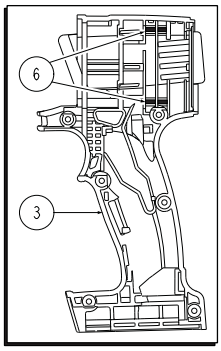
# SERVICE PARTS LIST

**BULLETIN NO. 54-26-2701**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | REVISED BULLETIN | DATE |
|---|---|---|
| **18 Volt 3/8" Square Impact Wrench** | 54-26-2700 | Mar. 2013 |
| **CATALOG NO. 2651-20** STARTING SERIAL NO. **B77B** | WIRING INSTRUCTION **SEE PAGE 3** | |

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



Place Rubber Slugs (6) as shown, four in each handle half (2,3).




| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| ★ 1 | 31-44-2435 | Handle Assembly | (1) |
| 2 | ---------- | Left Handle Half | (1) |
| 3 | ---------- | Right Handle Half | (1) |
| 4 | 42-52-0062 | End Cap | (1) |
| 5 | 45-24-0300 | Forward / Reverse Shuttle | (1) |
| 6 | 45-30-0250 | Rubber Slug | (8) |
| 7 | 42-70-5150 | Belt Hook | (1) |
| 8 | 40-50-1090 | Spring | (1) |
| 9 | ---------- | Contact Block | (1) |
| ★10 | 23-66-2830 | Switch | (1) |
| ★11 | 23-66-1238 | Switch/Brush Card Assembly | (1) |
| ★13 | ---------- | LED Assembly | (1) |
| ★15 | 22-22-1550 | Brush Card Assembly | (1) |
| 16 | 16-01-3010 | Service Armature Assembly | (1) |
| 17 | 18-01-3011 | Service Field | (1) |
| ★18 | ---------- | PCB Assembly | (1) |
| 19 | 14-30-0920 | Gear Box Assembly | (1) |
| 20 | ---------- | Rear Case | (1) |
| 21 | ---------- | Ring Gear | (1) |
| 22 | ---------- | Retaining Ring | (1) |
| 23 | ---------- | Ball Bearing | (1) |
| 24 | ---------- | Washer | (1) |
| 25 | ---------- | Pin | (2) |
| 26 | ---------- | Planet Gear | (2) |
| 27 | ---------- | Cam Shaft | (1) |
| 28 | ---------- | 3/16" Steel Ball | (2) |
| 29 | ---------- | Washer | (1) |
| 30 | ---------- | Compression Spring | (1) |
| 31 | ---------- | Washer | (1) |
| 32 | ---------- | 3.0mm Steel Ball | (30) |
| 33 | ---------- | Hammer | (1) |

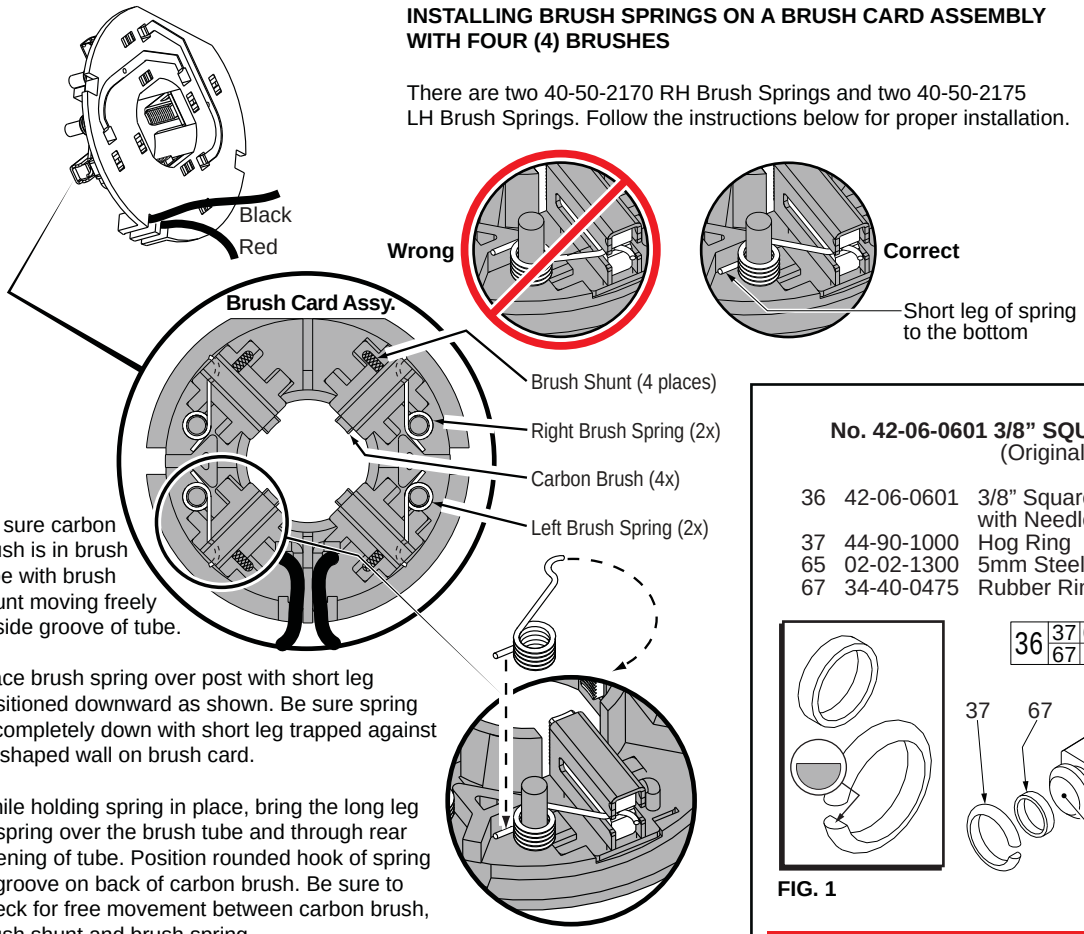
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 36 | ---------- | 3/8" Square Drive Anvil Assy. w/Bearing *(See page two)* | (1) |
| 37 | ---------- | Hog Ring *(See page two)* | (1) |
| 42 | 45-88-2025 | Front Washer | (1) |
| 43 | 28-50-0900 | Front Case Sub-Assembly w/ Bushing | (1) |
| 47 | 06-82-7010 | 8-18 x 24 Pan Hd. Screw | (4) |
| 55 | 06-82-6350 | M3 Pan Hd. T-10 Screw | (7) |
| 56 | 06-82-7336 | M3 Pan Hd. T-10 Screw | (4) |
| 57 | 06-82-5275 | 6-32 x 5/16" Slt. Pan Hd. T-15 Screw | (1) |
| 59 | 12-20-2650 | Service Nameplate Kit | (1) |
| 60 | 10-20-2695 | Warning Label | (1) |
| 65 | 02-02-1300 | 5mm Steel Ball | (1) |
| 67 | ---------- | Rubber Ring *(See page two)* | (1) |
| 68 | 42-55-2650 | Carrying Case | (1) |
| 69 | 40-50-2170 | Brush Spring - Right | (2) |
| 70 | 40-50-2175 | Brush Spring - Left | (2) |
| ★71 | 14-46-1710 | Cam Shaft/Hammer Kit | (1) |
| ★72 | 23-66-1239 | Switch and Housing Kit | (1) |
| 80 | 42-70-2653 | Belt Clip Assembly | (1) |
| 81 | ---------- | Belt Clip | (1) |
| 82 | ---------- | Belt Clip Screw | (1) |


**MILWAUKEE ELECTRIC TOOL CORPORATION**
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Drwg. 4

**INSTALLING BRUSH SPRINGS ON A BRUSH CARD ASSEMBLY WITH FOUR (4) BRUSHES**

There are two 40-50-2170 RH Brush Springs and two 40-50-2175 LH Brush Springs. Follow the instructions below for proper installation.




Be sure carbon brush is in brush tube with brush shunt moving freely in side groove of tube.

Place brush spring over post with short leg positioned downward as shown. Be sure spring is completely down with short leg trapped against 'Y' shaped wall on brush card.

While holding spring in place, bring the long leg of spring over the brush tube and through rear opening of tube. Position rounded hook of spring in groove on back of carbon brush. Be sure to check for free movement between carbon brush, brush shunt and brush spring.

| FIG. | NOTES: |
|---|---|
| 15,16,17 | See service note and illustration on the back of bulletin to aid with the removal and installation of the the Brush Card (15), Armature (16) and Field (17). |
| 17 | Field (17) to be positioned with side cut-outs to the front. |
| 20,21 | Position Ring Gear (21) with three lugs face down to interlock in the bottom of Rear Case (20). |
| 20,43 | Be sure to match the raised contours on the bottom of Rear Case (20) with raised contour on bottom of Front Case (43) when assembling. |
| 29,30 | Make sure concave side of Washer (29) faces Spring (30). |
| 42,43 | Tappered end of Front Washer (42) to face Front Case (43). |

| FIG. | LUBRICATION (Type 'J' Grease, No. 49-08-4220): |
|---|---|
| 21,26 | Lightly coat I.D. of the Ring Gear (21) and center of the two Planet Gears (26) with grease. |
| 27 | Place a dab of grease in the ball grooves of the Cam Shaft (27). |
| 36,37 | Lightly coat front washer surface of Anvil (36) with grease, place a dab in the Ball holes of Anvil and in Needle Bearing inside the Anvil. |
| 43 | Coat inside grooves of Bushing (inside of 43) with grease. |

**No. 42-06-0601 3/8" SQUARE ANVIL ASSEMBLY**
(Original Design)

| | | | |
|---|---|---|---|
| 36 | 42-06-0601 | 3/8" Square Drive Anvil Assembly with Needle Bearing | (1) |
| 37 | 44-90-1000 | Hog Ring | (1) |
| 65 | 02-02-1300 | 5mm Steel Ball | (1) |
| 67 | 34-40-0475 | Rubber Ring | (1) |




**FIG. 1**

**IMPORTANT!**
***Hog Ring* and *O-Ring* components of the 3/8" Square Anvil Assemblies for M18™ Impact Wrenches are unique and are *NOT INTERCHANGE-ABLE* between Anvil Assemblies**

**Original Anvil Assembly 42-06-0601 (Fig. 1) uses Hog Ring 44-90-1000 and O-Ring 34-40-0475**

**Service Replacement Anvil Assembly 42-06-0305 (Fig. 2), identified by an etched symbol on the front face of the anvil, use Hog Ring 44-90-1050 and O-Ring 34-40-1885**

**If you have any questions please call After-Sales Service-Technical Support 1.800.729.3878**

**No. 42-06-0305 3/8" SQUARE ANVIL ASSEMBLY**
(Service Replacement)

| | | | |
|---|---|---|---|
| 36 | **42-06-0305** | 3/8" Square Drive Anvil Assembly with Needle Bearing | (1) |
| 37 | 44-90-1050 | Hog Ring | (1) |
| 65 | 02-02-1300 | 5mm Steel Ball | (1) |
| 67 | 34-40-1885 | Rubber Ring | (1) |

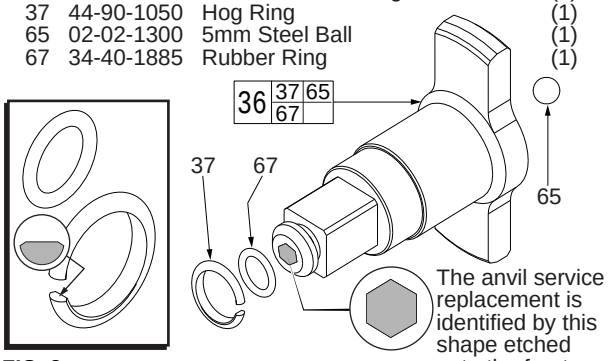
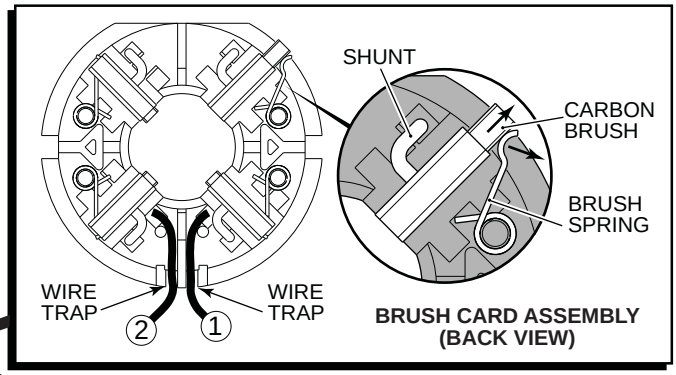



**FIG. 2**

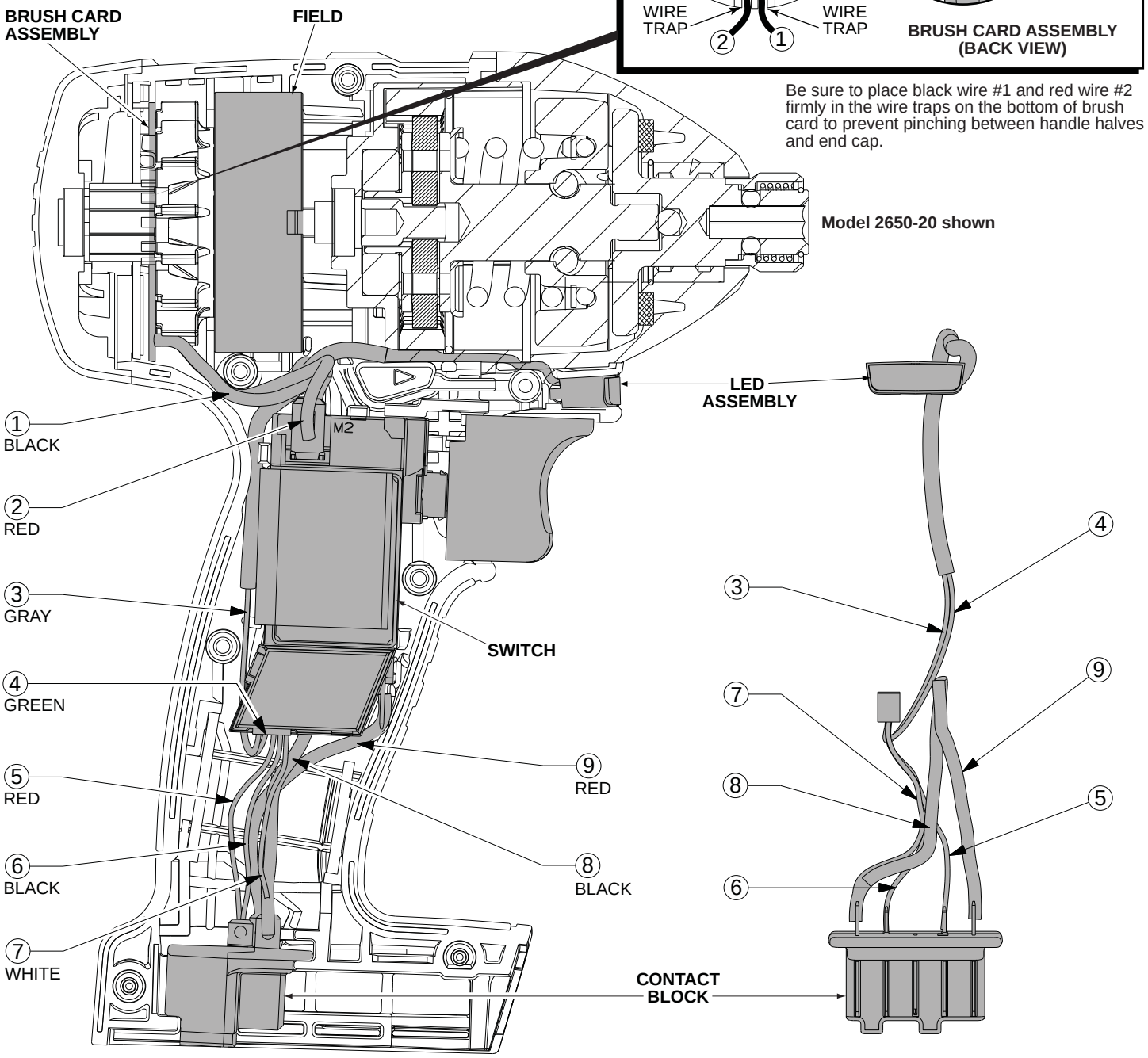
**NOTE:** Before attempting to remove armature or brush card assembly- Pull brush back until the brush spring slides from the back of the brush, onto the side of the brush as shown. (Do this to all four brushes). This will hold brushes out of the way for ease of servicing and will help prevent damage to the carbon brushes and the commutator of the armature.

To reinstall components, orient the Field with the cut-outs facing forward, place the Armature into the Field prior to assembling onto the Brush Card Assembly. Make sure that all brushes are returned to the proper position once Brush Card, Armature and Field are properly seated in the Left Handle Half.



**BRUSH CARD ASSEMBLY (BACK VIEW)**

Be sure to place black wire #1 and red wire #2 firmly in the wire traps on the bottom of brush card to prevent pinching between handle halves and end cap.



**Model 2650-20 shown**

| WIRING SPECIFICATIONS | | | | |
|---|---|---|---|---|
| Wire No. | Wire Color | Origin or Gauge | Length | Terminals, Connectors and 1 or 2 End Wire Preparation |
| 1 | Black | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 2 | Red | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 3 | Gray | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 4 | Green | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 5 | Red | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 6 | Black | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 7 | White | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 8 | Black | ----- | ----- | Component of the Switch/Brush Card Assembly. |
| 9 | Red | ----- | ----- | Component of the Switch/Brush Card Assembly. |

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

**BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.**