SERVICE PARTS LIST

BULLETIN NO. 54-27-2810

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18 FUEL™ 2" Pipe Threader			Sept. 2026
CATALOG NO. 2874-20	**SERIAL NO. K39A**	WIRING INSTRUCTION **See Page 4**	
NAMEPLATE SPECIFICATIONS:	18 V ⎓ Capacity: 1/8" - 2" (3.2 mm - 50.8 mm) FCC ID: Q0Q-BGM220S2 IC: 5123A-BGM220S2		

EXAMPLE: Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

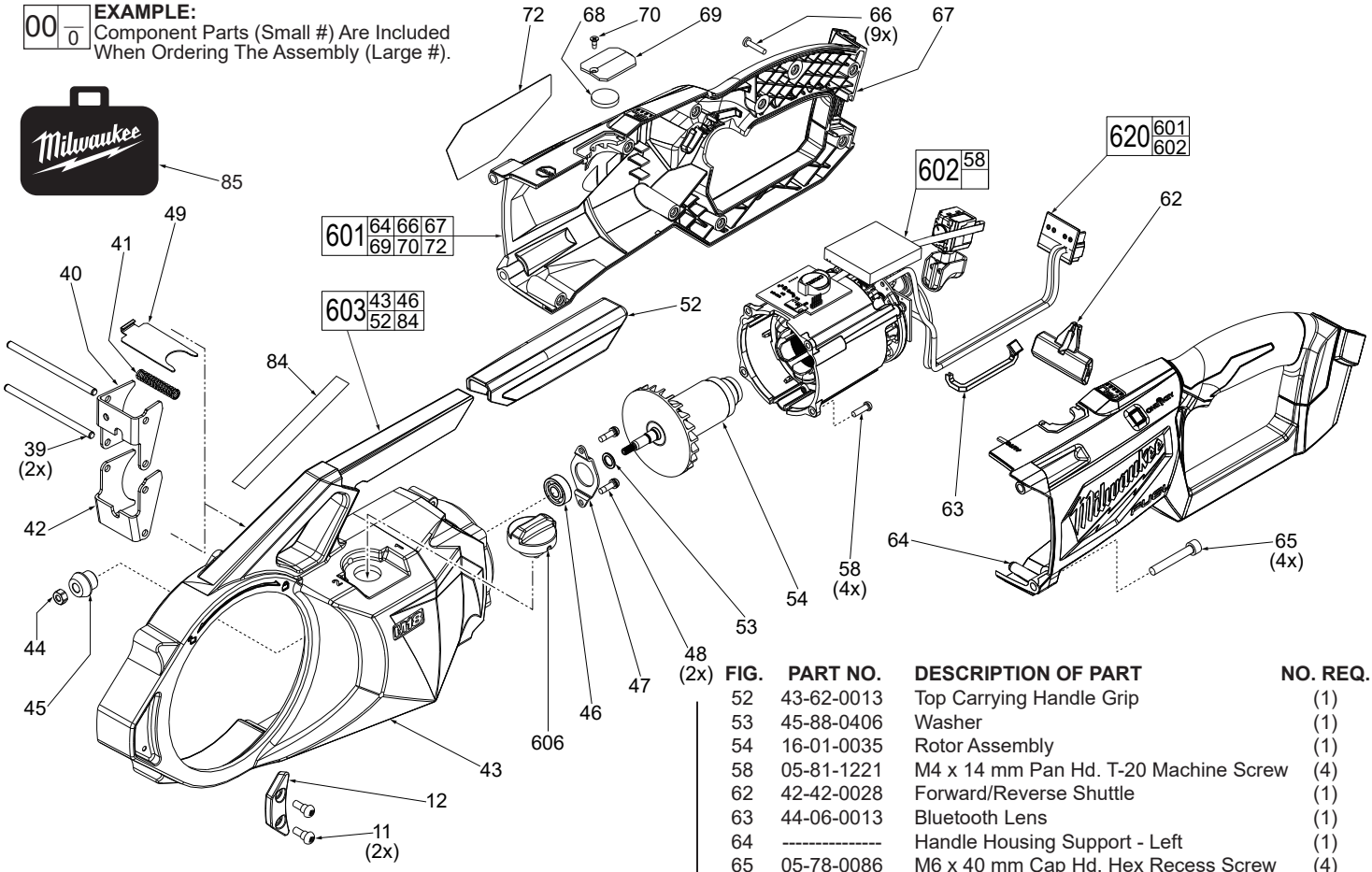


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
11	05-78-0023	#10-32 UNF Pan Hd. Shoulder Screw	(2)
12	45-88-0099	Palm Handle	(1)
39	44-94-0017	Guide Rod	(2)
40	42-36-0020	Shift Bracket A	(1)
41	40-50-0071	Spring	(1)
42	42-36-0029	Shift Bracket B	(1)
43	----------	Gearcase Support with Needle Brgs. & Pin	(1)
44	05-55-0620	Hex Nut	(1)
45	32-60-0165	Bevel Pinion	(1)
46	02-04-0845	Ball Bearing	(1)
47	44-66-0450	Bearing Retainer	(1)
48	06-81-0003	M4 x 10 mm Pan Hd. T-20 Machine Screw	(2)
49	44-86-0012	Shift Knob Retainer	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
52	43-62-0013	Top Carrying Handle Grip	(1)
53	45-88-0406	Washer	(1)
54	16-01-0035	Rotor Assembly	(1)
58	05-81-1221	M4 x 14 mm Pan Hd. T-20 Machine Screw	(4)
62	42-42-0028	Forward/Reverse Shuttle	(1)
63	44-06-0013	Bluetooth Lens	(1)
64	----------	Handle Housing Support - Left	(1)
65	05-78-0086	M6 x 40 mm Cap Hd. Hex Recess Screw	(4)
66	06-82-7261	#6-19 x 11/16" Pan Hd. T-15 ST Screw	(9)
67	----------	Handle Housing Cover - Right	(1)
68	----------	Coin Cell Battery (CR2032) - *See local hardware store*	(1)
69	31-21-0016	Coin Cell Door	(1)
70	05-78-0088	M3 x 8 mm Flat Head ST Phillips Screw	(1)
72	12-20-0148	Service Nameplate	(1)
84	10-20-3086	Warning Label	(1)
85	42-55-0066	Blow Molded Carrying Case	(1)
601	----------	Handle Housing Kit	(1)
602	----------	Electronics Assembly	(1)
603	14-30-0048	Gearcase Support Assembly	(1)
606	43-98-0024	Speed Selection Knob Assembly	(1)
620	14-20-9901	Housing Motor and PCBA Assembly	(1)

SCREW TORQUE SPECIFICATIONS

FIG.	PART NO.	DESCRIPTION OF FASTENER	WHERE USED	SEAT TORQUE (kgf-cm)	SEAT TORQUE (lb-in)
8	05-78-0013	M4 x 12 mm Flat Hd. T-20 Machine Screw	Retaining Plate	20±3	17±2
9	05-74-0026	M6 x 30 mm Cap Hd. Hex Recess Mach. Scr.	Gearcase Cover Assembly	25±3	21±2
10	05-78-0033	M5 x 20 mm Pan Hd. T-25 Machine Screw	Gearcase Cover Assembly	25±3	21±2
11	05-78-0023	#10-32 UNF Pan Hd. Shoulder Screw	Palm Handles	18±3	15±2
44	05-55-0620	Hex Nut	Bevel Pinion/ Rotor Spindle	100	86
48	06-81-0003	M4 x 10 mm Pan Hd. T-20 Machine Screw	Bearing Retainer	20±3	17±2
58	05-81-1221	M4 x 14 mm Pan Hd. T-20 Machine Screw	Motor Housing of Electronics Assembly	18±3	15±2
65	05-78-0086	M6 x 40 mm Cap Hd. Hex Recess Screw	Handle Housing Support and Cover	25±3	21±2
66	06-82-7261	#6-19 x 11/16" Pan Hd. T-15 ST Screw	Handle Housing Cover	16±3	14±2
70	05-78-0088	M3 x 8 mm Flat Hd. ST Phillips Screw	Coin Cell Door	4±2	3±1

Red denotes critical torque value

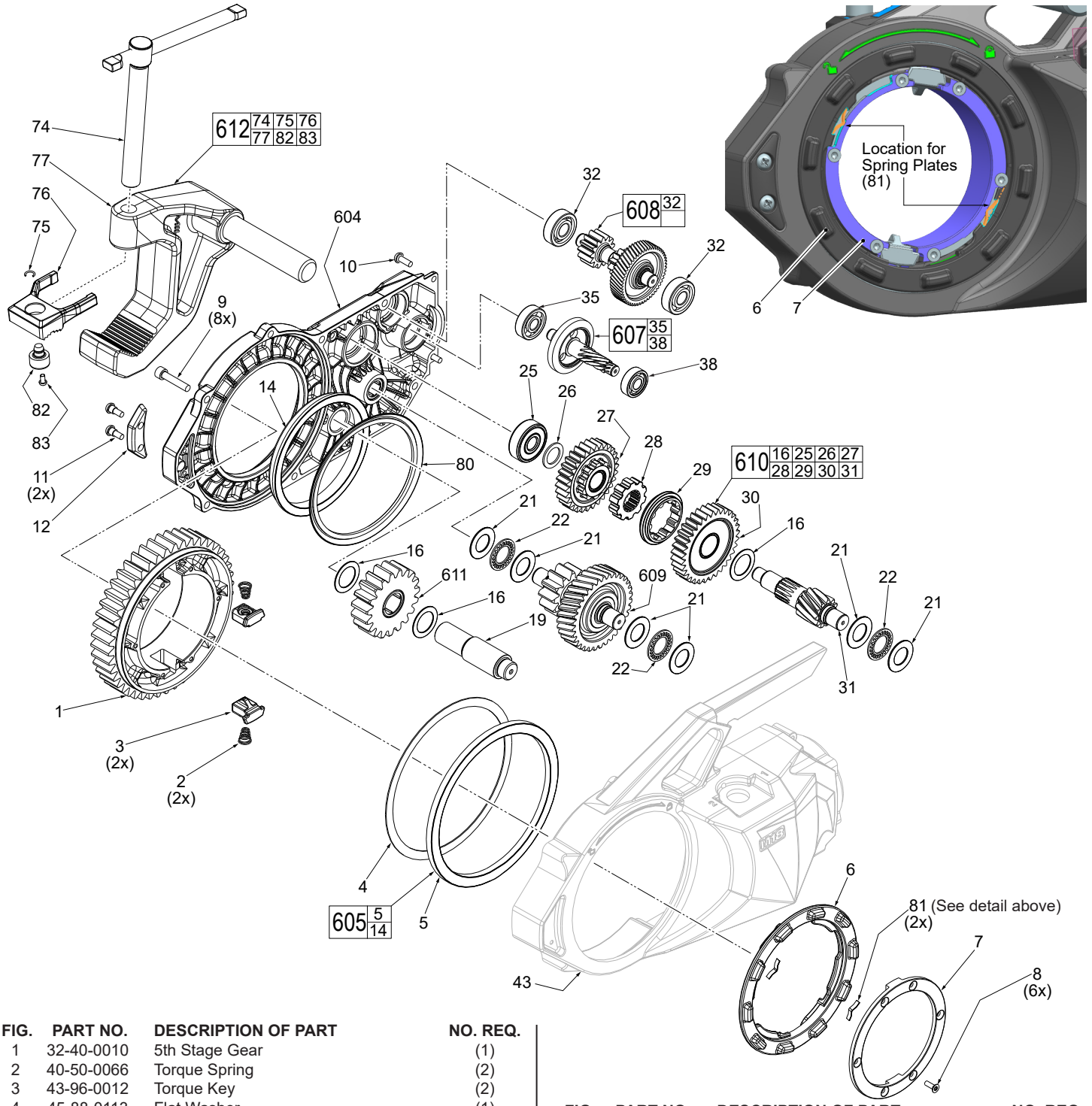


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	32-40-0010	5th Stage Gear	(1)
2	40-50-0066	Torque Spring	(2)
3	43-96-0012	Torque Key	(2)
4	45-88-0113	Flat Washer	(1)
5	----------	Front Output Gear Bushing	(1)
6	44-90-0038	Die Lock Ring	(1)
7	44-66-0088	Retaining Plate	(1)
8	05-78-0013	M4 x 12 mm Flat Head T-20 Machine Screw	(6)
9	05-74-0026	M6 x 30 mm Cap Hd. Hex Recess Mach. Scr.	(8)
10	05-78-0033	M5 x 20 mm Pan Hd. T-25 Machine Screw	(1)
11	05-78-0023	#10-32 UNF Pan Hd. Shoulder Screw	(2)
12	45-88-0099	Palm Handle	(1)
14	----------	Rear Output Gear Bushing	(1)
16	45-88-0133	Flat Washer	(3)
19	45-08-0014	Intermediate Shaft	(1)
21	45-88-0118	Flat Washer	(6)
22	02-50-0012	Thrust Bearing	(3)
25	02-04-0037	Ball Bearing	(1)
26	45-88-0120	Flat Washer	(1)
27	32-40-0012	Stage 3 Gear High	(1)
28	32-30-0012	Drive Hub	(1)
29	42-90-0023	Coupler	(1)
30	32-40-0014	Stage 3 Gear Low	(1)
31	32-40-0016	4th Stage Pinion Shaft	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
32	02-04-1860	Ball Bearing	(2)
35	02-04-0041	Ball Bearing	(1)
38	02-04-0047	Ball Bearing	(1)
43	----------	Gearcase Support	(1)
74	31-44-0114	Clamp Handle Assembly	(1)
75	34-60-0091	Retaining Ring	(1)
76	43-98-0026	Upper Jaw	(1)
77	31-44-0126	Clamp Body	(1)
80	45-06-0018	V-Ring Seal	(1)
81	40-50-0027	Spring Plate (see detail above)	(2)
82	45-08-0071	Upper Jaw Shaft	(1)
83	05-81-0166	M4 x 7 mm Pan Hd. T-20 Screw	(1)
604	42-92-0039	Gearcase Cover Assembly	(1)
605	42-40-0022	Output Gear Bushing Kit	(1)
607	36-66-0021	Intermediate Shaft Assembly-1	(1)
608	36-66-0023	Intermediate Shaft Assembly-2	(1)
609	36-66-0027	Intermediate Shaft Assembly-4	(1)
610	36-66-0031	Intermediate Shaft Assembly-3	(1)
611	36-66-0029	Intermediate Gear Assembly-5	(1)
612	31-17-0012	Material Clamping Assembly	(1)

LUBRICATION

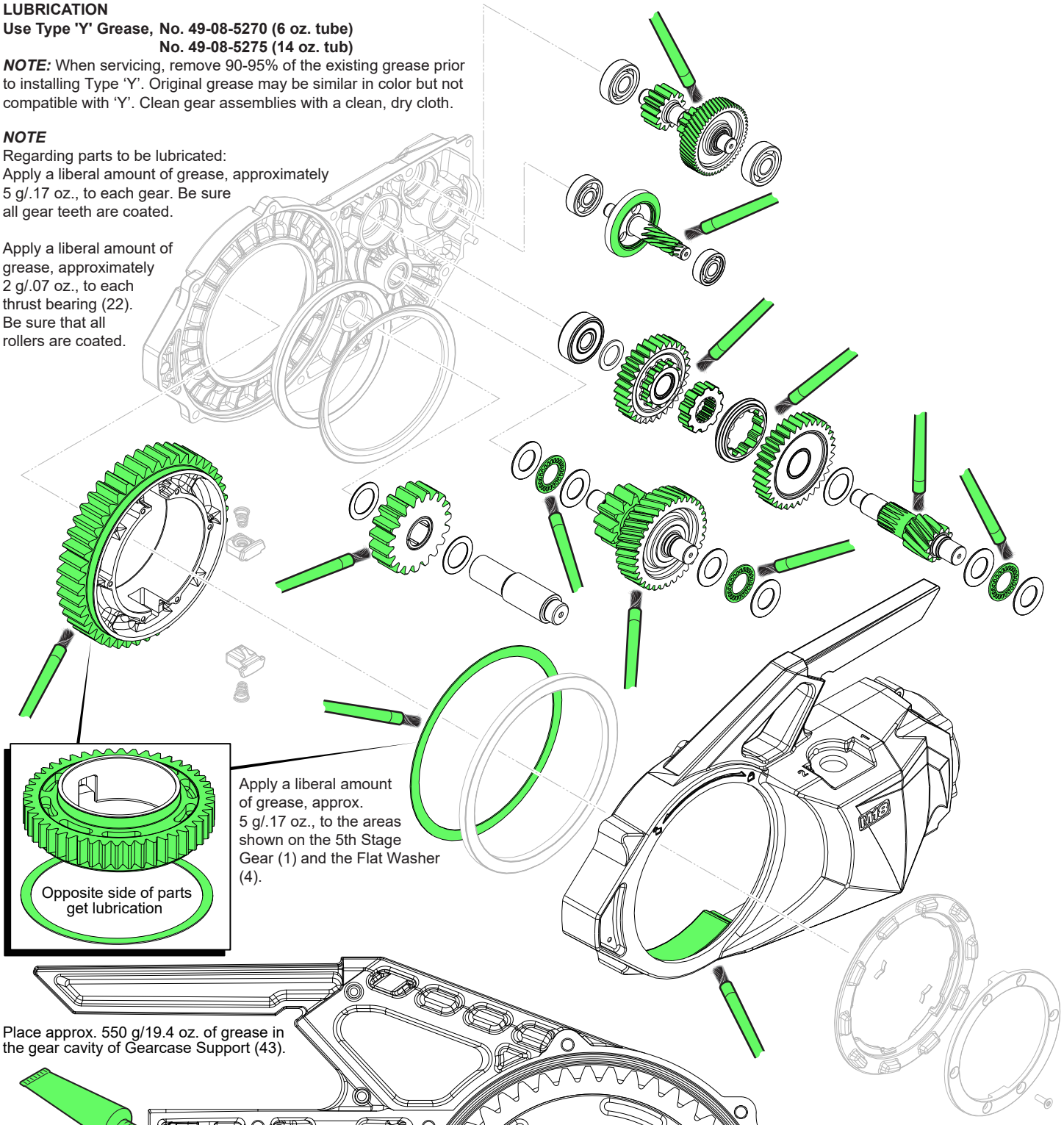
Use Type 'Y' Grease, No. 49-08-5270 (6 oz. tube)
No. 49-08-5275 (14 oz. tub)

NOTE: When servicing, remove 90-95% of the existing grease prior to installing Type 'Y'. Original grease may be similar in color but not compatible with 'Y'. Clean gear assemblies with a clean, dry cloth.

NOTE

Regarding parts to be lubricated:
Apply a liberal amount of grease, approximately 5 g/.17 oz., to each gear. Be sure all gear teeth are coated.

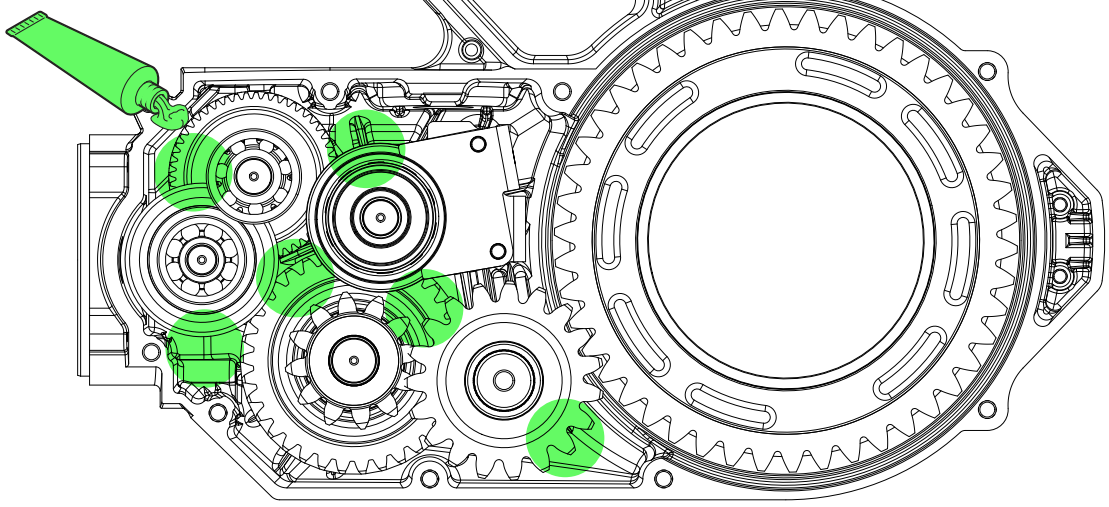
Apply a liberal amount of grease, approximately 2 g/.07 oz., to each thrust bearing (22). Be sure that all rollers are coated.



Opposite side of parts get lubrication

Apply a liberal amount of grease, approx. 5 g/.17 oz., to the areas shown on the 5th Stage Gear (1) and the Flat Washer (4).

Place approx. 550 g/19.4 oz. of grease in the gear cavity of Gearcase Support (43).



As an aid to reassembly, take notice of wire routing and position in wire guides and traps while dismantling tool.

Be sure all electrical components are firmly and squarely seated in handle cavities.

Be careful and avoid pinching wires between handle halves by tucking wires completely down in traps and channels when assembling.

Prior to installing the battery, check for proper functionality of switches, slides and buttons after housings and handles are secure.

Install battery and verify the proper operation of tool.

