



# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-24-6050**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>2" SPLINE ROTARY HAMMER</b>			Mar. 2013
CATALOG NO.	<b>5340-20</b>	SERIAL NUMBER	<b>A49A</b>
		WIRING INSTRUCTION	<b>58-01-0195</b>

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

**SEE PAGES 2 AND 3 FOR ADDITIONAL SERVICE NOTES, TORQUE AND LUBRICATION SPECIFICATIONS**

**IMPORTANT!**  
**SEE PAGE 4- CRANK ASSY. 'A' IS NO LONGER AVAILABLE**

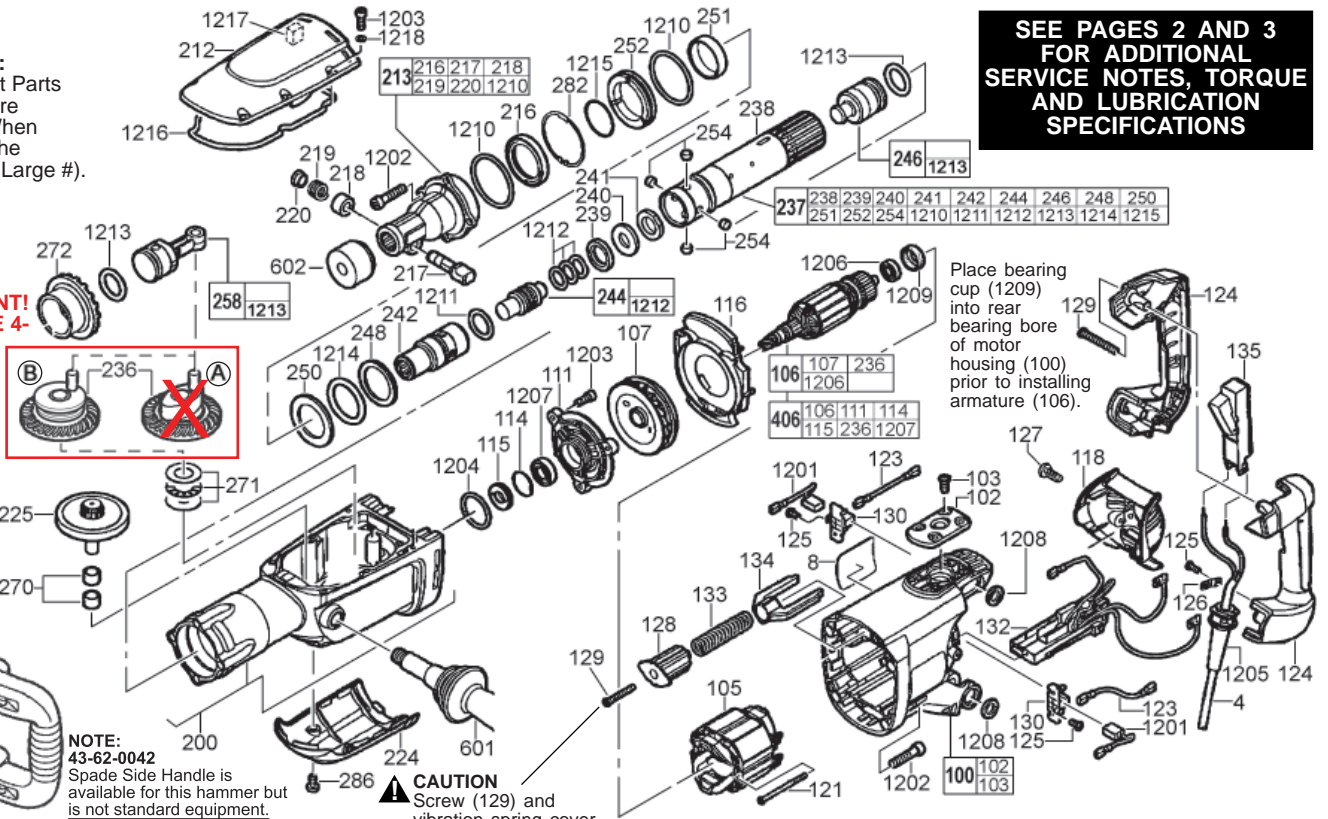


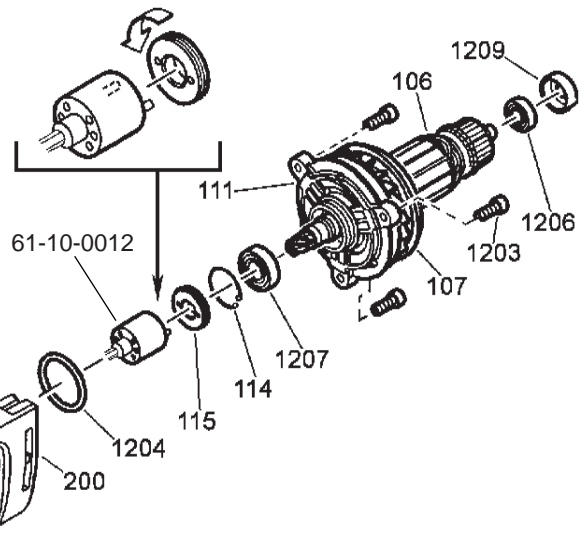
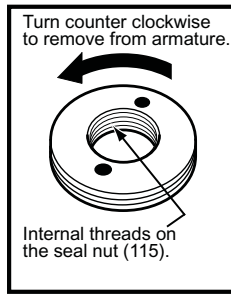
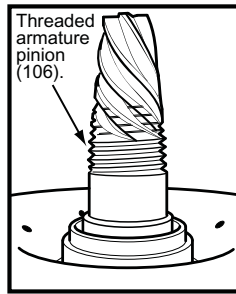
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
4	22-64-0022	CORD SET	1
8	12-20-5340	SERVICE NAMEPLATE KIT	1
100	31-50-0033	MOTOR HOUSING	1
102	42-92-0106	SIDE HANDLE PLATE	1
103	05-78-0070	SCREW - SIDE HANDLE PLATE	4
105	18-11-0050	FIELD	1
106	16-10-0137	ARMATURE WITH CRANK ASSEMBLY	1
107	22-84-0442	FAN	1
111	28-28-0118	BEARING END PLATE	1
114	44-90-0019	RETAINING RING	1
115	44-40-0042	SEAL NUT	1
116	42-14-0105	AIR DEFLECTION RING	1
118	31-15-0051	SERVICING LID	1
121	05-78-0071	SCREW - FIELD	2
123	23-94-0031	WIRE - RED	2
124	31-15-0052	D - HANDLES SET	1
125	05-78-0072	SCREW	4
126	31-17-0110	STRAIN RELIEF CLAMP	1
127	05-78-0073	SCREW - SERVICING LID	2
128	31-15-0053	COVER - VIBRATION SPRING	1
129	05-78-0074	SCREW	5
130	22-20-0027	BRUSH HOLDER	2
132	22-75-0080	DIAL SWITCH	1
133	40-50-0041	SPRING - VIBRATION	1
134	31-10-0130	VIBRATION LEVER	1
135	23-66-0033	SWITCH - ON/OFF	1
200	31-40-0033	GEAR BOX WITH SPINDLE SLEEVE BEARING	1
212	31-15-0061	COVER - UPPER GEAR BOX	1
213	30-60-0030	NOSE PIECE ASSEMBLY	1
216	43-44-0062	SEAL RING	1
217	44-10-0040	LATCH BAR- NOSE PIECE	1
218	43-56-0072	SLEEVE - NOSE PIECE	1
219	40-50-0042	SPRING - NOSE PIECE	1
220	43-56-0073	LATCH - NOSE PIECE	1
224	31-15-0062	COVER - LOWER GEAR BOX	1
225	32-75-0107	GEAR CLUTCH	1
236	-----	CRANK ASSEMBLY	1
237	38-50-0043	SPINDLE ASSEMBLY	1
238	38-50-0044	SPINDLE SLEEVE	1
239	45-88-0052	THRUST COLLAR	1
240	34-40-0061	BACK PRESSURE O-RING	1
241	45-88-0185	WASHER	1

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
242	44-82-0072	STRIKER GUIDE	1
244	45-56-2527	STRIKER	1
246	44-82-0074	RAM	1
248	45-88-0053	ATTACHMENT WASHER (.118 THICK)	1
250	45-88-0054	WASHER (.154 THICK)	1
251	44-96-0132	ROLLER RACE	1
252	44-90-0018	THRUST COLLAR	1
254	44-96-0133	ROLLER	4
258	44-62-0053	PISTON	1
270	02-50-1213	NEEDLE BEARING	2
271	02-80-0117	THRUST BEARING WITH WASHERS	1
272	32-75-0108	SPINDLE BEVEL GEAR	1
282	44-90-0016	RETAINING RING	1
286	05-81-0703	SCREW - LOWER GEAR BOX COVER	2
406	16-10-0138	ARMATURE ASSEMBLY WITH BEARING END PLATE AND CRANK ASSEMBLY	1
601	43-62-0043	AUXILIARY SIDE HANDLE	1
602	42-52-0057	DUST GUARD CAP	1
1201	22-16-0026	CARBON BRUSH SET (PKG. 2)	2
1202	05-81-0701	SCREW M8 x 40	8
1203	05-81-0702	SCREW M5 x 16	9
1204	34-40-0062	O-RING - GEAR BOX	1
1205	44-76-0051	CORD PROTECTOR	1
1206	02-04-0061	BALL BEARING	1
1207	02-04-0062	BALL BEARING	1
1208	34-40-0063	O-RING - MOTOR HOUSING	4
1209	22-72-0200	BEARING CUP	1
1210	34-40-0064	O-RING	2
1211	34-40-0071	O-RING - STRIKER GUIDE	1
1212	34-40-0072	O-RING - STRIKER	3
1213	34-40-0073	O-RING	2
1214	34-40-0074	O-RING - SPINDLE SLEEVE	1
1215	44-90-0017	RETAINING RING	1
1216	43-44-0063	GASKET - GEAR BOX COVER	1
1217	43-84-0443	FELT	1
1218	45-88-0056	WASHER - GEAR BOX COVER	6
	48-55-5337	CARRYING CASE (NOT SHOWN)	1

◆=Component of the 14-46-0041 MAINTENANCE SET (NOT SHOWN)

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
13135 W. LISBON RD., BROOKFIELD, WI 53005  
Drwg.6

Service fixture No. 61-10-0012 is required to remove seal nut (115) from armature shaft (106)/ bearing end plate (111). Secure armature, insert pins of service fixture into holes located in seal nut and turn counter clockwise to remove. When reassembling seal nut to bearing plate, tighten to 141 in.-lbs. (16Nm).



Use forcing disc service fixture No. 61-10-0011 when removing the armature fan (107) from the armature (106).

End of armature shaft

6.29" / 6.22° (159mm)

Face of fan

Place Loctite® 401 here.

Press armature fan onto armature shaft to specifications shown. Apply Loctite® 401 Porous Material Bonding Adhesive around the entire base of fan (360°).

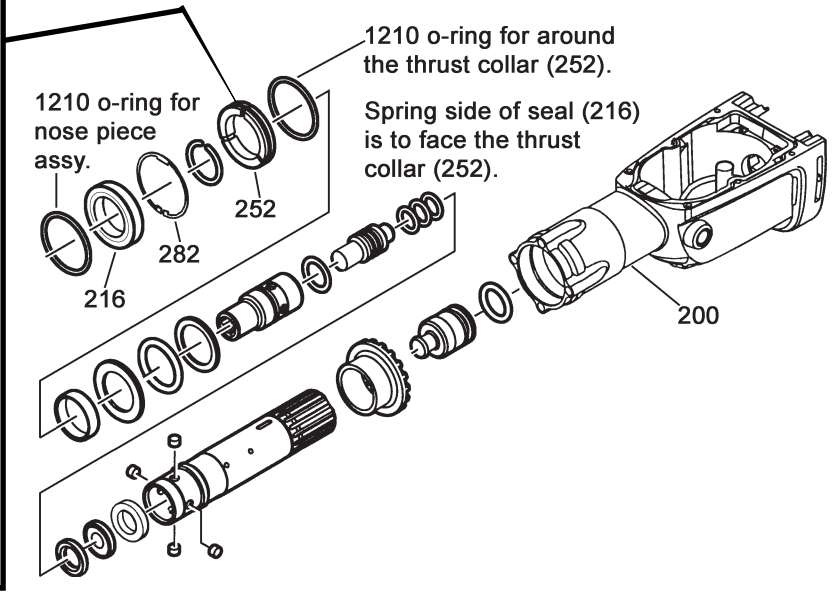
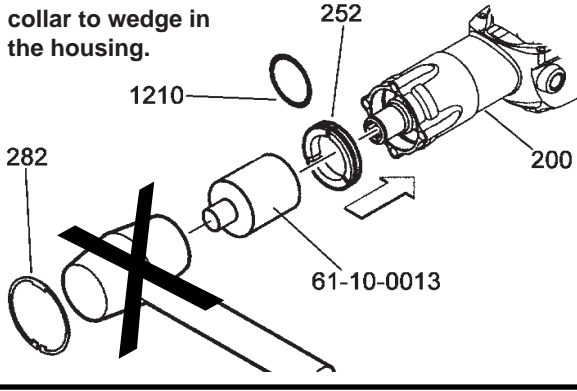
SEQUENCE AND TORQUES OF SCREWS			
Callout	Fastener/Part Description	Torque (Nm)	Torque (Lbs-In)
1203	Bearing End Plate Screws	4	35
1203	Upper Gear Box Cover Screws	4.5	40
286	Lower Gear Box Cover Screws	3	27
1202	Nose Piece Screws	18	159
1202	Motor Housing Screws	13	115
127	Servicing Lid Screws	1.3	12
129	D-Handle Screws	3	27
121	Field Screws	2	18
129	Anti-Vibration Mechanism Scr.	3	27
115	Seal Nut	16	141
125	Strain Relief Clamp Screws	1.3	12
125	Carbon Brush Holders	1.3	12
M	Switch Screws	0.5	4
103	Side Handle Plate Screws	4	35

Apply blue Loctite® ThreadLocker 242 adhesive, or the equivalent, to ALL #1202 and #1203 screws prior to reassembly.

When securing upper gear box cover to gear box, tighten the six [6] upper gear box screws in sequence illustrated.

**CAUTION**  
Screw and vibration spring cover are under spring pressure.

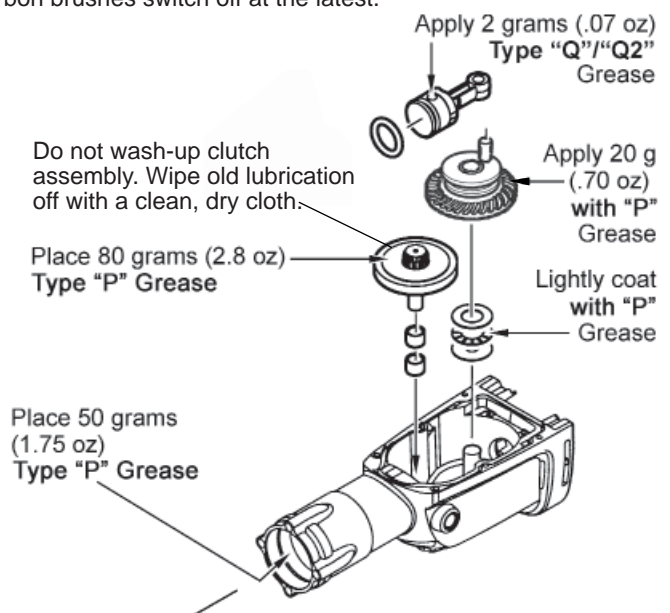
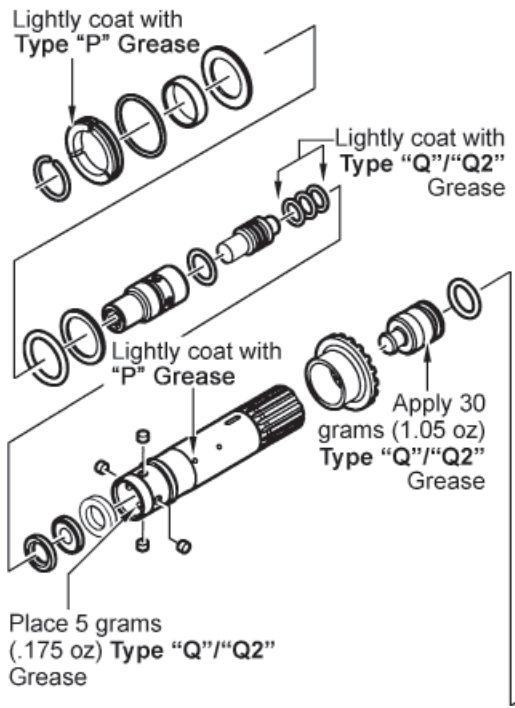
Place o-ring (1210) onto the thrust collar (252). Lightly grease the O.D. of the thrust collar. Insert the thrust collar assembly into gear box (200) until the outside face of the thrust collar assembly is flush with the face of the gear box. Place the open end of the service fixture 61-10-0013 over the spindle assembly and gently push the thrust collar assembly into the gearcase prior to installing the retaining ring (282). **Striking the service fixture with a hammer is not recommended, doing so may cause the thrust collar to wedge in the housing.**



**MAINTENANCE KIT CONTAINING "Q"/"Q2" GREASE, FOLLOW THESE INSTRUCTIONS**

Lubrication of this tool should be performed at regular intervals or when the carbon brushes switch off at the latest.

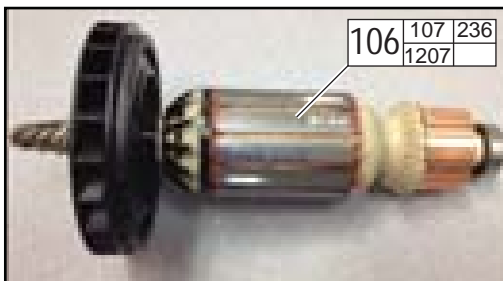
**FOR 5340-20 HAMMERS**



Approximately 150 grams (65.3 oz) of Type "P" Grease and 37 grams (1.32 oz) of Type "Q" or Type "Q2" Grease will be needed in total.

LUBRICATION CHART		
LUBRICATION DESCRIPTION	CATALOG NO.	QTY. REQ.
◆ Type "P" Grease (100 g tube)	49-08-5350	2
◆ Type "Q" Grease (45 g tube)	49-08-4255	1
◆ Type "Q2" Grease (45 g tube)	49-08-5345	1
◆ Hammer Bit Grease (20 g tube)	49-08-5383	1

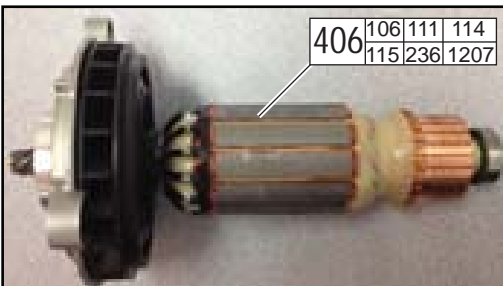
◆=Component of the 14-46-0041 Maintenance Set. **Note:** Maintenance Set includes either "Q" or "Q2" grease, not both!



#106, No. 16-10-0137  
Armature Assembly  
(Armature, fan and rear  
ball bearing) with  
Crank Assembly #236



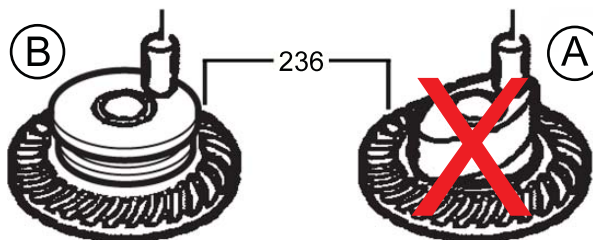
236 (Crank Assembly)



#406, No. 16-10-0138  
Armature Assembly  
(Armature, fan, rear ball  
bearing, bearing end  
plate, retaining ring, seal  
nut and front ball  
bearing) with Crank  
Assembly #236



236 (Crank Assembly)



The 'A' profile of Crank Assembly #236 was manufactured into the hammer models listed below. The 'A' design is no longer available. The 'B' profile of Crank Assembly #236 is the direct replacement.

- 3/4" Hex Demolition Hammer 5337-20, serial break A47A
- SDS Max Demolition Hammer 5339-20, serial break A48A
- 2" Spline Rotary Hammer 5340-20, serial break A49A
- SDS Max Rotary Hammer 5342-20, serial break A50A

The 'B' Crank Assembly is not available as an individual part but is a component of #106, Armature Assembly 16-10-0137 and #406, Armature Assembly 16-10-0138. **When installing any of these two armature assemblies, the new 'B' crank assembly that is supplied must be used.**

**DISCARD 'A' profile Crank Assemblies. DO NOT attempt to utilize an old crank assembly with the 'A' profile with a new service armature assembly! This may cause extensive damage to the tool.**