



SERVICE PARTS LIST

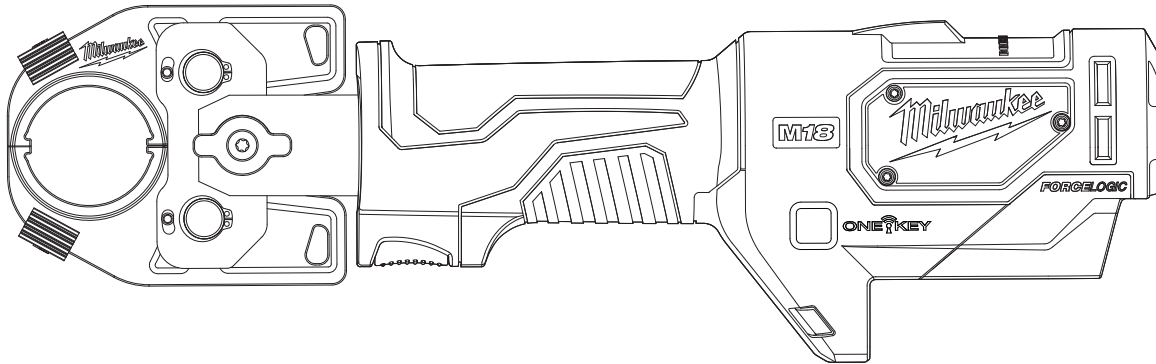
BULLETIN NO.
54-00-2679

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS			REVISED BULLETIN	DATE
M18™ FORCELOGIC™ 6T Commercial Crimper				Jan. 2025
CATALOG NUMBER	2679-20	SERIAL NUMBER	WIRING INSTRUCTION	
		G69(A thru E)		

CUTTER HEAD SERVICE PARTS PAGE 2-5

LUBRICATION INSTRUCTIONS PAGE 2-5

ACCESSORIES PAGE 2



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

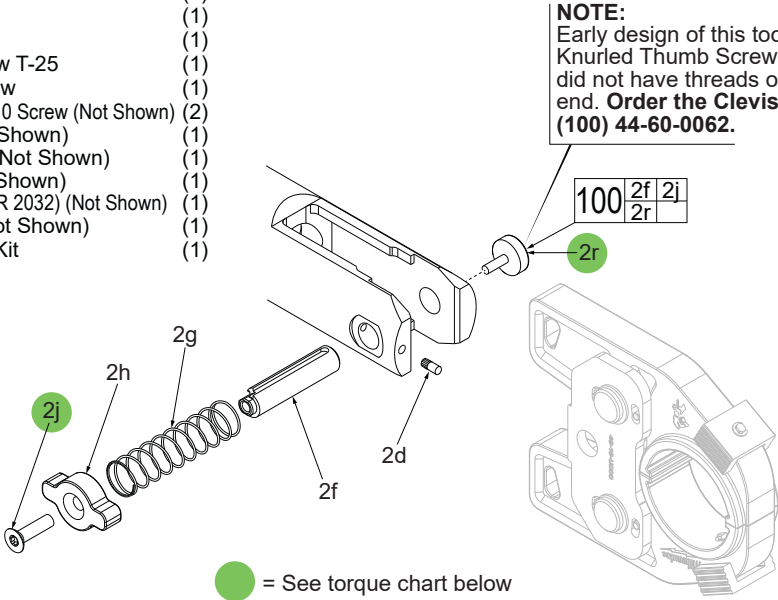
MILWAUKEE *factory* Central Repair Centers:

MILWAUKEE TOOL
Central Repair
1401 Sycamore Avenue
Greenwood, MS 38930

MILWAUKEE TOOL
Central Repair
2198 Southtech Drive
Greenwood, IN 46143

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.**

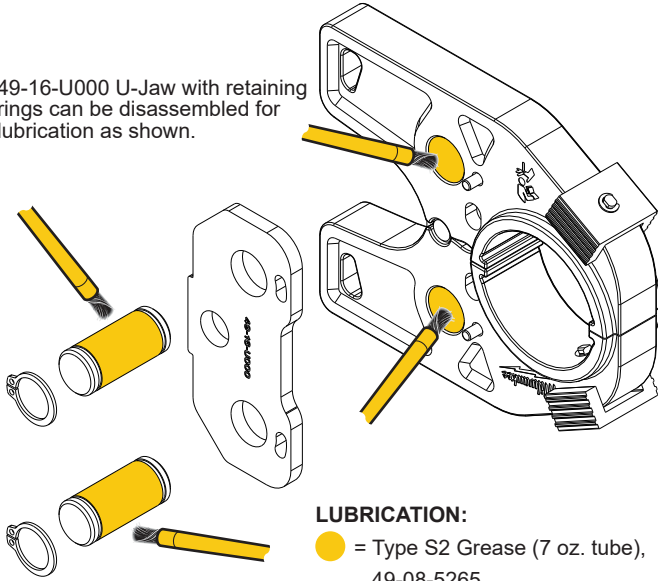
NOTE:
See page 3 for the servicing of the U Jaw Assembly 49-16-U000.
See page 4 for the servicing of the U Jaw Assembly 49-16-U111.
See page 5 for the servicing of Cu/Al Jaw Assembly 49-16-2780.

TORQUE SPECIFICATIONS				
FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(kgf-cm)	(lb-in)
2j	06-82-0050	Screw, Lock Pin Cap	80±3	69±2
2r	06-87-0010	Knurled Thumb Screw	4±1	3.5

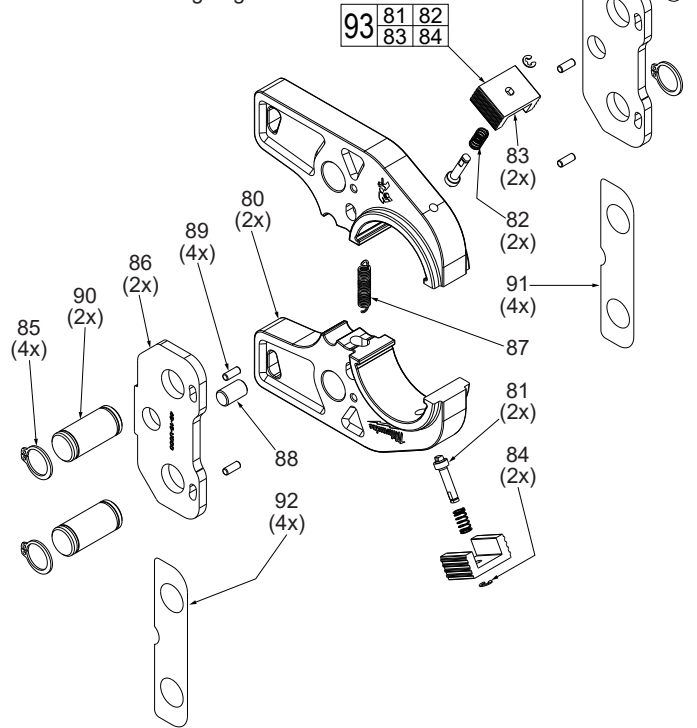
SERVICE PARTS EXPLODED VIEW

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)

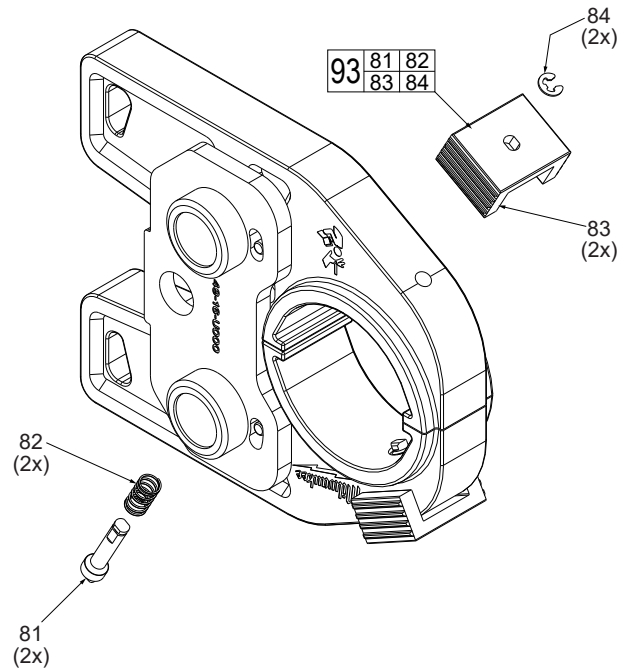
49-16-U000 U-Jaw with retaining rings can be disassembled for lubrication as shown.



49-16-U000 U-Jaw with retaining rings



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



49-16-U111
U Jaw

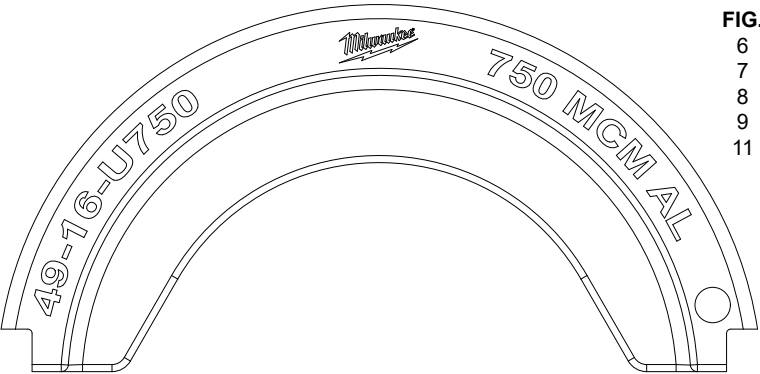
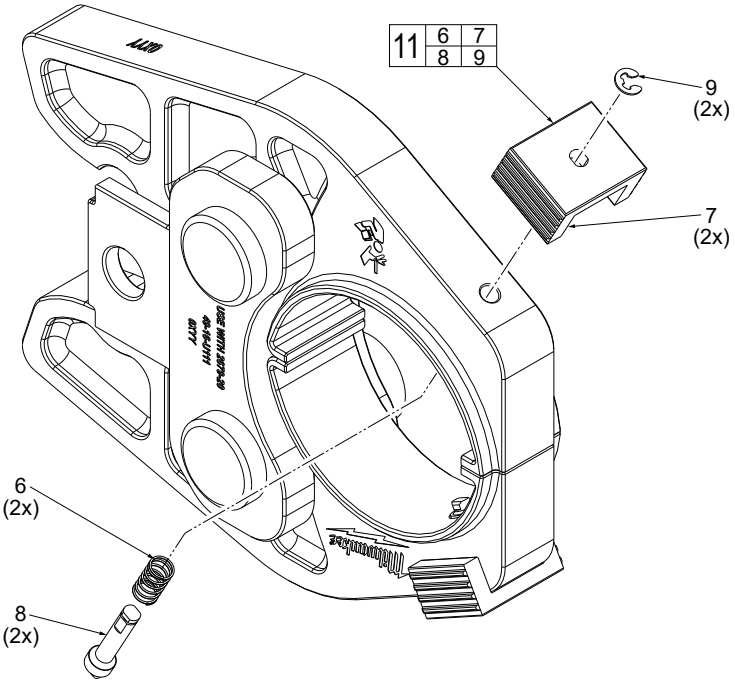
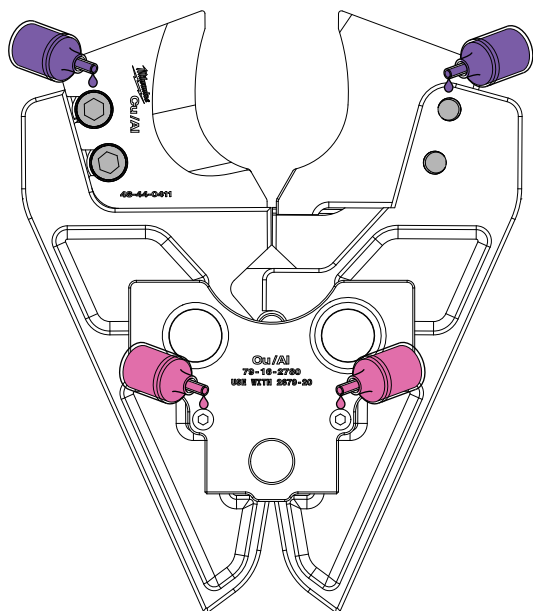


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
6	-----	U Die Spring	(2)
7	-----	Release Tab	(2)
8	-----	Die Pin	(2)
9	-----	C Clip Retaining Ring	(2)
11	44-60-0024	U-Jaw Die Pin Kit	(2)

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

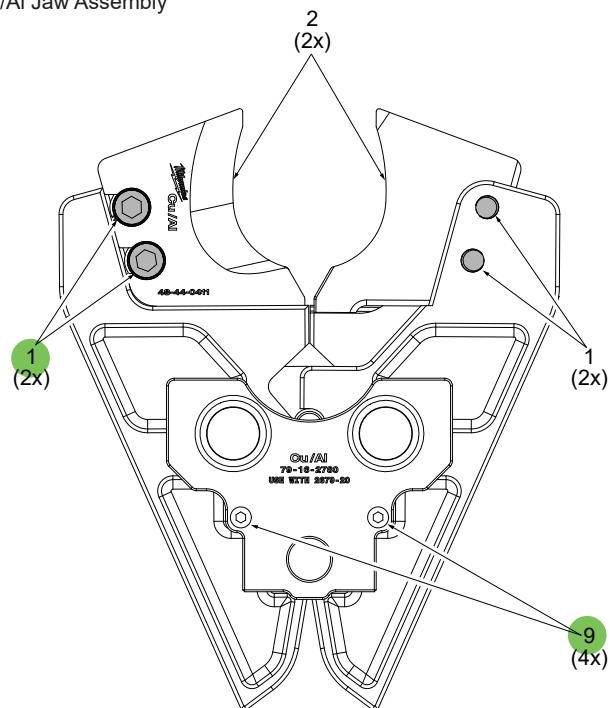


LUBRICATION:

● = 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			SEAT TORQUE	
FIG.	PART NO.	PART or WHERE USED	(kgf-cm)	(lb-in)
1	05-74-0018	Screw, Cu/Al Blades	100±3	87±3
9	05-74-0005	Screw, Plate	13±1	11±1