

**READ AND KEEP THIS FOR FUTURE REFERENCE**

# The Care and Operation of

**YOUR NEW**



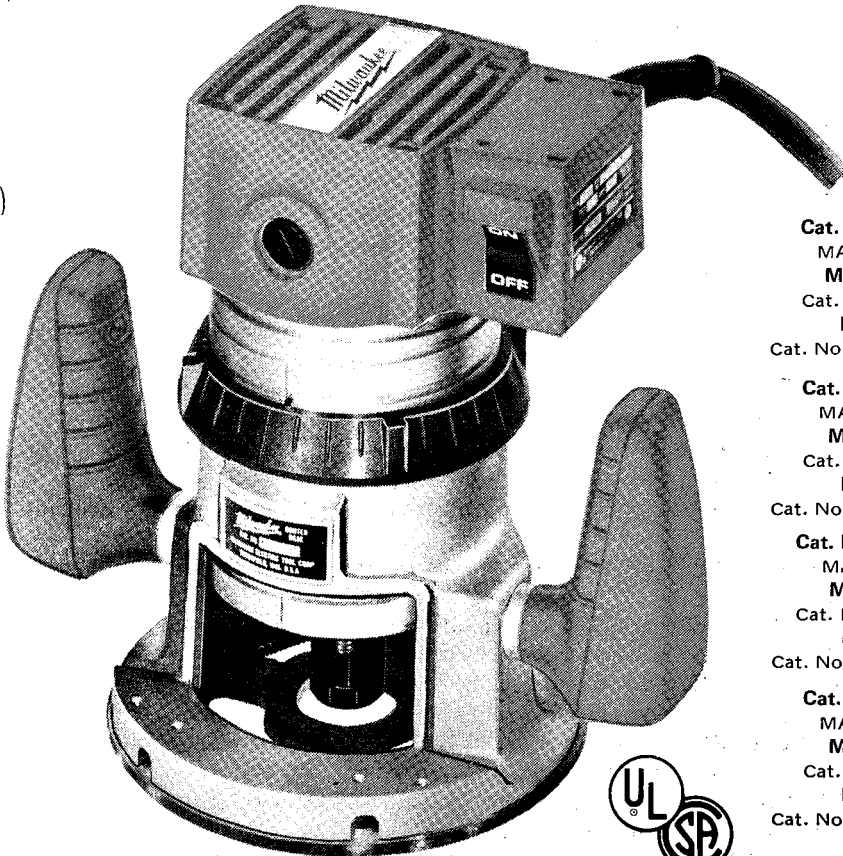
# HEAVY-DUTY ROUTER

Cat. No. 5620  
1 HP 23,000 RPM  
120 Volt

Cat. No. 5660  
1-1/2 HP 23,000 RPM  
120 Volt

Cat. No. 5660-2  
1-1/2 HP 23,000 RPM  
240 Volt

Cat. No. 5680  
2 HP 26,000 RPM  
120 Volt



Cat. No. 5620  
MADE OF  
MOTOR  
Cat. No. 5610  
BASE  
Cat. No. 48-10-0070

Cat. No. 5660  
MADE OF  
MOTOR  
Cat. No. 5650  
BASE  
Cat. No. 48-10-0070

Cat. No. 5660-2  
MADE OF  
MOTOR  
Cat. No. 5650-2  
BASE  
Cat. No. 48-10-0070

Cat. No. 5680  
MADE OF  
MOTOR  
Cat. No. 5670  
BASE  
Cat. No. 48-10-0070



**IMPORTANT**-Before placing tool in operation, record the following information from name plate.

Model Number \_\_\_\_\_ Serial Number \_\_\_\_\_ Date of Purchase \_\_\_\_\_



**MILWAUKEE ELECTRIC TOOL CORPORATION**

13135 West Lisbon Road • Brookfield, Wisconsin 53005

THIS SYMBOL



IS YOUR ASSURANCE -

1. That every tool manufactured by MILWAUKEE is produced in accordance with applicable Standards for Safety of Underwriters' Laboratories and American National Standards (ANSI).
2. That compliance with applicable safety standards is assured by independent inspection and testing conducted by Underwriters' Laboratories (UL).
3. That every motorized tool manufactured by MILWAUKEE is fully inspected.
4. That every tool has with it adequate instructions and a list of safety rules for the protection of the user.

### SAFETY INSTRUCTIONS FOR ALL POWER TOOLS

1. **KNOW YOUR POWER TOOL.** Read owner's manual carefully. Learn its applications and limitations as well as the specific potential hazards peculiar to this tool.
2. **GROUND ALL TOOLS—UNLESS DOUBLE-INSULATED.** If tool is equipped with three-prong plug, it should be plugged into a three-hole electrical receptacle. If adapter is used to accommodate two-pronged receptacle, the adapter wire must be attached to a known ground. Never remove third prong.
3. **KEEP GUARDS IN PLACE** and in working order.
4. **KEEP WORK AREA CLEAN.** Cluttered areas and benches invite accidents.
5. **AVOID DANGEROUS ENVIRONMENT.** Don't expose power tools to rain or use in damp, wet, or gaseous or explosive locations. Keep work area well lit.
6. **KEEP CHILDREN AWAY.** All visitors should be kept safe distance from work area.
7. **STORE IDLE TOOLS.** When not in use, tools should be stored in dry, high or locked-up place—out of reach of children.
8. **DON'T FORCE TOOL.** It will do the job better and safer at the rate for which it was designed.
9. **USE RIGHT TOOL.** Don't force small tool or attachment to do the job of a heavy-duty tool.
10. **WEAR PROPER APPAREL.** No loose clothing or jewelry to get caught in moving parts. Rubber gloves and footwear are recommended when working outdoors.
11. **USE SAFETY GLASSES** with most tools. Also face or dust mask if cutting operation is dusty.
12. **DON'T ABUSE CORD.** Never carry tool by cord or yank it to disconnect from receptacle. Keep cord from heat, oil and sharp edges.
13. **SECURE WORK.** Use clamps or a vise to hold work. It's safer than using your hand and it frees both hands to operate tool.
14. **DON'T OVERREACH.** Keep proper footing and balance at all times.
15. **MAINTAIN TOOLS WITH CARE.** Keep tools sharp and clean at all times for best and safest performance. Follow instructions for lubricating and changing accessories. **CAUTION:** Do not use carbon tetrachloride.

16. **DISCONNECT TOOLS.** When not in use, before servicing; when changing accessories such as blades, bits, cutters, etc.
17. **REMOVE ADJUSTING KEYS AND WRENCHES.** Form habit of checking to see that keys and adjusting wrenches are removed from tool before turning it on.
18. **AVOID ACCIDENTAL STARTING.** Don't carry plugged-in tool with finger on switch. Be sure switch is off when plugged in.
19. **WEAR EAR PROTECTORS** when using for extended periods.
20. **ACCESSORIES.** The use of any accessories other than those listed or recommended for this particular tool may be hazardous.
21. **KEEP HANDS AWAY FROM CUTTING EDGES AND ALL MOVING PARTS.**
22. **USE INSULATED SURFACES.** A double insulated or grounded tool may be made live if the blade or bit comes in contact with live wiring in a wall, floor, ceiling, etc. Always check the work area for live wires and hold the tool by the insulated surfaces when making "blind" or plunge cuts.
23. **GRINDING WHEELS.** Use only grinding wheels with "Safe Speed" at least as high as "No Load RPM" marked on the name plate.

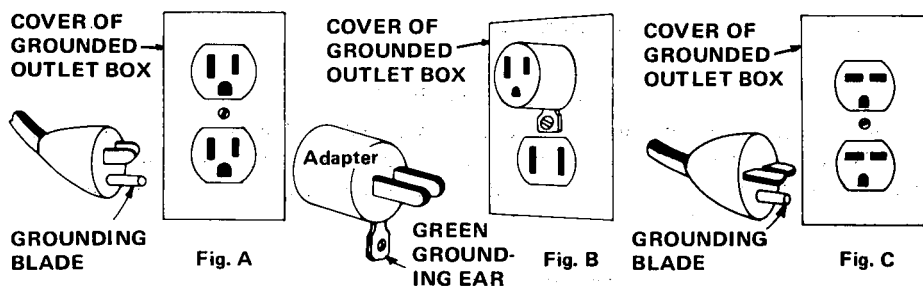
## GROUNDING INSTRUCTIONS

This tool should be grounded while in use to protect the operator from electric shock. The tool is equipped with an approved three-conductor cord and three-prong grounding-type plug to fit the proper grounding-type receptacle. The green conductor in the cord is the grounding wire. Never connect the green wire to a live terminal. If your unit is for use on less than 150 volts, it has a plug that looks like Fig. "A". If it is for use on 150 to 250 volts, it has a plug that looks like Fig. "C".

### NOTE

The use of 3-prong adapters in Canada is prohibited by the Canadian Electrical Code.

An adapter, Fig. "B" is available for connecting Fig. "A" plugs to two-prong receptacles. The green grounding ear extending from the adapter must be connected to a permanent ground such as to properly grounded outlet box. No adapter is available for Fig. "C" plugs.



**NOTE: RECEPTACLE MUST BE GROUNDED FOR SAFE USE OF ADAPTER; IF IN DOUBT CALL A QUALIFIED ELECTRICIAN AND HAVE THE RECEPTACLE CHECKED FOR GROUND.**

## EXTENSION CORDS

Use only three-wire extension cords which have three-prong grounding-type plugs and three-pole receptacles which accept the tool's plug. Replace or repair damaged cords.

### EXTENSION CORD CHART

When an extension cord is used, it should also be a 3 wire cord to permit proper grounding of the tool. As the distance from the supply outlet increases, heavier gauge extensions are required. The use of extension cords of inadequate size wire causes a serious drop in voltage, loss of power and possible motor damage. This table is based on limiting line voltage drop to 5 volts at 150% of rated amperes.

Ampere rating (on Nameplate)	0- 2,00	2,10- 3,4	3,5- 5,00	5,10- 7,0	7,10- 12,0	12,1- 16,0	
Ext. Cable Length	Wire Size						
25 Ft.	18	18	18	18	16	14	Not normally available as flexible extension cord.
50 Ft.	18	18	18	16	14	12	
75 Ft.	18	18	16	14	12	10	
100 Ft.	18	16	14	12	10	8	
150 Ft.	16	14	12	12	8	8	
200 Ft.	16	14	12	10	8	6	
300 Ft.	14	12	10	8	6	4	
400 Ft.	12	10	8	6	4	4	
500 Ft.	12	10	8	6	4	2	
600 Ft.	10	8	6	4	2	2	
800 Ft.	10	8	6	4	2	1	
1000 Ft.	8	6	4	2	1	0	

**IF USING EXTENSION CORD OUT OF DOORS, BE SURE IT IS RATED FOR OUTDOOR USE.**

## ROUTER BITS AND CUTTERS

Most router bits fall into three major categories. To assist in the selection of a MILWAUKEE Router Bit for a specific job, brief descriptions are listed below. Always use the right bit for the right job.

### HIGH SPEED STEEL BITS

High Speed Steel Bits are recommended for regular woods which contain no abrasives.

### CARBIDE TIP BITS

Carbide Tip Bits are recommended for cutting materials such as plywood, masonite, and other composites as well as solid lumber. Composites contain abrasives. Under abrasive conditions, a carbide tip bit will last from ten to twenty-five times longer than high speed steel bits.

### SOLID CARBIDE BITS

Solid Carbide Bits offer solid one-piece built in geometry. No brazing. The short functional lengths withstand high torque loads and are ideal for trimming edges on formica counters, trimming holes, slotting, ripping, scoring and other applications.

## CARBIDE TOOL CARE

Frequent honing can prolong the life of a carbide tip cutting tool and save a great deal of grinding time. However, bits and cutters will eventually become dull and grinding will be necessary. This should be done by an experienced specialist using a diamond grinding wheel or a diamond hone. When grinding or honing, the bit should never be dipped in water for cooling. This will crack the carbide. Always handle carbide tools with care since they are brittle and may shatter or crack if dropped. When not in use, store in the original protective case.

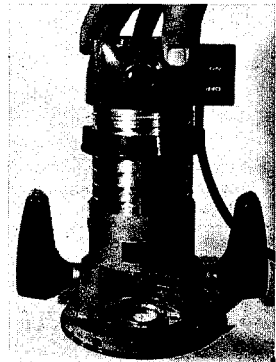
## BIT SELECTION

For fast, rough cuts the single flute bit is ideal, since it provides greater chip clearance. However, smoother cuts and a much better finish can be obtained with a two flute bit. The two flute bit provides a smoother finish because at the same speed and rate of feed, only half as large a chip load is taken per cut.

Do not select a bit which is longer than necessary. Moving a long bit up or down, using the whole length of the cutting edge, is not generally a good practice, and will result in excessive breakage.

## MOUNTING THE MOTOR INTO THE ROUTER BASE

Loosen locking knob on base and slide complete motor into base. Be sure the guide pin in the motor mates with the slot on the base properly. Tighten locking knob.



## COLLETS

MILWAUKEE routers starting with the following serial numbers use a special collet system not used on previous routers.

NO. 5620 1 H.P. Router starting with serial no. 451-12247

NO. 5660 1-1/2 H.P. Router starting with serial no. 452-19550

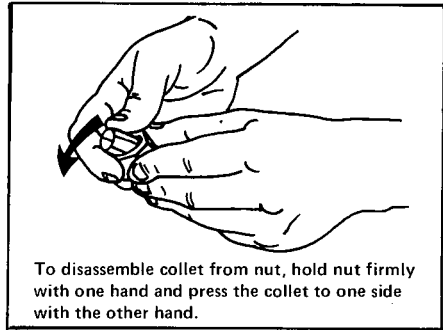
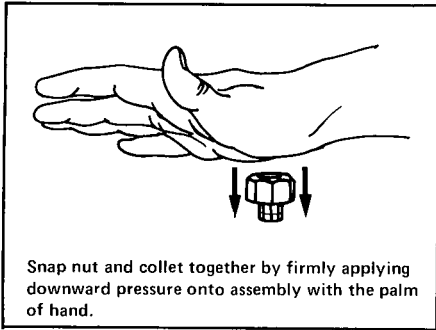
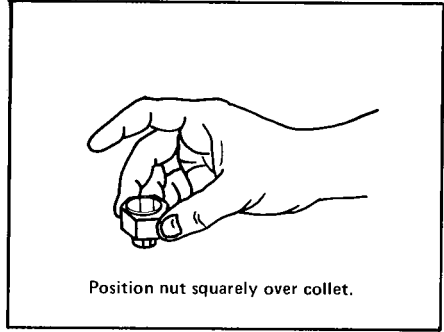
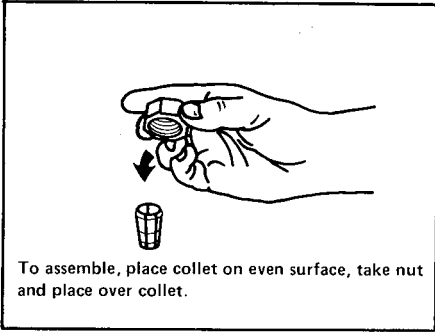
NO. 5680 2 H.P. Router starting with serial no. 608-2566

These routers use different chuck shanks, collet nuts and collets than the previous routers and these parts are not interchangeable with the parts on the older tools. For routers made before those with the above serial numbers, refer to Instruction Book No. 58-12-1320 - available from MILWAUKEE ELECTRIC TOOL CORP.

SERVICE DEPT.  
13135 W. Lisbon Road  
Brookfield, WI 53005

The collet must be attached to the collet nut before it is put into the chuck. Be sure that the size of the collet matches the size of the bit being used. If the wrong sized bit is used the collet may break. For attaching or detaching the collet nut to the collet, follow the illustrated instructions on the next page.

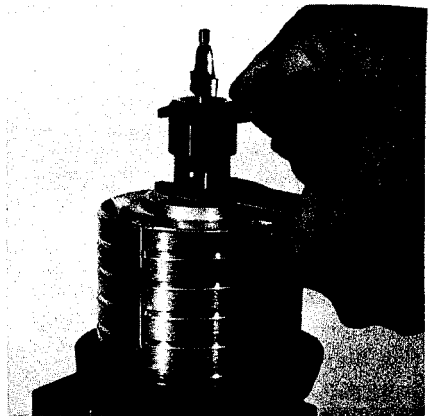
## ATTACHING COLLET TO COLLET NUT



## INSTALLING THE BIT

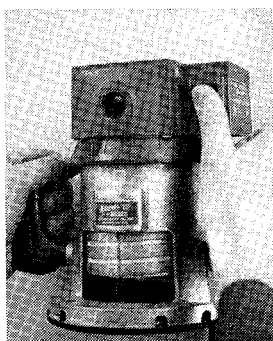
It is not necessary to remove the motor from the base to install a collet or a bit. If removal of the base is desired, simply loosen the locking knob on the side of the base assembly and remove the motor from the base. Always wipe wood chips, dust or other foreign materials from the chuck and collet before assembling.

Insert collet into chuck. Thread collet lock nut on chuck. Insert bit shank into collet as far as it will go and then back it out approximately 1/8" below the shoulder of the bit. To tighten the bit in the collet, set the router motor on its top, with chuck up. Slip the wrench on the chuck as shown in the illustration and tighten. **NEVER TIGHTEN COLLET LOCK NUT WITHOUT A BIT OF PROPER SIZE INSERTED.** To do so will cause possible breakage of the collet. Reverse this procedure when removing the bit. You will find this to be the easiest and safest way to install and remove bits.



## HOW TO ADJUST THE DEPTH OF CUT

Place the router on a flat wood surface and loosen the locking knob. Allow the motor to slide down until the bit just touches the surface of the wood. Tighten the locking knob. Rotate the depth adjustment ring counter-clockwise until the proper amount of bit will be exposed. Loosen the locking knob. Tip the router so the bit is away from the work and allow the adjustment ring to make contact with the base. Tighten the locking knob and the router is ready to be used. Each line on the depth adjustment ring equals  $1/64''$ . If you moved the adjustment ring 4 lines, the bit is exposed exactly  $1/16''$  below the base of the router. Always be sure adjustments are tightened before turning on the motor. **NEVER MAKE ADJUSTMENTS WHILE THE ROUTER IS RUNNING.**



## STARTING AND STOPPING THE ROUTER MOTOR

With a firm grip on the handles, extend your right thumb to the switch, push the top in to start. To stop the router, push the bottom of the switch in, place the router on its side so the bit is away from you and hold it until the bit stops turning.

## MAKING THE CUT

Before beginning the cut on the actual workpiece, it is advisable to take a sample cut on a scrap piece of lumber. This will show you exactly how the cut will look as well as enable you to check dimensions. Always be sure that the piece you are going to cut is rigidly held in position. When working on a bench, the workpiece should be held to the bench by means of wood clamps. When routing edges, the router should be held firmly down and against the work using both guiding handles.

Since the cutter rotates clockwise, more efficient cutting will be obtained if the router is moved from left to right as you stand facing the work. When working on the inside of a templet, move router in a clockwise direction. When working on the outside of a templet, move the router in a counterclockwise direction. The speed and depth of cut will depend largely on the type of material being worked on. Keep the cutting pressure constant but do not crowd the router so the motor speed slows excessively. It may be necessary on exceptionally hard woods or problem materials to make more than one pass at various settings to get the desired depth of cut.

The MILWAUKEE Electric Tool Corporation assumes no responsibility for any damage or accidents resulting from the use, misapplication, or nonadherence to safety precautionary measures.

## ROUTER GUIDE Cat. No. 49-54-0200

The router guide is useful for accurate straight or curved edge planning, parallel grooving, dadoing or slotting operations. To install, insert adjustment rods into front of router base and extend through to back side. Tighten lock screws from bottom of the base. A center cross line is located on the bottom of the base to establish cut setting.

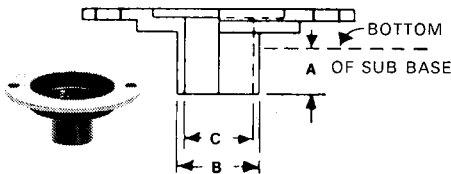
Supplied with the router guide is a trammel point assembly, Cat. No. 49-54-0210. To use, simply remove one of the adjustment rods from the router guide. Install in front of router base as described above. Slip trammel point onto rod and tighten set screw it hex wrench supplied. Determine radius of circle desired and set trammel point measuring from center of bit to trammel point. Set point into center of circle desired. Lift router from work surface and start motor. With both hands on handles, lower router bit into work surface. Rotate router around until circle is complete being careful not to lift trammel point from surface.



## TEMPLATE GUIDES

For use in pattern and template routing operations. To install, place guide over center hole in router base and align screw holes. Insert screws and tighten to base.

### GENERAL TEMPLATE GUIDES AND HINGE BUTT GUIDE For 1.00 H.P. and 1.50 H.P. Routers (Includes 2 screws)



TEMPLATE	DIMENSIONS			CATALOG NUMBER
	A	B	C	
GENERAL	5/16	1/4	3/16	49-54-0500
GENERAL	3/16	3/8	5/16	49-54-0510
GENERAL	5/16	7/16	3/8	49-54-0520
GENERAL	3/16	5/8	9/16	49-54-0530
HINGE BUTT	7/16	5/8	9/16	49-54-0550

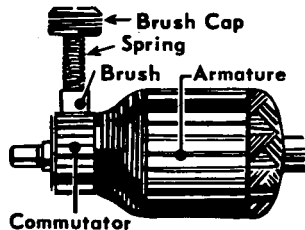
## MAINTENANCE

Keep the air passages clear by blowing them out at regular intervals. Clean, unclogged air passages assure a cool running motor and contribute to longer motor life. All servicing other than recommended in this instruction manual must be done by an Authorized MILWAUKEE Service Station.



## BRUSHES AND COMMUTATOR

Failure of the motor to start or to operate efficiently can usually be attributed to worn or damaged brushes, brushes sticking in the holders and failing to make proper contact with the commutator or to the commutator being dirty or rough. Frequent inspection of brushes and commutator is recommended.



To inspect the brushes, remove plug from power source. Unscrew brush retainer caps located on motor housing. Pull out brush retainer springs and brushes.

Replace brushes when worn down to 1/4". Always replace both brushes at the same time. When inspecting brushes, also check the commutator for wear. If worn badly, send the complete tool to an Authorized MILWAUKEE Service Station for under-cutting and dressing of the commutator.

## LUBRICATION

The precision sealed ball bearings used in your router are lubricated at the time of manufacture and require no further lubrication.

### USE ONLY IDENTICAL REPLACEMENT PARTS

Parts List Available On Request.

When ordering, include Catalog No. and Serial No. of Tool.

Write: MILWAUKEE ELECTRIC TOOL CORP. SERVICE DEPT.  
13135 W. Lisbon Rd. Brookfield, WI. 53005

## ACCESSORIES

See your MILWAUKEE catalog or MILWAUKEE dealer for bits, cutters and other MILWAUKEE router accessories.

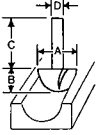
# HEAVY-DUTY ROUTER BITS

HIGHEST QUALITY  
FOR BEST PERFORMANCE AND LONG LIFE

MILWAUKEE ROUTER BITS are a select line, made from high-speed steel, carbide tipped and solid carbide steel. Each bit has been carefully evaluated and approved for routing applications with MILWAUKEE routers. Double-ground edges, consistent matching contours, high speed geometry and critical hardness control all add up to maximum accuracy and economy.

## CORE BOX BITS — TWO FLUTES

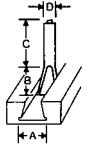
Especially effective in fluting flat surfaces (mantels and facades).



CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-0200	1/4	1/4	1	1/4
48-23-0210	3/8	1/4	1	1/4
48-23-0220	1/2	11/32	1	1/4
48-23-0230	5/8	3/8	1	1/4
48-23-0240	3/4	15/32	1	1/4

## DOVETAIL BITS

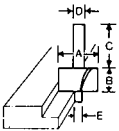
For making dovetail



CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-1310	9/16	17/32	1-3/32	1/4

## RABBETING BITS

With pilot For making rabbeting cuts without use of router guide. Carbide tip bit has replaceable ball bearing pilot.

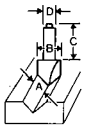


CATALOG NUMBER	RABBET DEPTH IN.	HIGH SPEED STEEL				
		A IN.	B IN.	C IN.	D IN.	E IN.
48-23-1400	1/4	11/16	7/16	1	1/4	3/16
48-23-1410	3/8	15/16	1/2	1	1/4	3/16

48-23-6400 3/8 1-1/4 1/2 1-1/2 1/4  
\*REPLACEMENT BALL BEARING 49-54-1060... By substituting Bearing 49-54-1070, rabbet depth can be increased to 1/2".

## V-GROOVING BITS

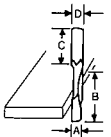
Excellent for lettering and sign work.



CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-0600	3/8	1/2	1	1/4
48-23-0610	7/8	1-1/8	1	1/4

## STAGGER TOOTH STRAIGHT BIT

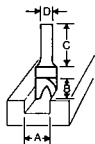
Excellent for cut outs. This design gives the bit two flute balance with single flute cutting speed.



CATALOG NUMBER	CARBIDE TIPPED			
	A IN.	B IN.	C IN.	D IN.
48-23-5143	1/2	2	1-5/8	1/2

## HINGE MORTISING BITS

Fast cutting bit for making mortises when cut is started from edge of work



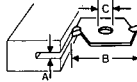
CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-1100	3/8	7/16	1-1/8	1/4
48-23-1120	1/2	3/4	1-5/16	1/4

CATALOG NUMBER	CARBIDE TIPPED			
	A IN.	B IN.	C IN.	D IN.
48-23-6100	1/2	3/4	1-7/32	1/4

## TWO WING SLOTTING CUTTERS

Used for slotting plywoods and core boards for "T" moldings.



CATALOG NUMBER	CARBIDE TIPPED		
	A IN.	B IN.	C IN.
48-23-8000	1/16	1-7/8	5/16
48-23-8020	3/32	1-7/8	5/16
48-23-8030	1/4	1-7/8	5/16

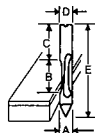
\*Stiffening Collars included with Slotting Cutters — two each for 1/16", 5/64" and 3/32" and one for 1/4".



NOTE  
USE ABOVE WITH  
SLOTTING CUTTER ARBOR  
Catalog No. 48-23-8050  
Includes 1/4" shank Slotting Cutter Arbor, Nut Washer and Bearing.  
Replacement Arbor Bearing No. 49-54-1080.

## COMBINATION PILOT PANEL BITS WITH DRILL POINTS — SINGLE FLUTE

For trimming veneer and for template panel routing.



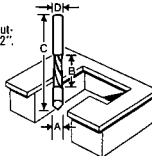
CATALOG NUMBER	HIGH SPEED STEEL				
	A IN.	B IN.	C IN.	D IN.	E IN.
48-23-1010	1/4	3/4	1	1/4	2-5/8
48-23-1015	3/8	7/8	1	3/8	3

CATALOG NUMBER	CARBIDE TIPPED				
	A IN.	B IN.	C IN.	D IN.	E IN.
48-23-6000	1/4	3/4	1-1/4	1/4	2-5/8
48-23-6020	3/8	7/8	1-1/4	3/8	2-7/8

## DOWN SPIRAL PILOT PANEL BITS WITH DRILL POINTS

For cutting aluminum sheet, plywood, wall panels, insulation sheeting and other synthetic materials.



CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-1020	1/4	3/4	2-5/8	1/4
48-23-1025	3/8	7/8	3-1/2	3/8
48-23-1030	1/2	1-3/4	4-1/2	1/2

## STRAIGHT BITS — TWO FLUTES

For all general purpose routing (rabbeting, grooving, dadoing, etc.) Smooth finish cuts. Use long shank bits where nature of cut requires longer shank extension

CATALOG NUMBER	HIGH SPEED STEEL			
	A IN.	B IN.	C IN.	D IN.
48-23-0050	1/4	5/8	1	1/4
48-23-0060	5/16	3/4	1-1/4	1/4
48-23-0070	3/8	3/4	1	1/4
48-23-0080	1/2	3/4	1	1/4
48-23-0085	9/16	1	1-1/4	1/4
48-23-0090	5/8	5/8	1	1/4
48-23-0100	3/4	5/8	1	1/4

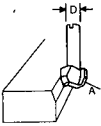
  

CATALOG NUMBER	CARBIDE TIPPED			
	A IN.	B IN.	C IN.	D IN.
48-23-5055	1/4	5/8	1	1/4
48-23-5056	1/4	7/8	1-1/4	1/4
48-23-5065	5/16	7/8	1-1/4	1/4
48-23-5070	3/8	1	1-1/2	1/4
48-23-5080	1/2	1	1-1/2	1/4
48-23-5141	1/2	1-1/4	1-3/8	1/2
48-23-5142	1/2	2	1-7/8	1/2
48-23-5090	5/8	3/4	1-1/4	1/4
48-23-5100	3/4	3/4	1-1/4	1/4
48-23-5150	3/4	3/4	1-3/8	1/2

**COMBINATION STRAIGHT AND 22° BEVEL TRIM BIT**

Combines 22° bevel trim and flush trim cuts in one bit.  
**CARBIDE TIPPED**

CATALOG NUMBER	A DEGREES	D IN.
48-23-6715	22	1/4

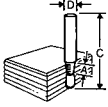


**7-1/2° BEVEL TRIMMER**

With pilot. For finish trim edge on plastic laminate doors, tables and furniture.

**SOLID CARBIDE**

CATALOG NUMBER	A DEGREES	C IN.	D IN.
48-23-5195	7-1/2	1-5/8	1/4

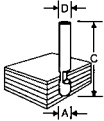


**FLUSH TRIM BIT**

With pilot. Produces square, flush edge on plastic laminates.

**SOLID CARBIDE**

CATALOG NUMBER	A IN.	C IN.	D IN.
48-23-5235	1/4	1-5/8	1/4



**PROVINCIAL DESIGN VEINER BITS**

Most practical for veining designs on panels, cabinet doors and furniture.

**SOLID CARBIDE**

CATALOG NUMBER	A IN.	C IN.	D IN.
48-23-5295	1/8	1-1/2	1/4
48-23-5300	3/16	1-1/2	1/4



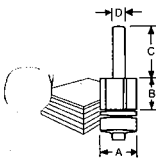
**HELIX LAMINATE TRIMMERS**

Designed to force the laminate against backing for chip free cuts—eliminates surface flake out. Replaceable ball bearing pilot.

**CARBIDE TIPPED**

CATALOG NUMBER	TYPE OF CUT	A IN.	B IN.	C IN.	D IN.
48-23-6700	Flush	3/4*	5/8	1	1/4"
48-23-6710	15°	3/4*	3/8	1	1/4

\*Replaceable Bearing 49-54-1050.



**CHAMFERING BITS—TWO FLUTES**

With pilot. For decorative edging and making concealed joints. Carbide tip bit has replaceable ball bearing pilot.

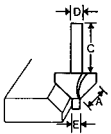
**HIGH SPEED STEEL**

CATALOG NUMBER	A IN.	C IN.	D IN.	E IN.
48-23-1200	1/2	1	1/4	3/16

**CARBIDE TIPPED**

48-23-6200	5/8	1	1/4	
------------	-----	---	-----	--

\* Replaceable Bearing 49-54-1090.



**CORNER ROUNDING BITS**

With pilot. For decorative edging and for drop leaf table joints. Carbide tip bits have replaceable ball bearing pilot.

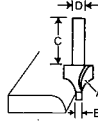
**HIGH SPEED STEEL**

CATALOG NUMBER	A IN. RADIUS	C IN.	D IN.	E IN.
48-23-0410	1/4	1	1/4	3/16
48-23-0430	3/8	1	1/4	3/16
48-23-0440	1/2	1	1/4	3/16

**CARBIDE TIPPED**

48-23-5410	1/4	1-1/8	1/4	*
48-23-5430	3/8	1-1/8	1/4	*

\* Replaceable Bearing 49-54-1060. Converts to Beading Bit by substituting Bearing No. 49-54-1070.

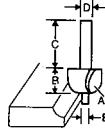


**COVE BITS—TWO FLUTES**

With pilot. For decorative edging and for drop leaf table joints.

**HIGH SPEED STEEL**

CATALOG NUMBER	A IN. RADIUS	B IN.	C IN.	D IN.	E IN.
48-23-0310	1/4	1/2	1	1/4	3/16
48-23-0320	3/8	5/8	1	1/4	3/16
48-23-0330	1/2	3/4	1	1/4	3/16

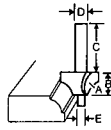


**BEADING BITS—TWO FLUTES**

With pilot. For decorative furniture. Pilot guides router along edge of work. Carbide tip bits have replaceable ball bearing pilot.

**HIGH SPEED STEEL**

CATALOG NUMBER	A IN. RADIUS	B IN.	C IN.	D IN.	E IN.
48-23-0500	1/16	3/16	1	1/4	3/16
48-23-0510	1/8	3/8	1	1/4	3/16
48-23-0520	1/4	1/2	1	1/4	3/16
48-23-0530	3/8	3/4	1	1/4	3/16



**CARBIDE TIPPED**

48-23-5520	1/4	1/2	1-1/8	1/4	*
48-23-5530	3/8	5/8	1-1/8	1/4	*

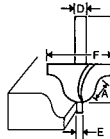
\* Replaceable Bearing 49-54-1070. Converts to Corner Rounding Bit by substituting Bearing 49-54-1080.

**ROMAN OGEE BITS**

With pilot. For decorative furniture. Pilot guides router along edge of work.

**HIGH SPEED STEEL**

CATALOG NUMBER	A IN.	B IN.	C IN.	D IN.	E IN.	F IN.
48-23-0800	5/32	1/2	1	1/4	3/16	15/16
48-23-0810	1/4	3/4	1	1/4	3/16	1-3/16

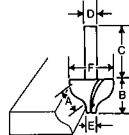


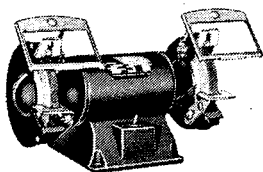
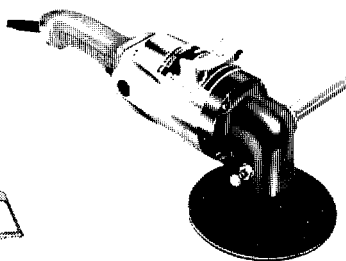
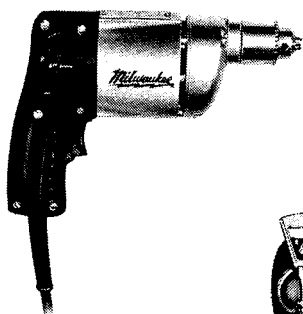
**OGEE BITS**

For decorative cuts. Clamp straight edge or template on the work and use as a guide for the outside edge of router base.

**HIGH SPEED STEEL**

CATALOG NUMBER	A IN.	B IN.	C IN.	D IN.	E IN.	F IN.
48-23-0900	3/16	5/8	1	1/4	3/16	13/16
48-23-0910	9/32	29/32	1	1/4	3/16	1-3/16

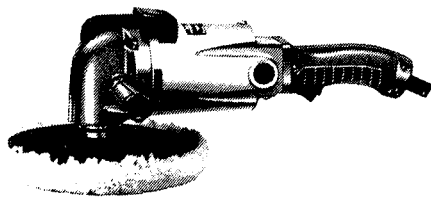
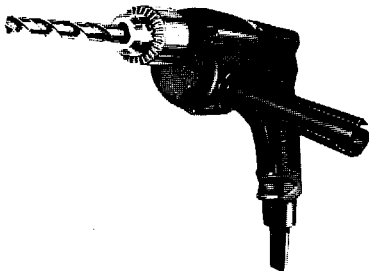
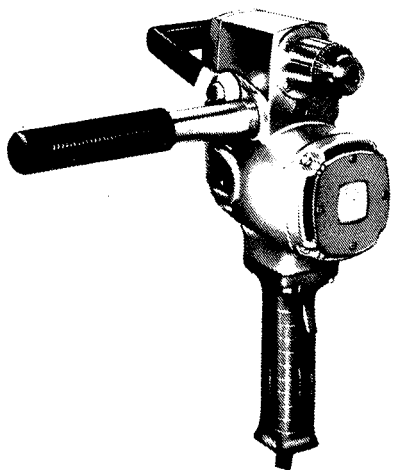




## LIMITED WARRANTY

Every MILWAUKEE Tool is thoroughly inspected and tested before leaving the factory. Should any trouble develop, return the complete tool prepaid to the Factory, Branch or nearest Authorized MILWAUKEE Service Station. If inspection shows the trouble is caused by defective workmanship or material, all repairs will be made without charge and the tool will be returned transportation prepaid.

This warranty does not apply where: (1) repairs or attempted repairs have been made by persons other than Factory, Branch or Authorized Service Station personnel; (2) repairs are required because of normal wear; (3) the tool has been abused or involved in an accident; (4) misuse is evident such as caused by overloading the tool beyond its rated capacity; (5) the tool has been used after partial failure or (6) the tool has been used with an improper accessory. No other warranty written or verbal, is authorized.



**MILWAUKEE ELECTRIC TOOL CORPORATION**

13135 W. LISBON ROAD      BROOKFIELD, WISCONSIN 53005