



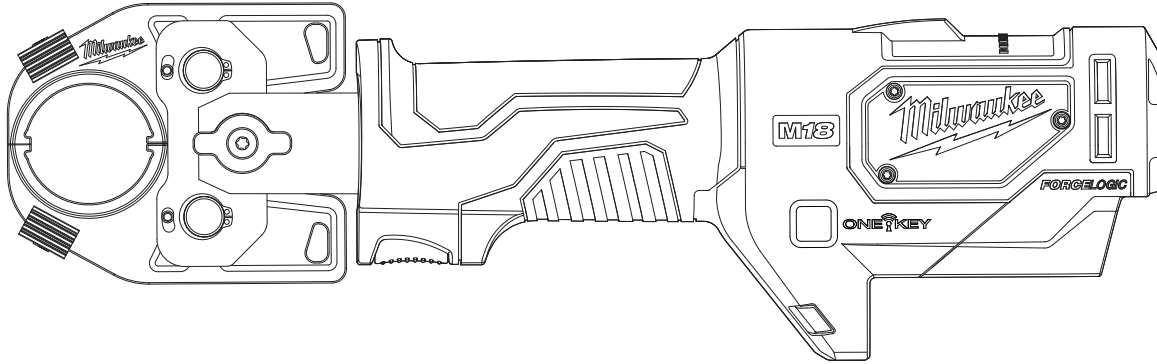
SERVICE PARTS LIST

BULLETIN NO.
54-00-2679

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ FORCELOGIC™ 6T Commercial Crimper			Jan. 2020
CATALOG NUMBER	2679-20	SERIAL NUMBER	G69(A thru D)
WIRING INSTRUCTION			

CUTTER HEAD SERVICE PARTS	PAGE 2-5
ACCESSORIES	PAGE 2

LUBRICATION INSTRUCTIONS	PAGE 2-5
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Due to the combination of hydraulics and electronics in this tool, service can only be performed at Milwaukee Authorized Hydraulic Repair Centers:

MILWAUKEE TOOL Central Repair
1401 Sycamore Avenue • Greenwood, MS 38930-7277
Please send your tool directly to this location for service.

Or

Via e-Service at: www.milwaukeetool.com/e-service
questions, please call 1.800.SAWDUST (1.800.729.3878)

Or

Visit www.milwaukeetool.com to find your closest Milwaukee authorized Hydraulic repair center

Or

Return it to a MILWAUKEE *factory* Service Center location, freight prepaid and insured. A copy of the proof of purchase should be included with the return product.

If you have questions please contact Milwaukee Product Service at:

Product Technical Support via phone at: 262.783.8642

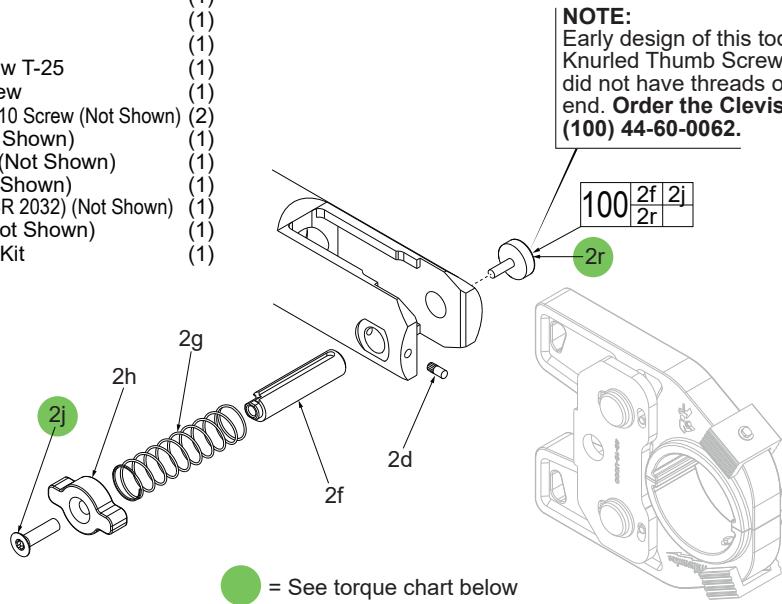
Or

Via email at: METProductSupport@milwaukeetool.com

Disassembly is not recommended and could void the warranty.

Accessories and External Service Parts for 2679-20 6T Commercial Crimper

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	49-16-U000	U-Jaw Assembly	(1)
2d	-----	Half Knurled Pin	(1)
2e	-----	Clevis	(1)
2f	44-60-0036	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)
31r	06-82-7225	M3 x 12 Pan Hd. ST T-10 Screw (Not Shown)	(2)
31x	31-50-0002	Coin Cell Door (Not Shown)	(1)
32	12-20-0044	Service Nameplate (Not Shown)	(1)
40	42-55-0160	Carrying Case (Not Shown)	(1)
49	-----	3V Coin Cell Battery (CR 2032) (Not Shown)	(1)
94	10-20-0919	Crimp Tool Label (Not Shown)	(1)
100	44-60-0062	Clevis Pin Upgrade Kit	(1)



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) 44-60-0062.**

NOTE:
See page 3 for the servicing of the U Jaw Assembly 49-16-U000.

See page 4 for the servicing of the U Jaw Assembly 49-16-U111.

See page 5 for the servicing of Cu/Al Jaw Assembly 49-16-2780.

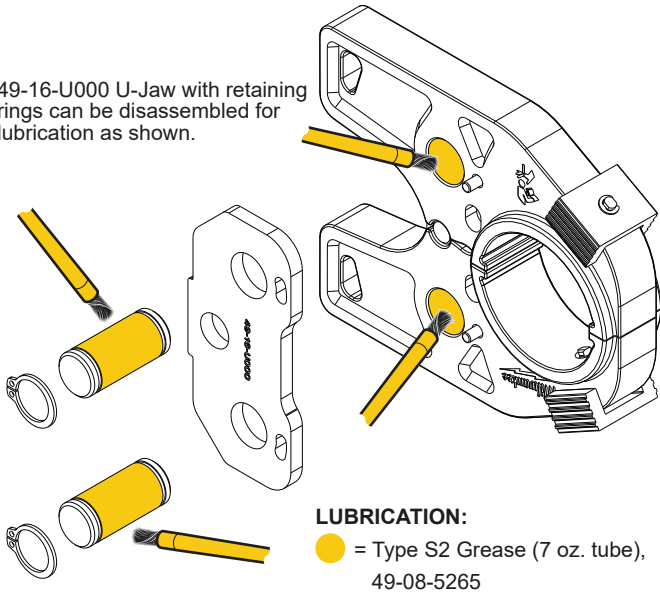
TORQUE SPECIFICATIONS

FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(KG/CM)	(IN/LBS)
2j	06-82-0050	Screw, Lock Pin Cap	80±3	69±2
2r	06-87-0010	Knurled Thumb Screw	4±1	3.5

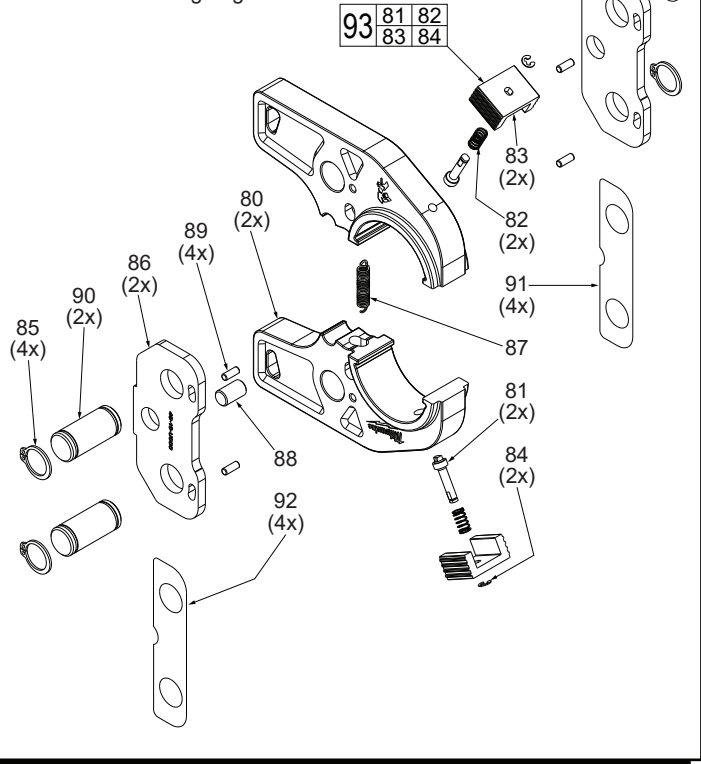
SERVICE PARTS EXPLODED VIEW

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	49-16-U000	U-Jaw Assembly	(1)
80	-----	U-Jaw	(2)
81	-----	U-Jaw Die Pin	(2)
82	-----	U-Jaw Die Spring	(2)
83	-----	U-Jaw Release Tab	(2)
84	-----	C-Clip	(2)
85	44-86-0026	Retaining Ring	(4)
86	-----	U-Jaw Side Plate	(2)
87	-----	Extension Spring	(1)
88	-----	Translation Pin	(1)
89	-----	Stop Pin	(4)
90	-----	Pivot Pin	(2)
91	-----	Jaw Shim - 0.15	(4)
92	-----	Jaw Shim - 0.25	(4)
93	44-60-0024	U-Jaw Die Pin Kit	(1)

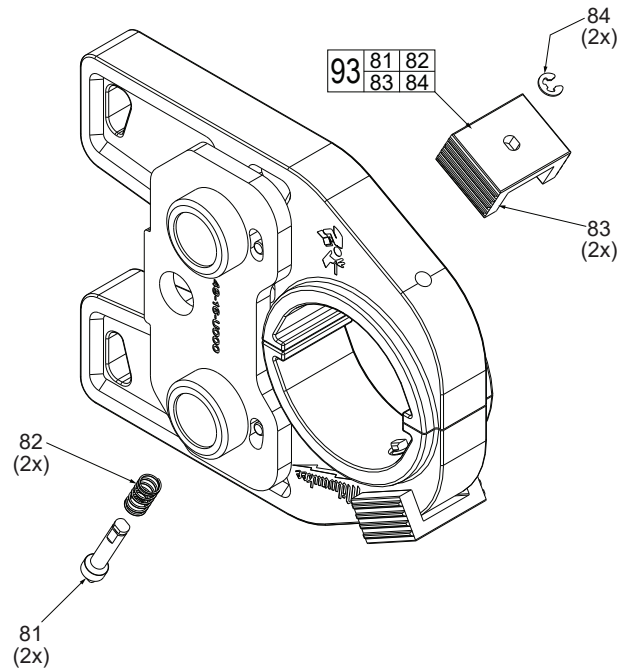
49-16-U000 U-Jaw with retaining rings can be disassembled for lubrication as shown.



49-16-U000
U-Jaw with retaining rings



49-16-U000
U-Jaw with press fit assembly



SERVICE PARTS EXPLODED VIEW

49-16-U111
U Jaw

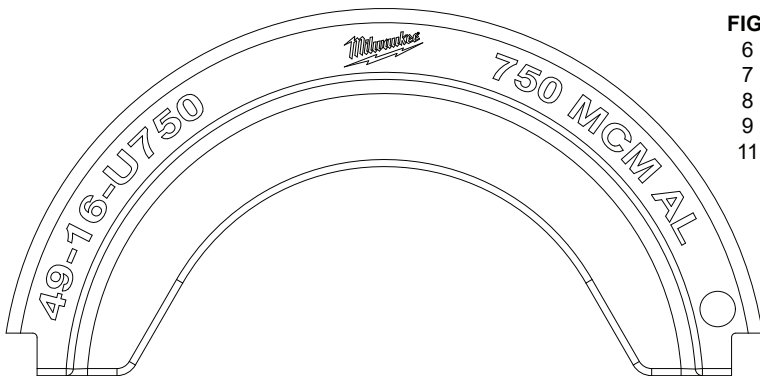
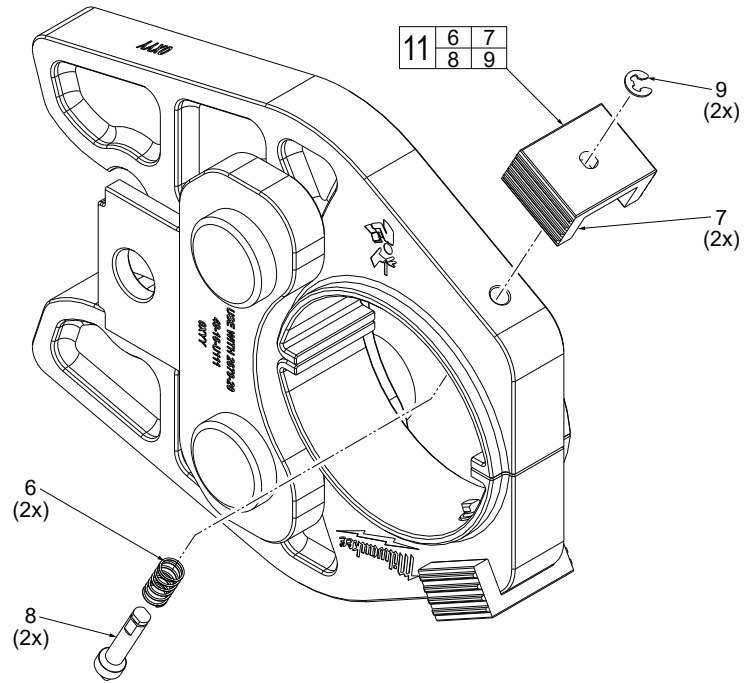
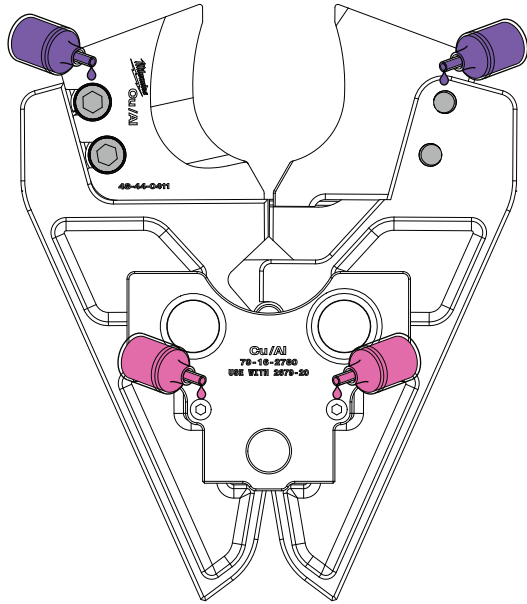


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
6	-----	U Die Spring	(2)
7	-----	Release Tab	(2)
8	-----	Die Pin	(2)
9	-----	C Clip Retaining Ring	(2)
11	44-60-0024	U-Jaw Die Pin Kit	(2)

CRIMPING DIES			
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	49-16-U750C	750 MCM Cu Crimping Die	(1)
2	49-16-U750	750 MCM Al Crimping Die	(1)
3	49-16-U600	600 MCM Al Crimping Die	(1)
4	49-16-U500	500 MCM Al Crimping Die	(1)
5	49-16-U400	400 MCM Al Crimping Die	(1)

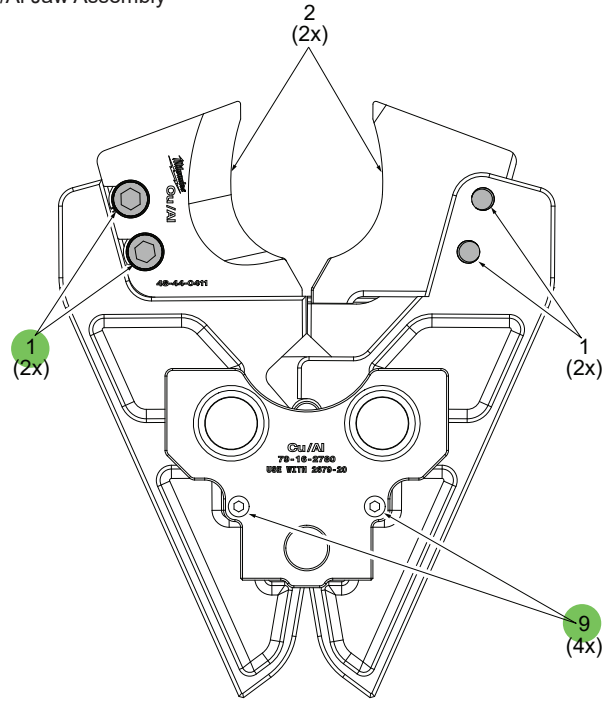
SERVICE PARTS EXPLODED VIEW



LUBRICATION:

- = 277 Red Loctite®, 44-22-0050
- = 243 Blue Loctite®, 44-22-0095

49-16-2780 Cu/Al Jaw Assembly



● = See torque chart below

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-74-0018	M6 x 14mm Pan Hd. T-30 Mach. Screw	(4)
2	48-44-0411	Cu/Al Replacement Blade (Set of 2)	(1)
9	05-74-0005	M3 x 4mm Cap Hd. Hex Recess Screw	(4)

TORQUE SPECIFICATIONS				
FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(KG/CM)	(IN/LBS)
1	05-74-0018	Screw, Cu/Al Blades	100±3	87±3
9	05-74-0005	Screw, Plate	13±1	11±1