## **SERVICE PARTS LIST**

Milwaukee

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

Cordless M18<sup>TM</sup> SDS Rotary Hammer

REVISED BULLETIN 54-24-2670 DATE Oct. 2017

CATALOG NO.

2612-20

STARTING SERIAL NO.

F28B

WIRING INSTRUCTION
SEE PAGE 4

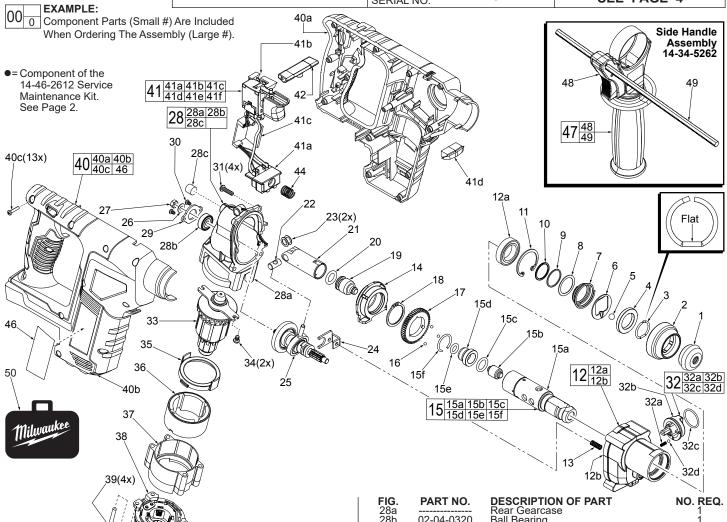
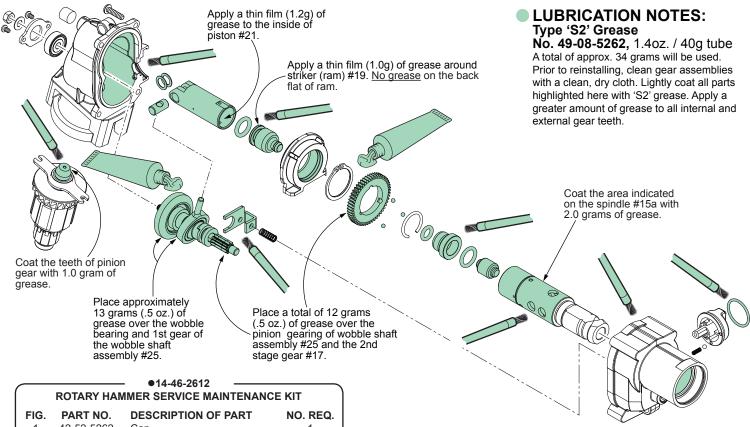


FIG.	PART NO.		D. REQ.
1	42-52-5262● 42-96-0035●	Cap Sleeve	1
2 3 4 5 6 7 8 9	44-90-0106	Snap Ring	1
4	44-90-0107	Holding Ring	1
5	02-02-0146	6.5mm Steel Ball	1
7	42-36-0039 40-50-5262	Support Plate Pressure Spring	1 1
8	45-88-0226	Flat Washer	1
9 10	45-88-0227	Flat Washer	1
11	44-90-0108 34-80-0210	Spiral Retaining Ring Retaining Ring	1
12	14-30-6235	Front Gearcase Assembly	1
12a 12b	02-04-0315	Ball Bearing	1
13	40-50-1215	Front Gearčase w/ Shift Pin & Needle Brg Shifter Spring	· 1
14	28-72-2612	Bearing Holder Assy. w/ Needle Bearing	1
15	38-50-1035	Spindle Assembly	1
15a 15b	38-50-1040 45-08-0505	Spindle Anvil	1
15c	34-40-0530	O-Ring	1
15d	45-22-0008 34-40-0531●	Sleeve Q-Ring	1
15e 15f	44-90-0109	Snap Ring	1 1 3 1 1
16	02-02-1230	3.0mm Steel Ball	3
17 18	32-44-5375	2nd Stage Gear	1
19	34-60-0140 45-56-0025	Retaining Ring Striker (Ram)	1
20	34-40-0532	O-Ring	1
21 22	44-62-0147	Piston	1
23	44-60-0555 45-88-0228●	Wrist Pin Washer	1 1 1 2 1
24	44-66-7020	Shifting Clip	1
25 26 27	36-92-5200	Wobble Shaft Assembly	1
26	45-88-0562● 05-55-0202●	Lock Washer Jam Nut	1
28	14-30-6236	Rear Gearcase Assembly w/ Ball Bearing	i
		, ,	

		12b	32u
FIG. 28ab 228c 290 331 32c 332b 332c 333 45 336 78 390 400c 41ab 41c 441d 441e 442 446 447 489 50	PART NO	Rear Gearcase Ball Bearing Felt Plug Intermediate Shaft Bearing Plate M3 x 5 Pan Hd. Torx M4 x 16mm Pan Hd. T-20 Screw Shift Knob Assembly Shift Knob Spring Shift Knob O-Ring 3.0mm Steel Ball Armature Assembly M4 x 6mm Screw Fan Baffle Service Field Motor Cage Brush Card Assembly M4 x 0.7 x 45mm t-20 Screw Handle Housing Assembly Support Housing (Left Housing Halve) Cover Housing (Right Housing Halve) 4-20 x 1/2" Pan Hd. Plastite T-10 Screw Switch / Electronics Assembly Terminal Block On-Off Switch PCB Assembly LED Assembly LED Assembly LED Assembly LED Assembly Fwd./Rev. Shuttle Terminal Block Spring Service Nameplate Side Handle Assembly Side Handle Blow Molded Carrying Case Type 'S2' Grease, 1.4 oz. / 40gr. Tube (Not Shown	2 1 1 1 1 1

13135 W. Lisbon Road, Brookfield, WI 53005



RUTARY HAMIMER SERVICE MAINTENANCE KIT					
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.		
1	42-52-5262	Cap	1		
2	42-96-0035	Sleeve	1		
3	44-90-0106	Snap Ring	1		
5	02-02-0146	6.5mm Steel Ball	1		
15c	34-40-0530	O-Ring	1		
15e	34-40-0531	O-Ring	1		
15f	44-90-0109	Snap Ring	1		
20	34-40-0532	O-Ring	1		
23	45-88-0228	Wrist Pin Washer	2		
26	45-88-0562	Lock Washer	1		
27	05-55-0202	Jam Nut	1		
28c	43-84-0300	Felt Plug	1		
32a	40-50-1220	Spring	1		
32c	34-40-0533	O-Ring	1		
32d	02-02-1230	3.0 Steel Ball	1		
38	22-22-5400	Brush Card Assembly	1		
-	49-08-5262	1.4 oz. / 40gr. Tube 'S 2' Grease	1		

## NOTE:

FIG. 27

30

31

34

39

40c

41e

PART NO.

05-55-0202

05-88-0926

05-74-0010

05-88-1202

05-88-1260

06-82-7225

As an aid to installing snap ring #15f into spindle #15a, rest the snap ring on rear spindle, perpendicular to the opening. To condense the snap ring, use a flat blade screwdriver to push snap ring down into the

**SCREW TORQUE SPECIFICATIONS** 

Inter. Shaft Bearing Plate

Brush Card / Motor Cage

Switch Wires to Brush Card

WHERE USED

Rear Gearcase

Cover Housing

Motor Bearing Plate

Jam Nut

**SEAT TORQUE** 

(KG/CM) (IN/LBS)

35-43

3-5

10-15

10-15

10-15

6-8

4-7

40-50

4-6

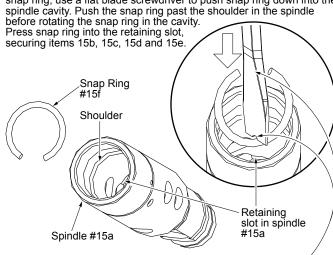
12-17

12-17

12-17

7-10

5-8

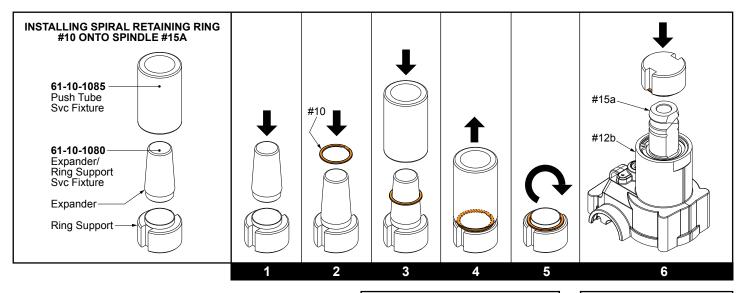


As an aid to installing snap ring, it may be helpful to file or grind a notch in the bottom flat of the screwdriver to accommodate the round of the snap ring. As force is applied to the snap ring, the open end of the ring will close in on the screwdriver. It may be necessary to do additional modifications to the screwdriver (grinding the sides of the blade or shaft) to allow for the insertion of the ring and the removal of the screwdriver.

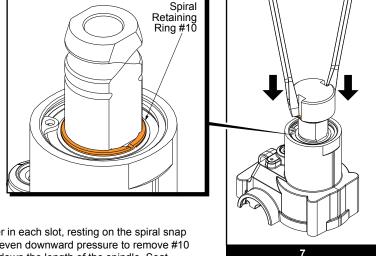
## NOTE:

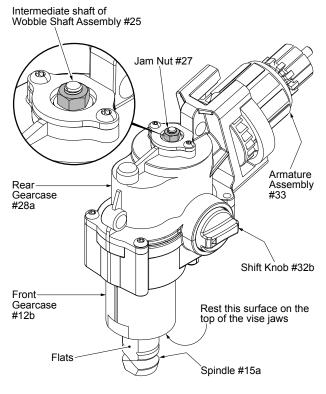
As an aid to installing items #15b, #15c, #15d and #15e squarely into spindle

As an aid to installing items #15b, #15c, #15d #15a, the following steps should be followed: 1. Place o-ring #15e inside sleeve #15d. 2. Place anvil #15b inside sleeve 15d. 3. Slide o-ring #15c onto anvil #15b. 4. Place that assembly of parts on top of an old piston #21 and gentily insert Piston #21 into the back end of spindle #15a until parts bottom out. Remove piston. Spindle Piston #21 O-Ring #15e Sleeve #15d O-Ring #15c Anvil #15b Spindle #15a



- Assemble Expander/Ring Support Service Fixture (61-10-1080) by inserting the expander into the ring support as shown.
- Place the assembled fixture on a flat, level surface. Place the Spiral Retaining Ring #10 squarely onto tapered end of the expander.
- Place the Push Tube Service Fixture (61-10-1085) over the expander until it rests against the spiral retaining ring. With the use of a mallet, drive the push tube and spiral retaining ring down onto the ring support.
- Remove the push tube. The spiral retaining ring has been expanded around the collar of the ring support.
- 5. Turn the ring support/spiral snap ring upside down.
- 6. Place the ring support/spiral snap ring over the top of spindle #15a.
- 7. Locate the two slots on the ring support. Place a flat blade screwdriver in each slot, resting on the spiral snap ring. (It is preferred that the same size screwdrivers are used). Place even downward pressure to remove #10 off of the ring support and onto the spindle. Slide the spiral snap ring down the length of the spindle. Seat squarely into groove of spindle as shown.





To properly secure the wobble shaft assembly #25 to the rear gearcase #28a, use the following procedures as an aid:

Place the assembly shown with the flats of the spindle #15a in a bench vise. Use brass vise jaw caps to protect the spindle. Assembly can rest with the front of the front gearcase #12b resting on top of the vise jaws for 'squareness' when setting the proper torque to the jam nut #27.

Place the shift knob #32b at the 'hammer with rotation' position.

Place an M10 hex socket on the jam nut. Hold by hand the armature assembly #33 (armature pinion gear meshing with the bevel gear of the wobble shaft assembly) to prevent the wobble shaft assembly from spinning.

Torque the jam nut to 3-4 ft/lbs (35-43 in/lbs, 40-50 kgf/cm).

