

# Owner's Manual & Safety Instructions

Save This Manual Keep this manual for the safety warnings and precautions, assembly, operating, inspection, maintenance and cleaning procedures. Write the product's serial number in the back of the manual near the assembly diagram (or month and year of purchase if product has no number). Keep this manual and the receipt in a safe and dry place for future reference.

20e



## 18 PIECE CARBON STEEL HOLE SAW SET



Visit our website at: <http://www.harborfreight.com>  
Email our technical support at: [productsupport@harborfreight.com](mailto:productsupport@harborfreight.com)

**68115**

When unpacking, make sure that the product is intact and undamaged. If any parts are missing or broken, please call 1-888-866-5797 as soon as possible.

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No portion of this manual or any artwork contained herein may be reproduced in any shape or form without the express written consent of Harbor Freight Tools. Diagrams within this manual may not be drawn proportionally. Due to continuing improvements, actual product may differ slightly from the product described herein. Tools required for assembly and service may not be included.

### **⚠WARNING**

Read this material before using this product.  
Failure to do so can result in serious injury.  
**SAVE THIS MANUAL.**

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## Specifications

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Type	Carbon Steel
Piece Count	18
Saw Sizes	3/4", 1", 1-1/8", 1-1/4", 1-1/2", 1-3/4", 2", 2-1/8", 2-1/2", 3", 3-1/2", 4", 5"
Other Pieces	Small Mandrel Large Mandrel Pilot Drill Bit Drive Plate Blow Molded Case

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## IMPORTANT SAFETY INFORMATION

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1. **Wear ANSI-approved safety goggles and heavy-duty work gloves during setup and use.**
2. **Set contains sharp blades.**  
Keep away from children.
3. **Use correct size arbor for selected Hole Saw.**
4. **Verify drill's chuck is in good condition and fits securely.**
5. **Do not use excessive pressure when cutting a hole.**
6. **Use as intended only; do not modify tools.**
7. **Inspect before every use; do not use if parts are loose or damaged.**
8. **Use both hands when drilling and keep blade at 90° to workpiece.**
9. **Store saw blades in Case in secure location away from children.**
10. **Read and adhere to all safety warnings and operating instructions of drill used with Set.**
11. **The warnings, cautions, and instructions discussed in this instruction manual cannot cover all possible conditions and situations that may occur.** It must be understood by the operator that common sense and caution are factors which cannot be built into this product, but must be supplied by the operator.



**SAVE THESE INSTRUCTIONS.**

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# SETUP

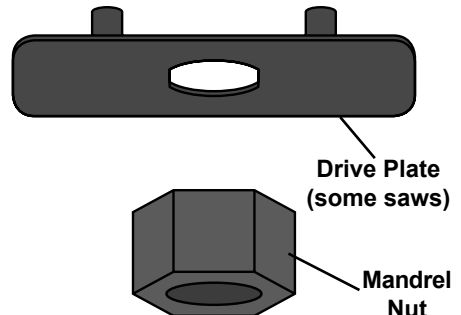
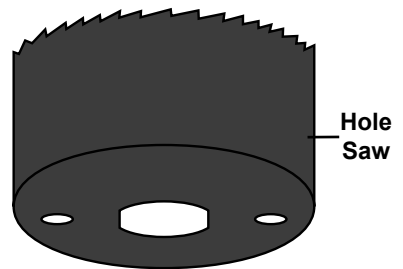
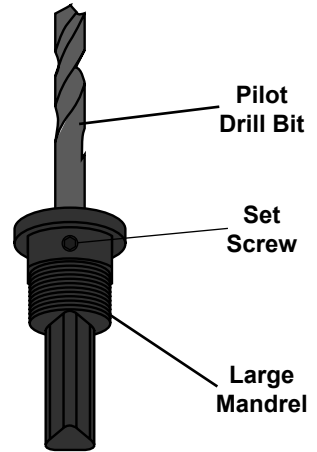
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## **⚠ CAUTION**

### **TO PREVENT INJURY:**

**Wear heavy-duty work gloves and ANSI-approved safety goggles during setup and whenever handling the Hole Saws.**

1. Select the desired size Hole Saw and either the Large or Small Mandrel.
2. The correct size Mandrel will fit exactly into the Hole Saw.
3. Unthread the Mandrel Nut from the back of the Mandrel.
4. If needed, move the Pilot Drill Bit to the selected Mandrel:
  - a. Remove the Mandrel Nut from both Mandrels.
  - b. Loosen Set Screw on the Mandrel with the Bit using the Hex Key.
  - c. Remove Pilot Drill Bit.
  - d. Insert it fully into the other Mandrel.
  - e. Tighten Set Screw to secure the Bit.
5. If the hole saw you are using has three holes, use a Drive Plate on the back of the Hole Saw.
6. Insert the Mandrel through the center of the Hole Saw and Drive Plate (if used), and secure in place using the Mandrel Nut.  
Make sure the Hole Saw is held securely by the Mandrel Nut; if not, the wrong Mandrel/ Drive Plate may have been used.
7. Open Jaws of Drill Chuck (sold separately).
8. Place the Mandrel Shaft completely into the Chuck and securely tighten the Chuck.



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## OPERATION

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1. Holding the drill at 90° to the workpiece, set the Hole Saw on the workpiece.
2. Press the drill's trigger to turn it on.
3. If the drill is a variable speed type, cut the workpiece slowly until a circle groove is made in the workpiece. Then cut faster.
4. When the hole is cut, release the trigger and wait for the Hole Saw to come to a complete stop before removing it from the workpiece.
5. When finished, remove the Hole Saw from drill's chuck.
6. Remove Hole Saw from the Mandrel and clean off Hole Saw with a cloth.
7. Store the Hole Saws inside case, out of reach of children.
8. Replace the Pilot Drill Bit if dull or broken. Make sure the Bit is securely held in place after being reinstalled.

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## LIMITED 90 DAY WARRANTY

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Harbor Freight Tools Co. makes every effort to assure that its products meet high quality and durability standards, and warrants to the original purchaser that this product is free from defects in materials and workmanship for the period of 90 days from the date of purchase. This warranty does not apply to damage due directly or indirectly, to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities, criminal activity, improper installation, normal wear and tear, or to lack of maintenance. We shall in no event be liable for death, injuries to persons or property, or for incidental, contingent, special or consequential damages arising from the use of our product. Some states do not allow the exclusion or limitation of incidental or consequential damages, so the above limitation of exclusion may not apply to you. THIS WARRANTY IS EXPRESSLY IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING THE WARRANTIES OF MERCHANTABILITY AND FITNESS.

To take advantage of this warranty, the product or part must be returned to us with transportation charges prepaid. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection verifies the defect, we will either repair or replace the product at our election or we may elect to refund the purchase price if we cannot readily and quickly provide you with a replacement. We will return repaired products at our expense, but if we determine there is no defect, or that the defect resulted from causes not within the scope of our warranty, then you must bear the cost of returning the product.

This warranty gives you specific legal rights and you may also have other rights which vary from state to state.

