Alignment Plugs -For Service Only
Not component of tool.

**Alignment Plugs**

1. Slide Water Barrier (54) over Quik-Lok Blade Clamp (49) and seat firmly on the front of the fully assembled Gear Case/Motor Assembly.

2. Insert Shoe (1) through the two slots on the Water Barrier (54) and secure to the assembled Gear Case with two T-20 Screws (41).

FIG. PART NO. DESCRIPTION OF PART NO. REQ.

1 45-16-0925 Shoe (1)
2 34-60-3680 Retaining Ring (1)
3 42-50-0076 Front Cam (1)
4 42-50-0077 Rear Cam (1)
5 44-60-0626 Lock Pin (1)
6 45-22-0081 Sleeve (1)
7 40-50-0161 Torsion Spring (1)
8 31-15-0511 Spring Cover (1)
9 44-86-0740 Front Cap (1)
10 45-06-0880 Felt Seal (1)
11 38-50-0411 Spindle and Bushing Kit (1)

12 45-16-0925 Shoe (1)

13 34-60-3680 Retaining Ring (1)

14 42-50-0076 Front Cam (1)

15 42-50-0077 Rear Cam (1)

16 44-60-0626 Lock Pin (1)

17 45-22-0081 Sleeve (1)

18 40-50-0161 Torsion Spring (1)

19 31-15-0511 Spring Cover (1)

20 44-86-0740 Front Cap (1)

21 45-06-0880 Felt Seal (1)

22 38-50-0411 Spindle and Bushing Kit (1)

**FIG. PART NO. DESCRIPTION OF PART NO. REQ.**

**SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS**

**CATALOG NO. 2625-20**

**STARTING SERIAL NO. C41D**

**NOTE:**
Clean Gearcase Kits (44 and 45) with a clean, dry cloth. DO NOT wash up.

**Alignment Plugs**

- For Service Only
- Not component of tool.

**FIG. PART NO. DESCRIPTION OF PART NO. REQ.**

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**WIRING INSTRUCTION SEE PAGE 3**

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

**FIG. PART NO. DESCRIPTION OF PART NO. REQ.**

**CATALOG NO. 2625-20**

**STARTING SERIAL NO. C41D**

**SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS**

**CATALOG NO. 2625-20**

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**FIG. PART NO. DESCRIPTION OF PART NO. REQ.**

**CATALOG NO. 2625-20**

**STARTING SERIAL NO. C41D**

**NOTE:**
Clean Gearcase Kits (44 and 45) with a clean, dry cloth. DO NOT wash up.
Picture “A and B” show the components that make-up the Right and Left Gearcase kits for M18 Cordless Hackzall 2625-20. Each kit contains one [1] Alignment Plug / Key and [1] round Aluminum adhesive backed disc (not sold separately) which will be needed when servicing / replacing the gearcase assemblies of the M18 Hackzall.

The Right and Left helical gear assemblies are supported independently in their respective gearcase assembly and turn independently. Each of the helical gears have a counter weight and when the two gearcase halves are assembled together gearing must be synchronized to eliminate excessive vibration.

Synchronization of the two gear case halves can be accomplished by using the Alignment Plug / Key supplied with each gearcase kit. Anytime motor assembly 23-30-0901 has to be removed from the gearcase halves, helical gears will need to be resynchronized using the alignment plug / key.

**Synchronizing / Assembling Gearcase Kit Assemblies 14-30-1031 – 14-30-1041**

Once the motor assembly has been removed from the gearcase assembly the keyway cut into each helical gear will no longer be aligned with the gearcase keyway (fig. 1) due to the counter balance of the helical gear.

1. Rotate (by hand) helical gear in right gearcase (picture “A”) until helical gear keyway is in-line with the gearcase keyway (fig. 2).
2. Install plug / key from kit into gearcase / helical gear keyway (fig. 3).
3. Install drive pin sleeve onto pin located on right helical gear (coat with type “L” grease).
4. Install spindle / gearcase bushing assembly into right gearcase (coat components with type “L” grease and make sure spindle lock pin hole faces right gearcase).
   Note: If new felt seal is being installed saturate seal with a lightweight oil.
5. Place approximately 1/8oz. Type “L” grease onto teeth of right helical gear. (Set assembly aside).
6. Rotate (by hand) helical gear in left gearcase (picture “B”) until helical gear keyway is in-line with the gearcase keyway (fig. 2).
7. Install plug / key from kit into gearcase / helical gear keyway (fig. 3).
8. Place approximately 1/8oz. Type “L” grease onto teeth of left helical gear.
10. Install motor assembly 23-30-0900 and secure to gearcase assembly.
11. Remove left and right alignment plug (s) and apply aluminum tape disc from kits to each side of gearcase (fig.4). **SAVE PLUGS** in case motor needs servicing or replacing.
REMOVING THE STEEL QUIK-LOK® BLADE CLAMP (49)
- Remove external retaining ring (2) and pull front cam (3) off.
- Pull lock pin (5) out and remove remainder of parts and discard.

REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP (49)
- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.
- Place spring cover (8) onto spindle.
- Slide torsion spring (7) onto spindle with spring leg on hole side of spindle.
- Slide sleeve (6) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (4) over sleeve (6) until it bottoms on sleeve shoulder, ensure leg of spring (7) inserts into outer slot in rear cam (4).
- Rotate rear cam in the direction of the arrows located on spring cover until there is clearance for lock pin (5) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (3) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring groove on the spindle shaft (12) should be completely visible.
- Attach retaining ring (2) by separating coils and inserting end of ring into groove, then wind remainder of ring into groove. Ensure ring is seated in groove.
- Blade clamp should rotate freely. During normal usage, debris may not allow blade clamp to rotate freely. The use of spray lubricant can help free blade clamp. In extreme conditions, follow these instructions to remove, clean and reassemble blade clamp.