



SERVICE PARTS LIST

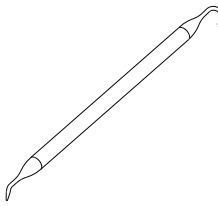
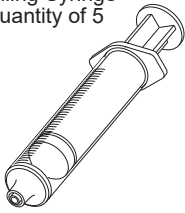
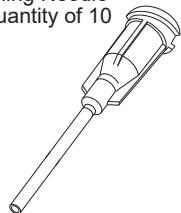
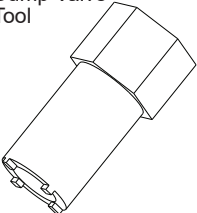
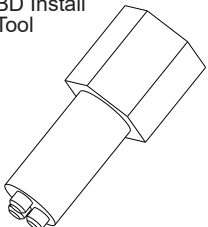
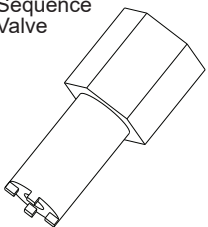
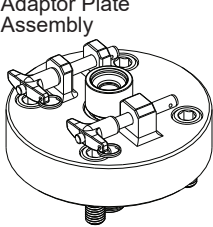
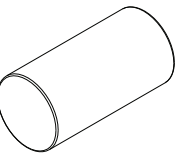
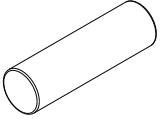
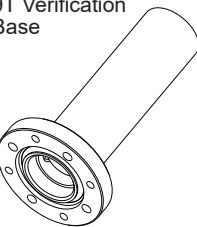
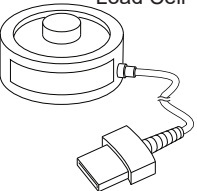
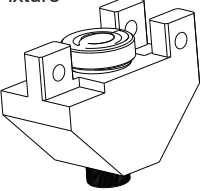
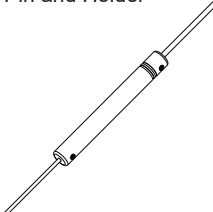
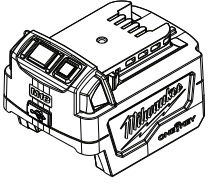
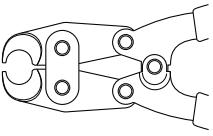
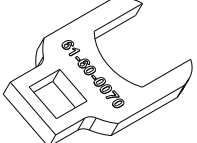
BULLETIN NO.
54-47-2870

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ ONE-KEY™ FORCELOGIC™ Dieless Crimper			Nov. 2019
CAT. NO.	2877-20	STARTING SERIAL	K16A
		WIRING INSTRUCTION SEE PAGE 4	

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-  **BEST PRACTICES when Servicing he 2877-20:**
- Caution:** Always assume Hydraulic tool is under pressure, before starting any repair procedures, manually engage the relief valve. Confirm no hydraulic pressure remains.
- **Important!** The pressure sensor is a monitoring device that is calibrated with the electronics assembly. **Always** replace pressure sensor and electronics assembly **as a set!**
 - **Always** wear P.P.E. (Personal Protective Equipment) when working with hydraulic fluid.
 - **Do not** use Hammers or Impact tools.
 - **Do not** use sharp metal objects on seals or sealing surfaces.
 - **Always** use recommended service tools and fixtures.
 - **Always** ensure new hydraulic parts are free of burrs or defects.
 - **Always** establish a clean work area free of dirt and debris.
 - **Always** insure that clean parts are used prior to assembly.
 - **Always** follow proper torque specifications.
 - **Always** confirm repair by testing on verification fixtures.
 - **Always** use appropriate hydraulic oil, MILWAUKEE FORCELOGIC™ Hydraulic Oil, No. 49-32-0110.
 - **Always** remove battery pack before changing or removing accessories. Only use accessories specifically recommended for this tool. Others may be hazardous. For a complete listing of accessories, go online to www.milwaukeetool.com or contact a local MILWAUKEE distributor.

SERVICE TOOLS / FIXTURES

Indicator  61-50-0020	Fill Bottle  61-50-0040	Seal Pick Tool  61-50-0050	Filling Syringe Quantity of 5  61-50-0100	Filling Needle Quantity of 10  61-50-0110	Dump Valve Tool  61-60-0025
BD Install Tool  61-60-0035	Sequence Valve  61-60-0045	Adaptor Plate Assembly  61-60-0105	Callibration Pin  61-60-0135	Distance Verification Pin  61-60-0145	9T Verification Base  61-60-0170
30k Button Load Cell  61-60-0215	Sequence Valve Fixture  61-60-0230	Pin and Holder  61-60-0260	One Key™ Adaptor  2700-20	Crimping Service Tool  61-60-0265	Pressure Sensor Crowfoot Wrench  61-60-0070



Service Videos are available to aid in repair and maintenance of Dieless Crimper.



Repair Guides are available that illustrate/explain any special assembly, settings or procedures.

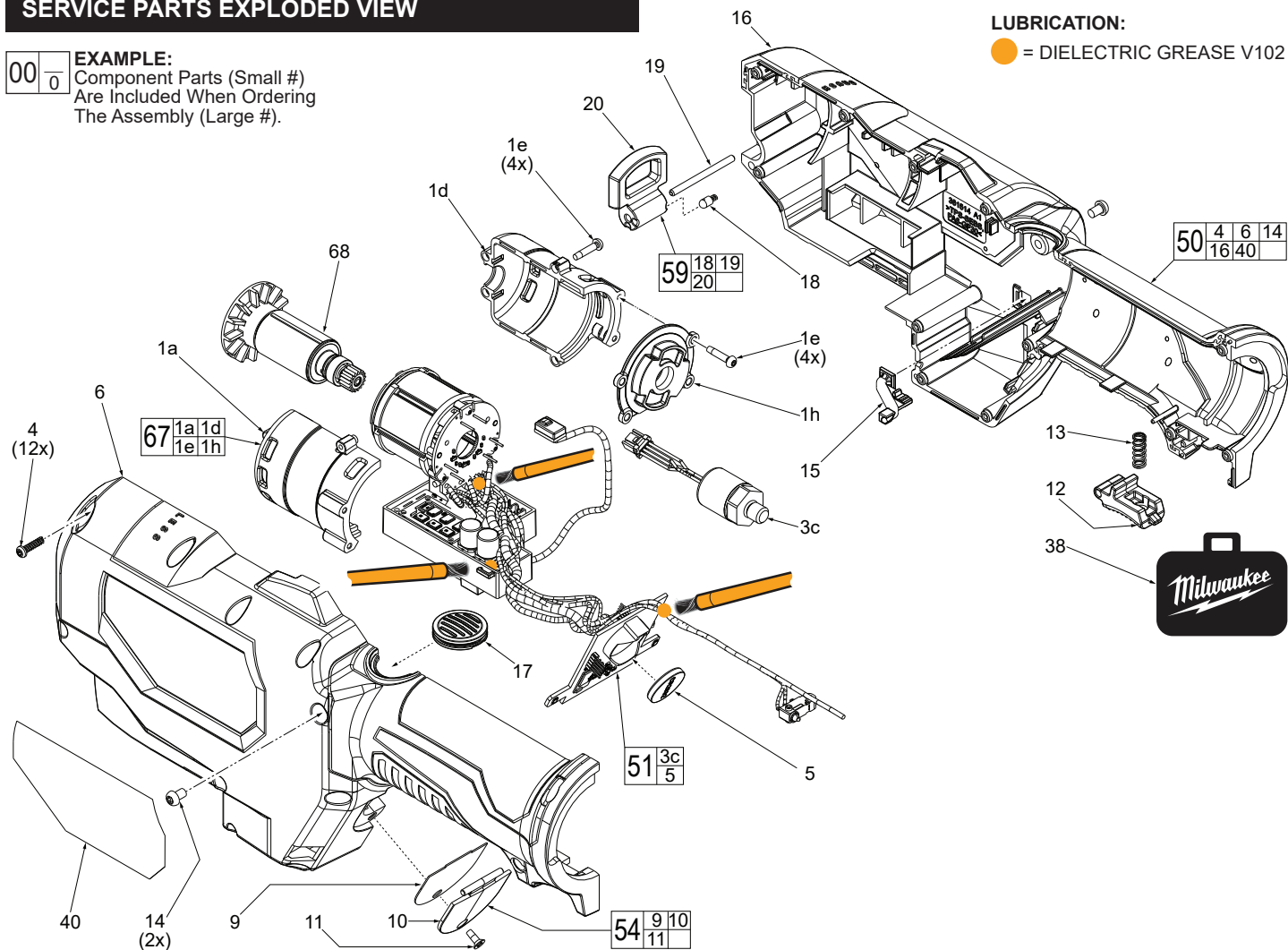


Verification Procedures are covered in service videos as well as repair guides.

SERVICE PARTS EXPLODED VIEW

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



LUBRICATION:

● = DIELECTRIC GREASE V102

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1a	-----	Motor Insulator Support - Right	(1)
1d	-----	Motor Insulator Cover - Left	(1)
1e	06-82-1080	M3 x 14mm Pan Hd. Plast. T-10 Screw	(8)
1h	-----	Motor Plate	(1)
3c	-----	Pressure Sensor	(1)
4	06-82-7225	4-20 x 1/2" Pan Hd. Plast. T-10 Screw	(12)
5	-----	3V Coin Cell Battery (CR2032)	(1)
6	-----	Housing Cover - Right Halve	(1)
9	-----	Rubber Anti Static Seal	(1)
10	-----	Coin Cell Door	(1)
11	05-78-0088	M3 x 8mm Flat Hd. ST Phillips Screw	(1)
12	45-72-0015	Trigger	(1)
13	40-50-0024	Trigger Spring	(1)
14	05-88-1202	M4 x 6mm Pan Hd. T-10 Mach. Screw	(2)
15	44-06-0006	Bluetooth Indicator Lens	(1)
16	-----	Housing Support - Left Halve	(1)
17	42-42-0016	Release Button Cover	(1)
18	44-60-5380	Steel Cap Detent Assembly	(1)
19	-----	Steel Pin	(1)
20	-----	Lanyard Latch Ring	(1)
38	42-55-0038	Blow Molded Carrying Case	(1)
40	12-20-0162	Service Nameplate	(1)
50	31-44-0072	Housing Kit	(1)
51	22-06-0021	Electronics Assy. w/ Pressure Sensor	(1)
54	42-92-0091	Coin Cell Door Kit	(1)
59	14-36-0027	Lanyard Latch Ring Kit	(1)
67	31-50-0732	Insulator Housing Kit	(1)
68	16-07-0023	Rotor Assembly	(1)

TORQUE SPECIFICATIONS *Red denotes Critical Torque

FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(KG/CM)	(IN/LBS)
1e	06-82-1080	Motor Plate	13±2	11±2
1e	06-82-1080	Motor Insulator Cover	6±1	5±1
3c	-----	Pressure Sensor	204±3	177±2
4	06-82-7225	Right Housing-Cover	9±1	8±1
7	05-81-0015	Gearbox Assembly	12±3	10±2
14	05-88-1202	Right and Left Housing	13±1	11±1
21	05-88-0031	Pump Body	45±3	39±2
22	05-88-0051	Pump Body	135±6	117±5
24	05-88-0041	Pump Body	15±3	13±2
28b	-----	Bladder	15±2	13±2
36	06-82-9225	Encoder	7±2	6±2
64	31-94-0015	Sequence Valve	207±3	180±2
62	31-94-0307	Release Valve	200±6	174±5
66	31-94-0407	Burst Disc Lock Cap	194±6	168±5

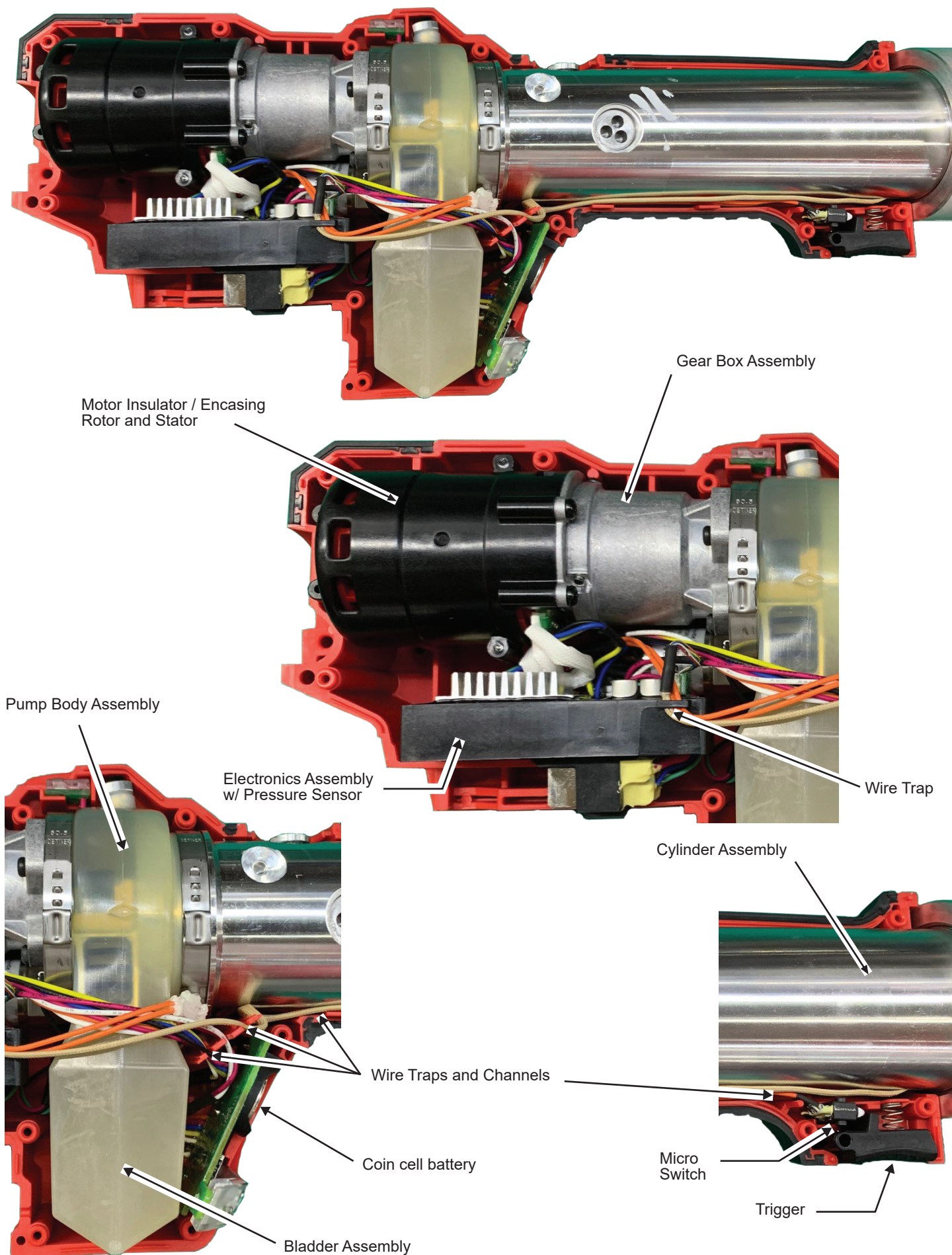
* = Pre-tighten with hand screw driver

** = Tighten with torque wrench



Service Verification Specification 13,000-14,500 lbs

SERVICE WIRING DIAGRAM



LUBRICATION INSTRUCTIONS

Reference Page 3 for callouts on exploded views.

LUBRICATION:

- = Type S2 Grease (7 oz. tube), 49-08-5265
- = Type S2-80 White Lithium Grease, 49-08-0145
- = 243 Blue Loctite, 44-22-0095
- = Loctite 51007 Copper LB 8008 C5-A, Anti-Seize Lubricant (1 lb. can), 44-22-0035

