



SERVICE PARTS LIST

BULLETIN NO.
54-44-2621

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

M18™ Metal Cutting Shear with 18 Ga. Single Cut Head

CATALOG NO. **2637-20**

STARTING
SERIAL NO.

F88B

REVISED BULLETIN
54-44-2620

DATE
Sept. 2019

WIRING INSTRUCTION
SEE PAGE THREE

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EXAMPLE:

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



★ = Part number change
from previous service parts list.

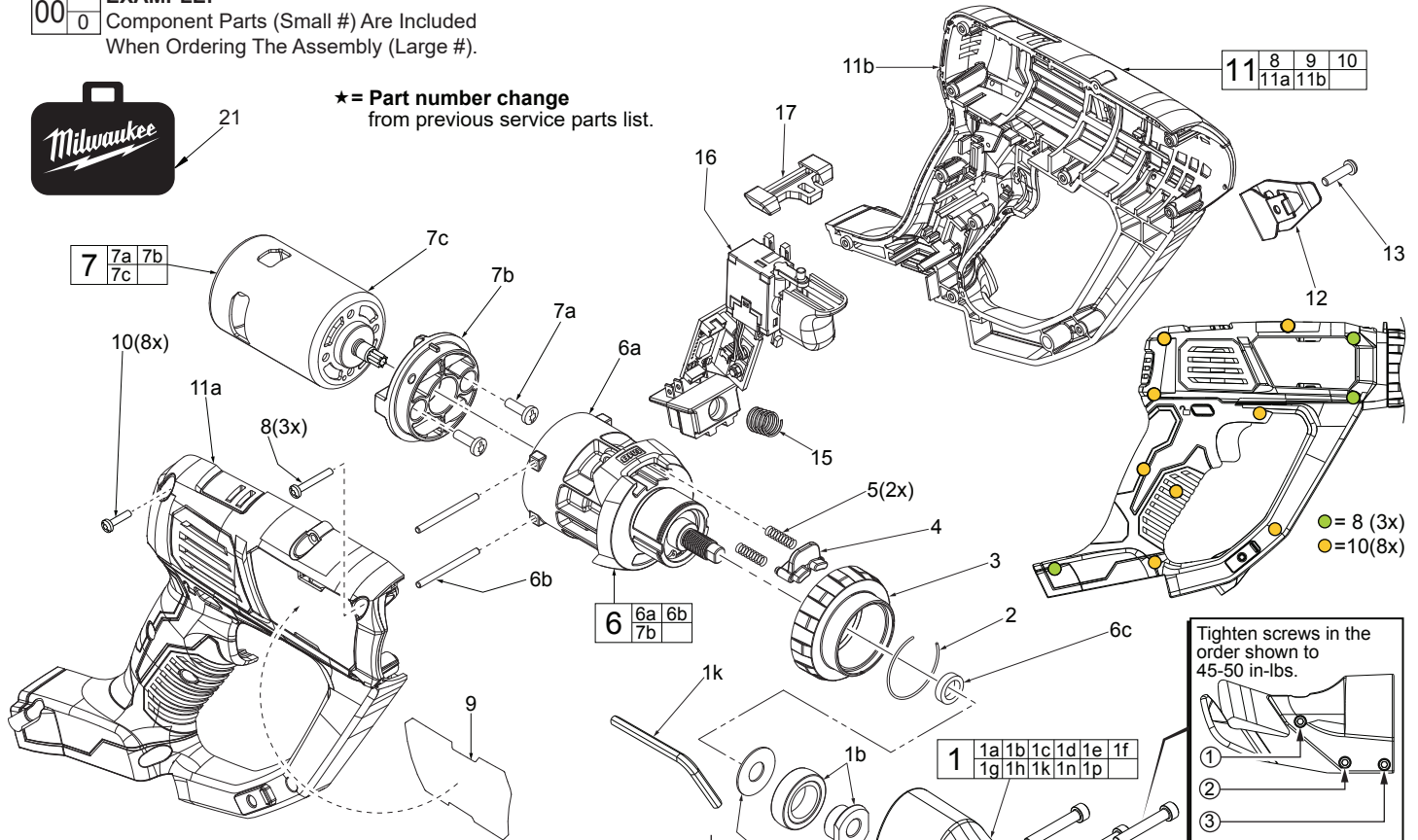


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	48-08-0507	Shear Head Assy. (Includes 1a thru 1p)	1
★1a	45-88-7311	Washer	1
1b	43-16-0117	Eccentric Assembly	1
★1c	43-84-0462	Knurled Insert	3
★1d	43-76-0418	Shear Housing	1
★1e	06-75-2117	10-32 x 1-1/4" Skt. Hd. Cap Screw	3
★1f	48-44-0168	Side Knife	1
★1g	42-40-0531	Bushing	2
★1h	48-44-0158	Blade - Center	1
★1k	49-96-0071	5/32" Hex Allen Wrench	1
★1n	42-40-0532	Spacer Bushing	1
★1p	42-40-0533	Side Spacer	1
2	34-60-0905	'C' Retaining Ring	1
3	28-84-0130	Rotational Collar	1
4	31-52-0070	Rotational Head Release Lever	1
5	40-50-1085	Spring	2
6	14-30-2637	Gearbox Assembly	1
6a	-----	Gearbox	1
6b	-----	2.5mm x 47mm Steel Pin	2
6c	45-88-7940	Washer (Spacer)	1
7	14-50-2635	Motor Assembly	1
7a	-----	M5.0 x 12mm Screw	2
7b	-----	Motor Mount Plate	1
7c	-----	Motor	1
8	05-86-0300	M3.0 x 22.5mm Pan Hd. ST T-10 Screw	3
9	12-20-2635	Service Nameplate	1
10	06-82-6350	M3.0 x 16mm Pan Hd. ST T-10 Screw	8
11	31-44-2900	Handle Housing Assembly	1
11a	-----	Handle Half - Right (Cover)	1
11b	-----	Handle Half - Left (Support)	1
12	42-70-0095	Belt Clip	1
13	06-81-4205	6-32 x .75" Pan Hd. Phillips Machine Screw	1
15	40-50-1090	Compression Spring	1
16	23-66-6000	Electronics Assembly (Includes On-Off Switch, PCBA and Terminal Connector Block)	1
17	42-42-0515	Lock-Off Shuttle	1
21	48-55-3490	Contractors Bag	1

NOTE: See
page two of
this bulletin for
service details
relating to the Shear Head
Assembly, No. 48-08-0507

FIG. NOTES:
1b,6a

To remove the eccentric assembly (1b) from the output shaft of the gearbox (6a) a 1/4" open end wrench should be used to secure the end of the shaft. Use a thin walled 7/8" wrench to tighten/loosen the eccentric.

2,3,4

When replacing Rotational Collar (3), remove 'C' Retaining Ring (2). Pull back Release Lever (4) while turning Rotational Collar (3) 90° in either direction, lining up the lugs in the Rotational Collar with the slots on the front of the Gearbox.

3,4,5,6a

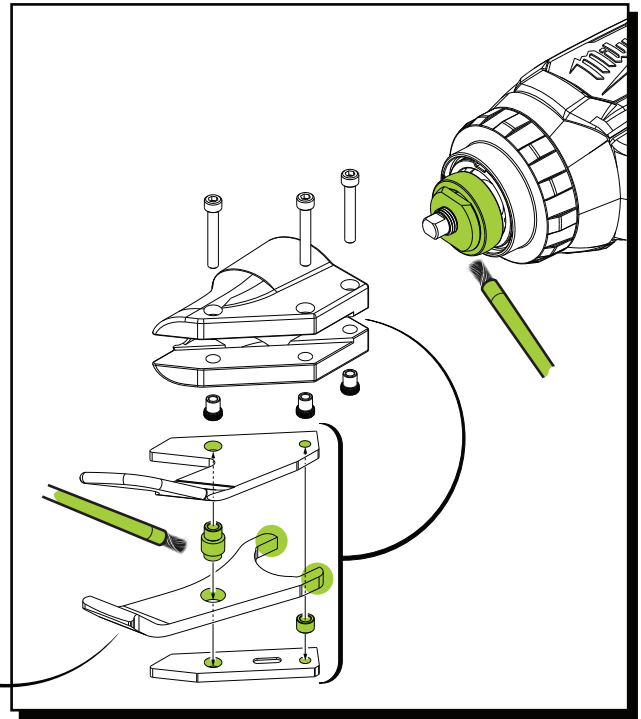
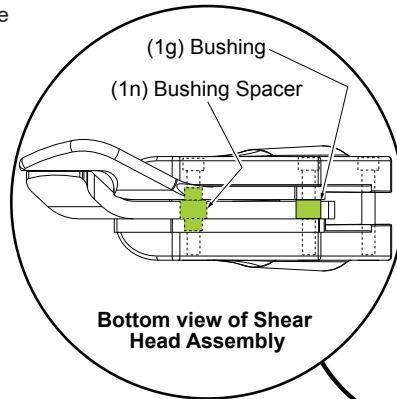
Place a light film of Type 'E' Grease, No. 49-08-4122 to the inside diameter of the Rotational Collar (3), to the front neck of Gearbox (6a), to the underside of the Release Lever (4) and the two Release Lever Springs (5).

6,7,7b

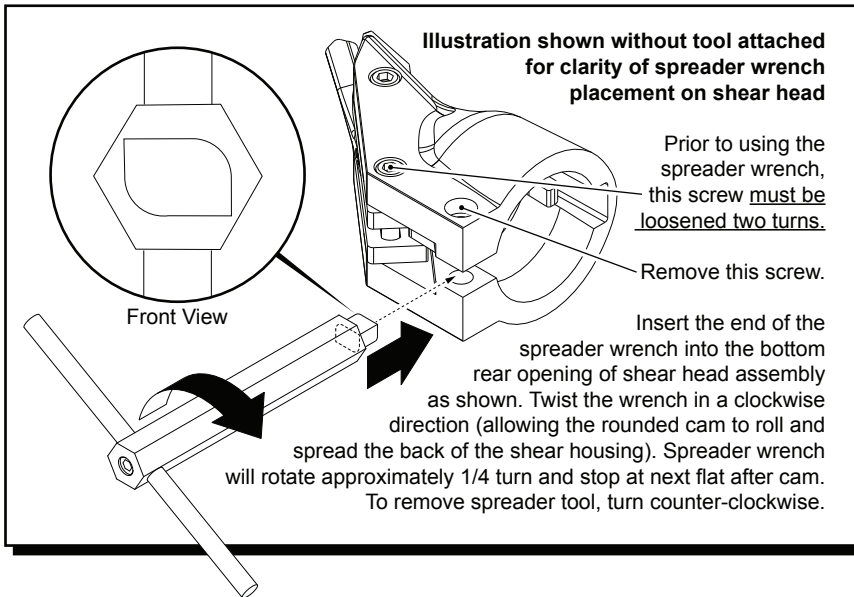
Service replacement gearbox assembly (6) comes with a motor mount plate (7b) that must be removed and discarded when servicing. A motor mount plate already exists on the motor assembly (7).

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. Lisbon Road, Brookfield, WI 53005
Drwg. 1

When servicing **Shear Head Assembly No. 48-08-0507** pay close attention to the placement of the Bushings. One is to be placed in the hole of the Center Blade and the front most holes of the Side Knife and the Side Spacer. It is to be held in place with the front most screw on the Shear Housing. The other bushing is to be located below and behind the Center Blade and is to be secured with the middle screw on the Shear Housing. Prior to assembly, it is recommended to use Type 'E' Grease, No. 49-08-4122 on the following areas: Place a dab of grease in the pivot (bushing) hole and on the bushing notch of the Center Blade. Place a dab of grease on the rear flats of the Center Blade. Coat both bushings completely with grease. Place a liberal amount of grease on the entire Eccentric Assembly.



REMOVING SHEAR HEAD ASSEMBLY FROM TOOL



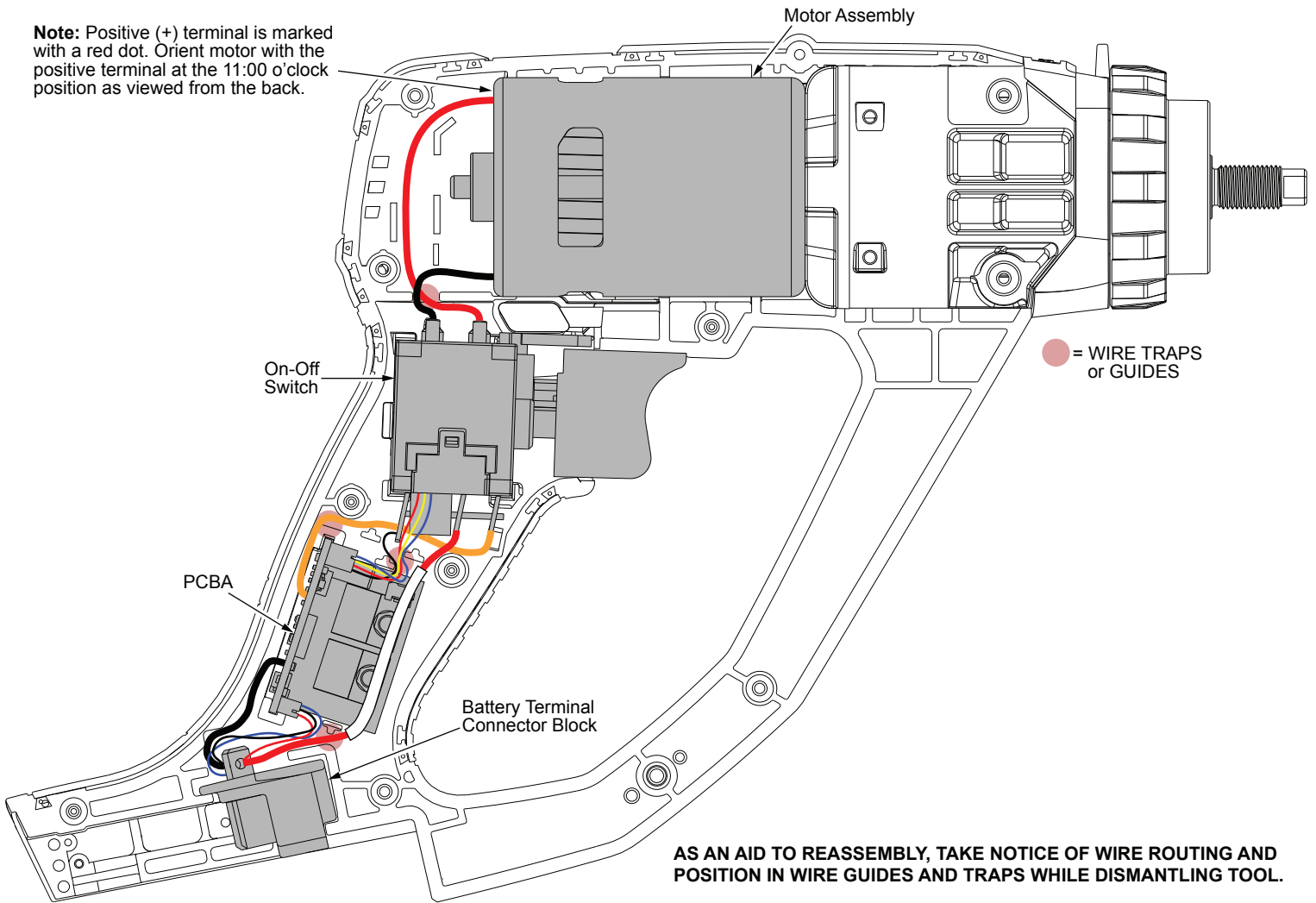
SERVICE TOOLS:

Spreader Wrench No. 61-30-0300
for 14 Gauge Shear Head 48-08-0505
used on Shear No. 2636-20

for 18 Gauge Shear Head 48-08-0507
used on Shear 2637-20

Spreader Wrench No. 61-30-0310
for 18 Gauge Shear Head 48-08-0500
used on Shears 2635-20 and 6852-20

Note: Positive (+) terminal is marked with a red dot. Orient motor with the positive terminal at the 11:00 o'clock position as viewed from the back.



AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE SURE THAT ALL COMPONENTS OF THE ELECTRONICS KIT ARE SEATED FIRMLY AND SQUARELY IN THE HANDLE RECESSES.

AVOID PINCHED WIRES, BE SURE THAT ALL WIRES AND SLEEVES ARE PRESSED COMPLETELY DOWN IN WIRE GUIDES AND TRAPS.

PRIOR TO INSTALLING THE HANDLE COVER ONTO THE HANDLE SUPPORT, BE SURE THAT THERE ARE NO INTERFERENCES.