

# 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	

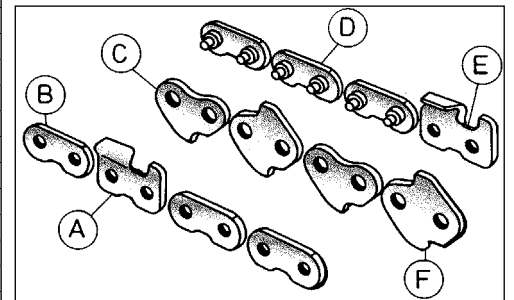
HM = Half chisel, VM = Full chisel



## 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:

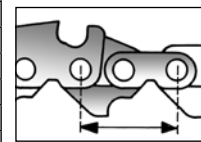
A = RH cutter, B = tie strap, C = drive link, D = pre-set tie strap, E = LH cutter, F = safety drive link



### 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 Part No.
		mm	inches	Top plate angle	Horizontal	With 10° angle down		mm	inches	
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