



SERVICE PARTS LIST

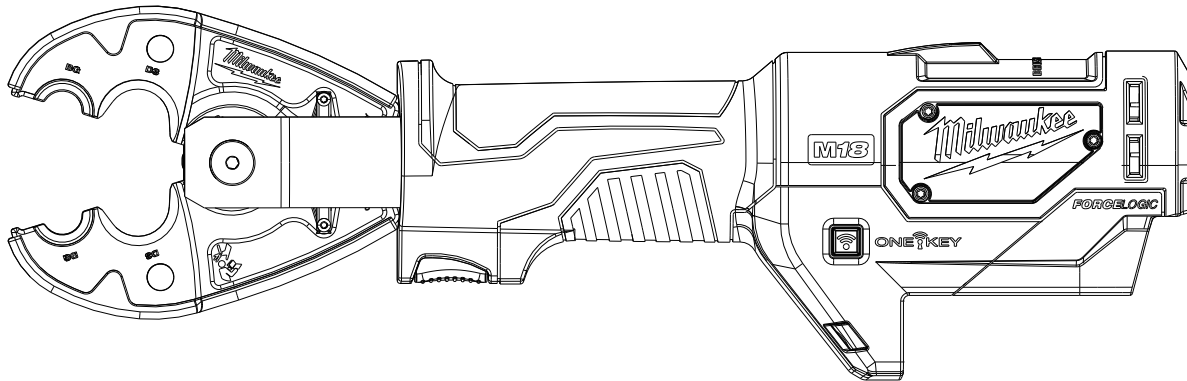
BULLETIN NO.
54-00-2678

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS			REVISED BULLETIN	DATE
M18™ <i>FORCELOGIC</i> ™ 6T Utility Crimper				Jan. 2025
CATALOG NUMBER	2678-20	SERIAL NUMBER	WIRING INSTRUCTION	
		G68(A thru E)		

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Only maintenance, service, repairs, and replacements of parts as defined in the Operator's Manual can be performed by the user.

All other repairs are to **ONLY** be performed by personnel authorized by MILWAUKEE TOOL. Do not attempt to install other parts; this **COULD** void your tool warranty.

For service, parts, or inquiries, contact us:

- Customer Service at 1.800.SAWDUST (1.800.729.3878)
- E-Service tool repair at: www.milwaukeetool.com/e-service
- Find a local authorized MILWAUKEE service location at Milwaukeetool.com
- Find a MILWAUKEE *factory* Service Center Location or MILWAUKEE *factory* Central Repair Center at Milwaukeetool.com. Send the following, posted paid and insured:
 - Your name, address, and phone number
 - Description of the issues
 - Copy of the proof of purchase
 - Tool, charger, and batteries involved with the issues

MILWAUKEE *factory* Central Repair Centers:

MILWAUKEE TOOL
Central Repair
1401 Sycamore Avenue
Greenwood, MS 38930

MILWAUKEE TOOL
Central Repair
2198 Southtech Drive
Greenwood, IN 46143

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
2d	-----	Half Knurled Pin	(1)
2e	-----	Clevis	(1)
2f	44-60-0044	Lock Pin	(1)
2g	40-50-0019	Lock Pin Spring	(1)
2h	31-12-0018	Lock Pin Cap	(1)
2j	06-82-0050	Clevis Pin Cap Screw T-25	(1)
2r	06-87-0010	Knurled Thumb Screw	(1)
80	49-16-BGD3	D3-BG Jaw	(1)
81	49-16-00D3	D3-O Jaw	(1)
82	49-16-00D3	D3 Jaw	(1)
83	49-16-KEAR	Kearney Jaw	(1)
84	43-90-0250	Jaw Spring and Cover Kit (Set of 1)	(2)

NOTE:

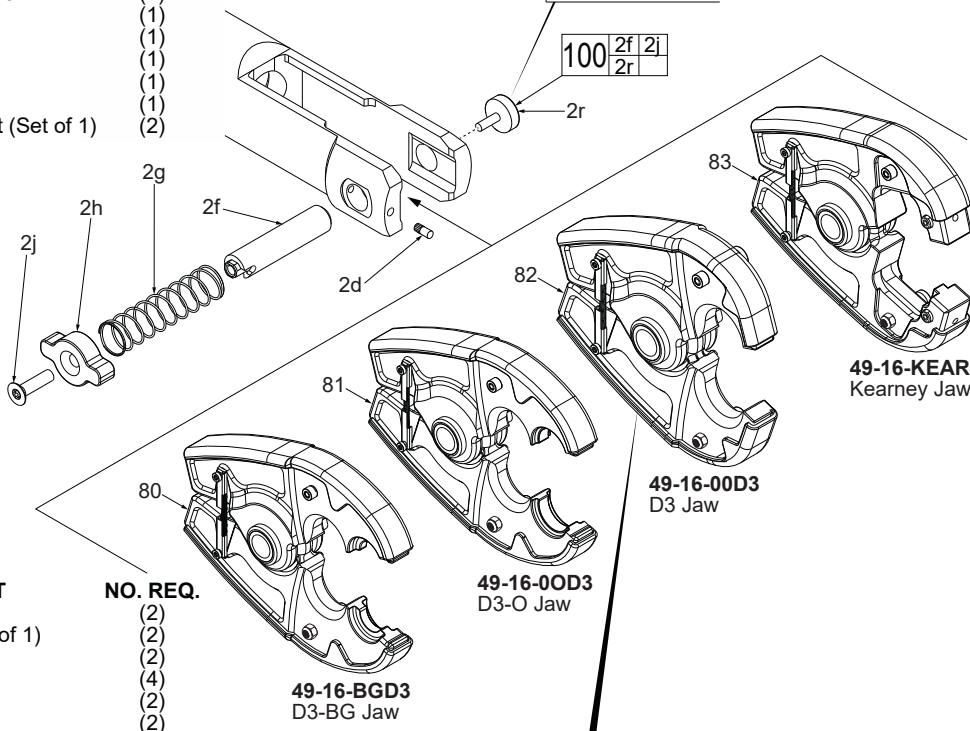
Early design of this tool did not have the Knurled Thumb Screw (2r). The Lock Pin (2f) did not have threads on that corresponding end. **Order the Clevis Pin Upgrade Kit (100) 44-60-0043.**

Accessories and External Service Parts for 2678-20 6T Utility Crimper

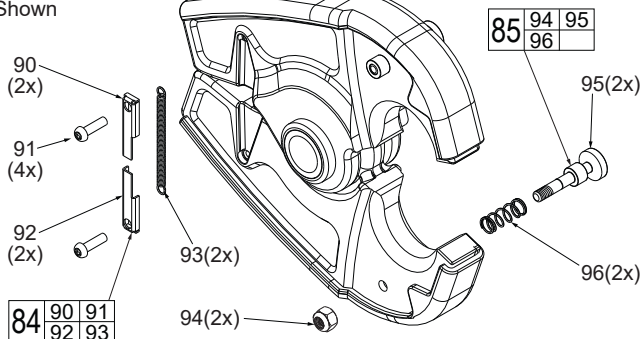
TORQUE SPECIFICATIONS

FIG.	PART NO.	SEAT TORQUE	
		(kgf-cm)	(lb-in)
2j	06-82-0050	80±3	69±2
2r	06-87-0010	4±1	3.5

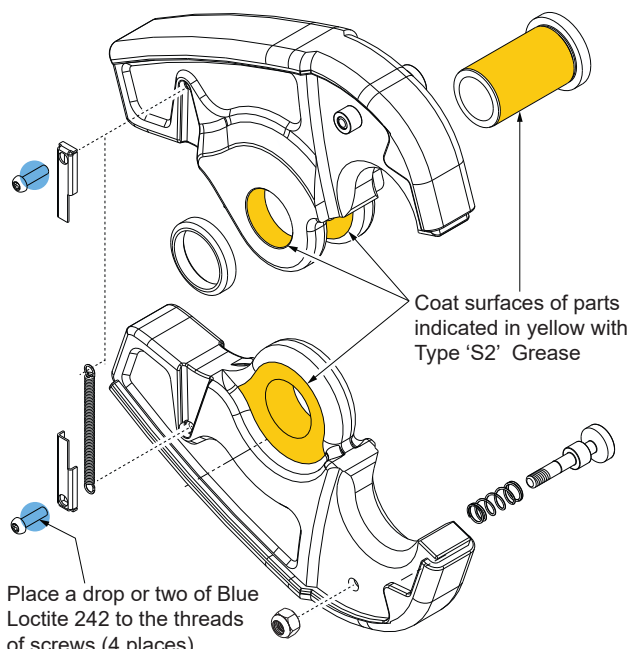
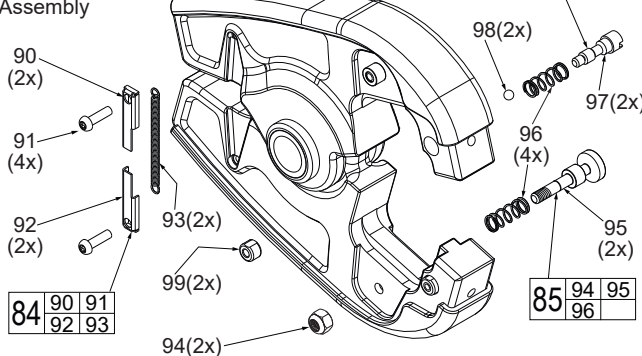
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
85	44-60-0071	W Die Pin Kit (Set of 1)	(2)
86	44-60-0016	Kearney Die Pin Kit (Set of 1)	(2)
90	-----	Left Spring Cover	(2)
91	-----	Spring Mount Screw	(4)
92	-----	Right Spring Cover	(2)
93	-----	Outer Spring	(2)
94	-----	Lock Nut	(2)
95	-----	Die Pin Post	(2)
96	-----	Die Pin Spring	(2)
97	-----	Kearney Die Pin	(2)
98	-----	Kearney Detent Ball	(2)
99	-----	Kearney Die Pin Cap	(2)
100	44-60-0043	Clevis Pin Upgrade Kit	(1)
31r	06-82-7225	Coin Cell Door Screw (Not Shown)	(2)
31x	31-50-0002	Coin Cell Door (Not Shown)	(1)
32	12-20-0044	Service Nameplate (Not Shown)	(1)
40	48-22-8278	Utility Bag (Not Shown)	(1)
41	42-70-0027	Carabiner (Not Shown)	(1)
49	-----	3V Coin Cell Battery (CR 2032)(Not Shown)	(1)



49-16-00D3 D3-O Jaw Assembly Shown



49-16-KEAR Kearney Jaw Assembly



49-16-00D3 D3 Jaw Shown

LUBRICATION:

- = Type S2 Grease (7 oz. tube), 49-08-5265
- = 242 Blue Loctite, 44-22-0090

EHS Guy Wire
Jaw Assemblies
49-16-2772
49-16-2773
49-16-2777 (Shown)

Additional Cutting Jaws not shown:

49-16-2772 McM CU/AL Cutting Jaw Assembly
49-16-2773 477 ACSR Cutting Jaw Assembly
49-16-2778 Fine Strand Wire Cutting Jaw Assembly

49-16-2777
EHS Guy Wire
Jaw Assembly
(Shown)

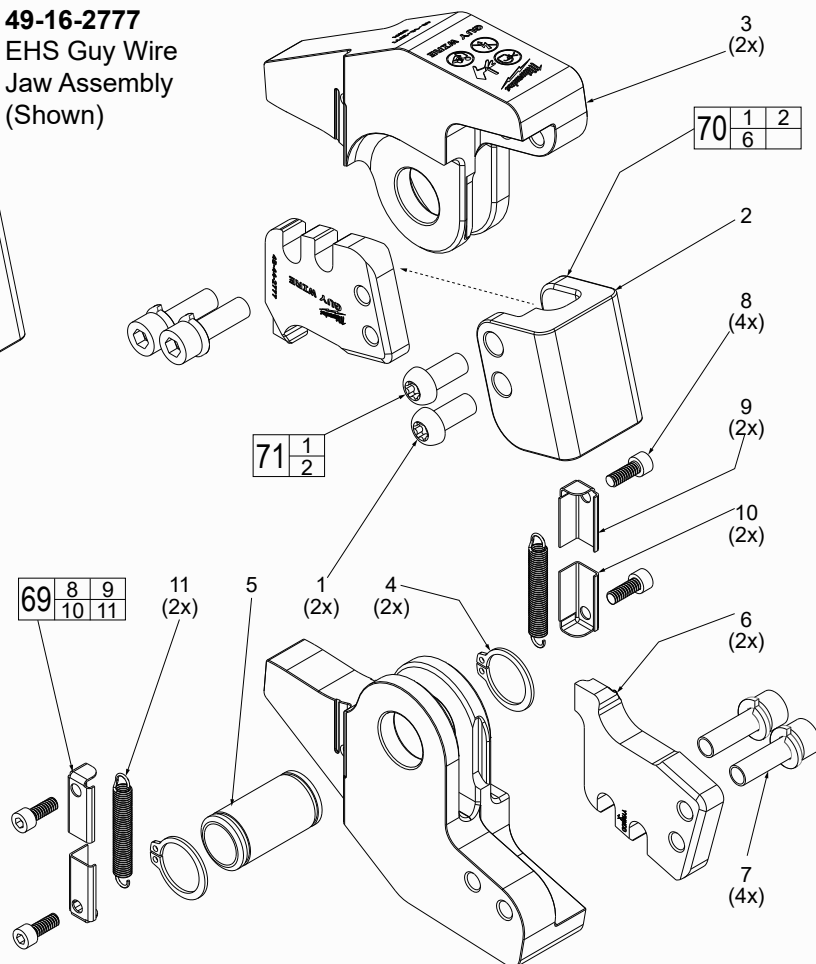
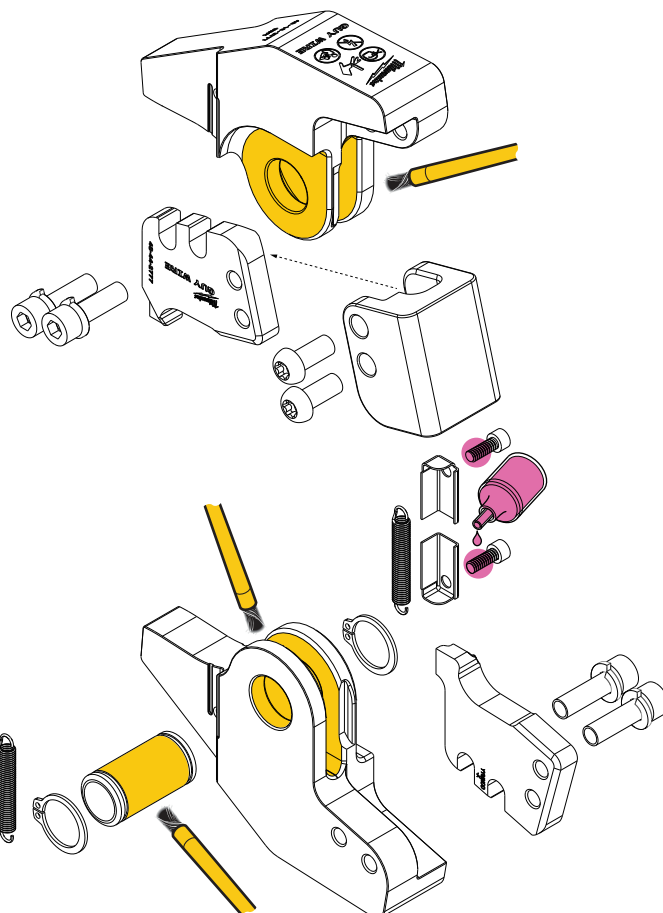


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-81-0132	M6 x 14mm Pan Hd. T-30 Mach. Screw	(2)
2	-----	Blade Retainer	(1)
3	-----	Guy Wire Jaw	(2)
4	44-86-0042	Retaining Ring	(2)
5	-----	Hollow Pin	(1)
6	-----	Guy Wire Blade	(2)
7	05-74-0001	M6 x 20mm Blade Mount Screw	(4)
8	-----	Spring Mounting Screw	(4)
9	-----	Left Spring Cover	(1)
10	-----	Right Spring Cover	(2)
11	-----	Outer Spring	(2)
69	14-46-0018	Jaw Spring and Cover Service Kit	(1)
70	48-44-2777	EHS Replacement Blade Kit	(1)
71	44-86-2777	Blade Retainer Kit	(1)



TORQUE SPECIFICATIONS

FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(kgf-cm)	(lb-in)
1	05-81-0132	Screw, Blade Retainer	90±3	78±3
7	05-74-0001	Screw, Guy Wire Blade	110±3	95±3
8	-----	Screw, Left and Right Spring Covers	3-4	2.6-3.4

LUBRICATION:

● = Type S2 Grease (7 oz. tube), 49-08-5265

● = 277 Red Loctite®, 44-22-0050