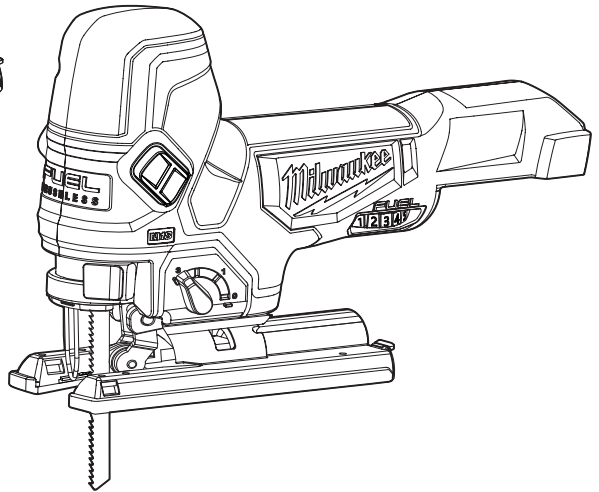
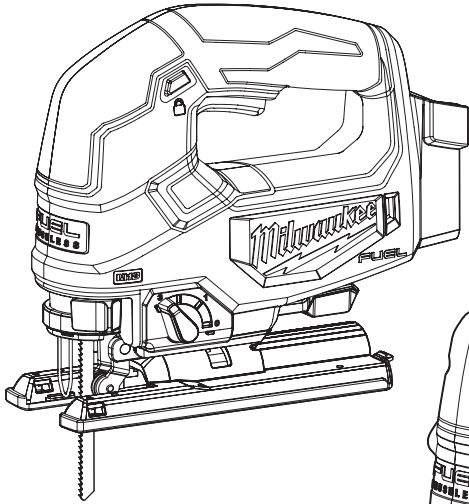




## OPERATOR'S MANUAL



Cat. No. / No de cat.  
2737-20, 2737B-20

### M18 FUEL™ JIG SAWS



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

**⚠ WARNING** To reduce the risk of injury in applications that produce a considerable amount of dust, use an OSHA compliant dust extraction solution in accordance with the solution's operating instructions.

- **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.

**⚠ WARNING** 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.

### SYMBOLOLOGY



Volts



Direct Current

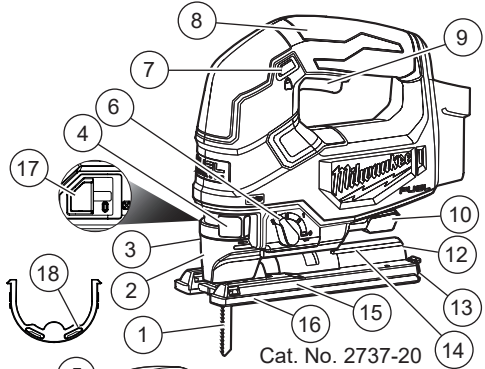
$n_0$  XXXX min<sup>-1</sup>

No Load Strokes per Minute (SPM)

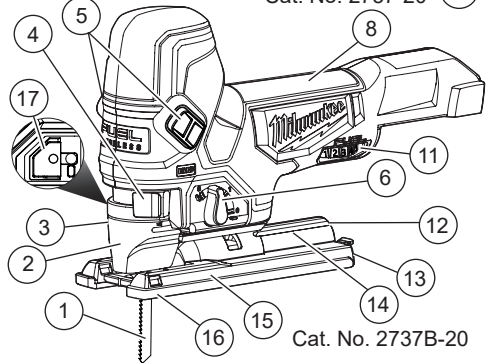


UL Listing for Canada and U.S.

### FUNCTIONAL DESCRIPTION



Cat. No. 2737-20



Cat. No. 2737B-20

- |                                  |                           |
|----------------------------------|---------------------------|
| 1. Blade                         | 10. Shoe adjustment lever |
| 2. Transparent blade cover       | 11. Variable speed dial   |
| 3. LED                           | 12. Dust chute            |
| 4. Quik-Lok tension lever        | 13. Wrench/wrench storage |
| 5. ON/OFF slide switches         | 14. Tilt angle scale      |
| 6. Orbital action selector lever | 15. Shoe                  |
| 7. Lock button                   | 16. Shoe cover            |
| 8. Handle                        | 17. Blower shuttle        |
| 9. Trigger                       | 18. LED cover             |

### SPECIFICATIONS

Volts.....	18 DC
Battery Type.....	M18™
Charger Type.....	M18™
Recommended Ambient Operating Temperature.....	0°F to 125°F
<b>Cat. No. ....</b>	<b>2737-20</b>
No Load Strokes per Minute.....	0 - 3500
Length of Stroke.....	1"
<b>Cat. No. ....</b>	<b>2737B-20</b>
No Load Strokes per Minute.....	800 - 3500
Length of Stroke.....	1"

## 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 battery pack before changing or removing accessories.

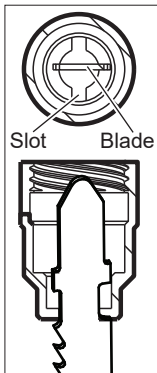
To insert the battery, slide the pack into the body of the tool. Make sure it latches securely into place.

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

### Installing Saw Blades

Use only T-Shank jig saw blades.

1. Remove the battery pack.
2. Push and hold the Quik-Lok tension lever to right to line up the slots.
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 Quik-Lok tension lever to secure the saw blade.
5. Check that the saw blade is held firmly; the slot in the plunger will be at an angle to the blade.
6. To remove the blade, push the lever to the right and the blade will be ejected.



### Installing the Transparent Blade Cover

Do not use the transparent blade cover and anti-splinter device when making bevel/angle cuts.

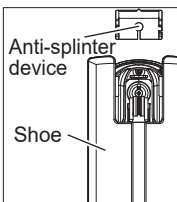
1. Remove the battery pack.
2. To install, place the transparent blade cover in front of the blade and slide it into place. The tabs will snap into the slots on the housing.
3. To remove, press in the sides of the transparent blade cover and pull away from the blade.

### Installing the Anti-Splinter Device

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

**NOTE:** Do not use the transparent blade cover and anti-splinter device when making bevel/angle cuts.

1. Remove the battery pack.
2. Slide the anti-splinter device onto the shoe. Make sure the anti-splinter device is installed flush with the bottom of the shoe.



### Installing the Shoe Cover

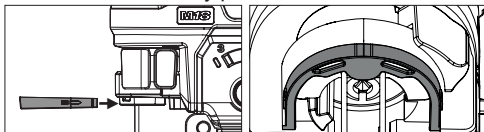
The shoe cover is used to prevent marring and scratching of the workpiece surface. To attach the shoe cover:

1. Remove the battery pack.
2. Hook the front of the cover over the steel 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.

### Installing the LED Cover

The LED cover is used to shield the LED when the tool is used in certain applications.

1. Remove the battery pack.



2. Slide the cover onto the tool in the orientation shown until it clips in place.
3. To remove, pull out the legs and away from tool.

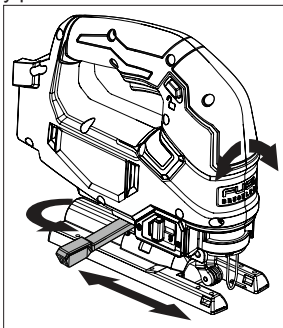
### Adjusting the Shoe

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

To set a tilt angle for bevel/angle cuts:

(Cat. No. 2737-20)

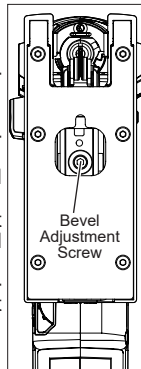
1. Remove the battery pack.
  2. Loosen the shoe adjustment lever.
  3. Pull the base forward slightly until the detents are not engaged.
  4. Tilt the shoe to the required pre-set angle (0°, 15°, 30°, or 45°) and push the shoe into the detent.
  5. To set an angle other than the pre-sets, set the desired angle without engaging a detent.
  6. Tighten the shoe adjustment lever.
  7. Make a test cut to verify the angle.
- NOTE:** If the shoe begins to slip when the lever is tightened, use the 4 mm hex wrench stored in the shoe to tighten the shoe adjustment hex sockets. Remove the shoe cover, turn the tool over, and tighten the hex sockets securely.



(Cat. No. 2737B-20)

**NOTE:** Do not attempt bevel cut with battery packs larger than 5.0Ah. Battery packs larger than 5.0Ah could result in the battery striking the workpiece during the cut.

1. Remove the battery pack.
2. Remove the shoe cover.
3. Turn the tool upside down to expose the bottom of the shoe.
4. Using the 4 mm hex wrench stored in the shoe, loosen the bevel adjustment screw.
5. Pull the base forward slightly until the detents are not engaged.
6. Tilt the shoe to the required preset angle (0°, 15°, 30°, or 45°) and push the shoe into the detent.
7. To set an angle other than the pre-sets, set the desired angle without engaging a detent.
8. Tighten the screw securely.
9. Make a test cut to verify the angle.



## Selecting Speed

Use lower speeds for materials such as plastics and laminates. Also, use lower speeds for hard metals. Use higher speeds for materials such as wood and soft metals (aluminum, copper, brass, etc.).

(Cat. No. 2737-20)

To vary the speed, increase or decrease pressure on the trigger. The further the trigger is pulled, the greater the speed.

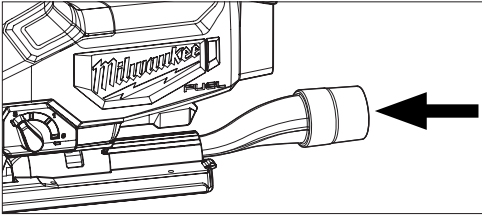
(Cat. No. 2737B-20)

Rotate the speed selector dial to the desired speed (1 through 6). Select "A" for Auto-Controlled Start to start out at 1500 SPM and ramps up to 3500 SPM once the workpiece is contacted.

**⚠WARNING** To reduce the risk of injury, wear a dust mask or use an OSHA compliant dust extraction solution when working in dusty situations.

## Dust Collection Attachment

**NOTE:** For the 2737B-20, the Dust Collection Attachment cannot be used with battery packs larger than 5.0Ah.



1. Remove the battery pack.
2. To **install**, line-up the small end of the dust collection attachment with the curved area at the back of the shoe. Slide into place.
3. To **remove**, pull the attachment away from saw.

## Blower shuttle

Set the blower shuttle to to blow air out the front of the jig saw to clear the cutting line of dust. Set the blower shuttle to to blow air out the dust chute when using a dust extraction solution.

## OPERATION

**⚠WARNING** Always remove battery pack before changing or removing accessories. Only use accessories specifically recommended for this tool. Others may be hazardous.

To reduce the risk of injury, wear safety goggles or glasses with side shields. Keep hands away from the blade and other moving parts.

To reduce the risk of injury, be sure the blade always extends beyond the shoe and workpiece throughout the stroke. Blades may shatter if they impact the workpiece.

## Starting and Stopping the Tool

(Cat. No. 2737-20)

1. To **start** the tool, grasp the handle firmly and pull the trigger.
2. To **vary** the speed, increase or decrease pressure on the trigger. The further the trigger is pulled, the greater the speed.
3. To **stop** the tool, release the trigger. Allow the tool to come to a complete stop before removing the blade from a partial cut or laying the tool down.

(Cat. No. 2737B-20)

1. Set the speed control dial to the desired speed.
2. To **start** the tool, push the slide switch forward until tool starts and release.
2. To **vary** the speed, turn the variable speed dial.
3. To **stop** the tool, press the slide switch and release. Allow the tool to come to a complete stop before removing the blade from a partial cut or laying the tool down.

**NOTE:** If the switch is held on for more than 3 seconds, the tool will shut off.

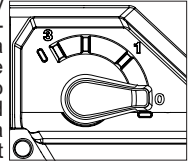
## Locking the Trigger

(Cat. No. 2737-20)

To **lock** the trigger, push the trigger lock from the lock side of the tool. The trigger will not work while the switch is in the locked position. Always lock the trigger and remove the battery pack before performing maintenance and changing accessories. Lock the trigger when storing the tool and when the tool is not in use. To **unlock** the trigger, push the trigger lock from the unlock side of the tool.

## Adjusting the Orbital Action

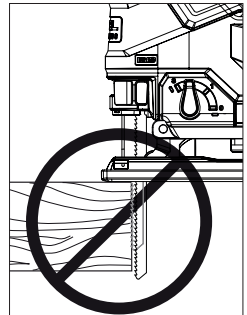
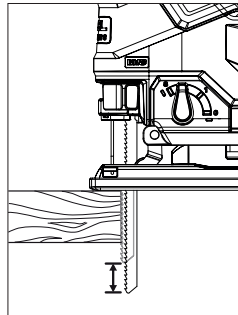
The amount of orbital action may be adjusted with the orbital action selector lever. In general, a large orbital action (3) should be used with soft materials and a no orbital action (0) should be used with hard materials. When a smooth cut is required, no orbit (0) should be used.



Material	Orbital Action
Wood	0-3
Metal	0-1
Aluminum	0-1
Plastic	0-2
Smooth Cut	0

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

To reduce the risk of injury, be sure the blade always extends beyond the shoe and workpiece throughout the stroke. Blades may shatter if they impact the workpiece.





## Making the Cut

1. Set the 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 shoe firmly against the workpiece and guide the tool 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

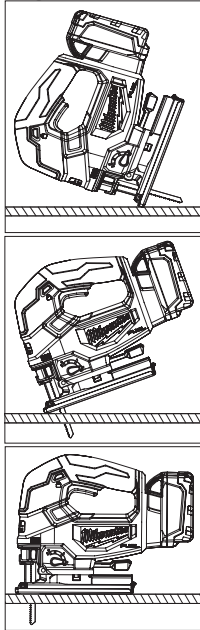
1. *Straight cuts* — To obtain a perfectly straight cut, clamp a strip of wood as a guide along the workpiece or use the rip guide (accessory).
2. *Bevel cuts* — adjust the shoe to the correct angle (see Adjusting the Shoe).
3. *Cutting Sheet Metal* — sheet metal may vibrate when being cut. To minimize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

**⚠WARNING** To reduce the risk of 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 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 tool, battery pack or charger. Contact a MILWAUKEE service facility for ALL 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 vents. Keep handles 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.