

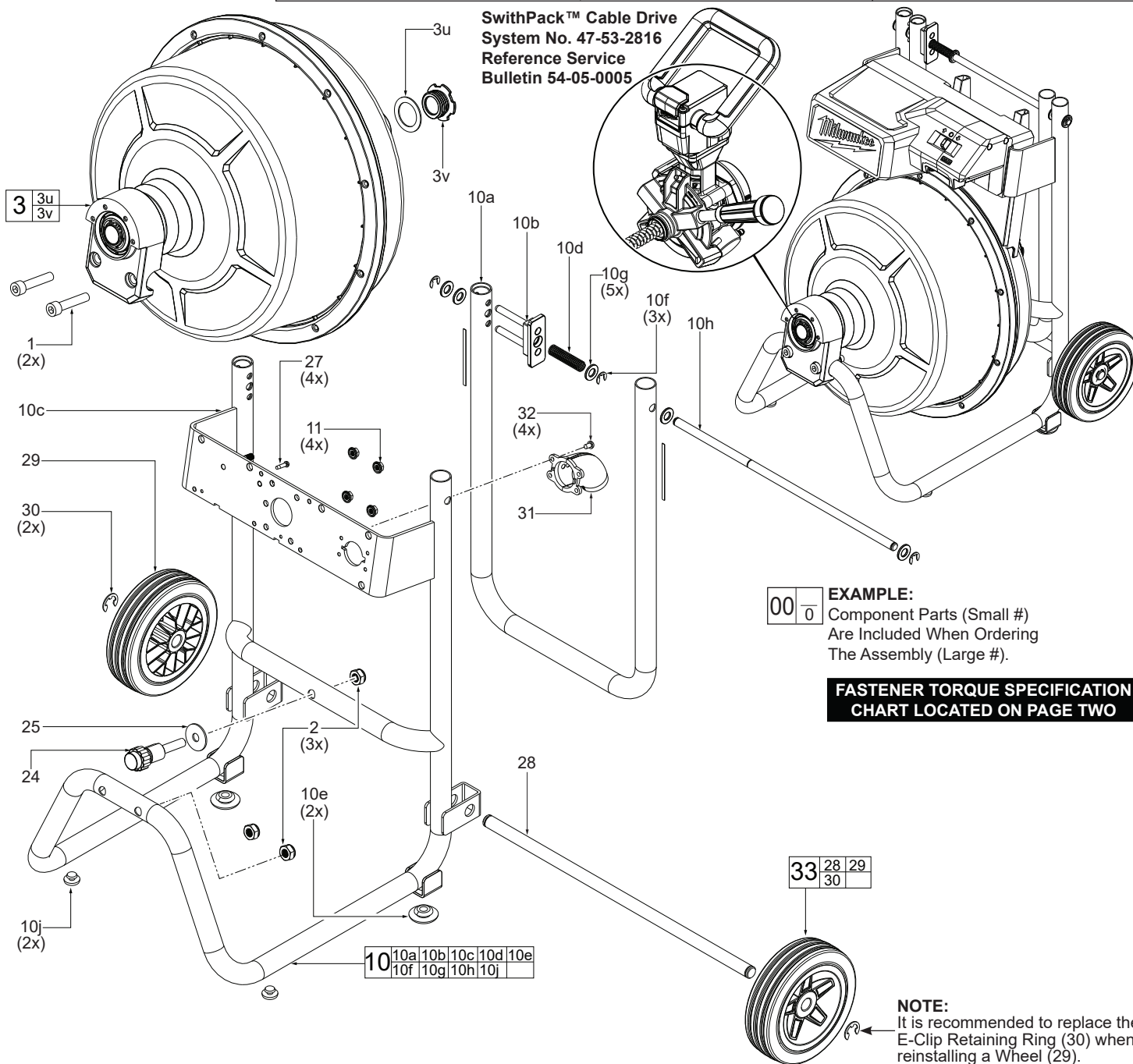


SERVICE PARTS LIST

BULLETIN NO.
54-05-0060

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ DRUM MACHINE for 3/8"-1/2" Cables			Mar. 2024
CATALOG NO.	2817-20	SERIAL NO.	M58A
		WIRING INSTRUCTION SEE PAGE 3	

SwitchPack™ Cable Drive
System No. 47-53-2816
Reference Service
Bulletin 54-05-0005



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

**FASTENER TORQUE SPECIFICATION
CHART LOCATED ON PAGE TWO**

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-81-1097	M10 x 50mm Cap Hd. Hex Recess	(2)
2	05-55-0158	M10 x 10mm Hex Nut	(3)
3	42-36-0142	Drum Assembly	(1)
3u	45-06-0072	Drum Plug Seal	(1)
3v	31-15-0296	Drum Plug	(1)
10	43-40-0048	Frame Assembly	(1)
10a	31-86-0017	Upper Frame Handle	(1)
10b	31-44-0313	Handle Lock Block	(1)
10c	43-40-0056	Lower Frame	(1)
10d	40-50-0284	Lock Spring	(1)
10e	44-34-0067	Large Rubber Foot	(2)
10f	34-60-0127	E-Clip Retaining Ring	(3)
10g	45-88-0159	Flat Washer	(5)
10h	44-94-0053	Pivot Rod	(1)
10j	44-34-0068	Small Rubber Foot	(2)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
11	06-57-0012	M6 Serrated Flange Lock Nut	(4)
24	36-90-0035	Drum Shaft	(1)
25	45-88-0268	Flat Washer	(1)
27	06-82-4003	M4 x 16mm Pan Hd. ST T-20 Screw	(4)
28	23-16-0022	Wheel Shaft	(1)
29	45-94-0033	Wheel	(2)
30	44-90-0206	E-Clip Retaining Ring	(2)
31	22-56-0055	Connector Housing Combination	(1)
32	05-81-1099	M5 x 8mm Pan Hd. T-25 Mach. Screw	(4)
33	45-94-0041	Wheel Service Kit	(1)
50	12-20-0349	Service Nameplate (Not Shown)	(1)

MILWAUKEE TOOL • www.milwaukeetool.com
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 4

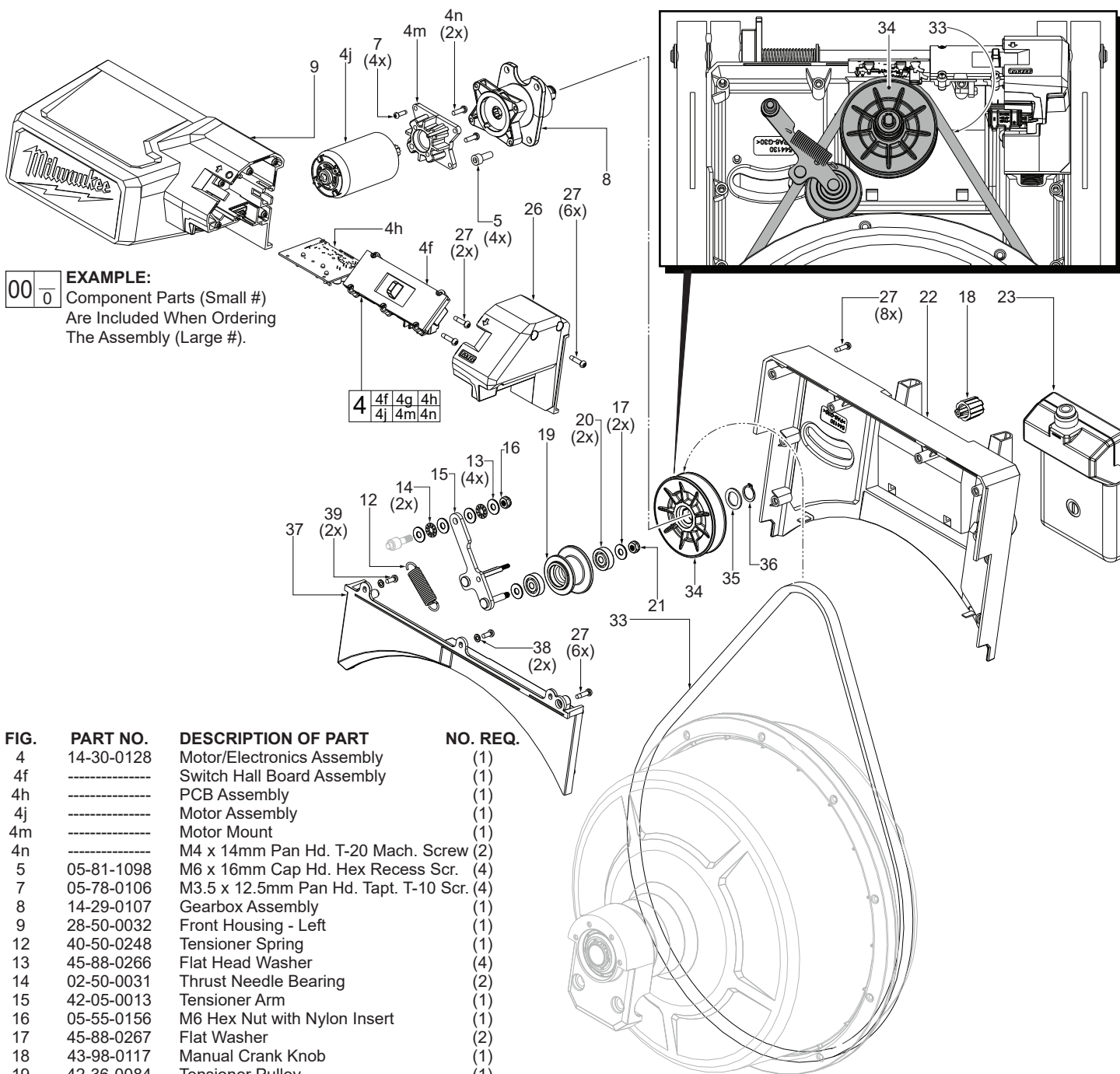


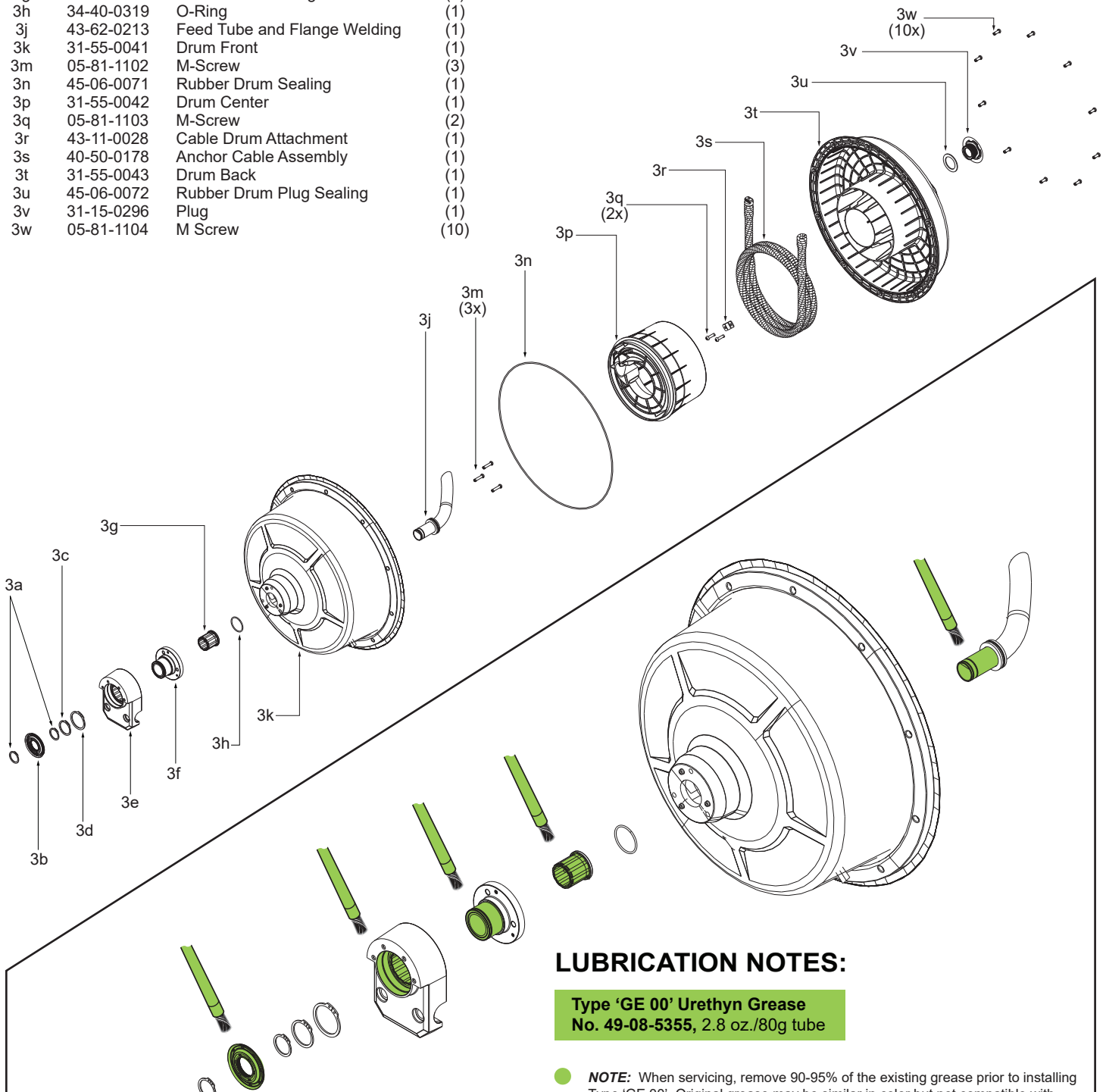
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
4	14-30-0128	Motor/Electronics Assembly	(1)
4f	-----	Switch Hall Board Assembly	(1)
4h	-----	PCB Assembly	(1)
4j	-----	Motor Assembly	(1)
4m	-----	Motor Mount	(1)
4n	-----	M4 x 14mm Pan Hd. T-20 Mach. Screw	(2)
5	05-81-1098	M6 x 16mm Cap Hd. Hex Recess Scr.	(4)
7	05-78-0106	M3.5 x 12.5mm Pan Hd. Tapt. T-10 Scr.	(4)
8	14-29-0107	Gearbox Assembly	(1)
9	28-50-0032	Front Housing - Left	(1)
12	40-50-0248	Tensioner Spring	(1)
13	45-88-0266	Flat Head Washer	(4)
14	02-50-0031	Thrust Needle Bearing	(2)
15	42-05-0013	Tensioner Arm	(1)
16	05-55-0156	M6 Hex Nut with Nylon Insert	(1)
17	45-88-0267	Flat Washer	(2)
18	43-98-0117	Manual Crank Knob	(1)
19	42-36-0084	Tensioner Pulley	(1)
20	02-02-0128	Ball Bearing	(2)
21	05-55-0157	M5 Hex Nut with Nylon Insert	(1)
22	31-17-0025	Cord Wrap	(1)
23	14-02-0000	Foot Pedal Assembly	(1)
26	31-86-0041	Front Housing - Right	(1)
27	05-74-0413	M4 x 16mm Pan Hd. ST T-20 Screw	(22)
33	40-50-0294	Single V Drive Belt - Type A51	(1)
34	44-77-0028	Driver Pulley	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
35	45-88-0269	Flat Washer	(1)
36	34-80-0026	Retaining Ring	(1)
37	42-92-0101	Belt Cover	(1)
38	05-74-0133	Flat Washer	(2)
39	05-81-1101	M4 x 10mm Pan Hd. T-20 Mach. Scr.	(2)

SCREW TORQUE SPECIFICATIONS

FIG.	PART NO.	DESCRIPTION OF FASTENER	WHERE USED	SEAT TORQUE	
				(kgf-cm)	(lb-in)
1	05-81-1097	M10 x 50mm Cap Hd. Hex Recess	Pillow Block to Frame	70-75	60.7-65.1
2	05-55-0158	M10 x 10mm Hex Nut	Pillow Block to Frame & Drum Shaft	70-75	60.7-65.1
4n	-----	M4 x 14mm Pan Hd. T-20 Mach. Screw	Motor Mount to Motor	10-12	8.6-10.4
5	45-04-1090	M6 x 16mm Cap Hd. Hex Recess Scr.	Gearbox Assembly to Frame	55-60	47.7-52.0
7	05-78-0106	M3.5 x 12.5mm Pan Hd. Tapt. T-10 Scr.	Motor Mount to Gearbox	8-9	6.9-7.8
11	06-57-0012	M6 Serrated Flange Lock Nut	Gearbox Assembly to Frame	N/A	N/A
16	05-55-0156	M6 Hex Nut with Nylon Insert	To welded stud on Lower Frame	13-15	11.2-13.0
21	05-55-0157	M5 Hex Nut with Nylon Insert	To welded stud on Tensioner Arm	13-15	11.2-13.0
27	06-82-4003	M4 x 16mm Pan Hd. ST T-20 Screw	All Locations	10-12	8.6-10.4
32	05-78-0029	M5 x 8mm Pan Hd. T-25 Mach. Screw	Connector Housing to Frame	13-15	11.2-13.0
39	05-81-1101	M4 x 10mm Pan Hd. T-20 Mach. Scr.	Belt Cover to Frame	10-12	8.6-10.4

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
3a	34-60-0112	Retaining Ring	(2)
3b	43-40-0202	Rubber Sealing for Feed Tube	(1)
3c	34-60-0113	Retaining Ring for Feed Tube	(1)
3d	34-60-0114	Retaining Ring for Front Mount	(1)
3e	43-56-0026	Front Pillow Block	(1)
3f	31-10-0122	Front Mount for Feed Tube	(1)
3g	42-40-0153	Feed Tube Bushing	(1)
3h	34-40-0319	O-Ring	(1)
3j	43-62-0213	Feed Tube and Flange Welding	(1)
3k	31-55-0041	Drum Front	(1)
3m	05-81-1102	M-Screw	(3)
3n	45-06-0071	Rubber Drum Sealing	(1)
3p	31-55-0042	Drum Center	(1)
3q	05-81-1103	M-Screw	(2)
3r	43-11-0028	Cable Drum Attachment	(1)
3s	40-50-0178	Anchor Cable Assembly	(1)
3t	31-55-0043	Drum Back	(1)
3u	45-06-0072	Rubber Drum Plug Sealing	(1)
3v	31-15-0296	Plug	(1)
3w	05-81-1104	M Screw	(10)



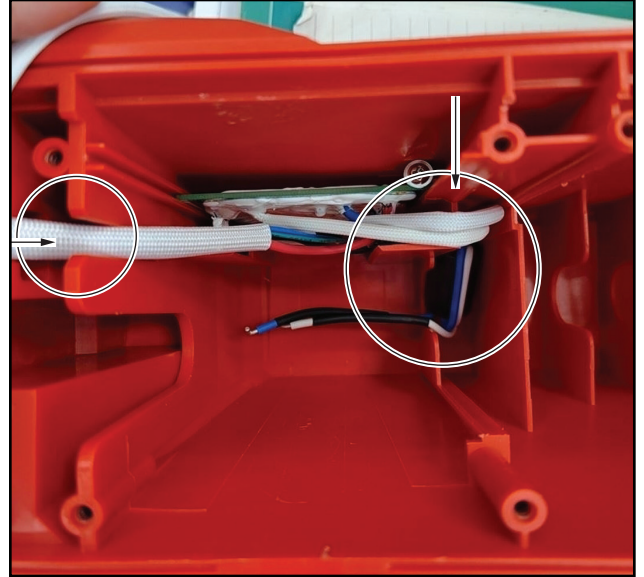
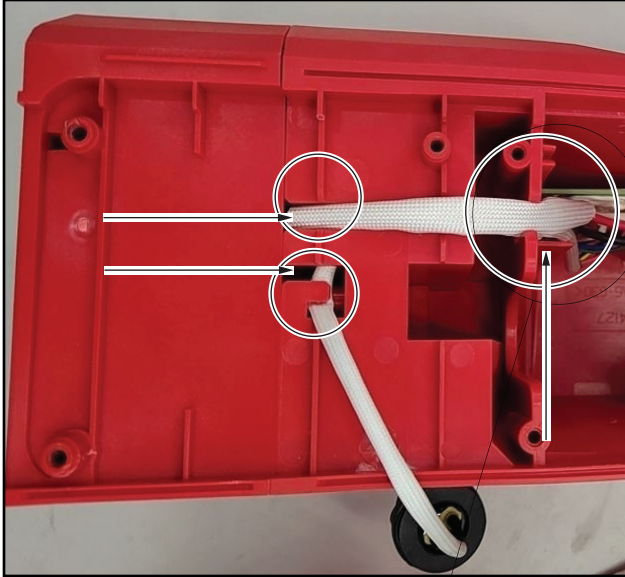
LUBRICATION NOTES:

Type 'GE 00' Urethyn Grease
No. 49-08-5355, 2.8 oz./80g tube

- NOTE:** When servicing, remove 90-95% of the existing grease prior to installing Type 'GE 00'. Original grease may be similar in color but not compatible with 'GE 00'. Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all individual parts highlighted here with grease. Apply a greater amount of grease to all internal and external gear teeth.
- Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all parts highlighted here with 'GE 00' grease. Apply a greater amount of grease to all internal and external gear teeth.
- Lightly coat all parts highlighted here with 'GE 00' grease unless directed otherwise.

SERVICE WIRING

Route wires around screw bosses and into wire traps and channels. Be sure all components are seated squarely and firmly in place. See pictures below for placement.



Make sure wiring is placed correctly through the ferrite bead and wire trap.

