

# **SABRE<sup>®</sup>**

## **PARTS LIST**

**S25** - (UT20561-C, D, E, F)

**S25C** - (UT20560-E, F, G)

**S25BC** - (UT15100-A)

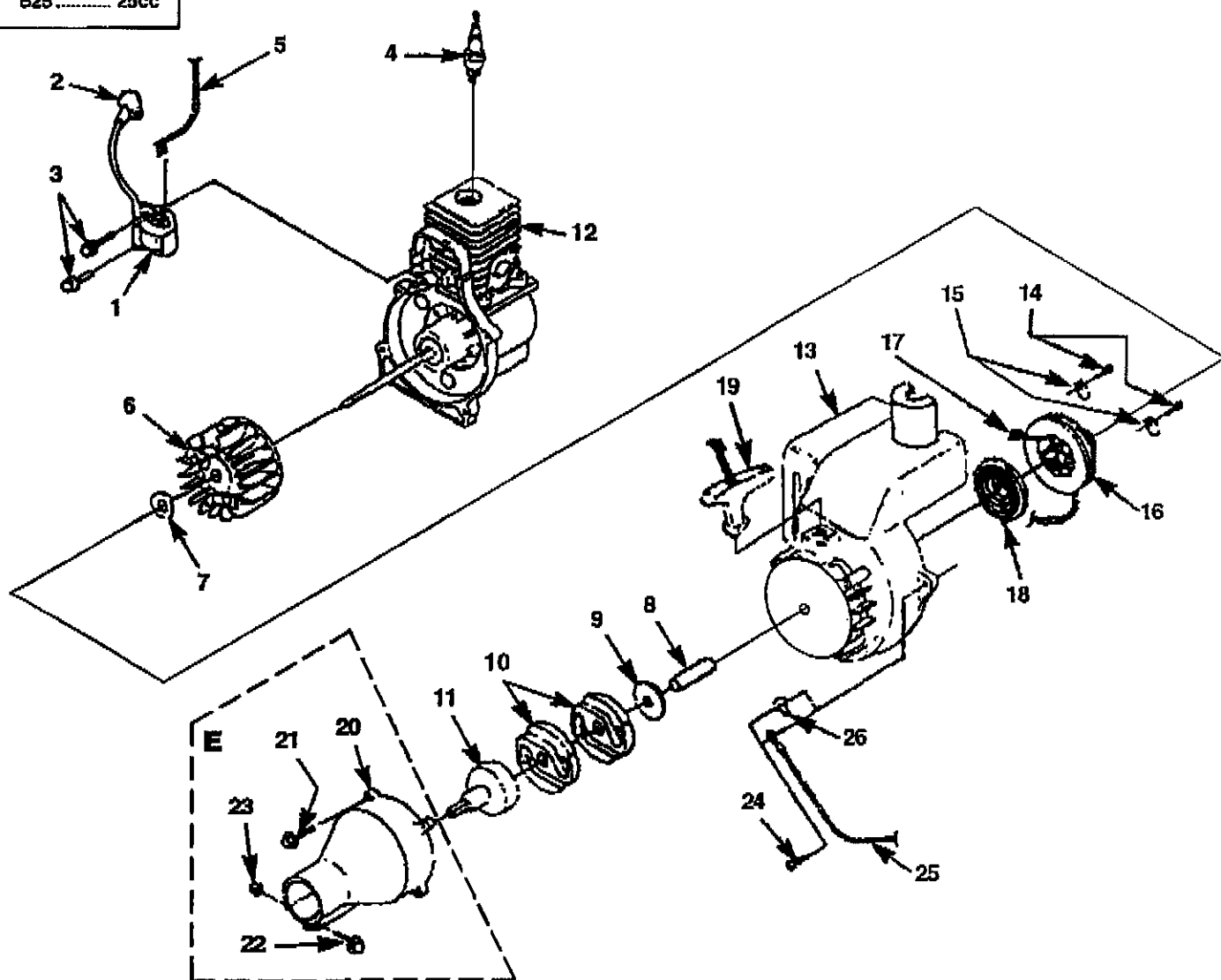
**S27** - (UT20603, A)

**B25** - (UT15055-D, E, F)



S25BC ..... 25cc  
S25C ..... 25cc  
B25 ..... 25cc

# IGNITION - ROTOR - STARTER - CLUTCH



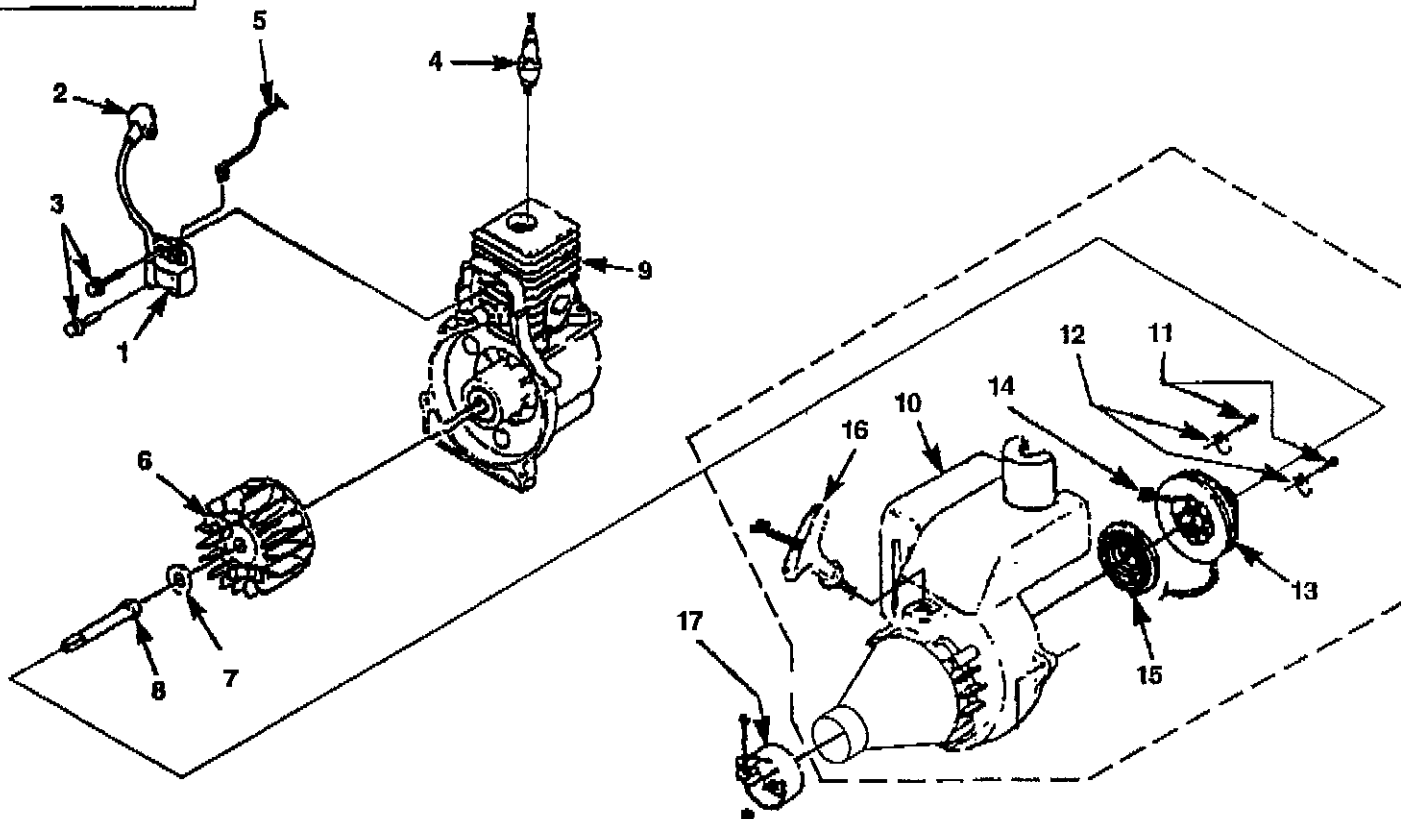
| No. | Part No.  | Description                         | Qty |
|-----|-----------|-------------------------------------|-----|
| 1   | 94711 CS  | MODULE-Ignition                     | 1   |
| 2   | A 33055   | TERMINAL & COVER                    | 1   |
| 3   | 82540     | SCREW-Tapite (8-32 X 1")            | 2   |
| 4   | 79252     | SPARK PLUG                          | 1   |
| 5   | A 00681   | LEAD-Electrical                     | 1   |
| 6   | A 04158 S | ROTOR KIT                           | 1   |
| 7   | 95479 A   | WASHER-Flat                         | 1   |
| 8   | 03566 1   | SPACER                              | 1   |
| 9   | 98929 A   | WASHER-Flat                         | 1   |
| 10  | 00242     | CLUTCH                              | 2   |
| 11  | A 02727   | CONNECTOR & DRUM                    | 1   |
| 12  |           | SHORT BLOCK (Ref. Pg. 4, Item 1)    | 1   |
| 13  | A 02097 B | STARTER HOUSING                     | 1   |
| 14  | 82541     | SCREW-Plastite (#10-1/2")           | 2   |
| 15  | 98791     | BRACKET-Retaining                   | 2   |
| 16  | 98770 A   | PULLEY-Starter                      | 1   |
| 17  | 97899 02  | ROPE-Starter (42")                  | 1   |
| 18  | A 98773 A | SPRING & CONTAINER                  | 1   |
| 19  | 02264     | GRIP-Starter                        | 1   |
| 20  | A 02396 A | TUBE ADAPTER                        | 1   |
| 21  | 88052     | SCREW-Hex Hd. (10-24 X 7/8")        | 4   |
| 22  | 98624     | SCREW-Sems Hex Hd. (10-24 X 1 1/8") | 1   |
| 23  | 81208     | NUT (10-24)                         | 1   |

| No. | Part No.  | Description                 | Qty |
|-----|-----------|-----------------------------|-----|
| 24  | 82538     | SCREW-Tapite (10-24 X 3/4") | 4   |
| 25  | A 98919 A | LEAD-Ground                 | 1   |
| 26  | 02851     | TERMINAL-Male               | 1   |

| Item No | Torque Specs |           | Required Loctite |
|---------|--------------|-----------|------------------|
|         | In/Lbs       | Nm        |                  |
| 3       | 30-40        | 3.4-4.5   |                  |
| 4       | 120-180      | 13.6-20.3 |                  |
| 14      | 30-40        | 3.4-4.5   |                  |
| 21      | 30-40        | 3.4-4.5   |                  |
| 23      | 40-50        | 4.5-5.6   |                  |
| 24      | 55-60        | 6.2-6.8   |                  |

S25 ..... 25cc  
S27 ..... 25cc

## IGNITION - ROTOR - STARTER



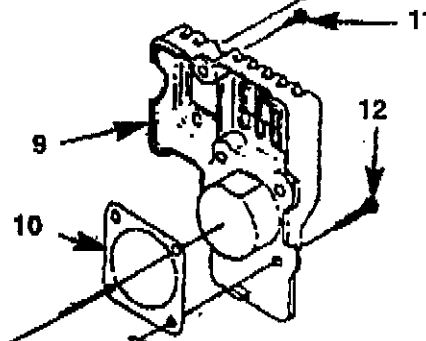
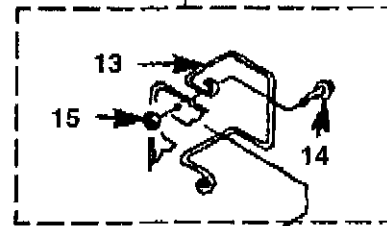
| No. | Part No.  | Description                      | Qty |
|-----|-----------|----------------------------------|-----|
| 1   | 94711 CS  | MODULE-Ignition                  | 1   |
| 2   | A 33055   | TERMINAL & COVER                 | 1   |
| 3   | 82540     | SCREW-Taplite (8-32 X 1")        | 2   |
| 4   | 79252     | SPARK PLUG                       | 1   |
| 5   | A 07298   | LEAD-Electrical                  | 1   |
| 6   | A 04158 S | ROTOR KIT                        | 1   |
| 7   | 95479 A   | WASHER-Flat                      | 1   |
| 8   | 98795 A   | CONNECTOR-Drive                  | 1   |
| 9   |           | SHORT BLOCK (Ref. Pg. 4, Item 1) | 1   |
| 10  | A 02096 B | STARTER HOUSING                  | 1   |
| 11  | 82541     | SCREW-Plasite (#10-1/2")         | 2   |
| 12  | 98791     | BRACKET-Retaining                | 2   |
| 13  | 98770 A   | PULLEY-Starter                   | 1   |
| 14  | 97899 02  | ROPE-Starter (42")               | 1   |
| 15  | A 98773 A | SPRING & CONTAINER               | 1   |
| 16  | 02264     | GRIP-Starter                     | 1   |
| 17  | 08469     | CLAMP w/fasteners                | 1   |

| Item No | In/Lbs  | Torque Specs Nm | Required Loctite |
|---------|---------|-----------------|------------------|
| 3       | 30-40   | 3.4-4.5         |                  |
| 4       | 120-180 | 13.6-20.3       |                  |
| 11      | 30-40   | 3.4-4.5         |                  |

# ENGINE INTERNAL

S25 ..... 25cc  
S25C ..... 25cc  
S25BC ..... 25cc  
S27 ..... 25cc  
B25 ..... 25cc

## OPTIONAL MUFFLER GUARD.

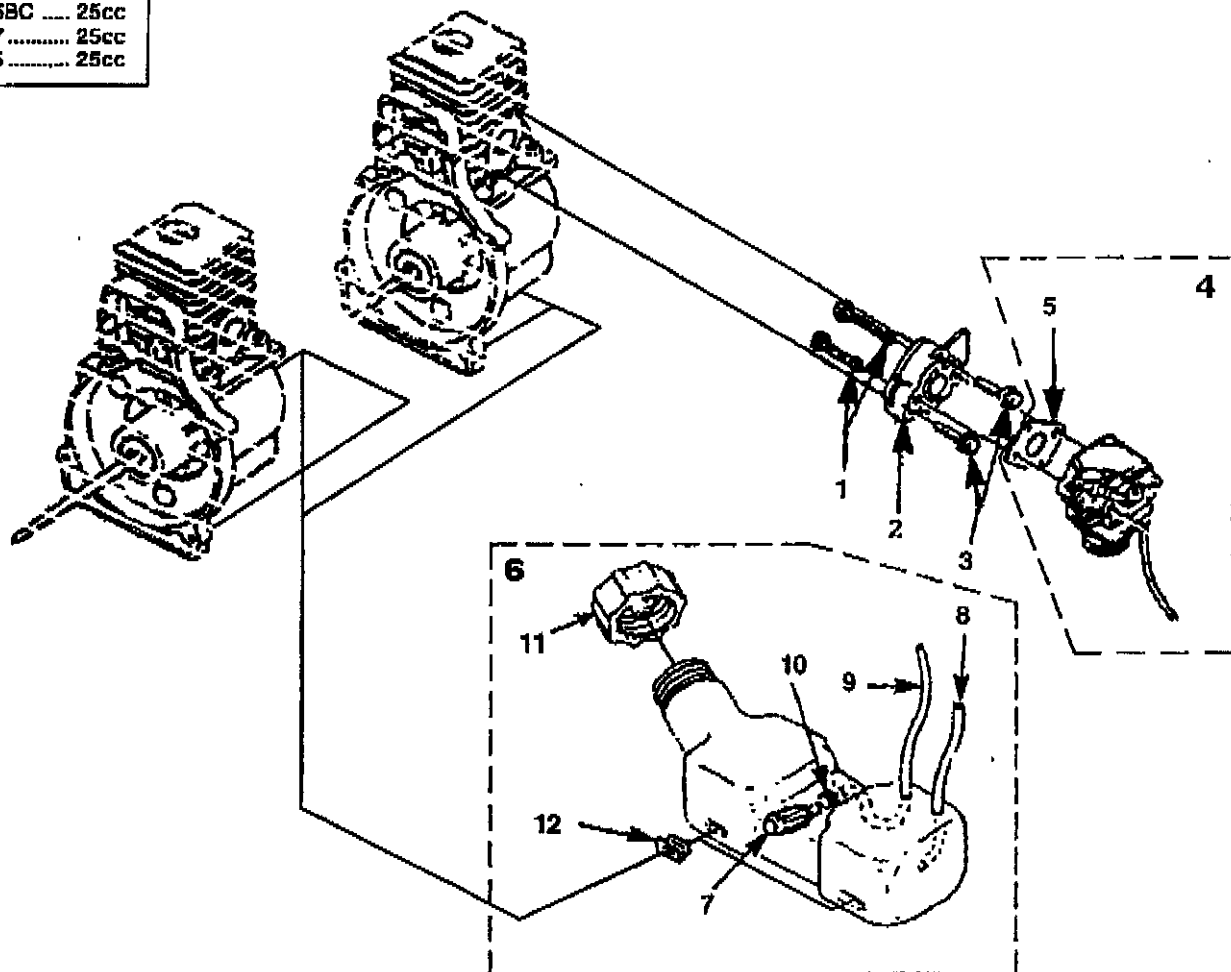


| Item No | In/Lbs | Torque Specs |  | Required Loctite |
|---------|--------|--------------|--|------------------|
|         |        | Nm           |  |                  |
| 8       | 55-65  | 6.2-7.3      |  |                  |
| 11      | 30-40  | 3.4-4.5      |  |                  |
| 12      | 25-30  | 2.6-3.4      |  |                  |
| 14      | 40-50  | 4.5-5.6      |  |                  |

| No. | Part No.   | Description                                    | Qty |
|-----|------------|------------------------------------------------|-----|
| 1   | •A 09055   | SHORT BLOCK (25CC Non Clutch)                  | 1   |
|     | •A 09056   | SHORT BLOCK (25CC Clutch)                      | 1   |
|     |            | NOTE: Both Short Blocks Include The Following: |     |
| 2   | •A 07314   | 25CC PISTON & ROD                              | 1   |
| 3   | 96935      | RING-Piston                                    | 1   |
| 4   | •A 07145   | 25CC CYLINDER KIT                              | 1   |
| 5   | 04388 B    | GASKET-Cylinder                                | 1   |
| 6   | 08840      | GASKET-Heat Dam                                | 1   |
| 7   | 69250      | KEY-Woodruff                                   | 1   |
| 8   | 82569 1    | SCREW-Thread Forming (10-24 X 3/4")            | 3   |
| 9   | •A 00858   | CRANKCASE COVER                                | 1   |
| 10  | 98767 A    | GASKET-Crankcase Cover                         | 1   |
| 11  | 82541      | SCREW-Plastite (#10 X 1/2")                    | 2   |
| 12  | 82536      | SCREW-Taptite (10-24 X 1/2")                   | 4   |
| 13  | •A 00254 A | WIRE GUARD KIT                                 | 1   |
| 14  | 88049      | SCREW-Hex Sems (10-24 X 1/2")                  | 2   |
| 15  | 81208      | NUT (10-24)                                    | 2   |

S25 ..... 25cc  
 S25C ..... 25cc  
 S25BC ..... 25cc  
 S27 ..... 25cc  
 B25 ..... 25cc

## CARBURETOR - FUEL TANK

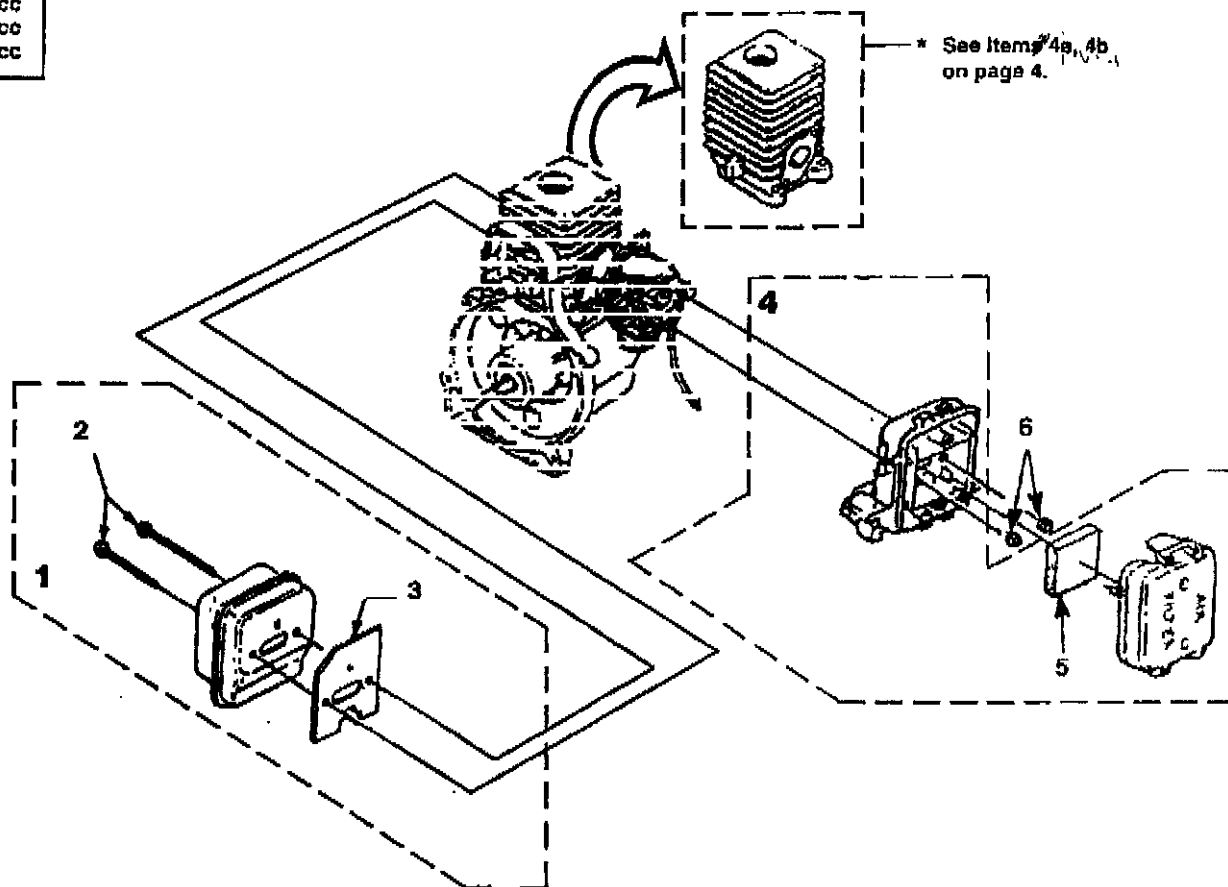


| No. | Part No.   | Description                    | Qty |
|-----|------------|--------------------------------|-----|
| 1   | 04474      | SCREW-Machine (10-24 X 2 1/4") | 2   |
| 2   | 98768      | HEAT DAM                       | 1   |
| 3   | 82549-1    | SCREW-Tap (10-24 X 1")         | 2   |
| 4   | *A 04445 A | CARBURETOR KIT                 | 1   |
| 5   | 98768 A    | GASKET-Carburetor              | 1   |
| 6   | *A 04447 C | FUEL TANK                      | 1   |
| 7   | 49422      | FILTER-Fuel                    | 1   |
| 8   | 01439 32   | TUBING-Rubber (8")             | 1   |
| 9   | 94772 32   | TUBING-Rubber (8")             | 1   |
| 10  | 98268      | CLAMP-Wire                     | 1   |
| 11  | A 00982 B  | FUEL CAP                       | 1   |
| 12  | 98792      | BUMPER-Rubber                  | 3   |

| Item<br>No | In/Lbs      | Torque Specs  |         | Required<br>Loctite |
|------------|-------------|---------------|---------|---------------------|
|            |             | Nm            |         |                     |
| 1          | 30-40 ..... | 3.4-4.5       |         |                     |
| 3          | 40-50 ..... | 4.5-5.6 ..... | Red 262 |                     |

S25 ..... 25cc  
 S25C ..... 25cc  
 S258C ..... 25cc  
 S27 ..... 25cc  
 B25 ..... 25cc

# MUFFLER - AIR CLEANER

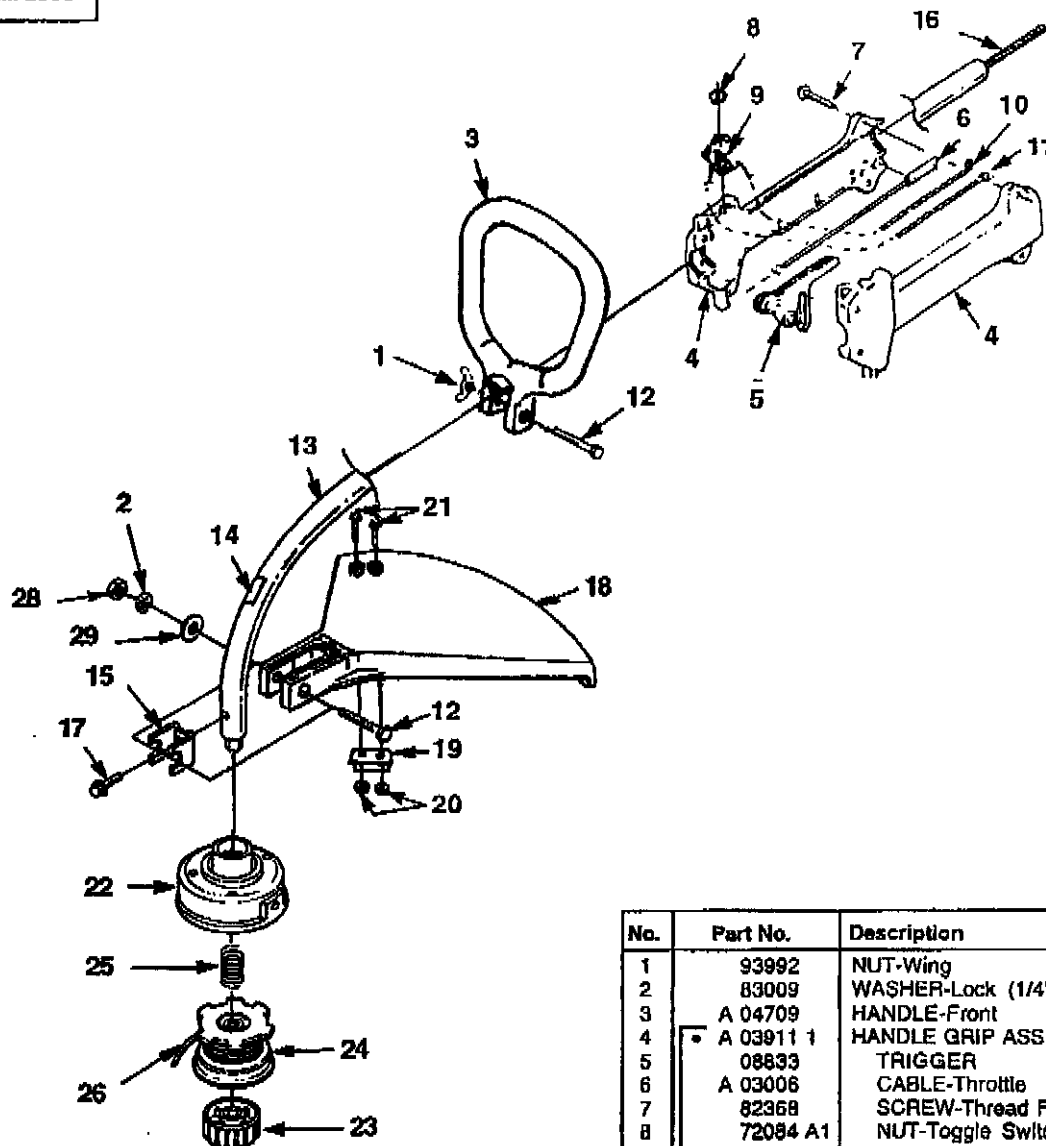


| No. | Part No.    | Description                           | Qty |
|-----|-------------|---------------------------------------|-----|
| 1   | • A 07315   | MUFFLER COMPLETE                      | 1   |
| 2   | 88060       | SCREW-Sams Hex (10-24 X 2 1/2")       | 2   |
| 3   | 98786 C     | GASKET-Muffler (Also Included with *) | 1   |
| 4   | • A 04707 A | AIR FILTER KIT                        | 1   |
| 5   | D 98760 B   | FILTER-AIR                            | 1   |
| 6   | 81208       | NUT-Hex (10-24)                       | 2   |

| Item No | In/Lbs      | Torque Specs |    | Required Loctite |
|---------|-------------|--------------|----|------------------|
|         |             |              | Nm |                  |
| 2       | 40-50 ..... | 4.5-5.6      |    |                  |
| 6       | 40-50 ..... | 4.5-5.6      |    |                  |

S25 ..... 25cc  
S25C ..... 25cc  
S27 ..... 25cc

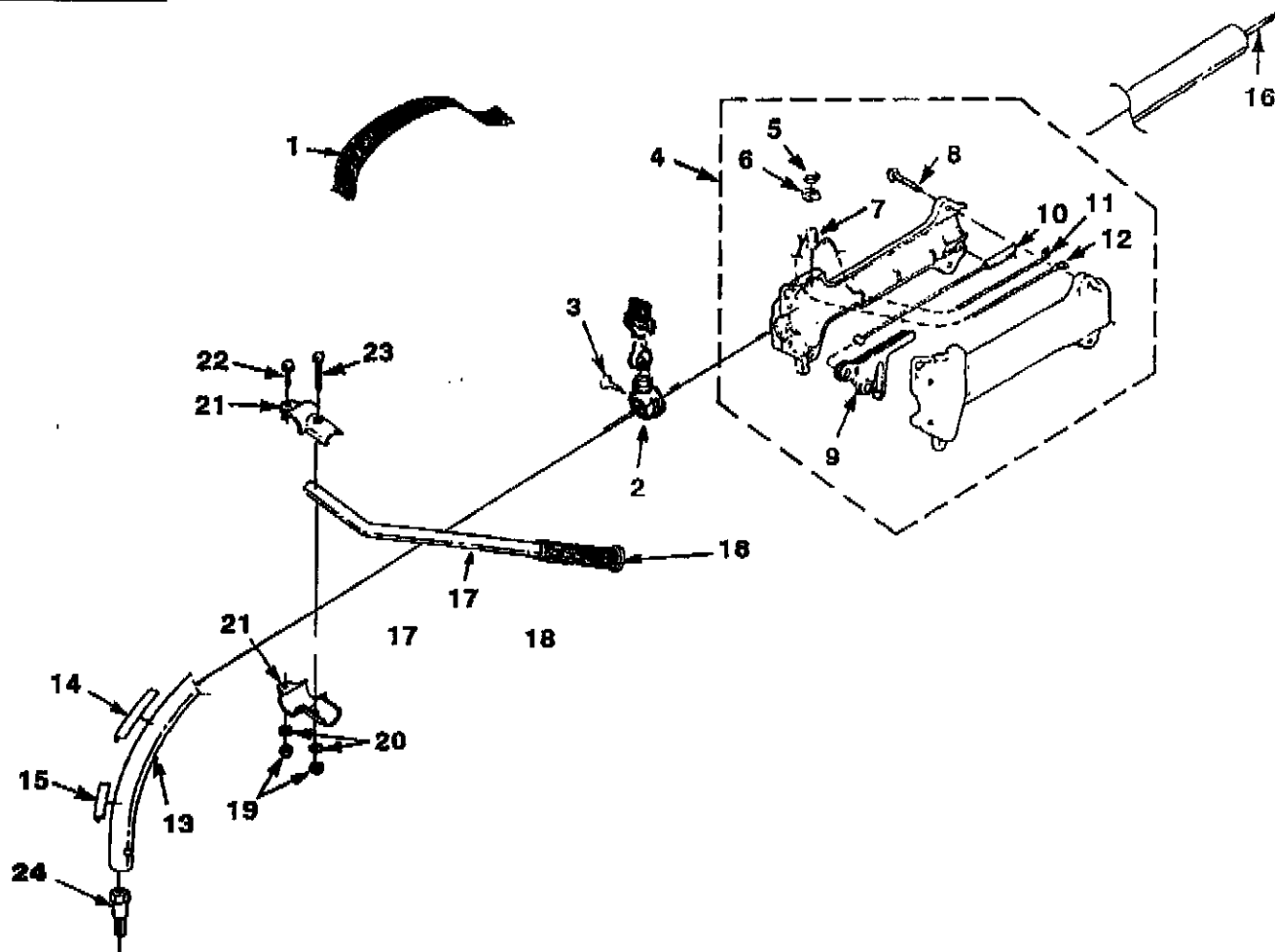
# CURVED SHAFT BOOM - HANDLE - THROTTLE - STRINGHEAD - GRASS DEFLECTOR



| Item<br>No | Torque Specs |         | Required<br>Loctite |
|------------|--------------|---------|---------------------|
|            | In/Lbs       | Nm      |                     |
| 7          | 15-25        | 1.7-2.8 |                     |
| 17         | 15-25        | 1.7-2.8 |                     |
| 21         | 15-20        | 1.7-2.8 |                     |

| No. | Part No.   | Description                      | Qty |
|-----|------------|----------------------------------|-----|
| 1   | 93992      | NUT-Wing                         | 2   |
| 2   | 83009      | WASHER-Lock (1/4")               | 1   |
| 3   | A 04709    | HANDLE-Front                     | 1   |
| 4   | A 03911 1  | HANDLE GRIP ASSEMBLY             | 1   |
| 5   | 08833      | TRIGGER                          | 1   |
| 6   | A 03006    | CABLE-Throttle                   | 1   |
| 7   | 82368      | SCREW-Thread Form. (#8 X 3/4")   | 5   |
| 8   | 72094 A1   | NUT-Toggle Switch                | 1   |
| 9   | 93653      | TOGGLE SWITCH                    | 1   |
| 10  | A 03912    | LEAD-Electrical                  | 1   |
| 11  | A 98919 A  | LEAD-Ground                      | 1   |
| 12  | 80295      | SCREW-Cap Hex Hd. (1/4-20 x 2")  | 2   |
| 13  | A 08738    | DRIVESHAFT HOUSING w/spacer      | 1   |
| 14  | 02985      | DECAL-Warning                    | 1   |
| 15  | 07928      | CLAMP                            | 1   |
| 16  | 98816      | SHAFT-Flexible                   | 1   |
| 17  | 88077      | SCREW-Thread Form. (#10 X 1/2")  | 1   |
| 18  | 00130      | DEFLECTOR (S25, S27)             | 1   |
|     | 02610      | DEFLECTOR (S25C)                 | 1   |
| 19  | A 03834    | BLADE-Cut-Off (S25)              | 1   |
|     | A 03832    | BLADE-Cut-Off (S25C, S27)        | 1   |
| 20  | 81261      | NUT-Hex (10-24)                  | 2   |
| 21  | 82531      | SCREW-Mach. Hex Hd. (10-24 X 1") | 2   |
| 22  | A 98231 A  | HOUSING & EYELET-Dual Line       | 1   |
| 23  | DA 98866 A | RETAINER-Spool                   | 1   |
| 24  | DA 98912 E | SPOOL & STRING (.080 Dia)        | 1   |
| 25  | B 06713    | SPRING-Compression               | 1   |
| 26  | 06511      | STRING (.080 Dia) (395 Ft.)      | 1   |
| 27  | 81242      | HEX NUT                          | 1   |
| 28  | 84006      | WASHER-Flat (1/4")               | 1   |

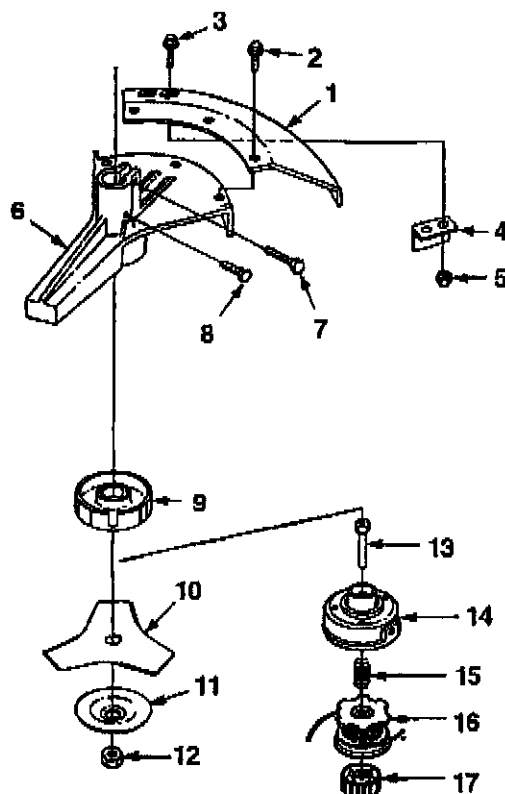
## SHAFT - HANDLE - THROTTLE



| No. | Part No.   | Description                        | Qty |
|-----|------------|------------------------------------|-----|
| 1   | DA 92703 C | HARNESS w/Connector                | 1   |
| 2   | A 94442    | BRACKET-Hanger                     | 1   |
| 3   | 82260      | SCREW-Thumb (10-24 X 1/2")         | 1   |
| 4   | A 03911 1  | HANDLE GRIP ASSEMBLY               | 1   |
| 5   | 72084 A1   | NUT-Toggle Switch-Hex Lock         | 1   |
| 6   | 95231      | PLATE-Indicating                   | 1   |
| 7   | 93653      | SWITCH-Toggle                      | 1   |
| 8   | 82368      | SCREW-Plastite (#8 X 3/4")         | 4   |
| 9   | 08833      | TRIGGER                            | 1   |
| 10  | A 03006    | CABLE-Throttle                     | 1   |
| 11  | A 03912    | LEAD-Electrical                    | 1   |
| 12  | A 98919 A  | LEAD-Ground                        | 1   |
| 13  | A 03287 B  | HOUSING-Drive Shaft (Black)        | 1   |
| 14  | 04458      | DECAL-Starting Instructions        | 1   |
| 15  | 04493      | DECAL-Warning                      | 1   |
| 16  | 98818      | SHAFT-Flex                         | 1   |
| 17  | A 04639    | HANDLE BAR                         | 1   |
| 18  | 94474 B    | GRIP                               | 1   |
| 19  | 81267      | NUT (1/4-20)                       | 2   |
| 20  | 83061      | WASHER (1/4")                      | 2   |
| 21  | 00422      | CLAMP-Handle Bar                   | 2   |
| 22  | 88078      | SCREW-Sems Hex Hd. (1/4-20 X 1")   | 1   |
| 23  | 88071      | SCREW-Sems Hex Hd. (1/4-20 X 1/2") | 1   |
| 24  | 98834 A    | SHAFT-Spindle                      | 1   |

| Item No | In/Lbs      | Torque Specs |    | Required Loctite |
|---------|-------------|--------------|----|------------------|
|         |             |              | Nm |                  |
| 5       | 18-24 ..... | 2.0-2.7      |    |                  |
| 8       | 16-26 ..... | 1.7-2.8      |    |                  |
| 22      | 75-85 ..... | 8.5-9.6      |    |                  |
| 23      | 75-85 ..... | 8.5-9.6      |    |                  |

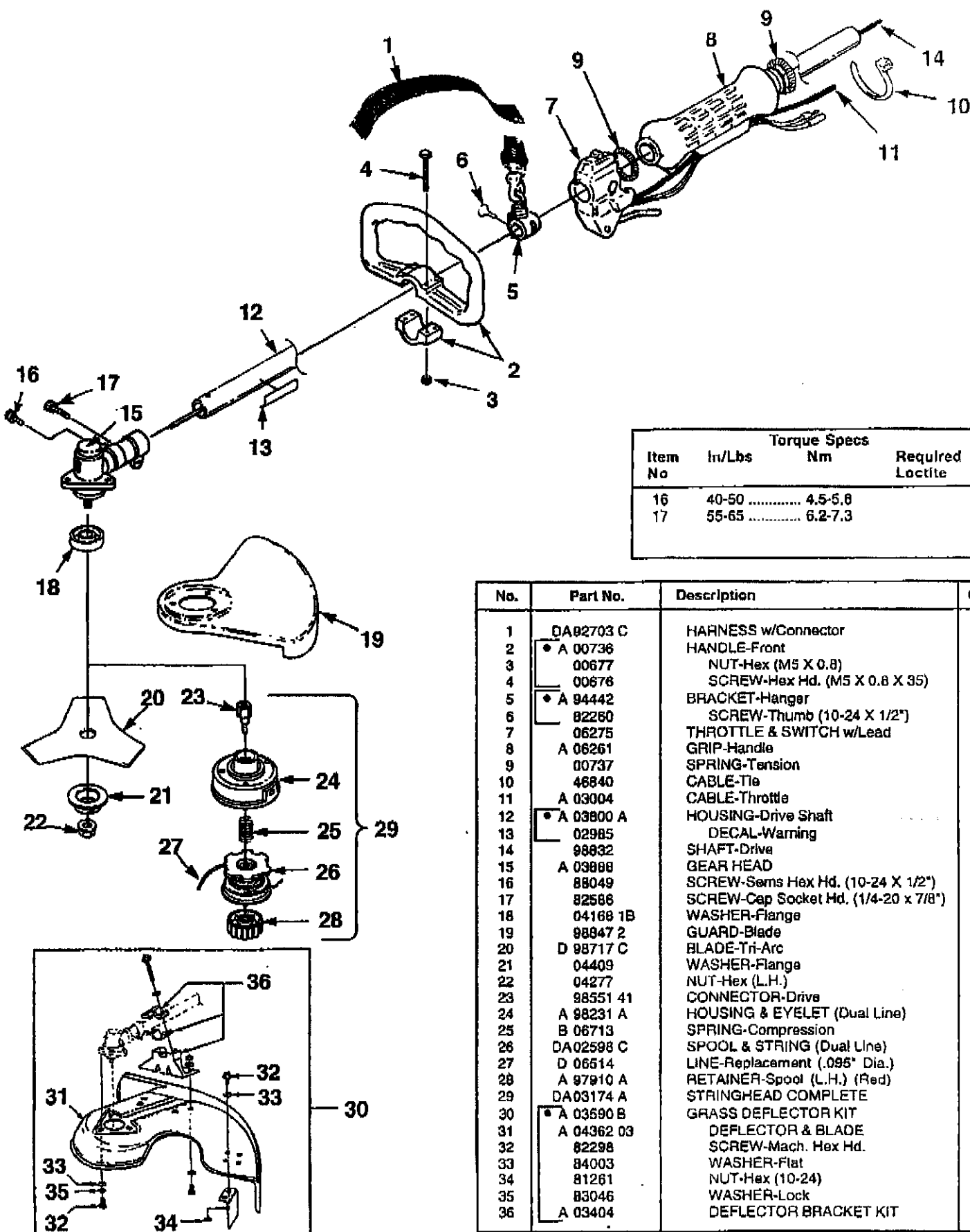


**SPOOL & STRING - DEFLECTOR**

| No. | Part No.   | Description                        | Qty |
|-----|------------|------------------------------------|-----|
| 1   | A 04706    | DEFLECTOR-Grass                    | 1   |
| 2   | 80681 3    | SCREW-Mach Hex Hd. (1/4-20 X 1/2") | 3   |
| 3   | 80869      | SCREW-Mach Hex Hd. (10-24 X 3/8")  | 2   |
| 4   | 07129      | BLADE-Cut-Off                      | 1   |
| 5   | 81208      | NUT (10-24)                        | 2   |
| 6   | A 04457 A  | HOUSING-Lower Bearing              | 1   |
| 7   | 88078      | SCREW-Sems Hex Hd. (1/4-20 X 1")   | 1   |
| 8   | 82450      | SCREW-Mach Hex Hd. (10-24 X 3/8")  | 1   |
| 9   | 98835 1B   | WASHER-Flanged                     | 1   |
| 10  | D 98717 C  | BLADE-Tri-Arc (8")                 | 1   |
| 11  | 98836      | WASHER-Cupped                      | 1   |
| 12  | 98897      | NUT-Hex Locking (R.H.)             | 1   |
| 13  | 98849      | CONNECTOR-Drive                    | 1   |
| 14  | A 98231 A  | HOUSING & EYELET (Dual Line)       | 1   |
| 15  | 06713      | SPRING-Compression                 | 1   |
| 16  | DA 98912 E | SPOOL & STRING (.080" Line)        | 1   |
| 17  | DA 98866 A | RETAINER-Spool (R.H. Thread)       | 1   |

| Item No | Torque Specs |         | Required Loctite |
|---------|--------------|---------|------------------|
|         | In/Lbs       | Nm      |                  |
| 3       | 20-30        | 2.3-3.4 | Red 262          |
| 7       | 75-85        | 8.5-9.6 |                  |
| 8       | 40-50        | 4.5-5.6 |                  |

# STRAIGHT SHAFT BOOM - HANDLE - THROTTLE - STRINGHEAD - GRASS DEFLECTOR



| No. | Part No.    | Description                          | Qty |
|-----|-------------|--------------------------------------|-----|
| 1   | DA02703 C   | HARNESS w/Connector                  | 1   |
| 2   | • A 00736   | HANDLE-Front                         | 1   |
| 3   | 00677       | NUT-Hex (M5 X 0.8)                   | 4   |
| 4   | 00676       | SCREW-Hex Hd. (M5 X 0.8 X 35)        | 4   |
| 5   | • A 94442   | BRACKET-Hanger                       | 1   |
| 6   | 82260       | SCREW-Thumb (10-24 X 1/2")           | 1   |
| 7   | 06275       | THROTTLE & SWITCH w/Lead             | 1   |
| 8   | A 06261     | GRIP-Handle                          | 1   |
| 9   | 00737       | SPRING-Tension                       | 2   |
| 10  | 46840       | CABLE-Tie                            | 1   |
| 11  | A 03004     | CABLE-Throttle                       | 1   |
| 12  | • A 03800 A | HOUSING-Drive Shaft                  | 1   |
| 13  | 02985       | DECAL-Warning                        | 1   |
| 14  | 98832       | SHAFT-Drive                          | 1   |
| 15  | A 03888     | GEAR HEAD                            | 1   |
| 16  | 88049       | SCREW-Sems Hex Hd. (10-24 X 1/2")    | 1   |
| 17  | 82586       | SCREW-Cap Socket Hd. (1/4-20 x 7/8") | 1   |
| 18  | 04168 1B    | WASHER-Flange                        | 1   |
| 19  | 98847 2     | GUARD-Blade                          | 1   |
| 20  | D 98717 C   | BLADE-Tri-Arc                        | 1   |
| 21  | 04409       | WASHER-Flange                        | 1   |
| 22  | 04277       | NUT-Hex (L.H.)                       | 1   |
| 23  | 98551 41    | CONNECTOR-Drive                      | 1   |
| 24  | A 98231 A   | HOUSING & EYELET (Dual Line)         | 1   |
| 25  | B 06713     | SPRING-Compression                   | 1   |
| 26  | DA02598 C   | SPOOL & STRING (Dual Line)           | 1   |
| 27  | D 06514     | LINE-Replacement (.095" Dia.)        | 1   |
| 28  | A 97910 A   | RETAINER-Spool (L.H.) (Red)          | 1   |
| 29  | DA03174 A   | STRINGHEAD COMPLETE                  | 1   |
| 30  | • A 03590 B | GRASS DEFLECTOR KIT                  | 1   |
| 31  | A 04362 03  | DEFLECTOR & BLADE                    | 1   |
| 32  | 82298       | SCREW-Mach. Hex Hd.                  | 5   |
| 33  | 84003       | WASHER-Flat                          | 5   |
| 34  | 81261       | NUT-Hex (10-24)                      | 2   |
| 35  | 83046       | WASHER-Lock                          | 3   |
| 36  | A 03404     | DEFLECTOR BRACKET KIT                | 1   |