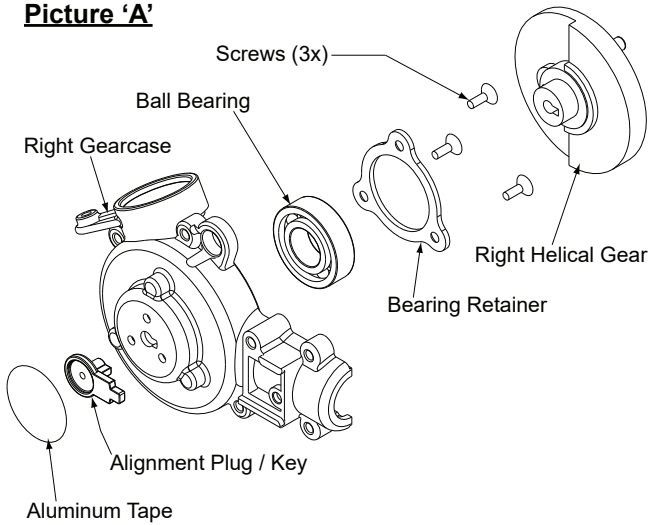


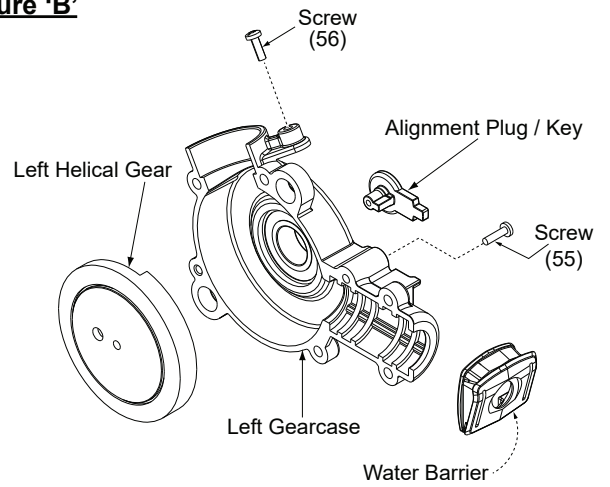


**Picture 'A'**



Components of **Right Gearcase Kit #14-30-1031**

**Picture 'B'**



Components of **Left Gearcase Kit #14-30-1051**

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. The right gearcase kit has an aluminum adhesive backed disc (not sold separately) which will be needed when servicing / replacing the right gearcase assembly.

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.**

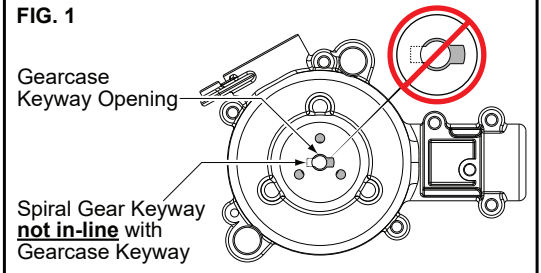
Synchronization of the two gear case halves can be accomplished by using the Alignment Plug / Key supplied with each gearcase kit. Anytime motor assembly 23-30-0901 has to be removed from the gearcase halves, helical gears will need to be resynchronized using the alignment plug / keys.

**Synchronizing / Assembling Gearcase Kit Assemblies 14-30-1031 – 14-30-1051**

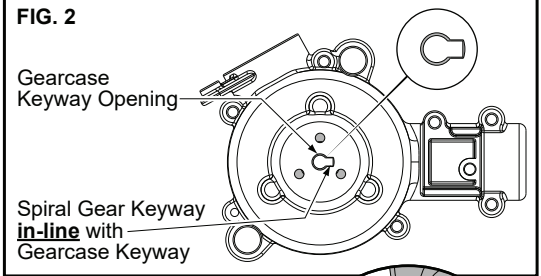
Once the **motor assembly** has been removed from the gearcase assembly the keyway cut into each **helical gear** will no longer be aligned with the **gearcase keyway** ( fig. 1) due to the counter balance of the helical gear.

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).

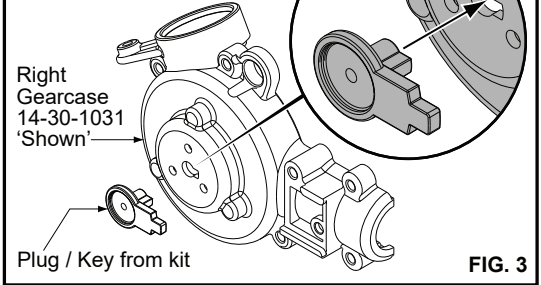
**FIG. 1**



**FIG. 2**

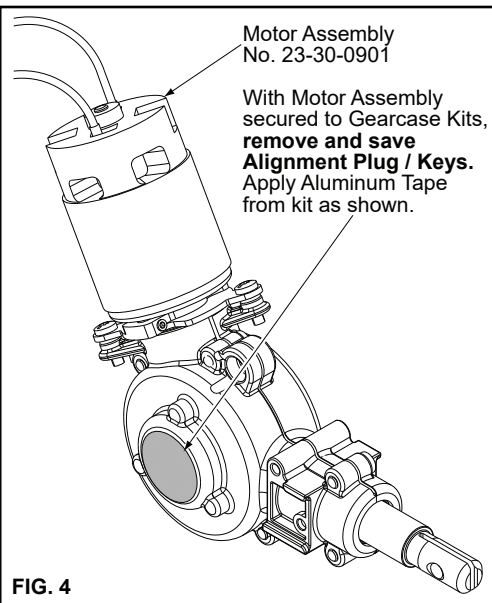


**Alignment Plug / Key installed in Gearcase**



**FIG. 3**

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.
9. Assemble lubricated left gearcase assembly onto lubricated right gearcase assembly and install five [5] gearcase screws.
10. Install motor assembly 23-30-0901 and secure to gearcase assembly.
11. Remove left and right alignment plug (s) and apply aluminum tape disc from kit to the right of gearcase (fig.4). **SAVE PLUGS** incase motor needs servicing or replacing.



**FIG. 4**

