EXAMPLE:

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

* = Component of the 14-46-5266 5262-21 Maintenance Service Kit

SEE PAGE TWO FOR THE PROCEDURE ON CHECKING THE STATIC SLIP VALUES OF THE CLUTCH

NOTE:
There are two different designs for service replacement 14-13-0060 Diaphragm Assembly (17). Both designs are directly interchangeable.
To check the static slip values of the clutch you must do the following:

- Position Red spring loaded shifting lever at the hammer only icon.
- Lock motor housing of tool into the jaws of a vise having brass jaws or the equivalent.
- Insert a SDS Plus adaptor* into spindle.
- Turn torque wrench clockwise as viewed from the front of the tool until the single slip cycle has been accomplished. Observe the torque reading. Slip clutch a minimum of three times for the most accurate reading.

*SDS Plus Adaptor being used is made by threading a ½" x 20 hex nut onto the threads of SDS adaptor No. 48-03-3005.

**Note:** Apply RED Loctite to threads of hex nut prior to tightening.

Max = 240in/lbs or 20ft/lbs  •  Min = 150in/lbs or 12.5ft/lbs

IMPORTANT:
Rounded side of Washers (14) must be placed facing the inside surface of Piston (13) as shown.
Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all parts highlighted here with ‘S2’ grease. Apply a greater amount of grease to all internal and external gear teeth.

**LUBRICATION NOTES:**

**Type ‘S2’ Grease**

No. 49-08-5262, 1.4 oz. / 40g tube (2 included)

Approximately 2.1 oz. / 60g needed

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Lubrication Note: MILWAUKEE recommends that scheduled maintenance of this Rotary Hammer include lubrication replacement, and replacement of vital O-rings and gaskets at each carbon brush change. Doing so will prolong the life of the hammer by reducing wear to gears and mechanism parts. The carbon brushes and armature commutator in this MILWAUKEE Rotary Hammer are designed and matched for many hours of reliable performance.

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**Lightly coat the exterior of the entire spindle**

Place approx. 27.5 grams, (1.0 oz.) of ‘S2’ grease on the spindle gear and bevel gear once the spindle sleeve and gear assembly and reduction gear assembly are installed into the diaphragm assembly.

Place a very liberal amount of grease to the rear of the piston.

Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all parts highlighted here with ‘S2’ grease. Apply a greater amount of grease to all internal and external gear teeth.

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**LUBRICATION NOTES:**

**Type ‘Q2’ Grease**

No. 49-08-5355, 2.8 oz. / 80g tube

Approximately .3 oz. / 8.7g needed

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Lightly coat all parts highlighted here with ‘Q2’ grease unless directed otherwise.

Coat the o-ring on the shift lever with grease.

Coat the inside cavity of the sleeve and spindle with ‘Q2’ grease.

There is to be no grease on the back wall.

Apply a very light film of grease on the side wall of piston. There is to be no grease on the back wall.

Lightly coat exterior of piston.

There is to be no grease on the face of the ram.
Assembly of internal Spindle components:

1. Lubricate Ram Catcher and O-Rings. Assemble O-Rings onto and into Ram Catcher.
2. Assemble Anvil Assembly into Ram Catcher Assembly (large end into Ram Catcher as shown).
3. Place the chamfered end of the Stop Washer over the small end of the Anvil.
4. Place the assembled components from step 4 into the cavity of an old piston as shown. Use the old piston as an aid to push the assembled components deep into the Spindle cavity. 
5. C-Ring (10k) will be used to secure internal components inside the spindle. It is recommended to modify a flat blade screwdriver by filing or grinding a notch into the blade. Place the C-Ring upright as shown with the opening of the ring straight up. Use the modified screwdriver to push the C-Ring down into the Spindle cavity. Rotate the C-Ring in the spindle cavity as shown. Place the old piston into the Spindle cavity and tap the piston with a mallet to secure the C-Ring in the groove.

Assembly of external Spindle components:

6. Install Washer 10m and Spring 10n onto spindle. Lubricate and install the Clutch Gear 10p and Clutch Plate 10q onto the Spindle. Be sure to orient the part as shown and position with the three notches on the back of the plate over the holes in the spindle.
   
   Place C-Ring 10s onto Spindle. (C-Ring 10s has a thicker cross section than C-Ring 10t.) With the aid of a snap ring pliers, work the C-Ring past the first spindle groove down to the other parts assembled onto spindle.

7. Place Spindle Service Fixture 61-30-0290 over the assembled parts and the Spindle. Position so the fixture rests on Clutch Plate 10q. Be sure the three notches are not covered. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the three holes in the Spindle. As an aid, put a dab of grease on your finger to pick up and place the three Steel Balls 10r into the three small holes on the Spindle just above Clutch Plate. Ensure the notches in the Clutch Plate are aligned with the Steel Balls.

   While compressed, A use a screwdriver B to work C-Ring 10s into the Spindle groove. Ensure the Steel Balls are in place and slowly retract the arbor press. The Clutch Plate should slide over the Steel Balls until it is in contact with the C-Ring.

   Place C-Ring 10t onto Spindle. With the aid of a snap ring pliers, work the C-Ring into the first spindle groove and snap into place.
Assembly of external Spindle components:

6. Install Washer 10m and Spring 10n onto spindle. Lubricate and install the Clutch Gear 10p onto the Spindle 10a. Be sure to orient the part as shown with the three flats on the Clutch Gear centered over the holes in the spindle.

7. Place Spindle Service Fixture No. 61-30-0290 over the assembled parts and the Spindle. Position so the fixture rests on the Clutch Gear 10p. Be sure the three holes on the Spindle are not covered. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the three holes in the Spindle.

As an aid, put a dab of grease on your finger to pick up and place the three steel balls 10r into the three small holes on the Spindle just above the Clutch Gear.

Remove the Spindle from the arbor press.

8. Lubricate and install the Clutch Plate 10q onto the Spindle. Be sure to orient the part such that three inside notches on the plate cover the Steel Balls in the Spindle. Place the C-Ring 10s onto the Spindle. **NOTE:** C-Ring 10s is thicker than 10t. With the aid of a snap ring pliers, work the C-Ring past the first spindle groove, down to the other parts assembled onto the spindle.

Place Spindle Service Fixture No. 61-30-0290 over the assembled parts and the Spindle. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the C-Ring groove in the Spindle.

While compressed, use a flat blade screwdriver to work C-Ring 10s into the spindle groove. Ensure that the Steel Balls are still in the spindle. Slowly retract the arbor press. The Clutch Plate should slide over the Steel Balls until it is in contact with the C-Ring.

With the aid of a snap ring pliers, work C-Ring 10t into top groove of Spindle.
NOTE: As an aid to reassembly, take note of the wire routings and position of the wires in the wire guides and traps prior to dismantling the tool.

Watch for pinched wires when placing the handle cover back over the housing assembly.

Check for the proper switch and shuttle functionality before attempting to use tool.

NOTE: Cord jacket is to extend approximately .25” beyond the cord clamp area.

Torque screws to 6±1 kg-cm (5 in-lbs). Recheck to correct relaxation.

WIRING SPECIFICATIONS

<table>
<thead>
<tr>
<th>Wire No.</th>
<th>Wire Color</th>
<th>Origin or Gauge</th>
<th>Length</th>
<th>Terminals, Connectors and 1 or 2 End Wire Preparation</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>White</td>
<td></td>
<td></td>
<td>Component of cord set. Connect to '2\downarrow' position on bottom of switch.</td>
</tr>
<tr>
<td>2</td>
<td>Black</td>
<td></td>
<td></td>
<td>Component of cord set. Connect to '1\downarrow' position on bottom of switch.</td>
</tr>
<tr>
<td>3</td>
<td>Blue 23-94-0037</td>
<td></td>
<td></td>
<td>Connect to position '7' on right side of switch and the right brush holder.</td>
</tr>
<tr>
<td>4</td>
<td>Yellow</td>
<td></td>
<td></td>
<td>From top left field coil to position '6' on right side of switch.</td>
</tr>
<tr>
<td>5</td>
<td>Black 23-94-0033</td>
<td></td>
<td></td>
<td>From bottom right field coil to position '5' on left side of switch.</td>
</tr>
<tr>
<td>6</td>
<td>Red</td>
<td></td>
<td></td>
<td>Connect to position '8' on switch and the left brush holder.</td>
</tr>
<tr>
<td>7</td>
<td>White</td>
<td></td>
<td></td>
<td>From bottom left field coil to position '1' on bottom of switch.</td>
</tr>
<tr>
<td>8</td>
<td>Black</td>
<td></td>
<td></td>
<td>From top right field coil to '2' on bottom of switch.</td>
</tr>
</tbody>
</table>

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