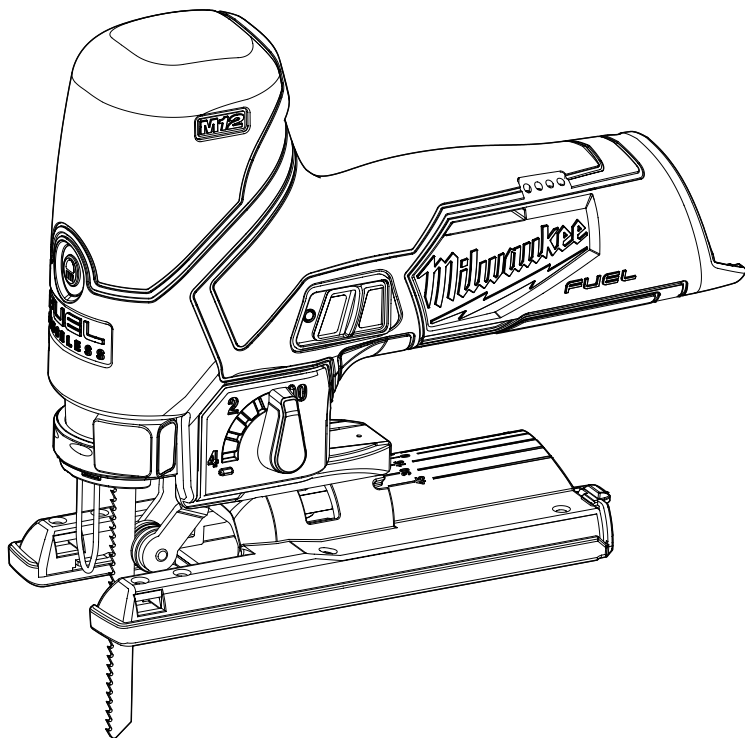




OPERATOR'S MANUAL
MANUEL de L'UTILISATEUR
MANUAL del OPERADOR



Cat. No. / No de cat.
2545-20

M12 FUEL™ JIG SAW
SCIE SAUTEUSE M12 FUEL™
SIERRA CALADORA M12 FUEL™



WARNING To reduce the risk of injury, user must read and understand operator's manual.

AVERTISSEMENT Afin de réduire le risque de blessures, l'utilisateur doit lire et bien comprendre le manuel.

ADVERTENCIA Para reducir el riesgo de lesiones, el usuario debe leer y entender el manual.

GENERAL POWER TOOL SAFETY WARNINGS

WARNING Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. **Save all warnings and instructions for future reference.** The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

WORK AREA SAFETY

- **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- **Do not operate power tools in explosive atmospheres,** such as in the presence of flammable liquids, gases or dust. Power tools create sparks which may ignite the dust or fumes.
- **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

ELECTRICAL SAFETY

- **Power tool plugs must match the outlet.** Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- **Avoid body contact with earthed or grounded surfaces,** such as pipes, radiators, ranges and refrigerators. There is an increased risk of electric shock if your body is earthed or grounded.
- **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- **Do not abuse the cord.** Never use the cord for carrying, pulling or unplugging the power tool. **Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- **When operating a power tool outdoors,** use an extension cord suitable for outdoor use. Use of a cord suitable for outdoor use reduces the risk of electric shock.
- **If operating a power tool in a damp location is unavoidable,** use a ground fault circuit interrupter (GFCI) protected supply. Use of an GFCI reduces the risk of electric shock.

PERSONAL SAFETY

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- **Use personal protective equipment. Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting.** Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool. Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.

- **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.
- **Do not overreach.** Keep proper footing and balance at all times. This enables better control of the power tool in unexpected situations.
- **Dress properly. Do not wear loose clothing or jewelry. Keep your hair and clothing away from moving parts.** Loose clothes, jewelry or long hair can be caught in moving parts.
- **If devices are provided for the connection of dust extraction and collection facilities,** ensure these are connected and properly used. Use of dust collection can reduce dust-related hazards.
- **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

POWER TOOL USE AND CARE

- **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
 - **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
 - **Disconnect the plug from the power source and/ or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
 - **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
 - **Maintain power tools and accessories.** Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation. If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.
 - **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
 - **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.
 - **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.
- ### BATTERY TOOL USE AND CARE
- **Recharge only with the charger specified by the manufacturer.** A charger that is suitable for one type of battery pack may create a risk of fire when used with another battery pack.
 - **Use power tools only with specifically designated battery packs.** Use of any other battery packs may create a risk of injury and fire.

- When battery pack is not in use, keep it away from other metal objects, like paper clips, coins, keys, nails, screws or other small metal objects, that can make a connection from one terminal to another. Shorting the battery terminals together may cause burns or a fire.
- Under abusive conditions, liquid may be ejected from the battery; avoid contact. If contact accidentally occurs, flush with water. If liquid contacts eyes, additionally seek medical help. Liquid ejected from the battery may cause irritation or burns.
- Do not use a battery pack or tool that is damaged or modified. Damaged or modified batteries may exhibit unpredictable behavior resulting in fire, explosion or risk of injury.
- Do not expose a battery pack or tool to fire or excessive temperature. Exposure to fire or temperature above 265°F (130°C) may cause explosion.
- Follow all charging instructions and do not charge the battery pack or tool outside the temperature range specified in the instructions. Charging improperly or at temperatures outside the specified range may damage the battery and increase the risk of fire.

SERVICE

- Have your power tool serviced by a qualified repair person using only identical replacement parts. This will ensure that the safety of the power tool is maintained.
- Never service damaged battery packs. Service of battery packs should only be performed by the manufacturer or authorized service providers.

SPECIFIC SAFETY RULES FOR JIG SAWS

- Hold power tool by insulated gripping surfaces, when performing an operation where the cutting accessory may contact hidden wiring. Cutting accessory contacting a "live" wire may make exposed metal parts of the power tool "live" and could give the operator an electric shock.
- Use clamps or another practical way to secure and support the workpiece to a stable platform. Holding the work by hand or against your body leaves it unstable and may lead to loss of control.
- Keep hands away from all cutting edges and moving parts.
- AWARNING** To reduce the risk of injury, when working in dusty situations, wear appropriate respiratory protection or use an OSHA compliant dust extraction solution.
- Always use common sense and be cautious when using tools. It is not possible to anticipate every situation that could result in a dangerous outcome. Do not use this tool if you do not understand these operating instructions or you feel the work is beyond your capability; contact Milwaukee Tool or a trained professional for additional information or training.
- Maintain labels and nameplates. These carry important information. If unreadable or missing, contact a MILWAUKEE service facility for a free replacement.

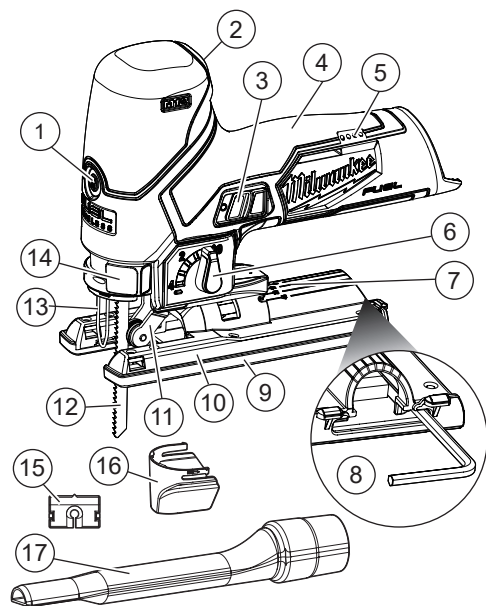
- AWARNING** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
 - lead from lead-based paint
 - crystalline silica from bricks and cement and other masonry products, and
 - arsenic and chromium from chemically-treated lumber.

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

SPECIFICATIONS

Cat. No.....	2545-20
Volts.....	12 DC
Battery Type.....	M12™
Charger Type.....	M12™
No Load Strokes Per Minute (SPM).....	800 - 3,000
Length of Stroke.....	7/8"
Recommended Ambient	
Operating Temperature.....	0°F to 125°F

FUNCTIONAL DESCRIPTION



- | | |
|----------------------------------|-------------------------|
| 1. LED On/Off button | 9. Shoe cover |
| 2. Speed dial | 10. Shoe |
| 3. Power switch | 11. Orbital arm |
| 4. Handle | 12. Blade |
| 5. Fuel gauge | 13. Blade guard |
| 6. Orbital action selector lever | 14. Blade change lever |
| 7. Bevel scale | 15. Anti-splinter plate |
| 8. Wrench storage | 16. Dust cover |
| | 17. Vacuum hose adapter |

SYMBOLLOGY



Volts



Direct Current

n , XXXX min⁻¹ No Load Strokes per Minute (SPM)



UL Listing for Canada and U.S.

ASSEMBLY

⚠ WARNING Recharge only with the charger specified for the battery. For specific charging instructions, read the operator's manual supplied with your charger and battery.

Removing/Inserting the Battery

To **remove** the battery, push in the release buttons and pull the battery pack away from the tool.

⚠ WARNING Always remove the battery pack any time the tool is not in use.

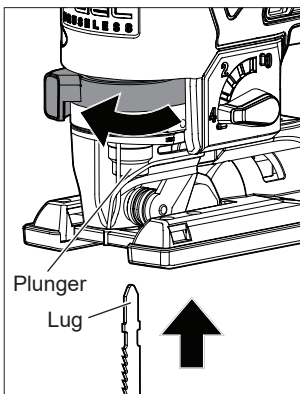
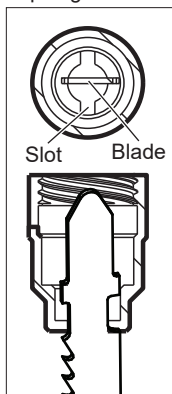
To **insert** the battery, slide the pack into the body of the tool. Make sure it latches securely into place.

⚠ WARNING Only use accessories specifically recommended for this tool. Others may be hazardous.

Installing Saw Blades

Use only T-Shank jig saw blades.

1. **⚠ WARNING!** Remove battery to avoid starting the tool.
2. Firmly rotate the blade change lever as far as it will go and hold it in position.
3. Fit the saw blade into the groove in the support roller and push it firmly into the plunger as far as it will go; the lug of the saw blade must be in the plunger.

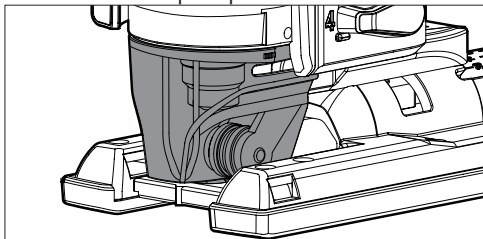


4. Release the blade change lever and the saw blade is automatically held.
5. Check that the saw blade is held firmly; the slot in the plunger will be at an angle to the blade.

Installing the Dust Cover

The dust cover is used with the vacuum attachment to help seal the dust around the front of the tool for more efficient dust collection.

1. **⚠ WARNING!** Remove battery to avoid starting the tool.
2. Slide the cover onto the tool in the orientation shown until it clips in place.

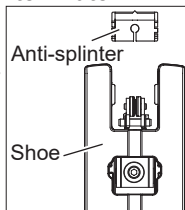


3. To **remove**, squeeze and pull away from the tool.
- NOTE:** Do not use the dust cover when making bevel/angle cuts.

Using the Anti-Splinter Plate

The anti-splinter plate helps stabilize the workpiece and reduce workpiece splinter.

1. **⚠ WARNING!** Remove battery to avoid starting the tool.
2. Slide the anti-splinter plate onto the shoe. Make sure the anti-splinter plate is installed flush with the bottom of the shoe.



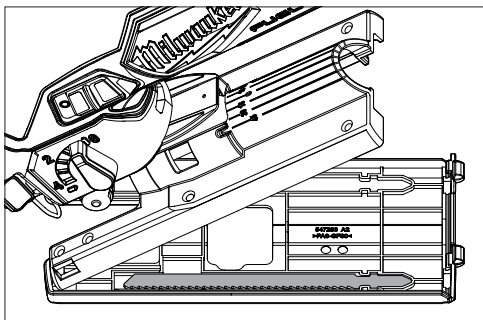
NOTE: Do not use the anti-splinter plate when making bevel/angle cuts.

Using the Shoe Cover

The shoe cover is used to prevent marring and scratching of the workpiece surface.

To **attach** the shoe cover:

1. **⚠ WARNING!** Remove battery to avoid starting the tool.
2. Hook the front of the cover over the metal shoe.
3. Snap the rear of the shoe cover over the back of the shoe. Be sure both sides are snapped in place.
4. When the shoe cover is not needed, remove it by pulling the tabs on rear of the shoe cover down. Unhook the front of the shoe cover and remove.
5. Two saw blades can be stored inside the shoe cover.

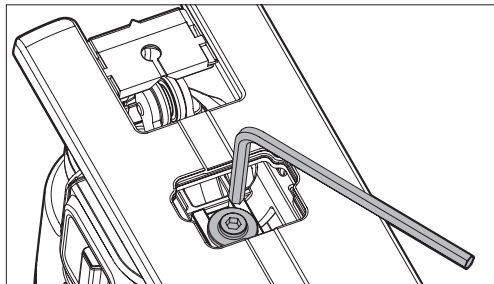


Adjusting Bevel Angle

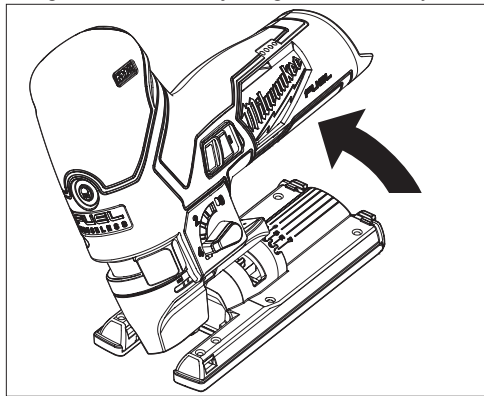
The shoe may be tilted up to 45° in either direction. Do not use the transparent blade cover or anti-splinter plate when making bevel/angle cuts.

To set a tilt angle for bevel/angle cuts:

1. **WARNING!** Remove battery to avoid starting the tool.
2. Loosen the bevel adjusting screw with the onboard hex wrench.



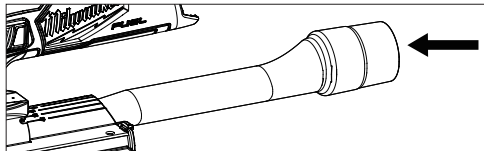
3. Hold the shoe and rotate the jig saw by the handle to the desired angle as indicated by the markings on the bevel scale.
4. Tighten the bevel adjusting screw securely.



Vacuum Hose Adapter

Use the vacuum hose adapter to attach the jig saw to a vacuum hose.

1. **WARNING!** Remove battery to avoid starting the tool.
2. To **insert**, slide the adapter into the jig saw, as shown.



3. Push the jig saw and adapter together firmly.
4. Connect the vacuum hose to the adapter, twisting together to secure.
5. To **remove**, disconnect the vacuum hose from the adapter. Then, grasp the jig saw and adapter firmly and pull apart.

OPERATION

WARNING To reduce the risk of injury, always wear proper eye protection marked to comply with ANSI Z87.1.

When working in dusty situations, wear appropriate respiratory protection or use an OSHA compliant dust extraction solution.

Fuel Gauge



To determine the amount of charge left in the battery, turn the tool **ON**. The fuel gauge will light up for 2-3 seconds. When less than 10% of charge is left, 1 light on the fuel gauge will flash 4 times.

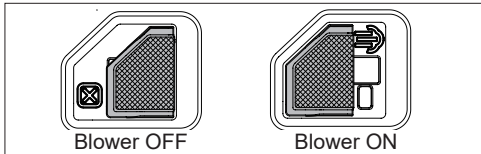
To signal the end of charge, 1 light on the fuel gauge will flash 8 times and the tool will not run. Charge the battery pack.

If the battery becomes too hot, the fuel gauge lights will flash and the tool will not run. Allow the battery to cool down.



Sawdust Blower

The sawdust blower removes sawdust ahead of the cut for improved visibility and dust collection.

1. To **start** the blower, slide the switch to reveal .
2. To **stop** the blower, slide the switch to reveal .



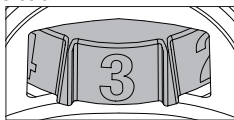
Starting and Stopping

1. To **start** the tool, slide the power switch to reveal .
2. The workpiece LED will light. Press the  button to turn the workpiece LED on and off.
3. To **stop** the tool, slide the power switch to reveal "O". Ensure the tool has come to a complete stop before laying the tool down.

Selecting the Speed

WARNING To reduce the risk of injury, only use saw blades rated for the operating speed setting of the tool.

The strokes per minute (SPM) of the tool can be changed by turning the speed dial. The numbers 1 through 5 and A (Auto-controlled start) are printed on the dial with 1 being the slowest speed and 5 the highest speed. Optimum cutting speeds should be determined by the user for specific cutting requirements. Strokes per minute may be adjusted when the tool is running or stopped.



Speed Setting	SPM
1	800
2	1200
3	1800
4	2500
5	3000
A	starts 1500 rises to 3000

Adjusting the Orbital Action

The amount of orbital action may be adjusted with the orbital action selector lever. In general, a large orbital action (4) should be used with soft materials and a no orbital action (0) should be used with hard materials. When a smooth cut is required no orbit (0) should be used. The optimum orbital action should be determined by the user for their specific cutting requirements. Orbital action may be adjusted when the tool is running or stopped.

Material	Orbital Action
Wood	0-4
Metal	0-1
Aluminum	0-1
Plastic	0-2
Smooth Cut	0

Making the Cut

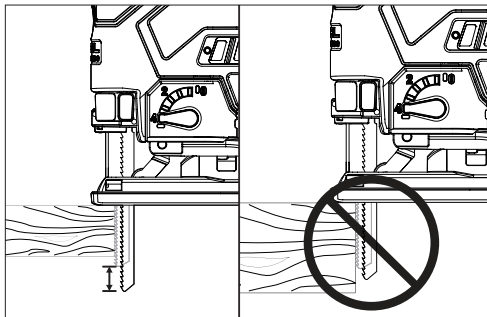
1. Set the stroke and orbital action according to the material to be cut.
2. Position the tool with the front part of the shoe on the workpiece and start the tool.
3. Hold the tool firmly against the workpiece and guide it along the desired cutting line. Do not feed into the work too hard, light pressure on the saw blade will achieve the optimum cutting speed.

Special Cutting Techniques

1. Straight cuts — To obtain a perfectly straight cut, clamp a strip of wood as a guide along the workpiece or use the rip guide (accessory).
2. Bevel cuts — adjust the shoe to the correct angle.
3. Cutting Sheet Metal — sheet metal may vibrate when being cut. To minimize vibration clamp, the workpiece to a wood base.

WARNING To reduce the risk of injury, do not start the tool with the blade contacting the workpiece.

Be sure the blade always extends beyond the shoe and workpiece throughout the stroke. Blades may shatter if they impact the workpiece.



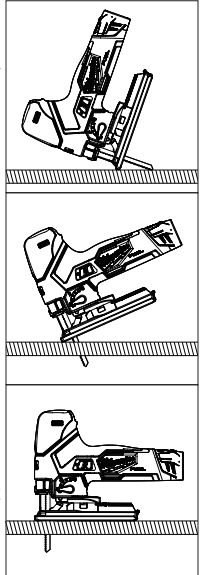
WARNING To reduce the risk of explosion, electric shock and property damage, always check the work area for hidden gas pipes, electrical wires or water pipes when making blind or plunge cuts.

Plunge Cutting

Plunge cuts can be made into soft materials without a pre-drilled hole. Harder materials require a starter hole with a diameter slightly over the width of the blade.

To make a plunge cut:

1. Set the orbital action selector lever to 0.
2. Make sure nothing below the intended cut area will be damaged.
3. Without turning the tool on, place the front edge of the shoe solidly on the workpiece.
4. Align the blade with the intended cut line, but keep it above the workpiece.
5. Using the front edge of the shoe as a pivot, turn on the tool and gradually lower the blade into the workpiece.
6. When the shoe is flat against the workpiece, normal cutting may take place.



MAINTENANCE

⚠WARNING To reduce the risk of injury, always unplug the charger and remove the battery pack from the charger or tool before performing any maintenance. Never disassemble the battery pack, charger, or tool, except as provided in these instructions. Contact a MILWAUKEE service facility for all other repairs.

Maintaining Tool

Keep your tool, battery pack and charger in good repair by adopting a regular maintenance program. Inspect your tool for issues such as undue noise, misalignment or binding of moving parts, breakage of parts, or any other condition that may affect the tool operation. Return the tool, battery pack, and charger to a MILWAUKEE service facility for repair. After six months to one year, depending on use, return the tool, battery pack and charger to a MILWAUKEE service facility for inspection.

If the tool does not start or operate at full power with a fully charged battery pack, clean the contacts on the battery pack. If the tool still does not work properly, return the tool, charger and battery pack, to a MILWAUKEE service facility for repairs.

⚠WARNING To reduce the risk of personal injury and damage, never immerse your tool, battery pack or charger in liquid or allow a liquid to flow inside them.

Cleaning

Clean dust and debris from any vents. Keep tool clean, dry and free of oil or grease. Use only mild soap and a damp cloth to clean, since certain cleaning agents and solvents are harmful to plastics and other insulated parts. Some of these include gasoline, turpentine, lacquer thinner, paint thinner, chlorinated cleaning solvents, ammonia and household detergents containing ammonia. Never use flammable or combustible solvents around tools.

Repairs

For repairs, return the tool, battery pack and charger to the nearest authorized service center.

ACCESSORIES

⚠WARNING Use only recommended accessories. Others may be hazardous.

For a complete listing of accessories, go online to www.milwaukeetool.com or contact a distributor.

SERVICE - UNITED STATES

1-800-SAWDUST (1.800.729.3878)

Monday-Friday, 7:00 AM - 6:30 PM CST
or visit www.milwaukeetool.com

Contact Corporate After Sales Service Technical Support with technical, service/repair, or warranty questions.

Email: metproductsupport@milwaukeetool.com

Become a Heavy Duty Club Member at www.milwaukeetool.com to receive important notifications regarding your tool purchases.

SERVICE - CANADA

Milwaukee Tool (Canada) Ltd
1.877.948.2360

Monday-Friday, 7:00 AM - 4:30 PM CST
or visit www.milwaukeetool.ca

LIMITED WARRANTY USA & CANADA

This MILWAUKEE power tool* is warranted to the original purchaser from an authorized MILWAUKEE distributor only to be free from defects in material and workmanship. Subject to certain exceptions, MILWAUKEE will repair or replace any part on this power tool which, after examination, is determined by MILWAUKEE to be defective in material or workmanship for a period of five (5) years after the date of purchase unless otherwise noted. Return of the power tool to a MILWAUKEE factory Service Center location or MILWAUKEE Authorized Service Station, freight prepaid and insured, is required. A copy of the proof of purchase should be included with the return product. This warranty does not apply to damage that MILWAUKEE determines to be from repairs made or attempted by anyone other than MILWAUKEE authorized personnel, misuse, alterations, abuse, normal wear and tear, lack of maintenance, or accidents.

Normal Wear: Many power tools need periodic parts replacement and service to achieve best performance. This warranty does not cover repair when normal use has exhausted the life of a part including, but not limited to, chucks, brushes, cords, saw shoes, blade clamps, o-rings, seals, bumpers, driver blades, pistons, strikers, lifters, and bumper cover washers.

*This warranty does not cover battery packs or all power tools. Refer to the separate and distinct warranties available for those products.

The warranty period for the LED in the LED Work Light (49-24-0171) and the LED Upgrade Bulb (49-81-0090) is the lifetime of the product subject to the limitations above. If during normal use the LED or LED Upgrade Bulb fails, the part will be replaced free of charge.

Warranty Registration is not necessary to obtain the applicable warranty on a MILWAUKEE power tool product. The manufacturing date of the product will be used to determine the warranty period if no proof of purchase is provided at the time warranty service is requested.

ACCEPTANCE OF THE EXCLUSIVE REPAIR AND REPLACEMENT REMEDIES DESCRIBED HEREIN IS A CONDITION OF THE CONTRACT FOR THE PURCHASE OF EVERY MILWAUKEE PRODUCT. IF YOU DO NOT AGREE TO THIS CONDITION, YOU SHOULD NOT PURCHASE THE PRODUCT. IN NO EVENT SHALL MILWAUKEE BE LIABLE FOR ANY INCIDENTAL, SPECIAL, CONSEQUENTIAL, OR PUNITIVE DAMAGES, OR FOR ANY COSTS, ATTORNEY FEES, EXPENSES, LOSSES OR DELAYS ALLEGED TO BE AS A CONSEQUENCE OF ANY DAMAGE TO, FAILURE OF, OR DEFECT IN ANY PRODUCT INCLUDING, BUT NOT LIMITED TO, ANY CLAIMS FOR LOSS OF PROFITS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU. THIS WARRANTY IS EXCLUSIVE AND IN LIEU OF ALL OTHER EXPRESS WARRANTIES, WRITTEN OR ORAL, TO THE EXTENT PERMITTED BY LAW, MILWAUKEE DISCLAIMS ANY IMPLIED WARRANTIES, INCLUDING WITHOUT LIMITATION ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR PURPOSE; TO THE EXTENT SUCH DISCLAIMER IS NOT PERMITTED BY LAW, SUCH IMPLIED WARRANTIES ARE LIMITED TO THE DURATION OF THE APPLICABLE EXPRESS WARRANTY AS DESCRIBED ABOVE. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG AN IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. THIS WARRANTY GIVES YOU SPECIFIC LEGAL RIGHTS, AND YOU MAY ALSO HAVE OTHER RIGHTS WHICH VARY FROM STATE TO STATE.

This warranty applies to product sold in the U.S.A. and Canada only. Please consult the "Service Center Search" in the Parts & Service section of MILWAUKEE's website www.milwaukeetool.com or call 1.800.SAWDUST (1.800.729.3878) to locate your nearest service facility for warranty and non-warranty service on a MILWAUKEE power tool.