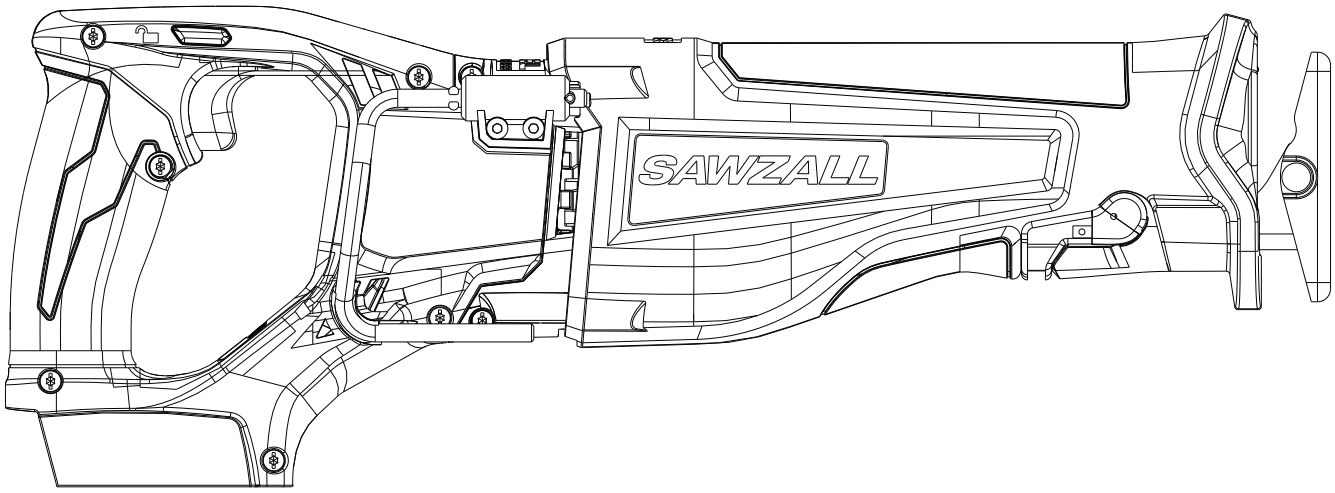
SERVICE PARTS LIST

BULLETIN NO.
54-00-2721

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ FUEL™ ONE KEY SAWZALL®			Oct. 2019
CATALOG NO. 2721-20	SERIAL NUMBER H31A & H31B	WIRING INSTRUCTION	

EXTERNAL SERVICE PARTS PAGE 2

SERVICE INSTRUCTIONS PAGE 3



Service for Milwaukee Tool ONE KEY Products
can only be performed at this
Milwaukee *factory* Central Repair Center:

MILWAUKEE TOOL Central Repair
1401 Sycamore Avenue • Greenwood, MS 38930-7277

Please send your tool directly to this location for service.

Or

Via *e*-Service at: www.milwaukeetool.com/e-service

questions, please call 1.800.SAWDUST (1.800.729.3878)

Or

Return it to a MILWAUKEE *factory* Service Center location, freight prepaid and insured.
A copy of the proof of purchase should be included with the return product.

If you have questions please contact Milwaukee Product Service at:

Product Technical Support via phone at: 262.783.8642

Or

Via email at: METProductSupport @milwaukeetool.com

Disassembly is not recommended and could void the warranty.

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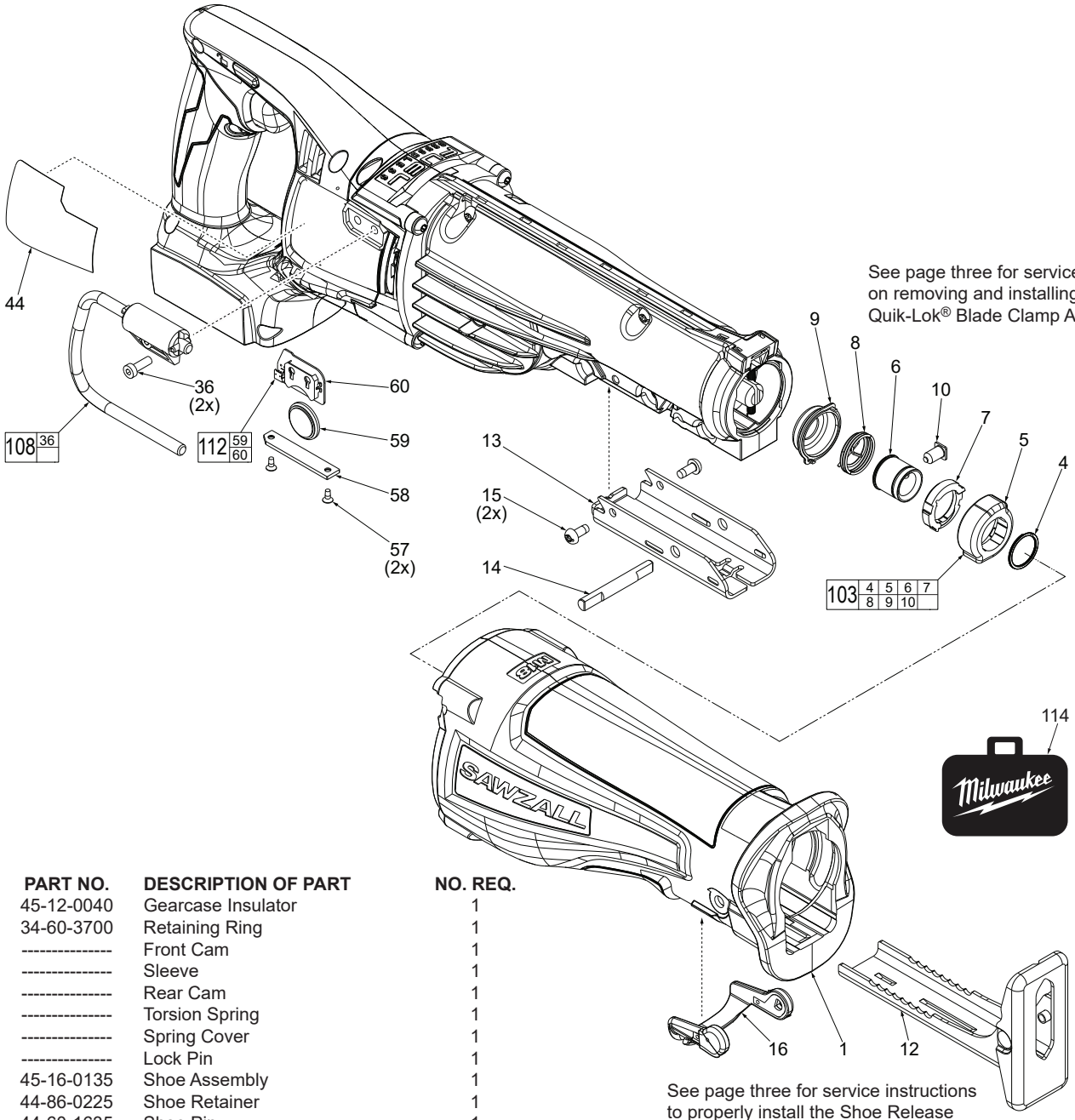
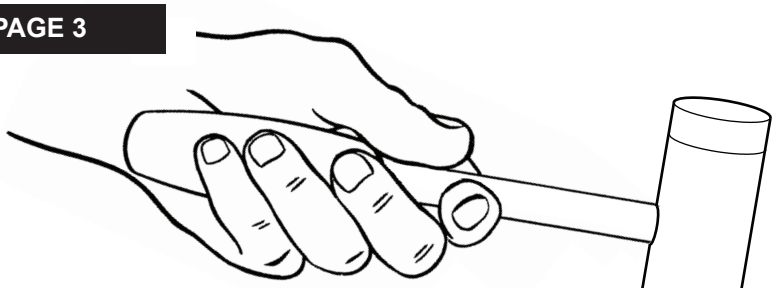
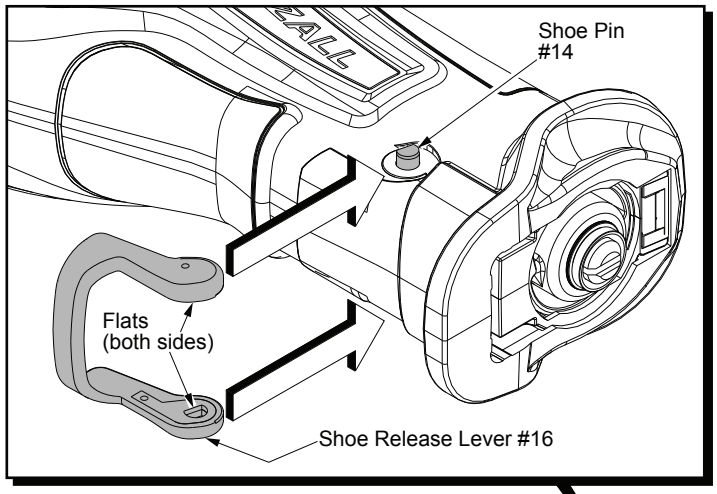


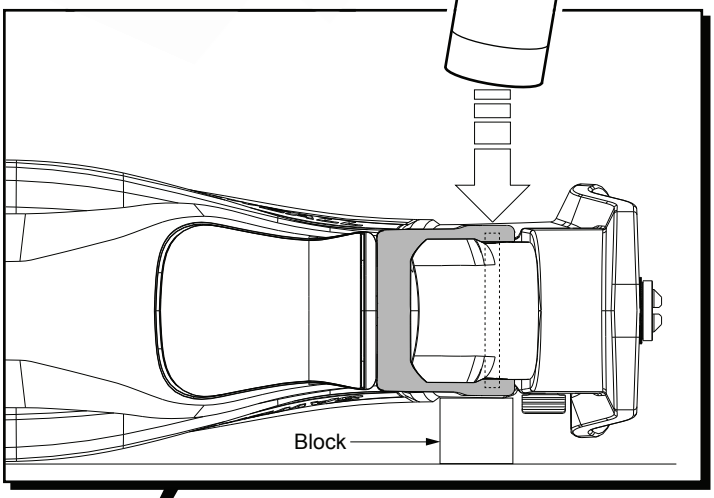
See page three for service instructions on removing and installing the Steel Quik-Lok® Blade Clamp Assy. (103).

See page three for service instructions to properly install the Shoe Release Lever (16) onto Shoe Pin (14).

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	45-12-0040	Gearcase Insulator	1
4	34-60-3700	Retaining Ring	1
5	----------	Front Cam	1
6	----------	Sleeve	1
7	----------	Rear Cam	1
8	----------	Torsion Spring	1
9	----------	Spring Cover	1
10	----------	Lock Pin	1
12	45-16-0135	Shoe Assembly	1
13	44-86-0225	Shoe Retainer	1
14	44-60-1635	Shoe Pin	1
15	06-82-7253	8-32 x 3/8" Pan Hd. Taptite T-20 Screw	2
36	05-78-0910	M4 x 12mm Fillister Hd. Screw	2
44	12-20-0078	Service Nameplate	1
57	05-81-1100	M2.6 x 6mm Flat Head Phillips Screw	2
58	31-15-0013	Coin Cell Cover	1
59	50-11-0020	3V Coin Cell Battery (CR 2032)	1
103	14-46-1064	Quik-Lok® Blade Clamp Kit	1
108	14-36-0340	Rafter Hook Assembly	1
112	22-09-2757	Bluetooth PCBA with Battery	1
114	42-55-0019	Carrying Case	1







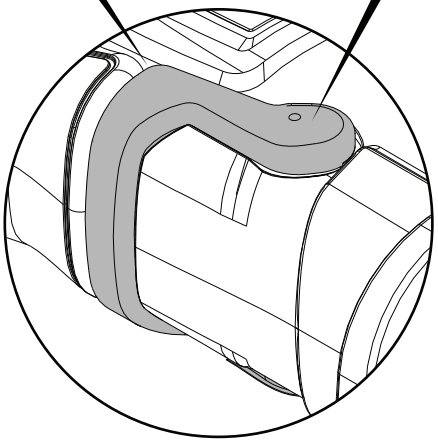
To properly install the Shoe Release Lever #16 onto the Shoe Pin #14 do the following:

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.

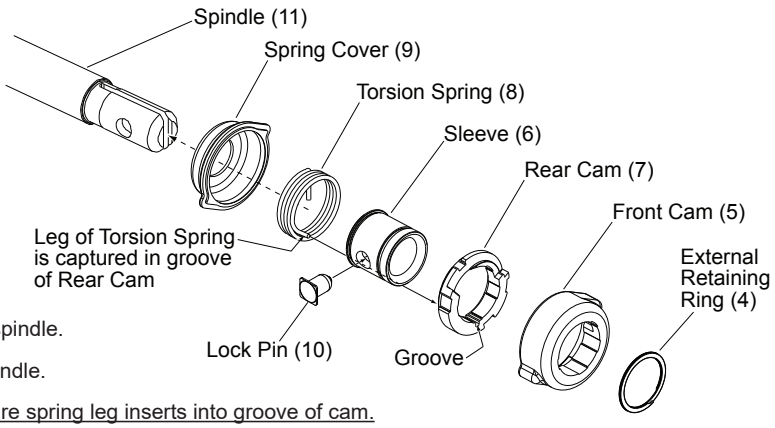


Place the tool on its side on a hard flat surface. Place a small wood block approximately 1-1/8" thick under the tool, between the hard surface and the shoe release lever, directly beneath the pin.

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

REMOVING THE STEEL QUIK-LOK® BLADE CLAMP -

- Remove external retaining ring (4) and pull front cam (5) off.
- Pull lock pin (10) 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 (8) 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 (10) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (5) 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 (4) 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.