**SERVICE PARTS LIST**

**CATALOG NO.** 6740-20  **STARTING SERIAL NO.** 143B

---

**FIG. NOTES:**

- Needle bearings to be pressed flush to .010 under flush, from end which has the vendor identification.
- Needle bearing to have it’s seal toward the front of the tool. Needle bearing to be pressed .133-.143 under flush.
- 3 Needle bearings to be pressed flush to .010 under flush.
- 2 Needle bearings to be pressed .133-.143 under flush.
- 4 Needle bearings to be pressed flush to .010 under flush.

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**FIELD TERMINAL POCKETS**

Fill cavities with Type “X” contact grease No. 49-08-5000, 4 places. Do not over fill and allow grease to extend past edges.

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**LUBRICATION (Type “Y” Grease, No. 49-08-5270)**

- Fill the 3 enlarged clutch pockets of the clutch gear assembly (21) with .5 gm. (.02 oz.) grease.
- Apply the same amount of grease in the bias spring (25).
- Apply in total .5 gm. (.02 oz.) grease to the clutch thrust washer (35), thrust pin (31) and separator spring (24).
- Place 3.6 gm. (.13 oz.) of grease on top of the inserted intermediate needle bearing (4).
- Place 13 gm. (.46 oz.) of grease at the armature pin location in the gearcase (14) and fill to slightly above the intermediate gear (22).
- Apply a light film of grease to the lead chamfer of the clutch chuck (27) prior to assembly.
- Place 3.6 gm. (.13 oz.) of grease at the armature pin location in the gearcase (14) and fill to slightly above the intermediate gear (22).

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**EXAMPLE:**

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

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**EXCEPTIONS:**

- Cat. No. 31-53-0205 Lock Button Plug

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**BULLETIN NO.** 54-42-6151  **REVISED BULLETIN** 54-42-6150  **DATE** June 2011

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**MILWAUKEE ELECTRIC TOOL CORPORATION**

13135 W. LISON RD., BROOKFIELD, WI 53005

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**FIG. PART NO.**

<table>
<thead>
<tr>
<th>FIG. PART NO.</th>
<th>DESCRIPTION OF PART</th>
<th>NO. REQ.</th>
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<tbody>
<tr>
<td>1</td>
<td>02-04-0640 Ball Bearing</td>
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<tr>
<td>2</td>
<td>02-04-0645 Ball Bearing</td>
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<td>3</td>
<td>02-04-0852 Ball Bearing</td>
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<td>4</td>
<td>02-50-2400 Needle Bearing</td>
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<td>5</td>
<td>02-50-3245 Needle Bearing</td>
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<td>7</td>
<td>06-82-7275 7-18 x 3/4 Slotted Plastite Torx T-20</td>
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<td>8</td>
<td>12-99-2665 Service Nameplate</td>
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<td>9</td>
<td>16-10-2205 Armature</td>
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<td>10</td>
<td>18-07-2200 Field</td>
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<td>11</td>
<td>22-18-1210 Brush Card Assembly</td>
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<td>12</td>
<td>22-64-6510 Cord Assembly</td>
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<td><strong>13</strong></td>
<td>23-66-2605 Switch</td>
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<td>14</td>
<td>28-14-2380 Gearcase</td>
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<td>15</td>
<td>28-28-2315 Diaphragm</td>
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<td>30-37-0046 Drywall Nose Guide</td>
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<td>17</td>
<td>31-15-2010 Handle Halve</td>
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<td><strong>18</strong></td>
<td>31-50-4010 Motor Housing</td>
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<td>31-51-0095 Drywall Locator</td>
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<td>31-58-0515 Snap Sleeve</td>
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<td>21</td>
<td>32-10-0525 Clutch Gear Assembly</td>
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<td>22</td>
<td>32-40-0100 Intermediate Gear</td>
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<td>23</td>
<td>36-66-0120 Intermediate Shaft</td>
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<td>24</td>
<td>40-50-0095 Separator Spring</td>
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<td>25</td>
<td>40-50-8515 Bias Spring</td>
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<td>26</td>
<td>42-14-0460 Baffle Assembly</td>
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<td>42-66-0715 Clutch Chuck Assembly</td>
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<td>30</td>
<td>43-44-0985 Gasket</td>
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<td>45-36-1280 Spacer</td>
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<td>42</td>
<td>45-30-0035 Slug</td>
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<td>48-32-1040 #2 Phillips Insert Bit</td>
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<td>44</td>
<td>49-26-1036 Drywall Locator Assembly</td>
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