BULLETIN NO. 54-26-2700

SERVICE PARTS LIST

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

18 Volt 3/8” Square Impact Wrench

CATALOG NO. 2651-20

STARTING SERIAL NO. B77A

WIRING INSTRUCTION

SEE PAGE 4

1. Place Rubber Slugs (6) as shown, four in each handle half (2,3).

2. There are 2 belt clip designs for this tool. Belt Clip #7, 42-70-5150 is discontinued and replaced by Belt Clip Assembly 42-70-2653 (#80).

SEEE PAGE TWO FOR SERVICE OPTIONS

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. Lisbon Road, Brookfield, WI 53005

Drwg. 9

REVISED BULLETIN
DATE Aug. 2014

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

CATALOG NO. 2651-20

B77A

FIG. PART NO. DESCRIPTION OF PART NO. REQ.
1 31-44-2430 Handle Assembly (1)
2 --------------- Left Handle Half (1)
3 --------------- Right Handle Half (1)
4 42-52-0062 End Cap (1)
5 45-24-0300 Forward / Reverse Shuttle (1)
6 45-30-0250 Rubber Slug (8)
7 42-70-5150 Belt Hook (1)
8 40-50-1090 Spring (1)
9 --------------- Contact Block (1)
10 23-66-0425 Switch (1)
11 23-66-0426 Switch/Brush Card Assembly (1)
13 --------------- LED Assembly (1)
15 --------------- Brush Card (1)
16 16-01-3010 Service Armature Assembly (1)
17 18-01-3011 Service Field (1)
19 14-30-0920 Gear Box Assembly (1)
20 ------------- Rear Case (1)
21 ------------- Ring Gear (1)
22 ------------- Retaining Ring (1)
23 ------------- Ball Bearing (1)
24 ------------- Washer (1)
25 ------------- Pin (2)
26 ------------- Planet Gear (1)
27 ------------- Cam Shaft (1)
28 ------------- 3/16" Steel Ball (2)
29 ------------- Washer (1)
30 ------------- Compression Spring (1)
31 ------------- Washer (1)
32 ------------- 3.0mm Steel Ball (30)
33 ------------- Hammer (1)

FIG. PART NO. DESCRIPTION OF PART NO. REQ.
36 ------------- 3/8” Square Drive Anvil Assembly w/Bearing (See page two) (1)
37 ------------- Hog Ring (See page two) (1)
42 45-88-1317 Front Washer (1)
43 28-50-0900 Front Case Sub-Assembly (1)
47 06-82-7010 8-18 x 24 Pan Hd. Screw (4)
55 06-82-6350 M3 Pan Hd. T-10 Screw (7)
56 06-82-7336 M3 Pan Hd. T-10 Screw (4)
57 06-82-8275 6-32 x 5/16" Slt. Pan Hd. T-15 Screw (1)
59 12-20-2650 Service Nameplate Kit (1)
60 10-20-2695 Warning Label (1)
65 02-02-1300 5mm Steel Ball (1)
67 ------------- Rubber Ring (See page two) (1)
68 42-55-2650 Carrying Case (1)
71 14-46-1710 Cam Shaft/Hammer Kit (1)
72 05-88-0928 M3 x 5mmPan Hd. T10 Screw (2)
73 45-88-1980 Spring Washer (2)
74 ------------- Leadwire Assembly - Red (1)
75 ------------- Leadwire Assembly - Black (1)
76 14-46-2395 Leadwire/Screw/ Washer Kit (1)
77 14-46-2024 Brush Card Assembly (1)
80 42-70-2653 Belt Clip Assembly (1)
81 ------------- Belt Clip (1)
82 ------------- Belt Clip Screw (1)
Anvil Assembly No. 42-06-0305 (shown below) is an upgrade to Anvil Assembly No. 42-06-0601. The 42-06-0601 Anvil Assembly and all corresponding parts are to be discontinued when inventory is depleted.

If any of the above components is unavailable, Anvil Assembly No. 42-06-0305 must be ordered.

NOTE: The Anvil, Hog Ring and Rubber Ring ARE NOT INTERCHANGEABLE between the original and the upgraded design.
NOTE:
There are two Brush Card Assembly designs.

On the original brush card design the red and black wires that go to the switch are soldered on the brush card.

On the new brush card design the red and black wires that go to the switch are secured to the brush card with spring washers and screws.

The new brush card design is directly interchangeable in tools that have the old brush card design.

NOTE:
As an aid to prevent damage to the armature commutator or the brushes when removing and installing the armature assembly, it is recommended to pull the carbon brushes partially back into the brush tube. The carbon brushes will be held in place with the brush spring moving from the rear of the brush to the side of the brush.

In the unlikely event that the spring pops off follow the instructions below.

Fig. Notes:
15,16,17 See service note and illustration on the back of bulletin to aid with the removal and installation of the the Brush Card (15), Armature (16) and Field (17).

17 Field (17) to be positioned with side cut-outs to the front.

20,21 Position Ring Gear (21) with three lugs face down to interlock in the bottom of Rear Case (20).

20,43 Be sure to match the raised contours on the bottom of Rear Case (20) with raised contour on bottom of Front Case (43) when assembling.

29,30 Make sure concave side of Washer (29) faces Spring (30).

42,43 Tapped end of Front Washer (42) to face Front Case (43).

Lubrication (Type 'J' Grease, No. 49-08-4220):
21,26 Lightly coat I.D. of the Ring Gear (21) and center of the two Planet Gears (26) with grease.

27 Place a dab of grease in the ball grooves of the Cam Shaft (27).

36,37 Lightly coat front washer surface of Anvil (36) with grease, place a dab in the Ball holes of Anvil and in Needle Bearing inside the Anvil.

43 Coat inside grooves of Bushing (inside of 43) with grease.
NOTE: Before attempting to remove armature or brush card assembly, pull brush back until the brush spring slides from the back of the brush, onto the side of the brush as shown. (Do this to all four brushes). This will hold brushes out of the way for ease of servicing and will help prevent damage to the carbon brushes and the commutator of the armature.

To reinstall components, orient the Field with the cut-outs facing forward, place the Armature into the Field prior to assembling onto the Brush Card Assembly. Make sure that all brushes are returned to the proper position once Brush Card, Armature, and Field are properly seated in the Left Handle Half.

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>Black</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>2</td>
<td>Red</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>3</td>
<td>Gray</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>4</td>
<td>Green</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>5</td>
<td>Red</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>6</td>
<td>Black</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>7</td>
<td>White</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>8</td>
<td>Black</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
<tr>
<td>9</td>
<td>Red</td>
<td>-----</td>
<td>-----</td>
<td>Component of the Switch/Brush Card Assembly.</td>
</tr>
</tbody>
</table>

Be sure to place black wire #1 and red wire #2 firmly in the wire traps on the bottom of brush card to prevent pinching between handle halves and end cap.

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.