

BULLETIN NO.
54-26-2701

REVISED BULLETIN
54-26-2700

DATE
Aug. 2014

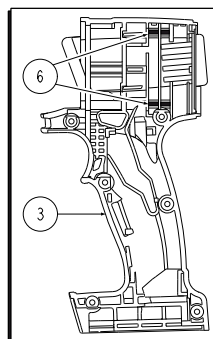
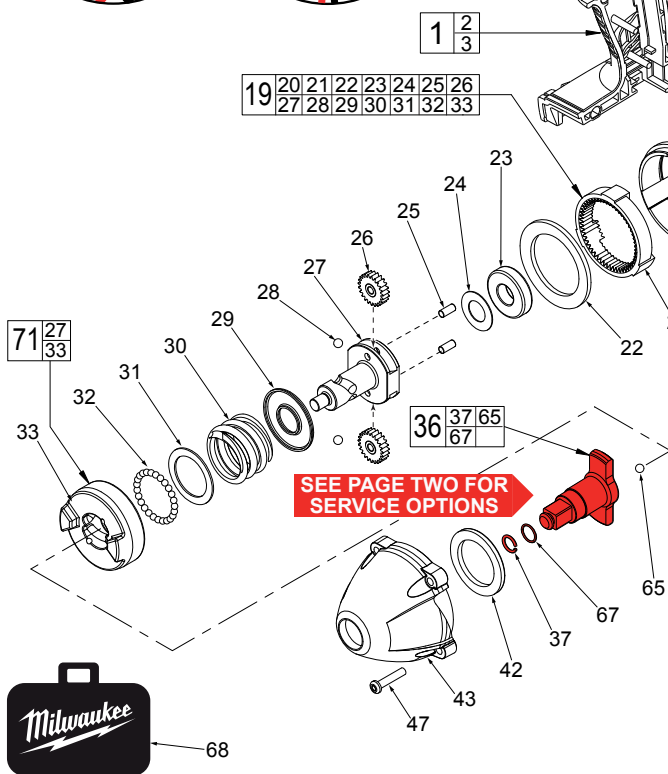
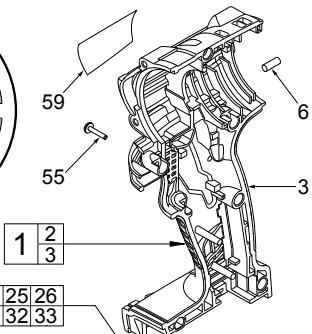
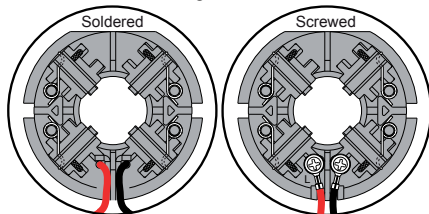
18 Volt 3/8" Square Impact Wrench

CATALOG NO. 2651-20

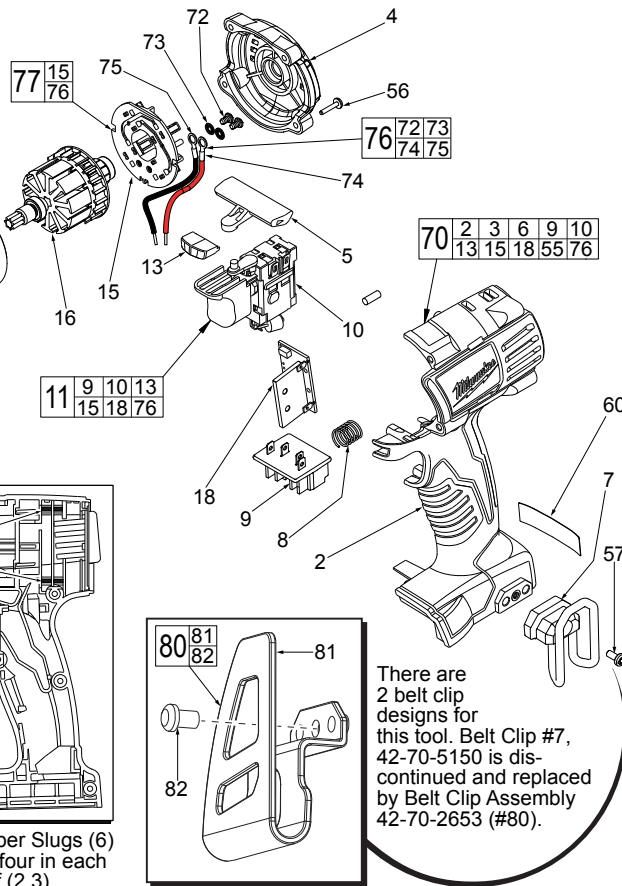
STARTING
SERIAL NO.

B77B

WIRING INSTRUCTION
SEE PAGE 4



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



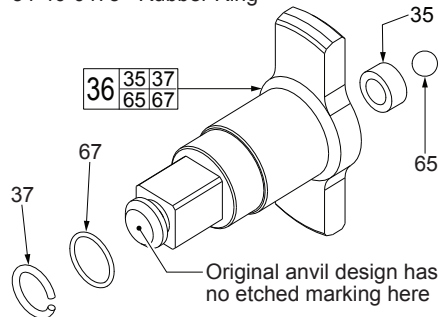
There are 2 belt clip designs for this tool. Belt Clip #7, 42-70-5150 is discontinued and replaced by Belt Clip Assembly 42-70-2653 (#80).

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	06-82-5275	6-32 x 5/16" Slit. 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)
★ 70	23-66-1239	Switch and Housing Kit	(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)

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. Lisbon Road, Brookfield, WI 53005
Drwa. 5

ORIGINAL ANVIL DESIGN

35	-----	Needle Bearing	(1)
36	42-06-0601	3/8" Square Drive Anvil Assembly	(1)
37	44-90-1000	Hog Ring	(1)
65	02-02-1300	5mm Steel Ball	(1)
67	34-40-0475	Rubber Ring	(1)



Anvil Assembly No. 42-06-0305 (shown below) is an upgrade to Anvil Assembly No. 42-06-0601.

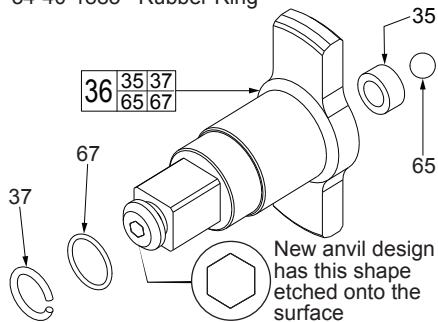
The 42-06-0601 Anvil Assembly and all corresponding parts are to be discontinued when inventory is depleted.

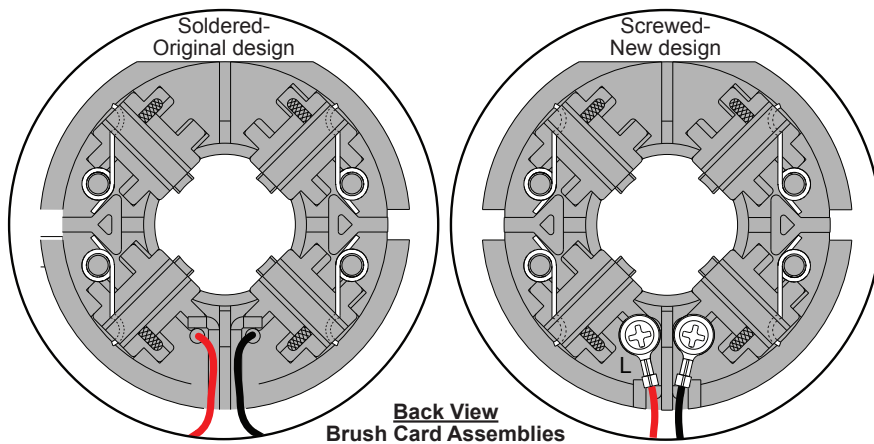
If any of the above components is unavailable, Anvil Assembly No. 42-06-0305 must be ordered.

NOTE:
The Anvil, Hog Ring and Rubber Ring **ARE NOT INTERCHANGEABLE** between the original and the upgraded design.

ANVIL DESIGN UPGRADE

35	-----	Needle Bearing	(1)
36	42-06-0305	3/8" Square Drive Anvil Assembly	(1)
37	44-90-1050	Hog Ring	(1)
65	02-02-1300	5mm Steel Ball	(1)
67	34-40-1885	Rubber Ring	(1)





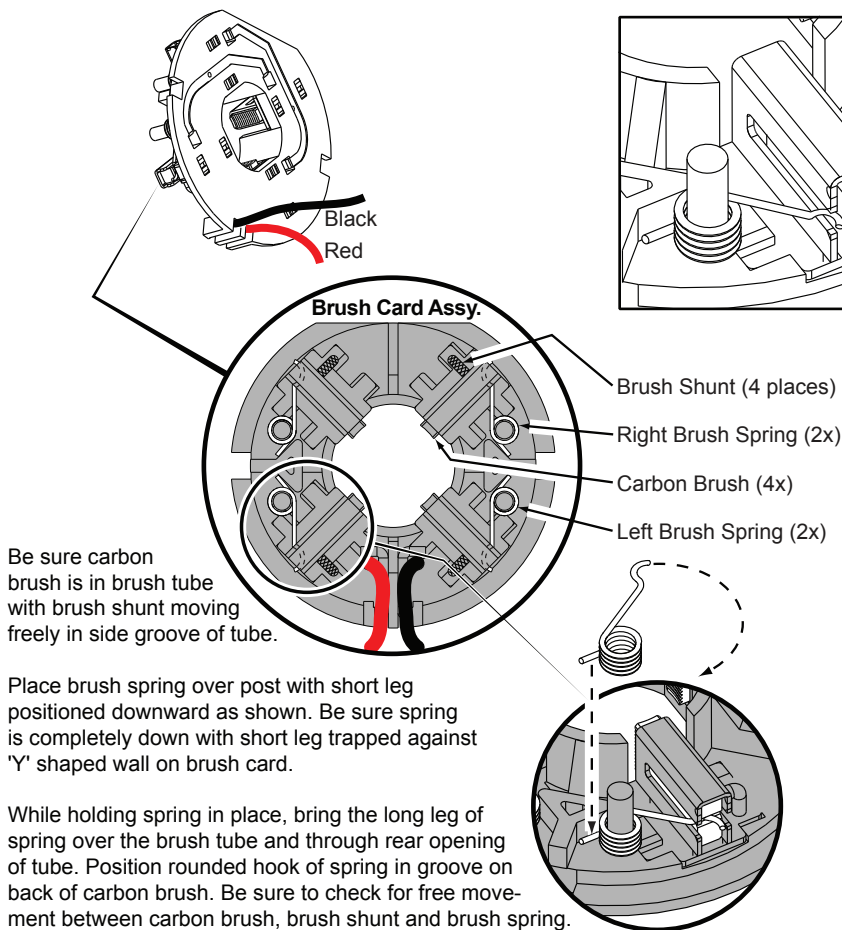
NOTE:

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.

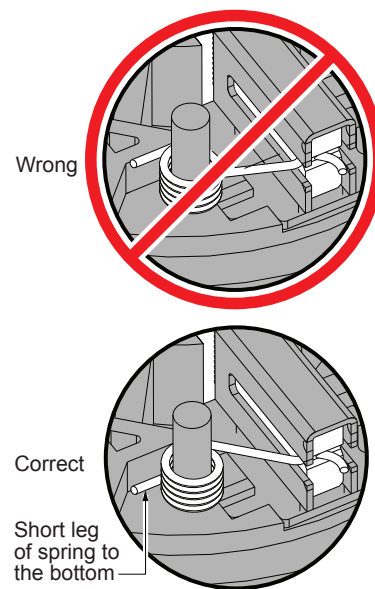


FIG. NOTES:

- 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 Tapered end of Front Washer (42) to face Front Case (43).

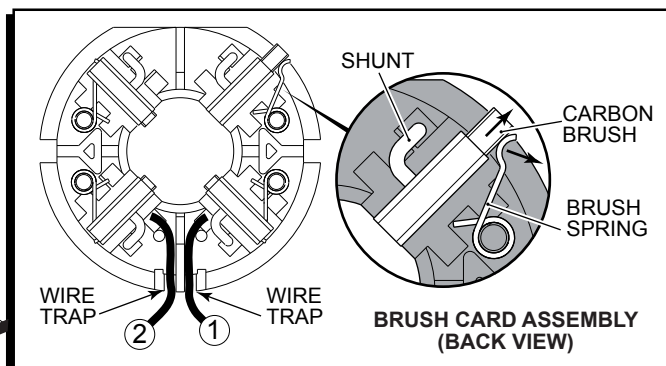
FIG. LUBRICATION

(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.

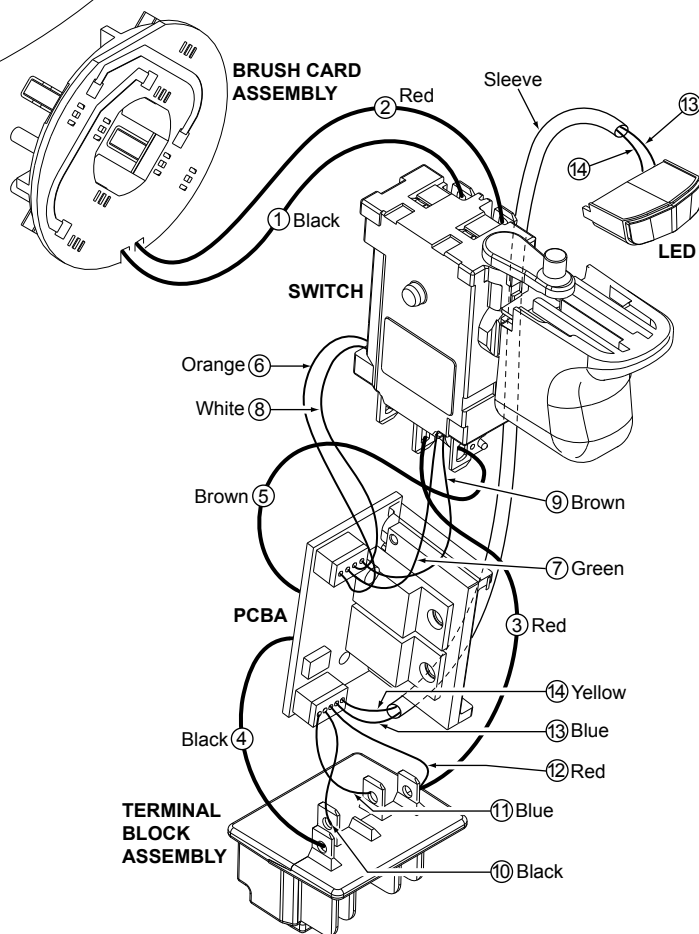
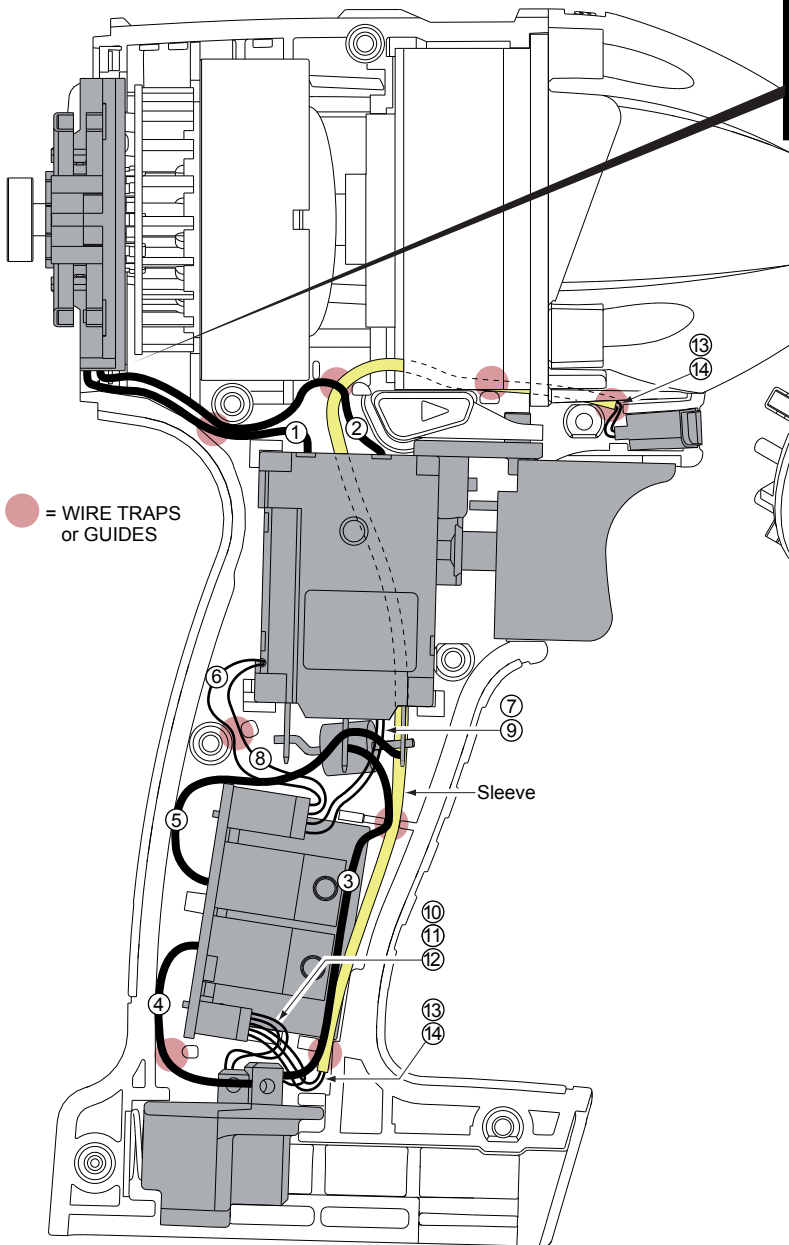
NOTE: Before attempting to remove armature or brush card assembly- Pull brush back until the brush spring slides from the back of the brush, onto the side of the brush as shown. (Do this to all four brushes). This will hold brushes out of the way for ease of servicing and will help prevent damage to 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.



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.

Model 2650-20 shown



WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	-----	-----	Component of Brush Card Assy. Connect to M2 on Switch.
2	Red	-----	-----	Component of Brush Card Assy. Connect to M1 on Switch.
3	Red	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
4	Black	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
5	Brown	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
6	Orange	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
7	Green	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
8	White	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
9	Brown	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
10	Black	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
11	Blue	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
12	Red	-----	-----	Component of Switch/Brush Card/Terminal Block Assembly.
13	Blue	-----	-----	Component of Switch/Brush Card/Terminal Block Assy. (LED)
14	Yellow	-----	-----	Component of Switch/Brush Card/Terminal Block Assy. (LED)

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.