

Replacement Saw Chains and Guide Bars



Model	Cutting length	Pitch	Drive Links	Loop Chain Part No.	Cutter Shape	Type	Guide Bar Part No.	Bar Mount
614	40 cm / 16"	3/8" spec.	57 E/.050"/1.3 mm	6900600	HM	91VG	6900900	A095
620	40 cm / 16"	3/8" spec.	57 E/.050"/1.3 mm	6900600	HM	91VG	6900685	A041
633	30 cm / 12"	3/8" spec.	45 E/.050"/1.3 mm	6900132	HM	91VG	6900133	A095
637	30 cm / 12"	3/8" spec.	45 E/.050"/1.3 mm	6900132	HM	91VG	6900133	A095
	35 cm / 14"	3/8" spec.	52 E/.050"/1.3 mm	6900136	HM	91VG	6900744	A095
635 / 636 / 642	30 cm / 12"	3/8" spec.	45 E/.050"/1.3 mm	6900132	HM	91VG	6900133	A095
	35 cm / 14"	3/8" spec.	52 E/.050"/1.3 mm	6900136	HM	91VG	6900744	A095
643 IP	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900704	HM	21BP	6900342	K095
	38 cm / 16"	.325"	64 E/.058"/1.5 mm	6900875	HM	21BP	6900343	K095
639 / 645 / 650 646 / 652	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900704	HM	21BP	6900342	K095
	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900875	HM	21BP	6900343	K095
	45 cm / 18"	.325"	72 E/.058"/1.5 mm	6900884	HM	21BP	6900861	K095
644	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900682	VM	21LP	6900500	K095
	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900871	VM	21LP	6900464	K095
651 SP	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900875	HM	21BP	6900343	K095
	45 cm / 18"	.325"	72 E/.058"/1.5 mm	6900884	HM	21BP	6900861	K095
651	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900682	VM	21LP	6900500	K095
	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900871	VM	21LP	6900464	K095
	45 cm / 18"	.325"	72 E/.058"/1.5 mm	6900889	VM	21LP	6900465	K095
656 SP	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900704	HM	21BP	6900342	K095
	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900875	HM	21BP	6900343	K095
	45 cm / 18"	.325"	72 E/.058"/1.5 mm	6900884	HM	21BP	6900861	K095
656 (.325")	33 cm / 13"	.325"	56 E/.058"/1.5 mm	6900682	VM	21LP	6900500	K095
	38 cm / 15"	.325"	64 E/.058"/1.5 mm	6900871	VM	21LP	6900464	K095
	45 cm / 18"	.325"	72 E/.058"/1.5 mm	6900889	VM	21LP	6900465	K095
656 (3/8")	40 cm / 16"	3/8"	60 E/.058"/1.5 mm	6900872	VM	73LP	6900466	K095
	45 cm / 18"	3/8"	68 E/.058"/1.5 mm	6900873	VM	73LP	6900742	K095
	50 cm / 20"	3/8"	72 E/.058"/1.5 mm	6900874	VM	73LP	6900467	K095
	40 cm / 16"	3/8"	60 E/.058"/1.5 mm	6900434	HM	73 DP	6900466	K095
	45 cm / 18"	3/8"	68 E/.058"/1.5 mm	6900443	HM	73 DP	6900742	K095
	50 cm / 20"	3/8"	72 E/.058"/1.5 mm	6900436	HM	73 DP	6900467	K095
665 / 675 / 681	40 cm / 16"	3/8"	60 E/.058"/1.5 mm	6900872	VM	73LP	6900368	D009
	45 cm / 18"	3/8"	68 E/.058"/1.5 mm	6900873	VM	73LP	6900498	D009
	50 cm / 20"	3/8"	72 E/.058"/1.5 mm	6900874	VM	73LP	6900370	D009
	60 cm / 24"	3/8"	84 E/.058"/1.5 mm	6900888	VM	73LP	6900372	D009
	70 cm / 28"	3/8"	92 E/.058"/1.5 mm	6900687	VM	73LP	6900937	D009
	40 cm / 16"	3/8"	60 E/.058"/1.5 mm	6900434	HM	73 DP	6900368	D009
	45 cm / 18"	3/8"	68 E/.058"/1.5 mm	6900435	HM	73 DP	6900498	D009
694 (3/8")	50 cm / 20"	3/8"	72 E/.058"/1.5 mm	6900874	VM	73LP	6900370	D009
	60 cm / 24"	3/8"	84 E/.058"/1.5 mm	6900888	VM	73LP	6900372	D009
	70 cm / 28"	3/8"	92 E/.058"/1.5 mm	6900941	VM	73LP	6900937	D009
	50 cm / 20"	3/8"	72 E/.058"/1.5 mm	6900436	HM	73 DP	6900370	D009
	60 cm / 24"	3/8"	84 E/.058"/1.5 mm	6900437	HM	73 DP	6900372	D009
	70 cm / 28"	3/8"	92 E/.058"/1.5 mm	6900438	HM	73 DP	6900937	D009
694 (.404")	60 cm / 24"	.404"	76 E/.063"/1.6 mm	6900481	HM	27.5	6900479	D009
	70 cm / 28"	.404"	84 E/.063"/1.6 mm	6900484	HM	27.5	6900482	D009
Pruning saw attachment 6900229	25 cm / 10"	3/8" lowpro	39 E/.043"/1.1 mm	6900541	HM	90VS	69 00 540	

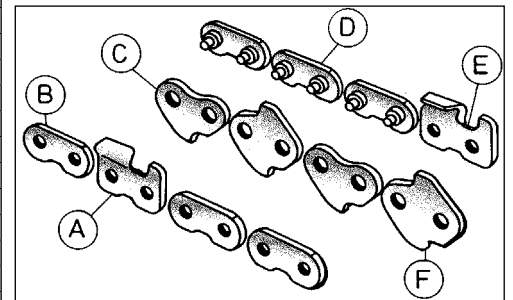
HM = Half chisel, VM = Full chisel



Brief Saw Chain Tutorial

The total engine drive power is converted to cutting performance by the saw chain. It is important to maintain a sharp chain at all times. The **chain structure** is relatively simple:

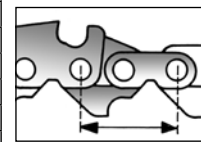
A = RH cutter, B = tie strap, C = drive link, D = pre-set tie strap, E = LH cutter, F = safety drive link



Cutter shape

Full chisel – sharp cutter edge for professional chain

Semi chisel – semi round cutter edge for semi-pro chain and hobby chain



The **saw pitch** is half the distance over three consecutive rivets (measured in inches)

Drive link



Drive link gauge
The gauge is the width of the drive link that runs in the guide bar groove.

Chain sharpening data for SOLO Chainsaws

Saw Model	Chain Pitch in inches	File Ø		Sharpening Angle			Grinder head tilt angle	Depth Gauge setting		File Holder with file
		mm	inches	Top plate angle	Horizontal	With 10° angle down		mm	inches	Part No.
620	3/8" spec. 91 VG	4,0	5/32"	30°	X		60°	0,64	.025"	00 80 447
633/637	3/8" spec. 91 VG	4,0	5/32"	30°	X		60°	0,64	.025"	00 80 447
635/636/642	3/8" spec. 91 VG	4,0	5/32"	30°	X		60°	0,64	.025"	00 80 447
643IP/646/652 651SP/656SP	0.325" 21 BP	4,8	3/16"	30°		X	60°	0,64	.025"	00 80 449
644	0.325" 21 LP	4,8	3/16"	25°		X	60°	0,64	.025"	00 80 449
651	0.325" 21 LP	4,8	3/16"	25°		X	60°	0,64	.025"	00 80 449
656	0.325" 21 LP	4,8	3/16"	25°		X	60°	0,64	.025"	00 80 449
656	3/8" 73 LP	5,5	7/32"	25°		X	60°	0,64	.025"	00 80 449
665/675/681	3/8" 73 LP	5,5	7/32"	25°		X	60°	0,64	.025"	00 80 450
656/665/675 681	3/8" 73 DP	5,5	7/32"	35°	X		60°	0,64	.025"	00 80 450
6900229 Pruning saw attachment	3/8" 90 SG	4,0	5/32"	30°	X		50°	0,64	.025"	00 80 447

21BP/73DP = Half chisel chain, 21LP/73 LP = Full chisel chain