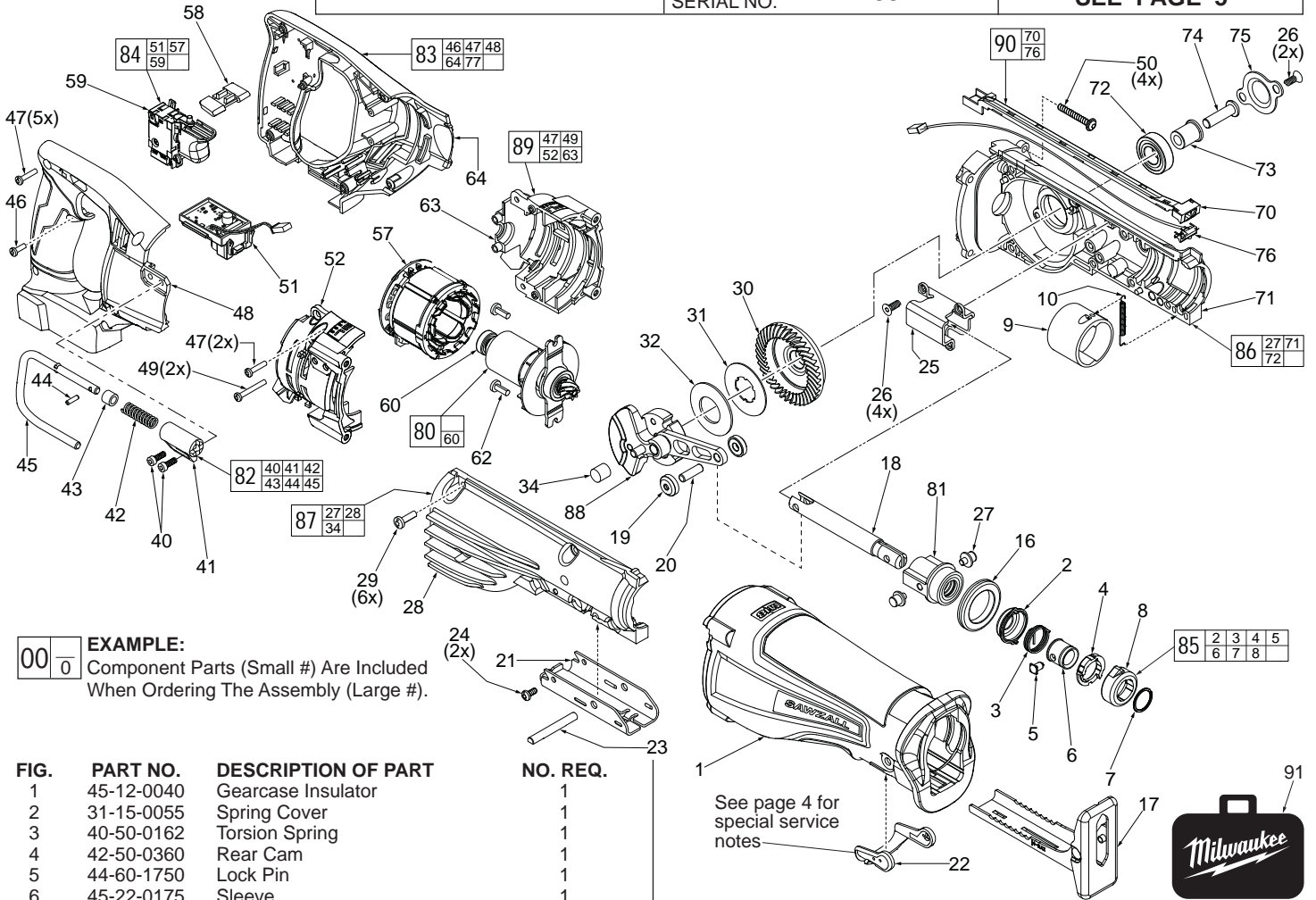




# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-40-2700**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>M18 FUEL™ SAWZALL® Reciprocating Saw</b>			Sept. 2013
CATALOG NO. <b>2720-20</b>	STARTING SERIAL NO. <b>F39A</b>	WIRING INSTRUCTION <b>SEE PAGE 5</b>	

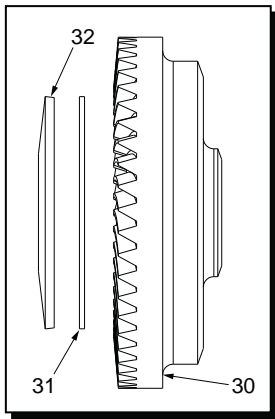
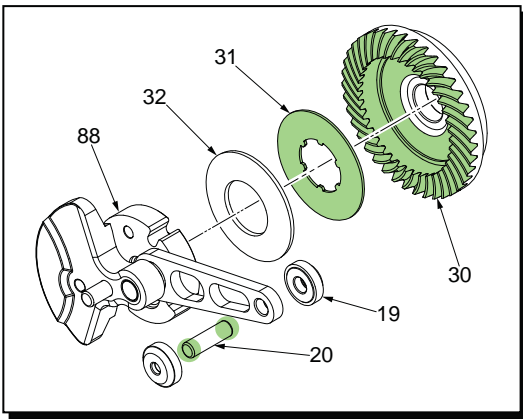


**EXAMPLE:**  
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	45-12-0040	Gearcase Insulator	1
2	31-15-0055	Spring Cover	1
3	40-50-0162	Torsion Spring	1
4	42-50-0360	Rear Cam	1
5	44-60-1750	Lock Pin	1
6	45-22-0175	Sleeve	1
7	34-60-3700	Retaining Ring	1
8	42-50-0025	Front Cam	1
9	31-11-0105	Barrel Cam	1
10	40-50-8805	Extension Spring	1
16	45-06-0230	'H' Seal	1
17	45-16-0135	Shoe Assembly	1
18	38-50-0076	Spindle	1
19	42-40-2052	Rollers	2
20	06-65-0145	Pin - Connecting Rod	1
21	44-86-0225	Shoe Retainer	1
22	31-15-2015	Shoe Release Lever	1
23	44-60-1635	Shoe Pin	1
24	06-82-7253	8-32 x 3/8" Pan Hd. Taptite T-20 Screw	2
25	43-56-0045	Orbit Slot	1
26	06-82-8870	1/2-DG50 Thread Form T-20 Screw	6
27	06-65-0135	Pivot Pin	2
28	-----	Gearcase Halve - Right	1
29	06-82-5411	10-24 x 0.625 Pan Hd. Taptite T-25 Scr.	6
30	32-05-1010	Bevel Gear	1
31	43-06-0025	Metal Plate	1
32	40-50-0595	Disc Spring	1
34	02-50-1640	Needle Bearing	1
40	05-78-0910	M4 x 12mm Fillister Hd. Screw	2
41	-----	Rafter Hook Mounting Bracket	1
42	-----	Rafter Hook Spring	1
43	-----	Rafter Hook Bushing	1
44	-----	Spring Pin	1
45	-----	Rafter Hook	1
46	06-82-7240	6-19 x 1/2" Pan Hd. Plast. T-15 Screw	1
47	06-82-7261	6-19 x 11/16" Pan Hd. Plast. T-15 Scr.	7
48	-----	Handle Halve - Right	1
49	06-82-7290	6-19 x 1-1/8" Pan Hd. Plast. T-15 Scr.	2
50	05-88-8309	M5 x 35mm Pan Hd. Taptite T-20 Screw	4

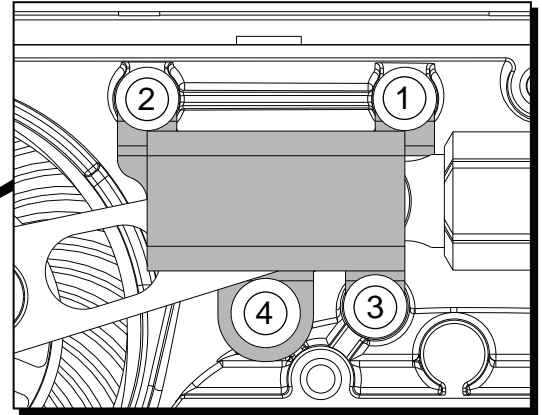
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
51	-----	Control Board/Terminal Connector Block	1
52	-----	Motor Cage - Right	1
57	-----	Stator/PCBA Assembly	1
58	42-42-0195	Lockoff Shuttle	1
59	-----	On-Off Switch	1
60	02-04-0645	Ball Bearing	1
62	06-82-5314	10-24 x 1/2" Pan Hd. Tapt. T-25 Screw	2
63	-----	Motor Cage - Left	1
64	-----	Handle Halve - Left	1
70	-----	LED Tray	1
71	-----	Gearcase Halve - Left (w/ locating pins)	1
72	02-04-1516	Ball Bearing	1
73	42-40-0076	Spacer	1
74	06-08-0019	Drive Hub Bolt (Left Hand Thread)	1
75	44-66-0280	Bearing Retaining Plate	1
76	-----	LED Assembly	1
77	12-20-2669	Service Nameplate (Not Shown)	1
80	16-01-0110	Rotor Assembly	1
81	14-86-0105	Front Bushing Assembly	1
82	14-36-0340	Rafter Hook Assembly	1
83	14-34-0260	Handle Halve Assembly	1
84	14-20-0325	Electronics Assembly	1
85	42-68-1200	Quik-Lok® Blade Clamp Kit	1
86	14-30-0185	Gearcase Halve - Left Assembly	1
87	14-30-0180	Gearcase Halve - Right Assembly	1
88	14-09-1000	Crankshaft Assembly	1
89	14-50-0215	Motor Cage Assembly	1
90	22-09-2600	LED and Tray Assembly	1
91	42-55-2720	Carrying Case	1

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
13135 W. Lisbon Road, Brookfield, WI 53005  
Drwg. 2



Concave side of disc spring (32) must face toward metal plate (31) and bevel gear (30).

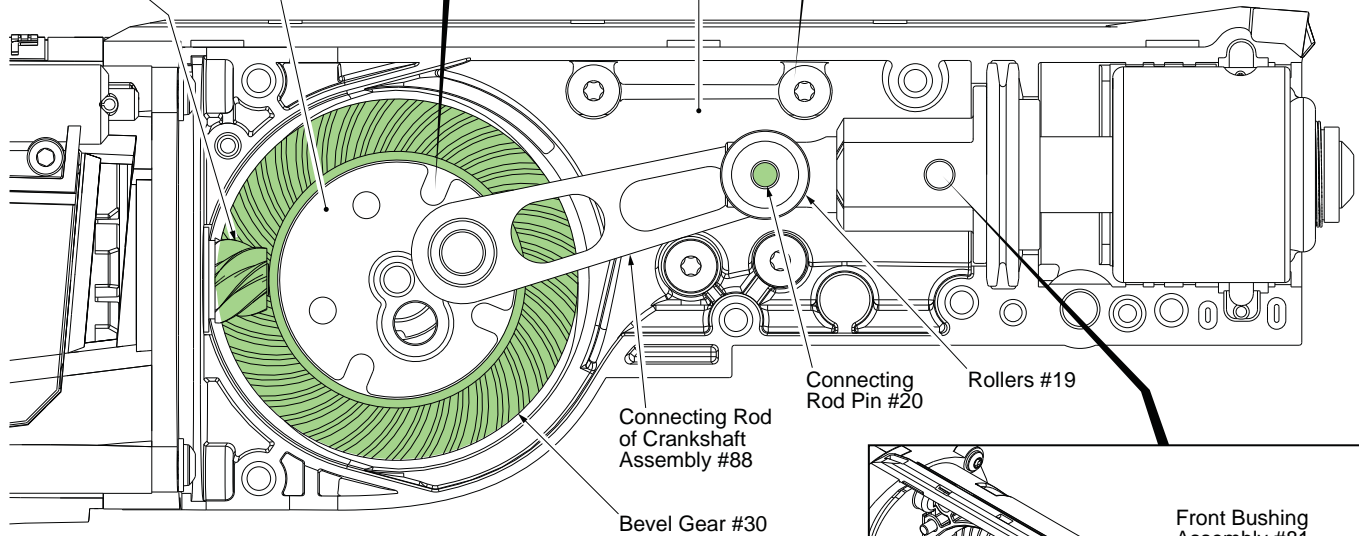
When securing the orbit slot (25), tighten screws (26) in the order shown.



Pinion Gear of Rotor Assembly #80

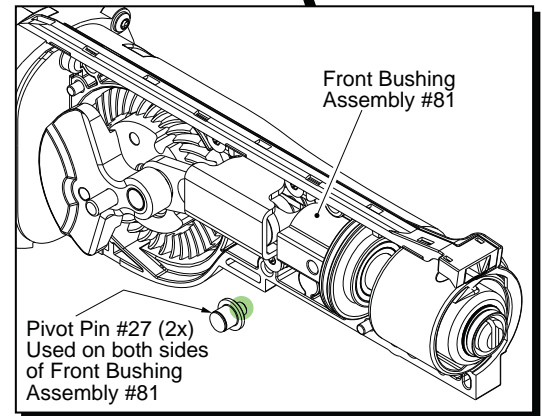
**NOTE:** Counter Weight of Crankshaft Assembly #88 has been removed for clarity (to reveal pinion gear)

**NOTE:** Orbit Slot #25 has been removed from this view for clarity (to reveal Connecting Rod Pin #20 and Rollers #19)



Connecting Rod Pin #20  
Rollers #19

Connecting Rod of Crankshaft Assembly #88  
Bevel Gear #30



Front Bushing Assembly #81

Pivot Pin #27 (2x)  
Used on both sides of Front Bushing Assembly #81

**LUBRICATION: Type 'L' Grease**  
**No. 49-08-4175 (16 oz. tub)**

- Place 30g ±3g (approx. 1 ounce) on top of gear (30) and pinion gear of rotor assembly (80), being sure to cover the middle of the gear and all teeth.
- Place 15g ±3g (approx. .5 ounce) to the area where the gear (30) and the connecting rod of crank shaft assembly (88) interface.
- Coat both sides of the metal clutch plate (31).
- Lightly coat both pivot pins (27) where connections go into holes of front bushing assembly (81).
- Lightly coat both ends of pin (20) prior to installing rollers (19).

**BACK VIEW**

Ball bearing (3) to be pressed to gearcase stop with seal to the outside.

Press needle bearing (5) flush to subflush .005".

Retaining Plate (75)

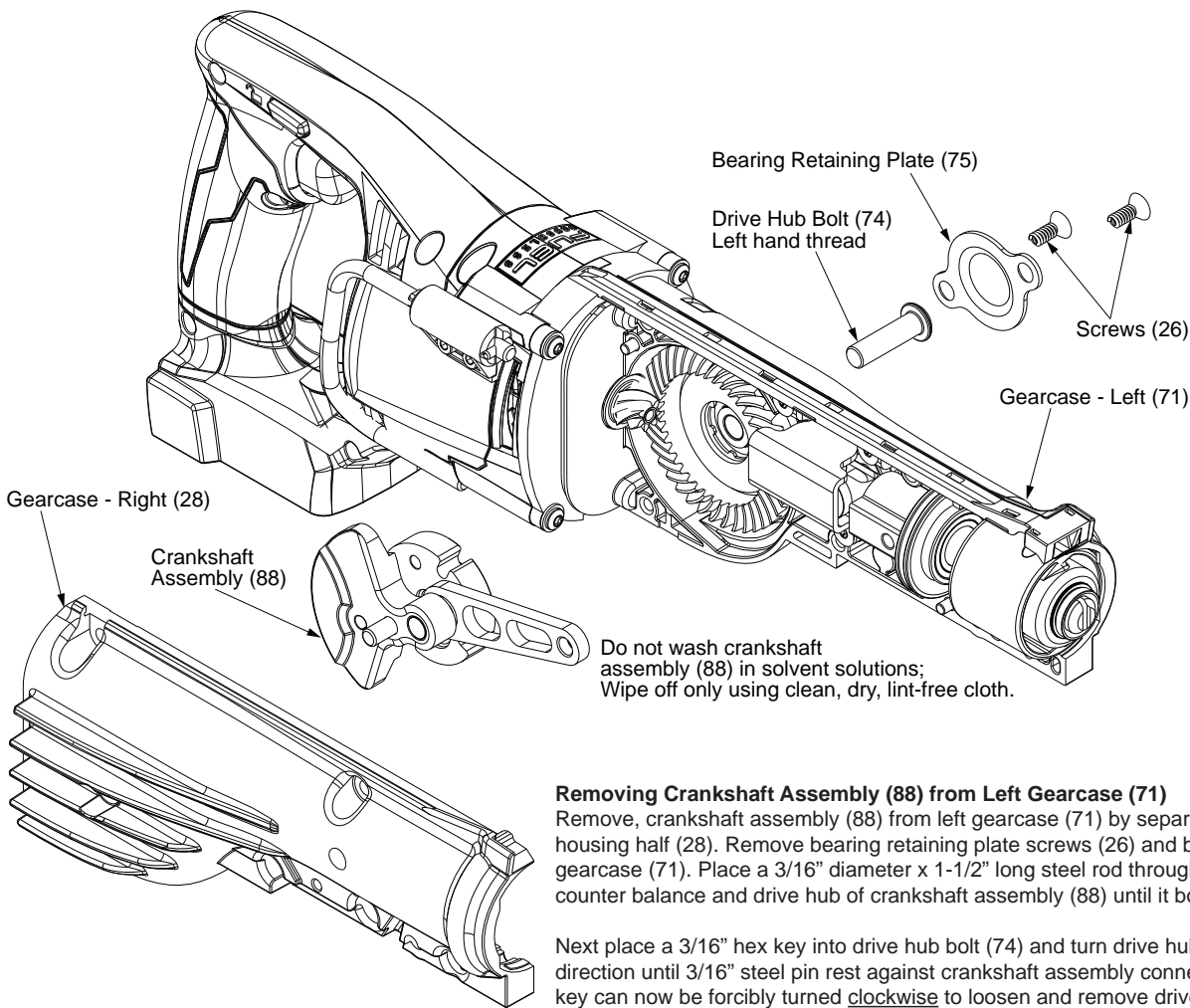
Seal

Gearcase stop

Approximately .020-.025 above gearcase bore

Ball bearing (72)





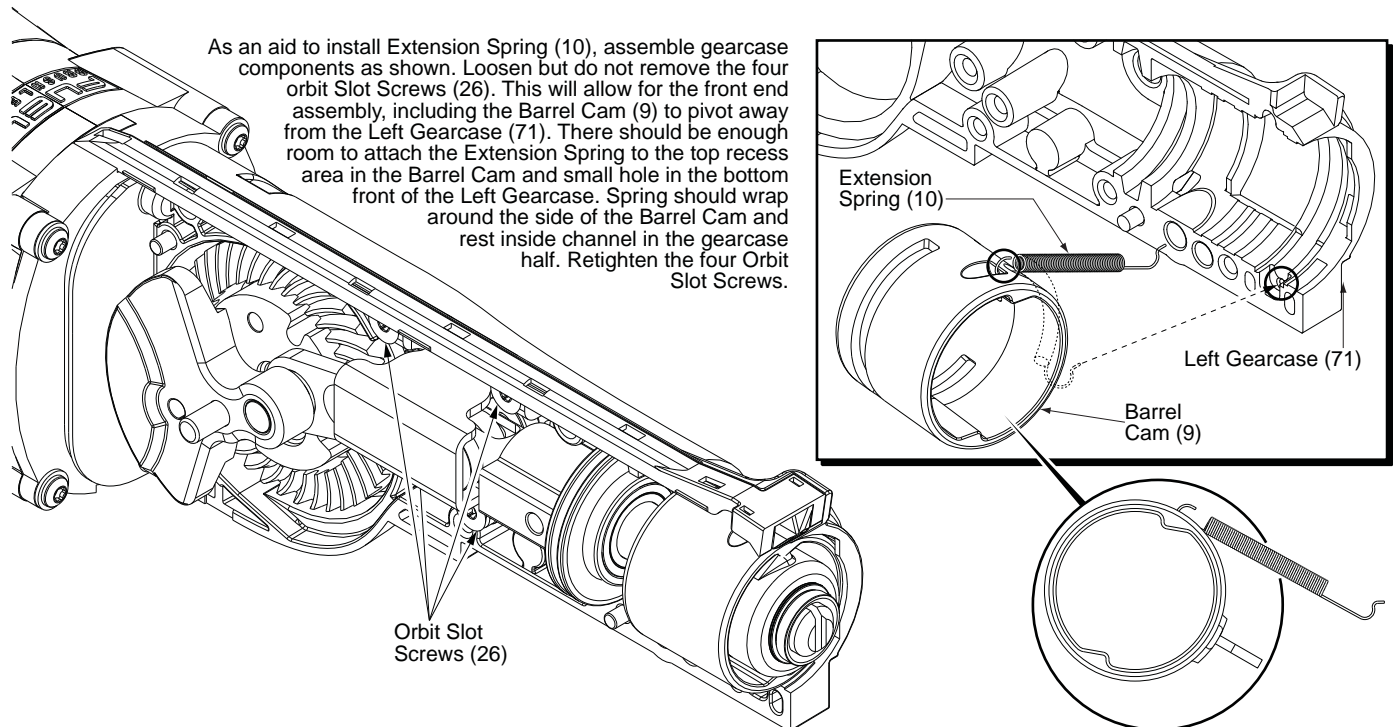
**Removing Crankshaft Assembly (88) from Left Gearcase (71)**

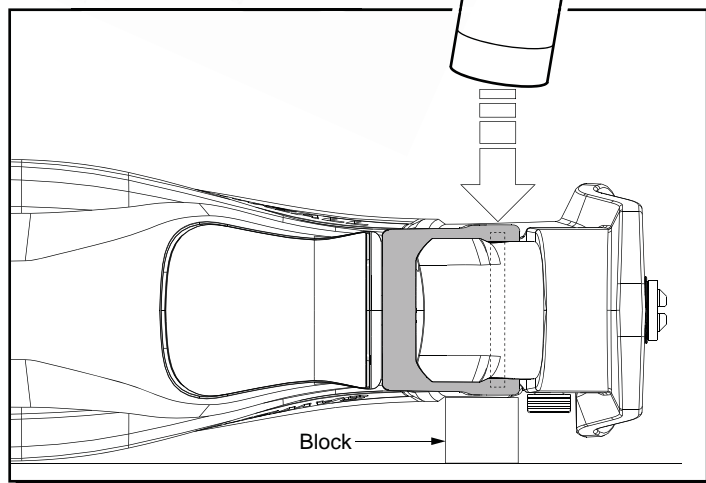
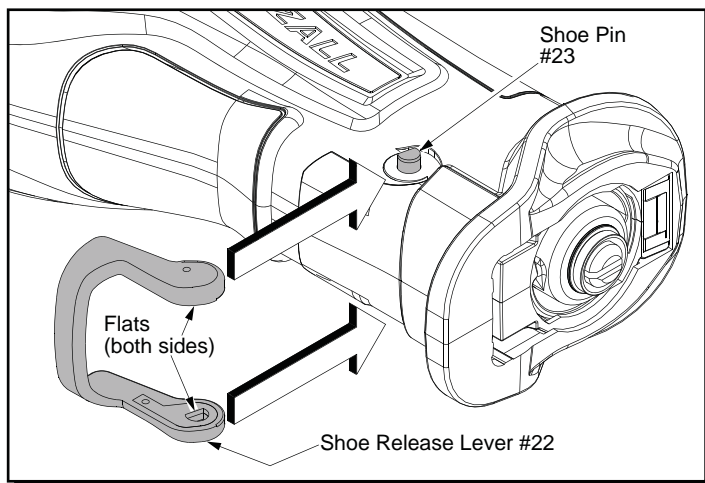
Remove crankshaft assembly (88) from left gearcase (71) by separating / removing right housing half (28). Remove bearing retaining plate screws (26) and bearing plate (75) from left gearcase (71). Place a 3/16" diameter x 1-1/2" long steel rod through the holes found in the counter balance and drive hub of crankshaft assembly (88) until it bottoms out.

Next place a 3/16" hex key into drive hub bolt (74) and turn drive hub bolt slowly in a clockwise direction until 3/16" steel pin rest against crankshaft assembly connecting rod. The 3/16" hex key can now be forcibly turned clockwise to loosen and remove drive hub bolt (74).

**Reinstalling Crankshaft Assembly (88) into Left Gearcase (71)**

To reinstall drive hub bolt (74) to crankshaft assembly (88) apply Blue Loctite® (44-20-0090) to threads of drive hub bolt (74) and insert through spacer (73) aligning threads of drive hub bolt (74) with internal threads of crankshaft assembly hub. Use a 3/16" hex key to turn the drive hub bolt (74) slowly in a counter clockwise direction until 3/16" steel pin rest against crankshaft assembly connecting rod (See 'Removing Crankshaft Assembly' instructions above). Using an inch pound torque wrench and a 3/16" hex key, torque drive hub bolt (74) to 210-240 in. lbs. or bolt can be tightened using a ft. lbs. torque wrench to 17-20 ft. lbs.





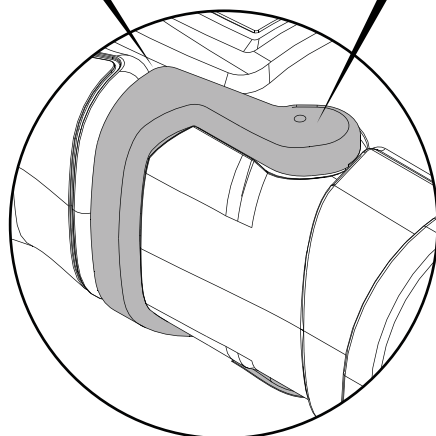
**To properly install the Shoe Release Lever #22 onto the Shoe Pin #23 do the following:**

Insert the shoe pin through the hole in the gearcase insulator. Center the shoe pin with equal amounts of the pin protruding from each side of the tool.

Rotate the shoe pin so the flats of the pin will align with the flats in the shoe release lever cavities.

The shoe release lever is stiff but flexible. Place the shoe release lever over the gearcase insulator. Lift one end of the shoe release lever onto the shoe pin (with flats aligned) and press into place.

Pull the other end of the shoe release lever over the other side of the pin and press in place.



Place the tool on its side on a hard flat surface. Place a small wood block approximately 1-1/8" thick under the tool, between the hard surface and the shoe release lever, directly beneath the pin.

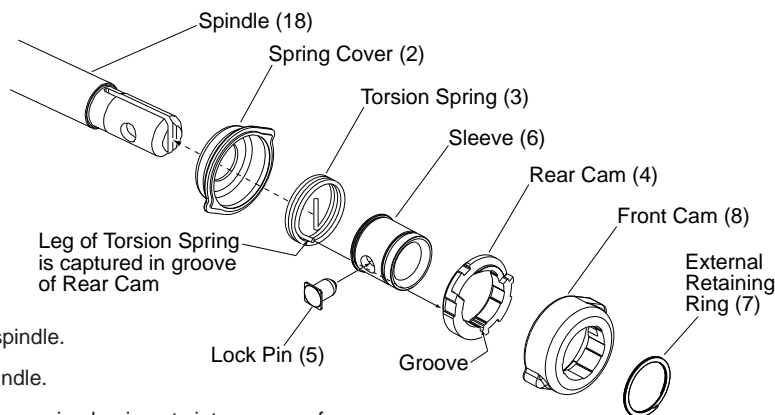
With a rubber mallet, strike the shoe release lever several times to completely seat the lever onto the pin and to assure that the pin is properly centered within the gearcase.

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP -**

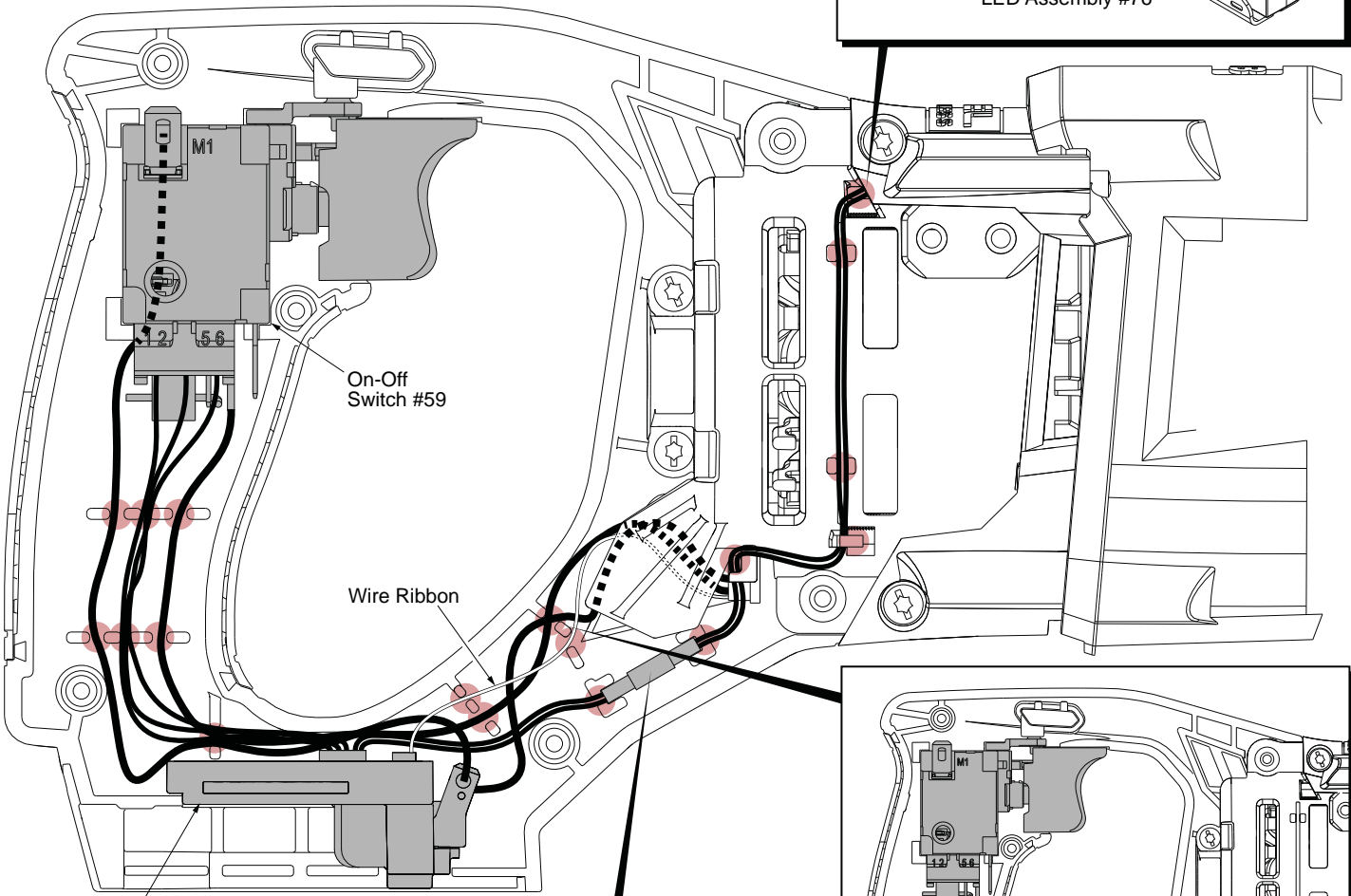
- Remove external retaining ring (7) and pull front cam (8) off.
- Pull lock pin (5) out and remove remainder of parts and discard.

**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.
- Place spring cover onto spindle.
- Slide torsion spring (3) 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 over sleeve until it bottoms on sleeve shoulder, ensure spring leg inserts into groove of cam.
- 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 (8) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring groove should be completely visible.
- Attach retaining ring (7) 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.



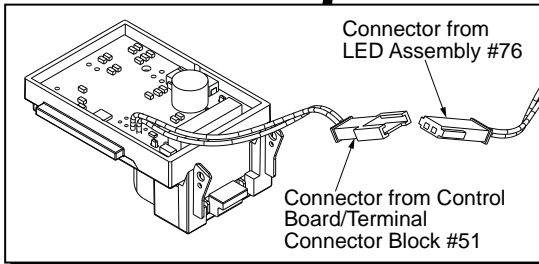
● = WIRE TRAPS or GUIDES



Control Board/  
Terminal Connector Block #51

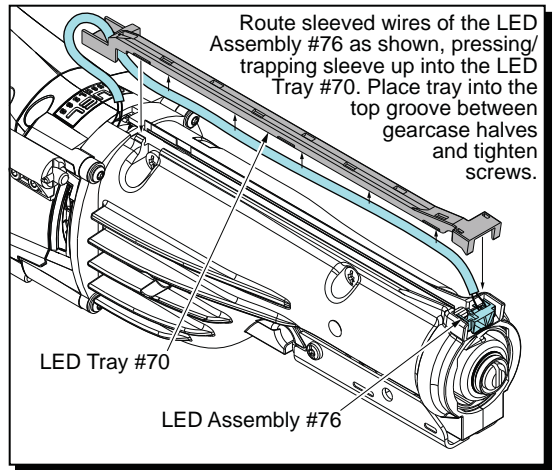
On-Off  
Switch #59

Wire Ribbon



Connector from  
LED Assembly #76

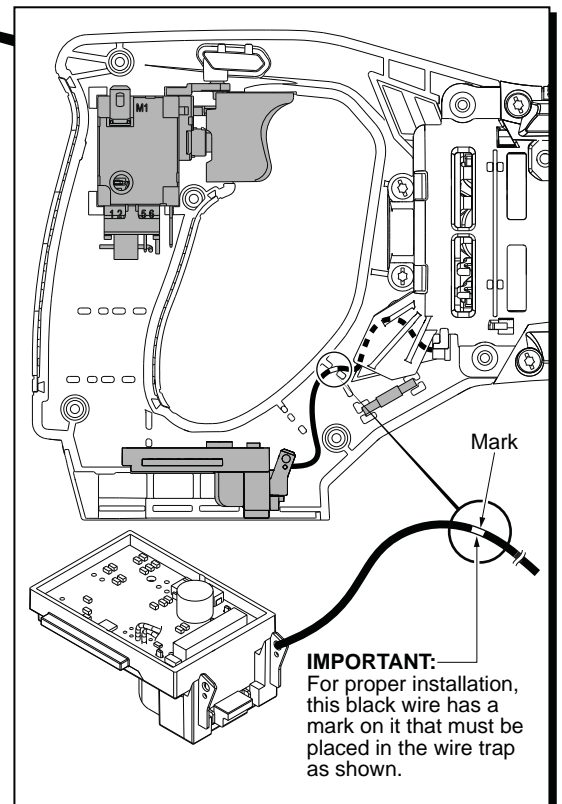
Connector from Control  
Board/Terminal  
Connector Block #51



Route sleeved wires of the LED  
Assembly #76 as shown, pressing/  
trapping sleeve up into the LED  
Tray #70. Place tray into the  
top groove between  
gearcase halves  
and tighten  
screws.

LED Tray #70

LED Assembly #76



Mark

**IMPORTANT:**  
For proper installation,  
this black wire has a  
mark on it that must be  
placed in the wire trap  
as shown.