SERVICE PARTS LIST

BULLETIN NO. 54-42-6002

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
ADJUSTABLE TORQUE SCREWDRIVER		54-42-6001	June 2012
CATALOG NO. 6580-20	STARTING SERIAL NO. **098C**	WIRING INSTRUCTION	**See Pages 3 & 4**

00 | 0 **EXAMPLE:** Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

★ = **Part number change** from previous service parts list.

FIG. NOTES:
5 Needle bearing to be pressed flush to .010 under flush from end which has the vendors identification.
6 Needle bearing to have seal toward the front of the tool.

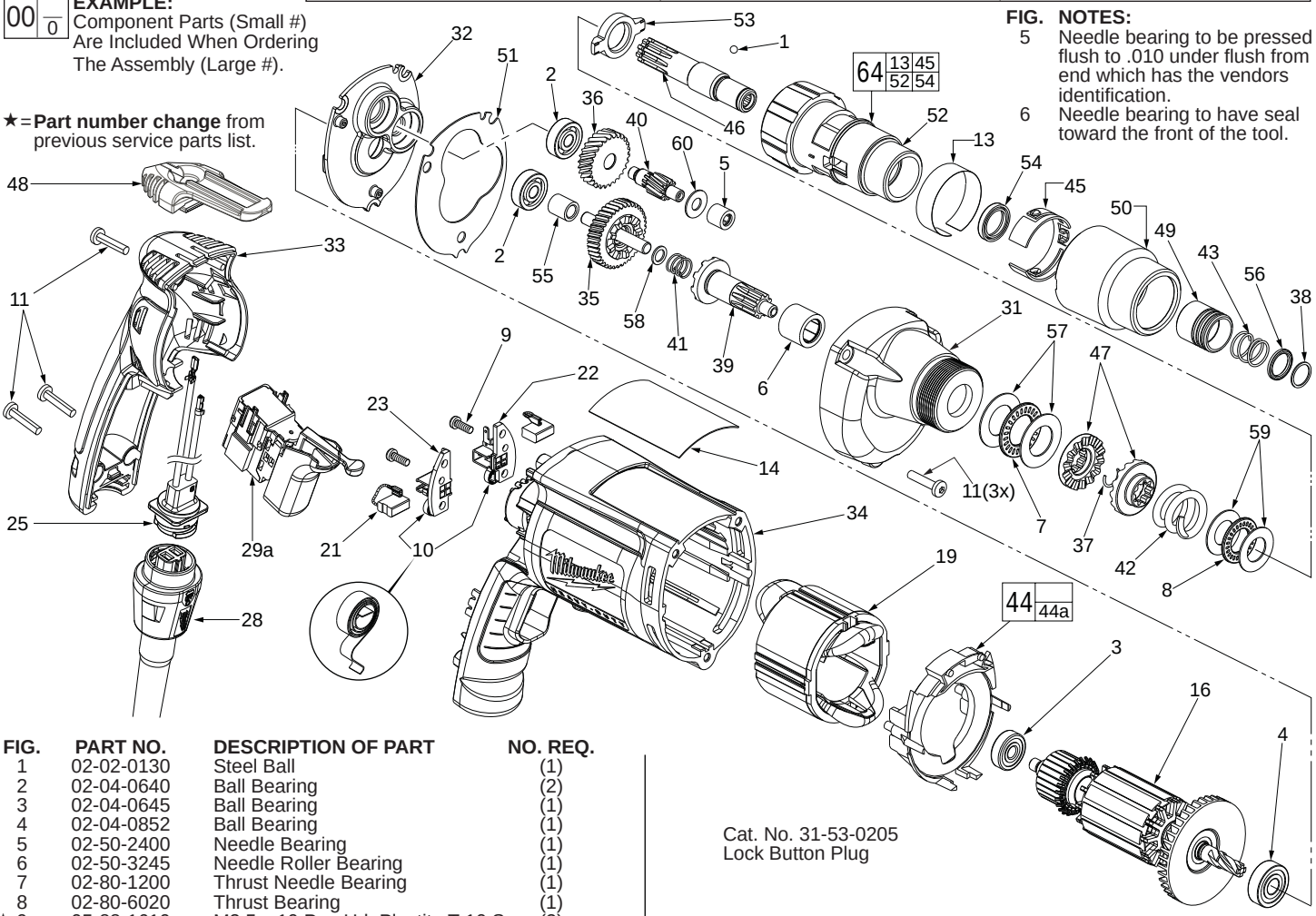


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-02-0130	Steel Ball	(1)
2	02-04-0640	Ball Bearing	(2)
3	02-04-0645	Ball Bearing	(1)
4	02-04-0852	Ball Bearing	(1)
5	02-50-2400	Needle Bearing	(1)
6	02-50-3245	Needle Roller Bearing	(1)
7	02-80-1200	Thrust Needle Bearing	(1)
8	02-80-6020	Thrust Bearing	(1)
★ 9	05-88-1610	M3.5 x 10 Pan Hd. Plastite T-10 Scr	(2)
10	23-52-1610	Brush Spring	(2)
11	06-82-7275	7-18 x 3/4 Slotted Plastite Torx T-20	(6)
13	10-79-3100	Torque Setting Label	(1)
14	12-99-2665	Service Nameplate	(1)
16	16-10-2205	Armature	(1)
★19	18-07-7210	Field	(1)
21	22-18-1310	Brush Assembly	(2)
★22	22-20-0090	Left Brush Holder	(1)
★23	22-20-0095	Right Brush Holder	(1)
25	22-56-1000	Blade Housing Assembly	(1)
28	48-76-5010	Quik-Lok Cord Set	(1)
29a	23-66-2605	Defond Switch (See page 3 wiring)	(1)
29b	23-66-2585	Marquardt Switch (See page 4 wiring)	(1)
31	28-14-2405	Gearcase	(1)
32	28-28-2315	Diaphragm	(1)
33	31-15-2030	Handle Halve	(1)
★34	31-50-3030	Motor Housing	(1)
35	32-10-4055	Clutch Gear Assembly	(1)
36	32-40-0100	Intermediate Gear	(1)
37	34-60-0545	Retaining Ring	(1)
38	34-60-2390	Retaining Ring	(1)
39	36-14-0665	Clutch Shaft Assembly	(1)
40	36-66-0105	Intermediate Shaft	(1)
41	40-50-6600	Separator Spring	(1)
42	40-50-8000	Clutch Spring	(1)
43	40-50-8005	Compression Spring	(1)
44	42-14-0460	Baffle Assembly	(1)
44a	45-30-0030	Slug (Not Shown)	(2)
45	42-16-0140	Adjustment Band	(1)
46	42-66-0676	Chuck Shaft	(1)
47	42-70-5016	Drive Clutch	(2)
48	42-70-5280	Belt Clip	(1)
49	42-76-0390	Locking Collar	(1)
50	42-76-0460	Adjustment Collar	(1)
51	43-44-0985	Gasket	(1)
52	43-76-0550	Clutch Housing	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
53	44-90-4280	Adjustment Ring	(1)
54	45-06-0106	Oil Seal	(1)
55	45-36-1280	Spacer	(1)
56	45-36-1300	Spacer	(1)
57	45-88-0510	Thrust Bearing Washer	(2)
58	45-88-0712	Thrust Washer	(1)
59	45-88-7150	Thrust Washer	(2)
60	45-88-7990	Thrust Washer	(1)
64	14-08-0190	Clutch Housing Assembly	(1)
★	23-94-0490	White Leadwire Assy. (See pages 3 & 4)	(1)
★	23-94-0495	Red Leadwire Assy. (See pages 3 & 4)	(1)

LUBRICATION (Type "L" Grease, No. 49-08-4170)

- Place 1.8 gm. (.06 oz.) of grease on the drive clutch surfaces (47).
- Equally distribute 1.8 gm. (.06 oz.) of grease on the thrust bearings (7 and 8), oil seal (54) and the tabs of the adjustment ring (53).

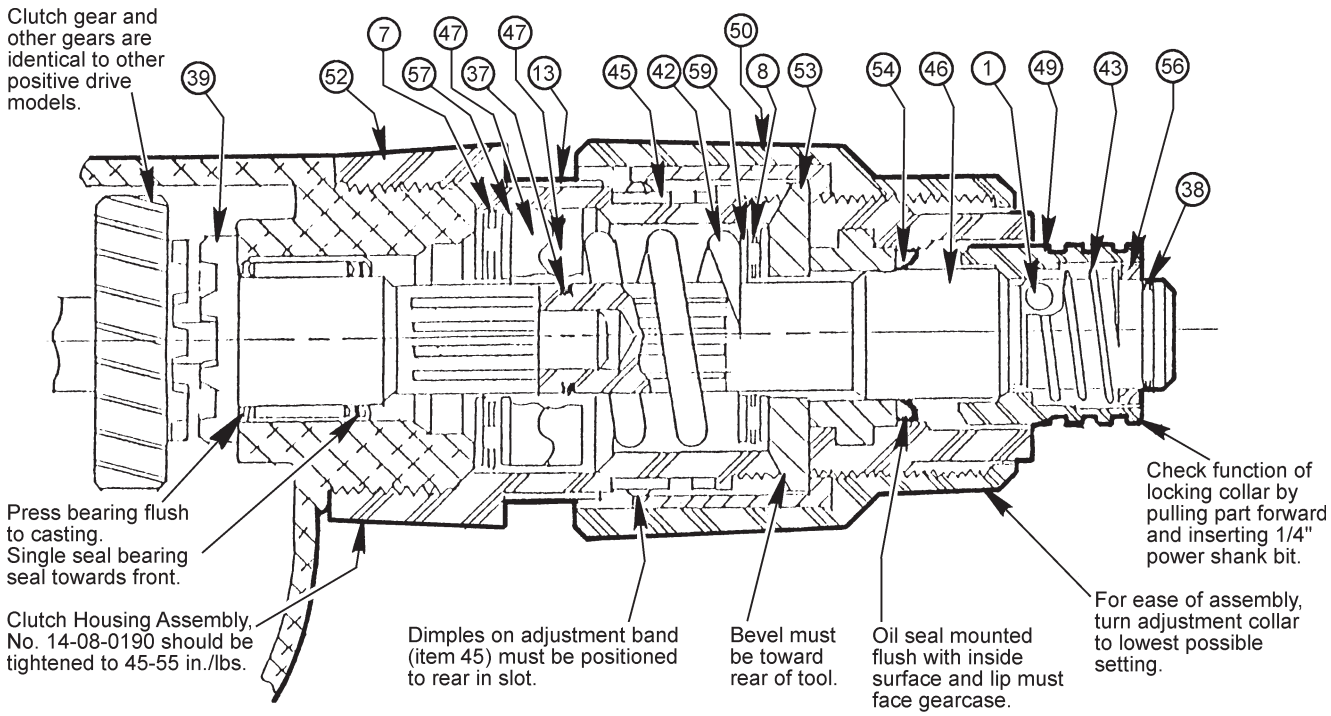
LUBRICATION (Type "Y" Grease, No. 49-08-5270)

- Equally distribute 1.5 gm. (.05 oz.) of grease on the lugs of the clutch gear (35), clutch shaft (39), separator spring (41) and the thrust washer (58).
- In the gearcase (31), place 3.6 gm. (.13 oz.) of grease in the counterbore above the inserted intermediate needle bearing (5).
- Place 13 gm. (.46 oz.) of grease at the armature pinion location in the gearcase (31) and fill to the top of the intermediate gear (36).

Before assembly, lightly coat all press fit areas with lightweight spindle oil.

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

Drwg. 1

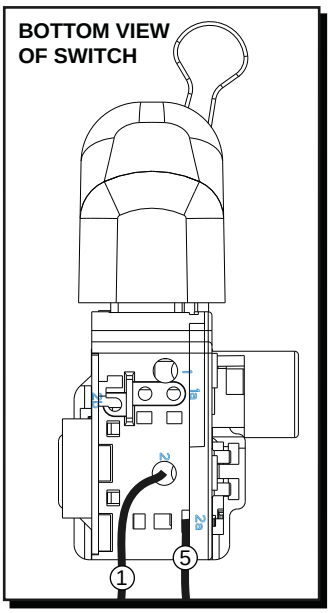


Drive clutches must slide back and forth freely on shaft splines. Defective splines that stick will not function properly.

Lubrication

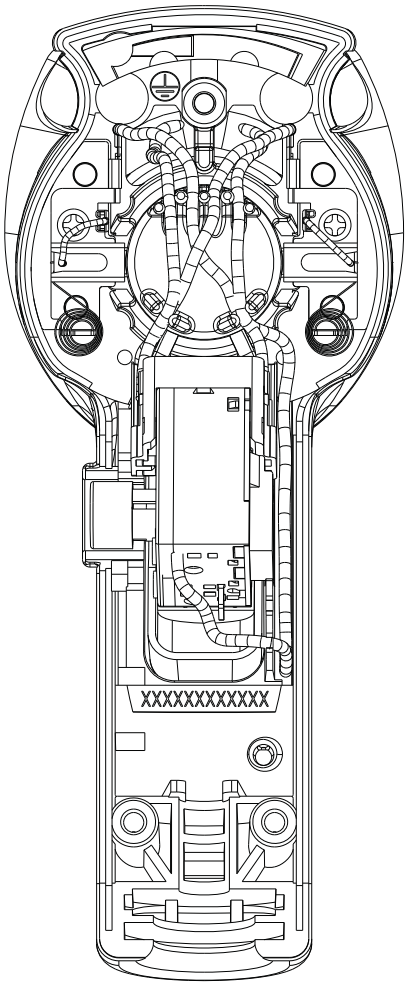
Apply 1/16 oz. Type "L" grease, No. 49-08-4170, on clutch faces of drive clutch (#47). Apply a small amount of "L" grease on thrust bearings (#7 and #8), oil seal lip (#54) and tabs of adjustment ring (#53).

	ORDER OF ASSEMBLY	ITEM NUMBER	PART NUMBER	DESCRIPTION	
Clutch Housing Assembly No. 14-08-0190	1	64	14-08-0190	Clutch Hsg. Assy. (Includes Bushing No. 42-40-0920)	**Clutch Sub-Assembly**
	2	54	45-06-0106	Oil Seal	
	3	45	42-16-0140	Adjustment Band	
	4	13	10-79-3100	Torque Setting Label	
	5	53	44-90-4280	Adjustment Ring	
	6	46	42-66-0676	Chuck Shaft	
	7	1	02-02-0130	Steel Ball	
	8	49	42-76-0390	Locking Collar	
	9	43	40-50-8005	Spring	
	10	56	45-36-1300	Spacer	
	11	38	34-60-2390	Retaining Ring	
	12	59	45-88-7150	Thrust Washers (2 each) (Place on each side of Item #8, Thrust Bearing)	
	13	8	02-80-6020	Thrust Bearing	
	14	42	40-50-8000	Clutch Spring	
	15	47	42-70-5016	Drive Clutch	
	16	37	34-60-0545	Retaining Ring	
		50	42-76-0460	Adjustment Collar (Includes insert No. 43-84-0740)	**Not In Order Of Assembly**
		39	36-14-0665	Clutch Shaft Assembly	
		57	45-88-0510	Thrust Bearing Washers (2 each) (Place on each side of Item #7, Thrust Bearing)	
		7	02-80-1200	Thrust Bearing	
		47	42-70-5016	Drive Clutch	



DEFOND SWITCH

= WIRE TRAPS
or GUIDES

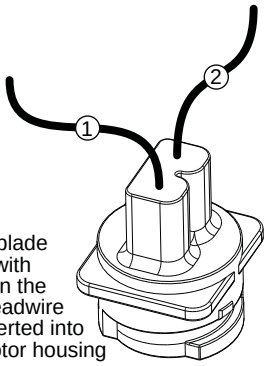


AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

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

WIRING SCHEMATIC with DEFOND SWITCH

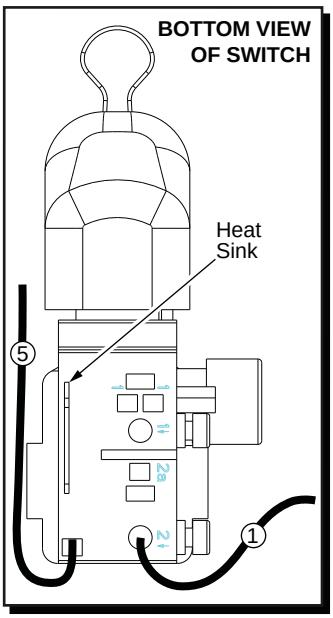
Once the cord and cord protector are properly seated in the motor housing, the cord jacket is to extend a minimium of .25” beyond the top of the cord protector before the handle halve is assembled.

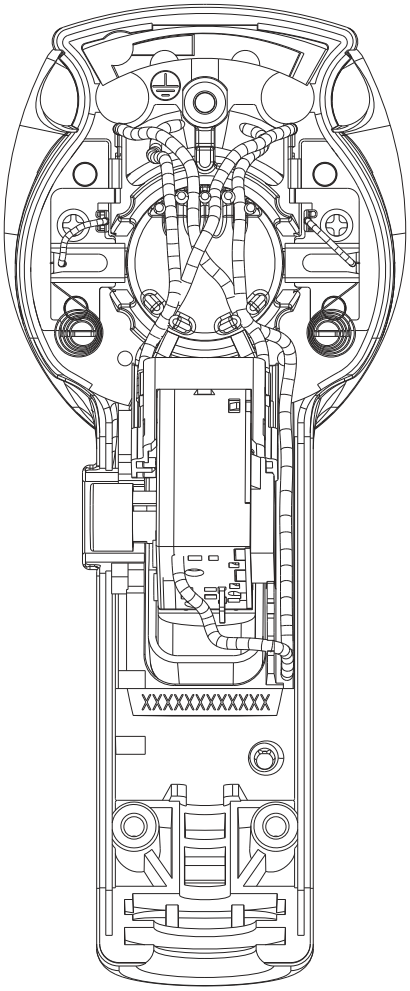


When used, orient blade housing assembly with white leadwire #2 on the bottom and black leadwire #1 on top when inserted into bottom cavity of motor housing

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #2 on switch bottom.
2	White	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #4 on switch top.
4	Brown	Field	-----	Component of field. Connect to #3 on switch top.
5	Black	Field	-----	Component of field. Connect to #2a on switch bottom.
6	White	23-94-0490	-----	Leadwire assembly. Connect to right brush holder and #5 on switch top.
7	Red	23-94-0495	-----	Leadwire assembly. Connect to left brush holder and #6 on switch top.

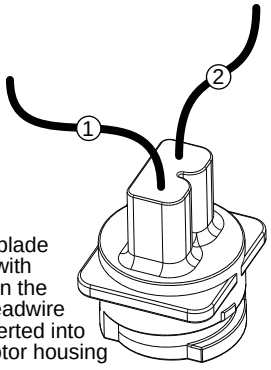




AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

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

WIRING SCHEMATIC with MARQUARDT SWITCH



When used, orient blade housing assembly with white leadwire #2 on the bottom and black leadwire #1 on top when inserted into bottom cavity of motor housing

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #2⇩ on switch bottom.
2	White	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #6 on switch top.
4	Brown	Field	-----	Component of field. Connect to #5 on switch top.
5	Black	Field	-----	Component of field. Connect to #2 on switch bottom.
6	White	23-94-0490	-----	Leadwire assembly. Connect to right brush holder and #8 on switch top.
7	Red	23-94-0495	-----	Leadwire assembly. Connect to left brush holder and #7 on switch top.