



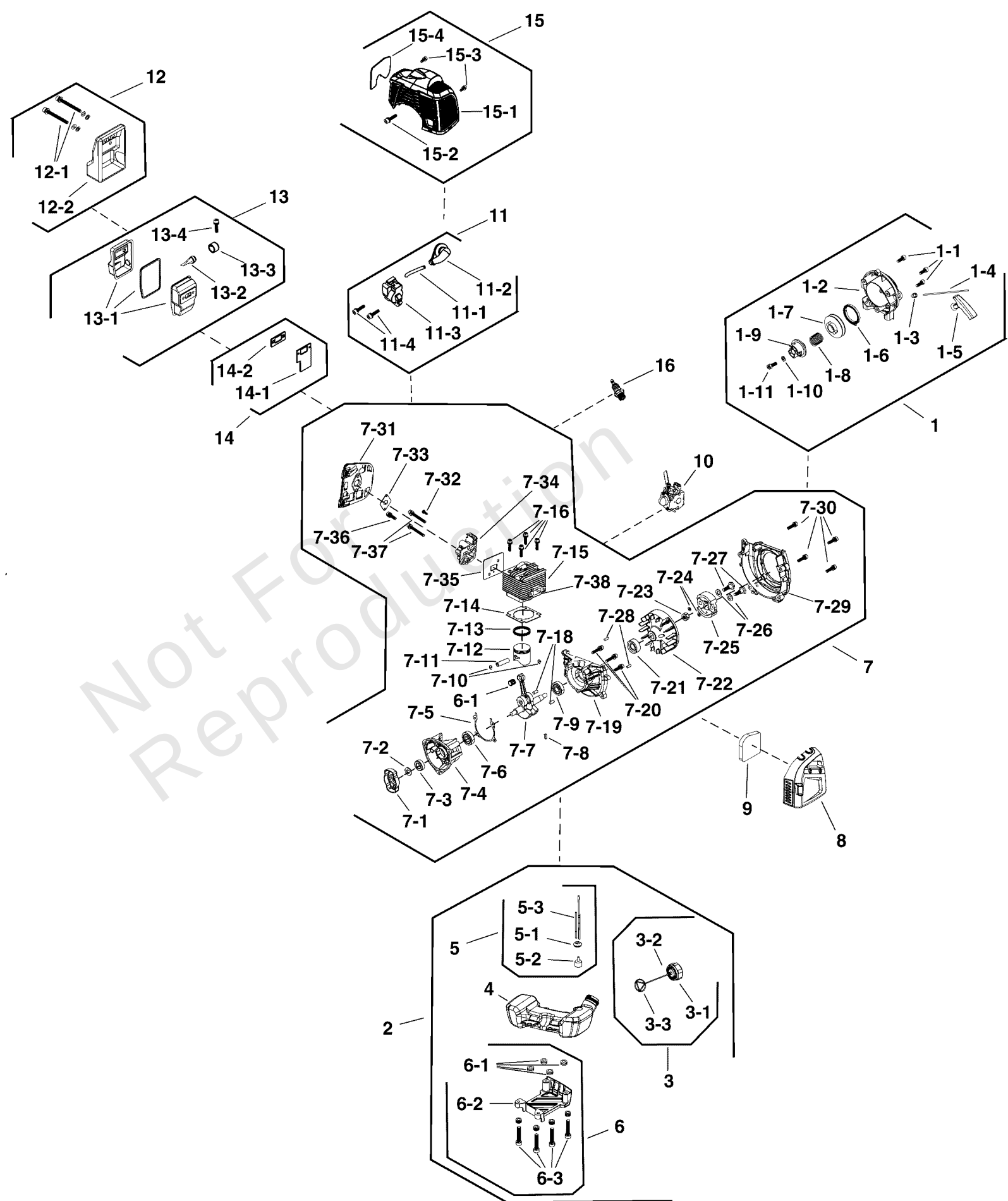
Parts Manual

Mfg. No: 883225-E
VICTA, 25CC Bent Shaft Trimmer



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Not For
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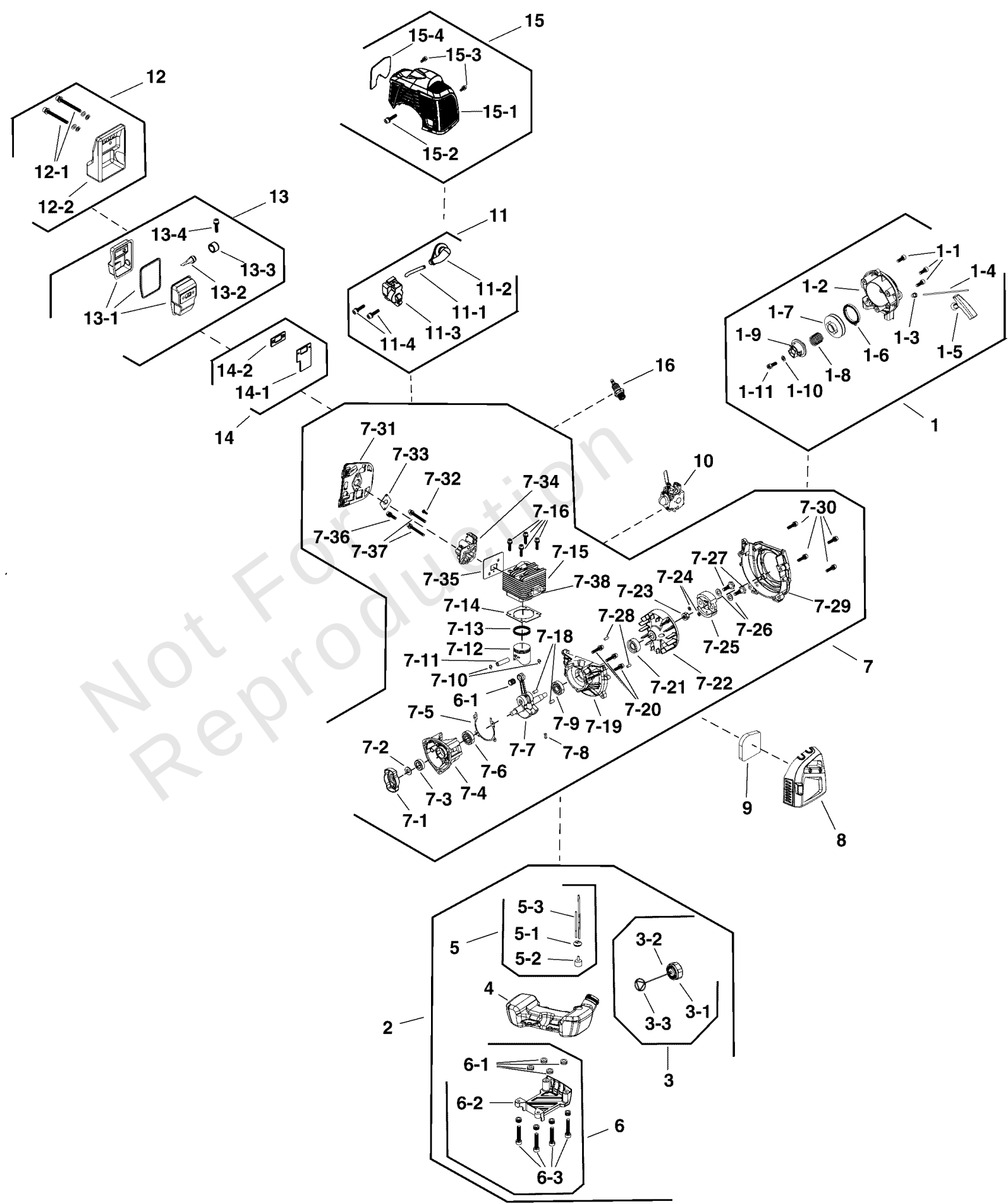
Engine Group

REF NO	PART NO	QTY	DESCRIPTION
--	TR02471A	1	ENGINE 25CC 2ST TRIMMER, EU2 -(Incl. Ref. Nos. 1 through 15)
1	TR02163A	1	STARTER ASSEMBLY -(Incl. Ref. Nos. 1-1 through 1-11)
1-1	-----	3	SCREW WASHER ASSEMBLY M5 x 12MM
1-2	-----	1	STARTER HOUSING
1-3	-----	1	GROMMET, Eyelet
1-4	-----	1	STARTER CHORD 2.5 x 800MM
1-5	-----	1	HANDLE
1-6	-----	1	COIL SPRING
1-7	-----	1	STARTER PULLEY
1-8	-----	1	SPRING
1-9	-----	1	RATCHET WHEEL
1-10	-----	1	WASHER ø5 X ø11 X 1.8MM
1-11	-----	1	ST SCREW 4.8 x 16MM
2	TR02161A	1	FUEL TANK ASSEMBLY -(Incl. Ref. Nos. 3 through 6)
3	TR02156A	1	FUEL CAP ASSEMBLY -(Incl. Ref. Nos. 3-1 through 3-3)
3-1	-----	1	FUEL CAP
3-2	-----	1	O RING
3-3	-----	1	FUEL CAP LOCK
4	TR02170A	1	FUEL TANK
5	TR02168A	1	FUEL FILTER ASSEMBLY -(Incl. Ref. Nos. 5-1 through 5-3)
5-1	-----	1	BALANCER, FUEL FILTER
5-2	-----	1	FUEL FILTER
5-3	-----	1	FUEL FILTER PIPING
6	TR02171A	1	FUEL TANK BASE ASSEMBLY -(Incl. Ref. Nos. 6-1 through 6-3)
6-1	-----	1	RUBBER DAMPENER
6-2	-----	1	BASE, FUEL TANK
6-3	-----	4	SCREW WASHER ASSEMBLY M5 x 25MM
7	TR02169A		25.4CC SHORT BLOCK ASSEMBLY -(Incl. Ref. Nos. 7-1 through 7-38)
7-1	TR02211A	1	START REEL
7-2	-----	1	WASHER M8 x 1.8MM
7-3	-----	1	OIL-SEAL 12 x 22 x 7MM
7-4	-----	1	CRANK CASE HOUSING RH
7-5	-----	1	GASKET CRANK CASE
7-6	-----	2	BEARING 6001
7-7	-----	1	CRANK SHAFT ASSEMBLY
7-8	-----	1	KEY 3 x 3.5 x 10MM
7-9	-----	1	BEARING 6001 8 x 11 x 11MM
7-10	-----	2	CIRCLIP
7-11	-----	1	PISTON PIN
7-12	-----	1	PISTON
7-13	-----	2	PISTON RING
7-14	-----	1	GASKET CYLINDER
7-15	-----	1	CYLINDER
7-16	-----	4	SCREW WASHER ASSEMBLY M5 x 20MM
7-18	-----	2	PIN ø5 x 10MM
7-19	-----	1	CRANK CASE LH

Engine Group

Note: Unless noted otherwise, use the standard torque specifications

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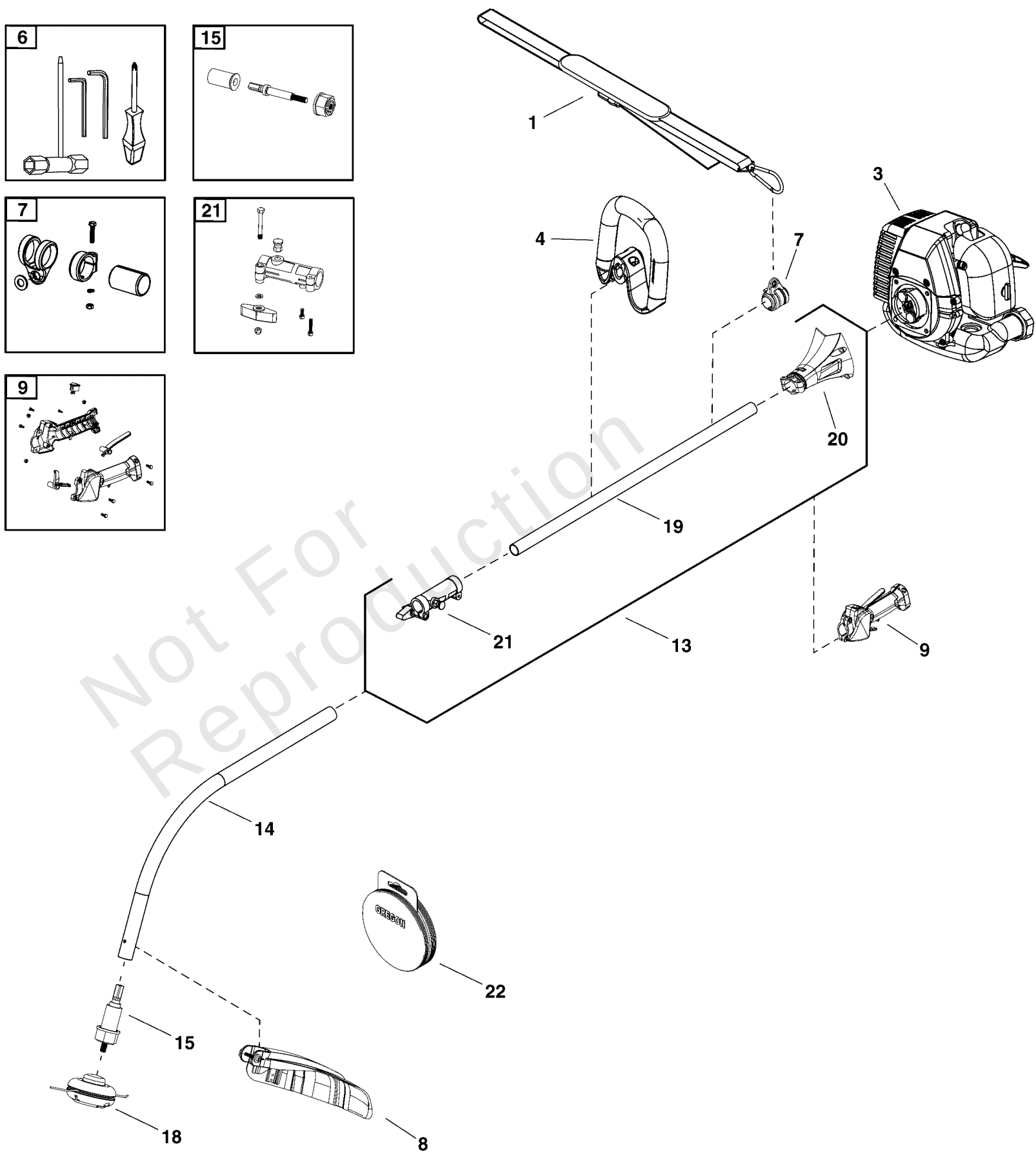
Engine Group

REF NO	PART NO	QTY	DESCRIPTION
7-20	-----	3	SCREW WASHER ASSEMBLY M5 x 25MM
7-21	-----	1	OIL-SEAL 12 x 22 x 7MM
7-22	-----	1	MAGNETO ROTOR
7-23	-----	1	FLANGED NUT M8 x 10MM
7-24	-----	2	FLAT WASHER
7-25	-----	1	CLUTCH ASSEMBLY
7-26	-----	2	WASHER
7-27	-----	2	BOLT
7-28	-----	2	PIN ø4 x 10MM
7-29	-----	1	FLYWHEEL COVER
7-30	-----	4	SCREW WASHER ASSEMBLY M5 x 20MM
7-31	-----	1	AIR FILTER BASE
7-32	-----	1	SCREW WASHER ASSEMBLY M5 x 45MM
7-33	-----	1	GASKET MANIFOLD
7-34	-----	1	MANIFOLD
7-35	-----	1	PRESSURE PLATE
7-36	-----	1	ST SCREW 3.5 x 9.5MM
7-37	-----	2	SCREW WASHER ASSEMBLY M5 x 20MM
7-38	-----	1	GASKET CARBURETOR
8	-----	1	AIR FILTER COVER
9	-----	1	FOAM AIR FILTER
10	TR02162A	1	CARBURETOR ASSEMBLY
11	TR02172A	1	IGNITION COIL ASSEMBLY -(Incl. Ref. Nos. 11-1 through 11-4)
11-1	-----	1	WIRING HARNESS ASSEMBLY
11-2	-----	1	SPARK PLUG COVER ASSEMBLY
11-3	-----	1	IGNITION COIL ASSEMBLY
11-4	-----	2	SCREW WASHER ASSEMBLY M5 x 20MM
12	TR02173A	1	MUFFLER HOUSING COVER ASSEMBLY -(Incl. Ref. Nos. 12-1 & 12-2)
12-1	-----	2	SCREW WASHER ASSEMBLY M5 x 52MM
12-2	-----	1	MUFFLER HOUSING COVER
13	TR02472A	1	MUFFLER ASSEMBLY, EU2 -(Incl. Ref. Nos. 13-1 through 13-4)
13-1	-----	1	MUFFLER, NO CAT CONVERTER
13-2	-----	1	SPARK ARRESTOR MESH
13-3	-----	1	SEAL
13-4	-----	1	SCREW WASHER ASSEMBLY M5 x 15MM
14	TR02174A	1	MUFFLER GASKET ASSEMBLY -(Incl. Ref. Nos. 14-1 & 14-2)
14-1	-----	1	INNER GASKET MUFFLER
14-2	-----	1	OUTER GASKET MUFFLER
15	TR02437A	1	TOP ENGINE COVER -(Incl. Ref. Nos. 15-1 through 15-4)
15-1	-----	1	TRIMMER TOP HOUSING
15-2	-----	1	ST SCREW 4.8 x 16MM
15-3	-----	2	SCREW M4 x 12MM
15-4	-----	1	REFLECTIVE THERMAL GASKET
16	HA25735A	1	SPARK PLUG

Shaft Group

Note: Unless noted otherwise, use the standard torque specifications

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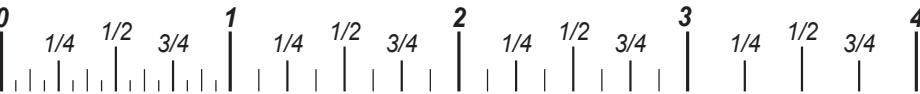
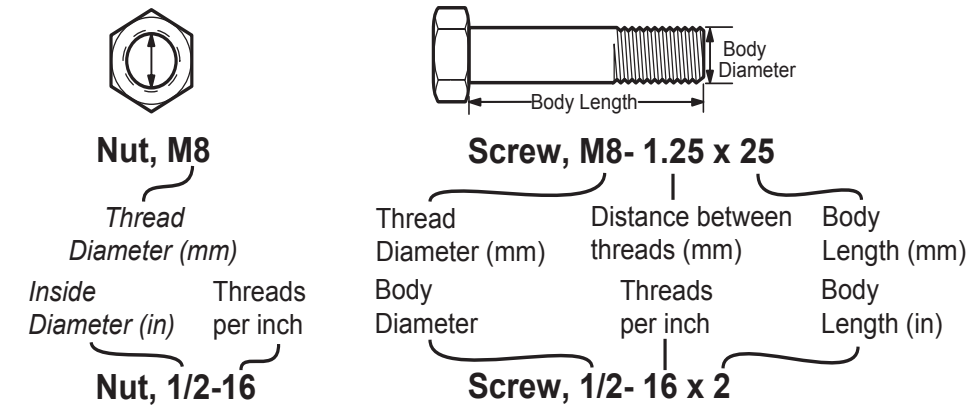
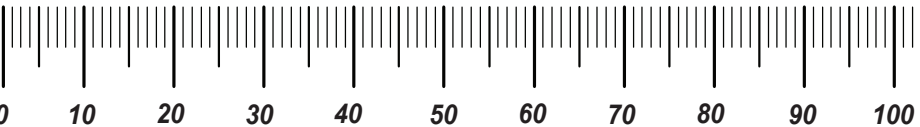
Shaft Group

REF NO	PART NO	QTY	DESCRIPTION
1	TR01935A	1	HARNESS, Shoulder
3	TR02471A	1	ENGINE 25CC 2ST TRIMMER, EU2
4	TR01930A	1	HANDLE ASSEMBLY
6	-----	1	TOOL KIT -(Not a serviceable part.)
7	TR01926A	1	BRACKET, Strap -(Includes all items shown in box.)
8	TR01932A	1	GUARD ASSEMBLY, Bent Shaft
9	TR01928A	1	TRIGGER HOUSING ASSEMBLY -(Includes all items shown in box.)
13	TR02435A	1	SHAFT ASSEMBLY, Upper
14	TR02449A	1	BENT SHAFT ASSEMBLY
15	TR02485A	1	GEAR HEAD ASSEMBLY, GSL HEAD -(Includes all items shown in box.)
18	24-260-A_AAB	1	GATOR SPEEDLOAD HEAD PRO SM
19	TR02428A	1	UPPER DRIVE SHAFT ASSEMBLY
20	TR02434A	1	CLUTCH ASSEMBLY
21	TR02422A	1	COUPLING ASSEMBLY -(Includes all items shown in box.)
22	24-295-03_AAB	1	GSL SMALL DISK TRIMMER LINE, 3 PACK

Hardware Identification & Torque Specifications

Torque Specification Chart								
FOR STANDARD METRIC MACHINE HARDWARE (Tolerance ± 20%)								
Property Class	 Class 5.6		 Class 8.8		 Class 10.9		 Class 12.9	
Size Of Hardware	in/lbs ft/lbs	Nm.	in/lbs ft/lbs	Nm.	in/lbs ft/lbs	Nm.	in/lbs ft/lbs	Nm.
M3	5.88	.56	13.44	1.28	19.2	1.80	22.92	2.15
M4	13.44	1.28	30.72	2.90	43.44	4.10	52.56	4.95
M5	26.4	2.50	60.96	5.75	5.97	8.10	7.15	9.7
M6	44.64	4.3	7.3	9.9	10.3	14	12.1	16.5
M7	5.2	7.1	12.1	16.5	16.9	23	19.9	27
M8	7.7	10.5	17.7	24	25	34	29	40
M10	15	21	35	48	50	67	59	81
M12	26	36	61	83	86.2	117	103	140
M14	42	58	101	132	136	185	162	220
M16	64	88	147	200	210	285	250	340
M18	89	121	202	275	287	390	346	470
M20	126	171	290	390	405	550	486	660
M22	169	230	390	530	559	745	656	890
M24	217	295	497	375	708	960	840	1140
M27	320	435	733	995	1032	1400	1239	1680
M30	435	590	995	1350	1401	1900	1681	2280
M33	590	800	1349	1830	1902	2580	2278	3090
M36	759	1030	1740	2360	2441	3310	2935	3980
M39	988	1340	2249	3050	3163	4290	3798	5150

The guides and ruler furnished below are designed to help you select the appropriate hardware.



Standard Hardware Sizing

When a washer or nut is identified as 1/2" (M8), this is the *Nominal size*, meaning the *inside diameter* is 1/2 inch (8mm metric thread diameter); if a second number is present it represents the *threads per inch* (distance between threads).

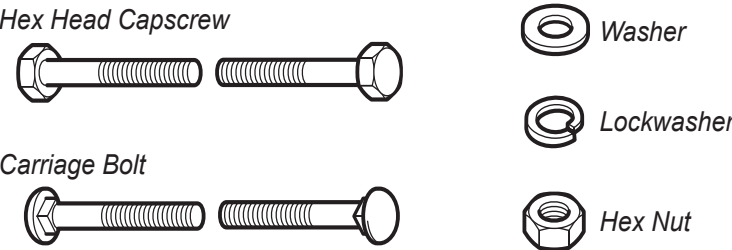
When bolt or capscrew is identified as 1/2 - 16 x 2" (M8 - 1.25 x 50), this means the *Nominal size*, or body diameter is 1/2 inch (8mm metric thread diameter), the second number, 16, represents the *threads per inch*, (*distance between threads*). The final number is the body length of the bolt or screw, 2 inches (50mm).

Torque Specification Chart						
FOR STANDARD MACHINE HARDWARE (Tolerance ± 20%)						
Hardware Grade	 SAE Grade 2		 SAE Grade 5		 SAE Grade 8	
Size Of Hardware	in/lbs ft/lbs	Nm.	in/lbs ft/lbs	Nm.	in/lbs ft/lbs	Nm.
8-32	19	2.1	30	3.4	41	4.6
8-36	20	2.3	31	3.5	43	4.9
10-24	27	3.1	43	4.9	60	6.8
10-32	31	3.5	49	5.5	68	7.7
1/4-20	66	7.6	8	10.9	12	16.3
1/4-28	76	8.6	10	13.6	14	19.0
5/16-18	11	15.0	17	23.1	25	34.0
5/16-24	12	16.3	19	25.8	29	34.0
3/8-16	20	27.2	30	40.8	45	61.2
3/8-24	23	31.3	35	47.6	50	68.0
7/16-14	30	40.8	50	68.0	70	95.2
7/16-20	35	47.6	55	74.8	80	108.8
1/2-13	50	68.0	75	102.0	110	149.6
1/2-20	55	74.8	90	122.4	120	163.2
9/16-12	65	88.4	110	149.6	150	204.0
9/16-18	75	102.0	120	163.2	170	231.2
5/8-11	90	122.4	150	204.0	220	299.2
5/8-18	100	136	180	244.8	240	326.4
3/4-10	160	217.6	260	353.6	386	525.0
3/4-16	180	244.8	300	408.0	420	571.2
7/8-9	140	190.4	400	544.0	600	816.0
7/8-14	155	210.8	440	598.4	660	897.6
1-8	220	299.2	580	788.8	900	1,244.0
1-12	240	326.4	640	870.4	1,000	1,360.0

NOTES

- These torque values are to be used for all hardware excluding: locknuts, self-tapping screws, thread forming screws, sheet metal screws and socket head setscrews.
- Recommended seating torque values for locknuts:
 - for prevailing torque locknuts - use 65% of grade 5 torques.
 - for flange whizlock nuts and screws - use 135% of grade 5 torques.
- Unless otherwise noted on assembly drawings, all torque values must meet this specification.

Common Hardware Types



Wrench & Fastener Size Guide

 1/4" Bolt or Nut Wrench—7/16"	 5/16" Bolt or Nut Wrench—1/2"	 3/8" Bolt or Nut Wrench—9/16"	 7/16" Bolt or Nut Wrench (Bolt)—5/8" Wrench (Nut)—11/16"	 1/2" Bolt or Nut Wrench—3/4"
M6 Bolt or Nut Wrench—10mm	M8 Bolt or Nut Wrench—13mm	M10 Bolt or Nut Wrench—17mm	M12 Bolt or Nut Wrench—19mm	M14 Bolt or Nut Wrench—22mm

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