	
X-227	Pump Tube Clamp Screw	Replaced by 15143
X-228	Pump Tube Support Pilot Screw 3/4-16-2 1/4	
X-231	Thrust Roller Holder Screw 1/4-20-3/4	
X-307	Motor Support Screw	Replaced by X-
X-310	Motor Support Screw 5/16-18x 1 1/4	
X-316	Table Protractor Lock Screw 3/8-24x2	

15146 LOWER BLADE GUIDE ASSEMBLY... NO LONGER AVAILABLE

X-417	Motor Support Screw Nut 5/16-18
X-420	Roller Holder Guide Screw Nut 1/4-20
X-421	Motor Rail Clip Screw Nut 1/4-20 Sq. Hd.
X-432	Protractor Guide Screw Nut 3/8-24
X-433	Protractor Scale Screw Nut No. 4-40
X-436	Lamp Bracket Screw Nut No. 5-40 Replaced by 15151
X-511	Pump Leather Retaining Screw No. 10-24x3/8
X-512	Protractor Pointer Screw No. 8-32x3/8
X-523	Shade Support Screw No. 5-40x5/16
X-524	Protractor Scale Screw No. 4-40x3/8
X-540	Guide Tube Spacer Screw No. 6-32x3/16
X-601	Motor Mounting Screw Washer 5/16 Std.
X-605	Hold Down Spring Lk. Washer 1/4 Std.
X-606	Boot Shield Washer 1/4 Std.
X-607	Crank Case Washer 1/4 Std.
X-608	Leather Retainer Sc. Lk. Washer 3/16 Std.

X-609	Lamp Bracket Screw Washer 3/16 Std.
X-611	Table Mounting Screw Lk. Washer 5/16 Std.
X-615	Lamp Bracket Spacing Washer 1/4 Std.
X-616	Prod. Guide Screw Lk. Washer 3/8 Std.
X-617	Pump Tube Clamp Screw Washer 5/16 Std.
X-618	Protractor Scale Lk. Washer No. 4 Std. Not Used
X-619	Plunger Housing Lk. Washer No. 5 Std.
X-620	Pump Leather Screw Washer 13/64-1
X1019	Lamp Bracket Mtg. Screw 3/16-24x3/8
X1103	Clamp Pin Cotter Pin 1/16 Std.
X1250	Lamp Bracket Mtg. Sc. Nut 3/16-24
X1304	Lower Guide Rod Check Ball 9/32
X-1400	Allen Wrench 5/32 Across Flats
X-2501	Filler Pipe 1/4 Pipe Coupling
X-2601	Filler Elbow 1/4 Std. Elbow
X-2701	Plug 1/4 Pipe Plug (Male)

THE FOLLOWING PARTS ARE SOLD SEPARATELY AS ACCESSORIES

RIP FENCE AND TABLE EXTENSIONS

15090	Complete Unit	See Sears Catalog No. 2278	12420	Lock Rod Nipple	Replaced by 12330
12254	Fence Guide Spacer		12330	Lock Rod Nipple	
12255	Fence Guide Screw-Long		15020	Fence Guide-Front	
12256	Fence Guide Screw-Short		15021	Fence Guide-Rear	
12260	Fence Sub-Assembly-Long		15046	Table Extension-Front	
12263	Fence End-Front		X-115	Aligning Screw	
12269	Rip Fence Equalizer		X-209	Equalizer Clamp Screw	
12270	Rip Fence Clamp Lever		X-428	Lock Rod Nut, Fence Guide Nut	
12272	Table Extension-Long		X-605	Fence Guide Screw Lock Washer, Equalizer Screw Lock Washer	
12291	Fence Assembly Complete		X-517	Fence Screw	
12315	Fence End-Rear		X-615	Equalizer Screw Plain Washer	
12317	Rip Fence Lock Rod-Long		X-1101	Cotter Pin	Not Used
12318	Rip Fence Clamp-Rear				
12319	Rip Fence Clamp Bolt				

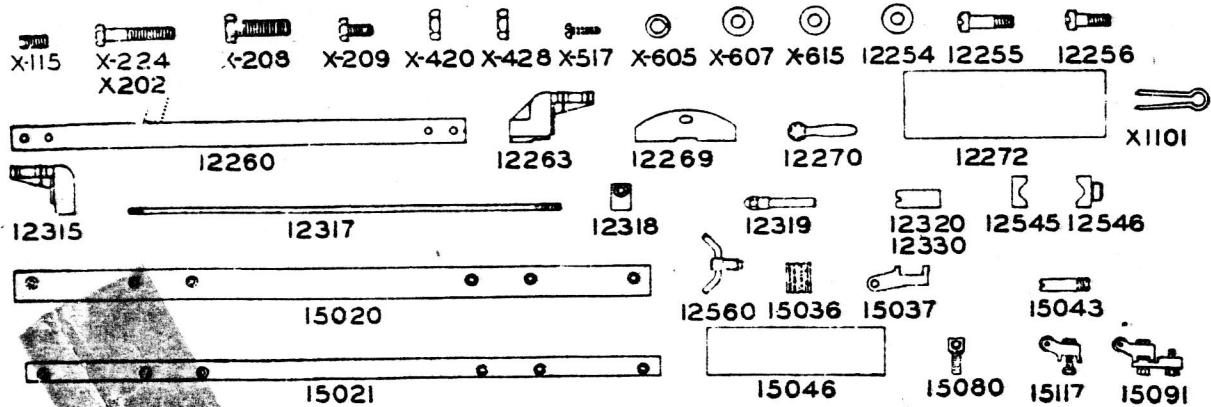
LOWER ROLLER GUIDE ASSEMBLY-COMLETE

15091	Complete Unit	Not Used	X-420	Holder Screw Nut	
15117	Lower Roller Guide Assembly Includes 15036 (1), 15037 (1), 15043 (1), X-202 (1), X-607 (1), X-420 (1)		X-601	Holder Support Screw Washer	Supplied with tool
15036	Saw Thrust Roller		X-605	Holder Screw Lock Washer	Supplied with tool
15037	Thrust Roller Holder		X-607	Holder Screw Washer	
15043	Thrust Roller Pin		X-611	Holder Support Screw Lock Washer	Supplied with tool
X-202	Holder Screw		X-208	Support Screw	Supplied with tool
			X-224	Holder Screw	Replaced by X-202

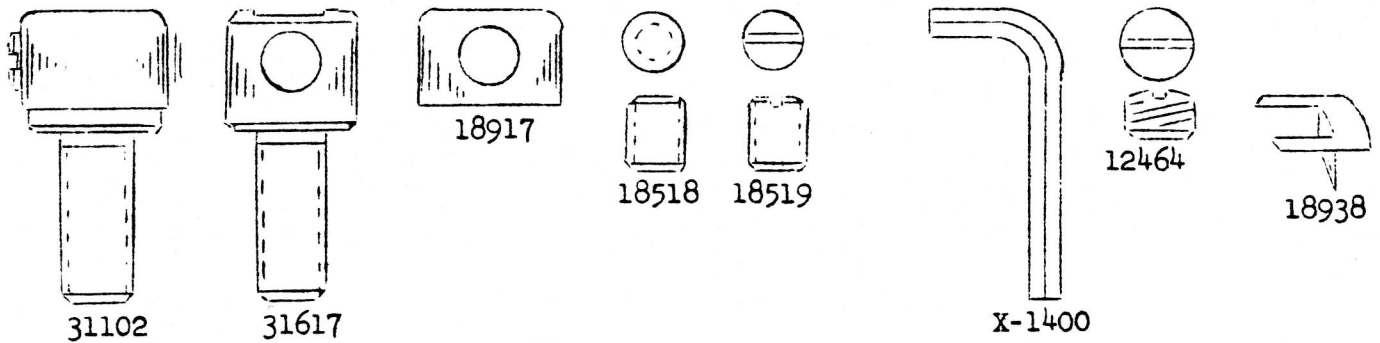
FILING JAWS

15092	Complete Unit	Replaced by 12460 plus 12464	12560	Jaw Clamp Screw	Replaced by 12460 plus 12464
12545	Movable Jaw	Replaced by 12460 plus 12464	15080	Filing Jaw Housing	Replaced by 12460 plus 12460
12546	Stationary Jaw	Replaced by 12460 plus 12464			

THE FOLLOWING PARTS ARE SOLD AS ACCESSORIES ONLY



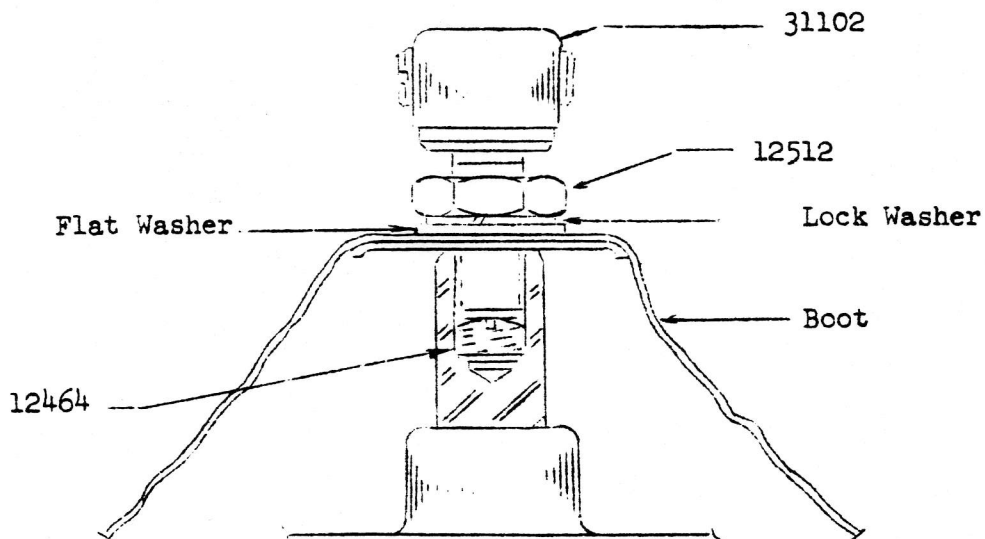
PARTS LIST FOR LOWER CHUCK FURNISHED AS A SUBSTITUTE FOR THE OLD
STYLE SQUARE JAWED TYPE USED ON MODELS 103.0403 AND 103.0404.



No.	PART NAME	No.	PART NAME
31102	Chuck Assembly Complete	18519	Slotted Head Set Screw
31617	Chuck Housing	X-1400	Allen Wrench
18917	Blade Centering Cover	12464	Threaded Plug
18518	Socket Head Clamp Screw	18938	Chuck Shoe

INSTALLATION INSTRUCTIONS

1. Unscrew and remove the lower chuck, holding the washers under the top of the boot in place.
2. Remove the washers and nut, No. 12512, from the old chuck stem and place them on the new chuck. (See sketch)
3. Screw the plug, No. 12464, into the lower guide rod turning it with a small screw driver until it seats. (See sketch)
4. Assemble chuck to tool as per following sketch:



IMPORTANT NOTICE

This new style chuck may be used to hold machine files or sabre saws. To insert these tools first remove the blade centering cover, No. 18917, and chuck shoe, No. 18938, by removing the screws 18518, 18519. Use only the set screw 18519 to hold files or sabre saws. For regular blades use Allen wrench for locking the blade in chuck. Whenever re-assembling chuck keep the relative position of 18518, 18519 and 18938 the same as originally assembled.

OPERATING INSTRUCTIONS FOR 24 INCH JIG SAW

LUBRICATION

To prepare for shipping, the oil has been removed from this tool. Do not run until refilled with a good grade of oil similar to S.A.E. No. 30. To refill, remove the pipe plug from filler pipe in front of crank case and pour in **SLIGHTLY LESS THAN ONE PINT OF OIL.**

THIS FILLING OF OIL SHOULD LAST INDEFINITELY, BUT IF MORE OIL IS ADDED, POUR IN ENOUGH TO HAVE IT JUST VISIBLE AT THE BOTTOM OF THE FILLER PIPE.

Any oil in excess of the above amount will be wasted as same will pass from crank case either through breather hole or vents around piston rod until required level is reached. The crank case mechanism and main bearing are lubricated by means of an oil pressure system. The pressure is produced by a simple pump arrangement in combination with the mechanism in crank case which pumps and forces the oil from the bottom of the crank case to all parts requiring lubrication in the crank case.

The square upper pump piston rod should be oiled or greased and a few drops of oil should be applied through the hole in the pump tube cap occasionally.

Periodic greasing of the table trunnions is recommended.

REASSEMBLY INSTRUCTIONS

This jig saw has once been completely assembled at the factory and to avoid breakage through rough handling while in transit the table has been removed.

Looking at the under side of this table you will note that one pair of trunnion bosses is close to one edge of the table. To reassemble table, place the table on the trunnions with these bosses toward the back.

The four mounting screws are in the cloth bag. Place the plain washer next to the trunnion boss, then the lock washer before tightening screws.

The blade has been pushed up into the upper chuck to avoid breakage.

CAUTION. For shipping purposes the upper pump tube assembly has been lowered and the clamp bolt tightened.

To raise or turn this tube loosen the clamp bolt and move the assembly by hand.

Do not turn pump tube with **WRENCH OR PLIERS.**

SPEEDS

The large pulley is mounted with large diameter next to the crank case and the small pulley is mounted on a 1750 R.P.M. motor with the small diameter adjacent to the motor. This will give approximate speeds of 1750—1284—926 and 657. 926 and 1284 are the recommended speeds. A $\frac{1}{3}$ horsepower motor is recommended for this saw.

PULLEY ON CRANK CASE MUST RUN IN DIRECTION INDICATED BY ARROW SHOWN ON OUTSIDE OF CRANK CASE SHAFT BEARING HOUSING.

MOTOR MOUNTING

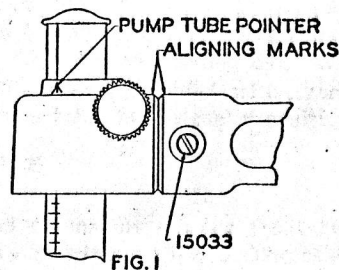
The motor mounting is in two parts, the front end being the conventional floating type pivoted in adjustable clips. The rear part has an adjusting screw so weight of motor can be relieved from the belt and bearings.

PUMP MECHANISM

The upper guide tube and pump mechanism is mounted in a housing which is fastened in the overarm by means of taper pointed screws which register against the angular surfaces of a groove in a pivot pilot which is bolted to the housing.

Loosening the screws permits the entire assembly to be turned radially. Removing the screws permits the removal of the assembly. Air for blowing dust away from the work is provided through a tube concealed in the pump tube. Additional air is exhausted through chuck jaws in upper guide tube.

The graduations on the pump tube signify the length of saw blades and the pounds pressure of the spring at the top of the stroke. For example, when using a 5" blade the 5"— $6\frac{1}{2}$ " # mark should register at the top edge of housing.



For radial alignment the vertical line through graduation on the tube must register with the pointer on support housing located 45° to the right from the front.

Fasten the tube securely in this position. For ripping turn the entire pump tube assembly and saw blade roller guide 90° to the right so that vertical line on the tube lines up with pointer.

JIG SAW WITH TENSIONER—MODEL 103.0404 ONLY

A blade tensioner is provided so that correct tension can be obtained when using various sizes of blades. Tension can be varied with blade in place and while machine is in operation.

Improper tension will cause vibration which will disappear when correct point is reached.

To increase or decrease the tension of the saw blade, loosen pump tube clamp screw and turn ball crank to the right or left. Lock clamp screw when desired tension is reached.

SAW BLADE ROLLER GUIDE AND HOLD DOWN SPRING

To move roller guide toward and away from the saw loosen bolt A in Fig. 2 and slide the assembly to the desired position. To move the roller laterally loosen the bolt B and slide the roller and hold down spring to the groove selected.

TO CHUCK SAW BLADES

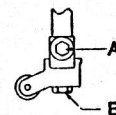


FIG. 2

1. Place blade in the lower chuck and tighten socket head clamp screw.
 2. Turn drive pulley until the lower chuck is raised to its highest position.
 3. Loosen pump tube clamp screw and set pump tube at proper position for length of saw blade being inserted.
 4. While in this position insert blade in upper chuck by pulling down upper chuck slightly and tightening the clamp screw.
 5. Turn pulley over by hand to make certain that the spring in head is under tension at the top of stroke. Failure to observe this condition will result in pounding.
- Install blade with cutting teeth pointing downward.
Blade will work best with cutting edge square with table.
Maximum thickness to cut with 5" blade is $\frac{3}{4}$ ". For thicker material use longer blades and raise pump tube.
Blades up to 10" long can be used without changing the setting for 5" blades, but the blade must be put through the upper chuck starting from below the table through the table insert.

FILING

The round shank files to be used in this machine, listed in the Sears Power Tool Catalog, are held in the lower chuck. To insert a file remove the chuck screws and lift off the blade centering cap. Place file in chuck and fasten securely by tightening slotted set screw only against the file shank. The table may be tilted to file angles or to correct for any bow in the file.

TABLE

To tilt the table unlock the front trunnion by pulling the lever wrench on to hexagon nut. Loosen. Pull plunger stop for important angular positions, intermediate angles must be lined up with the pointer. Relock with lever wrench on nut. The pointer on the graduated protractor is adjustable if necessary to correct any error on protractor with the table top.

OVERARM

Marks on the top of the overarm and pump tube housing at the joint permits the entire housing assembly to be returned to its normal alignment.

Overarm is pivoted at the rear of the base so it can be swung to the right or left or entirely removed by loosening the stud which clamps it to the base. The distance from the center of the saw to the inside of arm permits full 24" cuts.

At the overarm pivot joint at the rear end of the base a mark determines the normal sawing alignment of the arm.

RUBBER MOUNTING INSULATORS

Place one in each cored recess on the inside corners of base. These rubbers will help to level your saw and deaden sounds which may be transmitted through your mounting stand or bench.

SABRE SAWING ACCESSORY

Loosen blade in upper chuck. Remove roller guide and hold-down spring by taking out the screw at the bottom. Loosen acorn nut on rear of upper arm and move arm to either side. Tilt table to the left 45°. With long screw through slot, line up roller guide with small support casting (Part No. 15055) included with extra parts. Fasten this assembly to boss underneath the table and behind the blade. Return table to horizontal position.

ADDITIONAL ACCESSORIES AVAILABLE

FENCE AND TABLE EXTENSIONS

Provision is made in the ends of the table for attaching fence guides and extensions for the front and sides of the table. These extensions increase the table size from 14-3/16" square to 18-3/16" x 25-1/2". The table space in front of the saw is increased from 7-1/2" to 11-1/2".