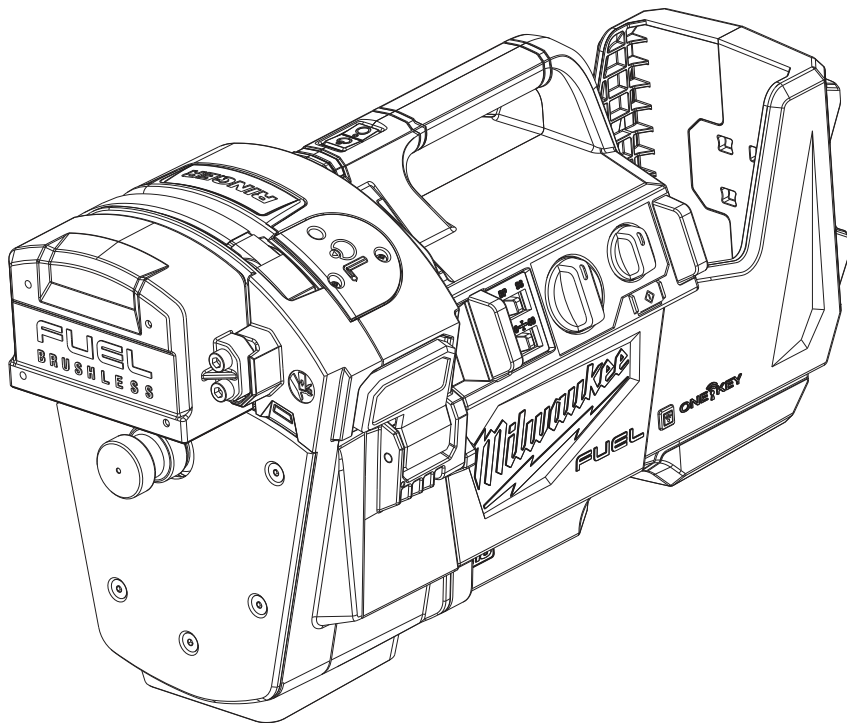




SERVICE PARTS LIST

BULLETIN NO.
PN0005272

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18 FUEL™ RINGER™ Roll Groover for 1-1/4"-4" SCH 10/40, 6" SCH 10			June 2025
CATALOG NO. 2927-20	SERIAL NO. P72A	WIRING INSTRUCTION See Page 4	



TORQUE SPECIFICATIONS 2

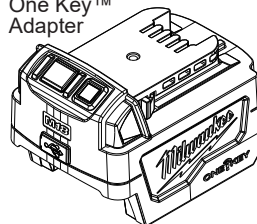
SERVICE PARTS EXPLODED VIEW 2-3

SERVICE WIRING DIAGRAM 4

LUBRICATION INSTRUCTIONS 5

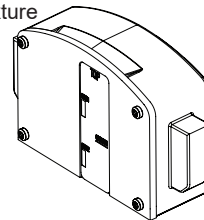
SERVICE TOOLS / FIXTURES

One Key™
Adapter



2800-20

Calibration
Fixture



61-60-1029

Only maintenance, service, repairs, and replacements of parts as defined in the Operator's Manual can be performed by the user.

All other repairs are to ONLY be performed by personnel authorized by MILWAUKEE TOOL. Do not attempt to install other parts; this COULD void your tool warranty.

For service, parts, or inquiries, contact us:

- Customer Service at 1.800.SAWDUST (1.800.729.3878)
- E-Service tool repair at: www.milwaukeetool.com/e-service
- Find a local authorized MILWAUKEE service location at Milwaukeetool.com
- Find a MILWAUKEE factory Service Center Location or MILWAUKEE factory Central Repair Center at Milwaukeetool.com. Send the following, prepaid and insured:
 - Your name, address, and phone number
 - Description of the issues
 - Copy of the proof of purchase
 - Tool, charger, and batteries involved with the issues

MILWAUKEE factory Central Repair Centers:

MILWAUKEE TOOL
Central Repair
1401 Sycamore Avenue
Greenwood, MS 38930

MILWAUKEE TOOL
Central Repair
2198 Southtech Drive
Greenwood, IN 46143

2927-20 Interior Housing & Gearcase Assemblies

EXAMPLE:
 00 0 Component Parts (Small #)
 Are Included When Ordering
 The Assembly (Large #).

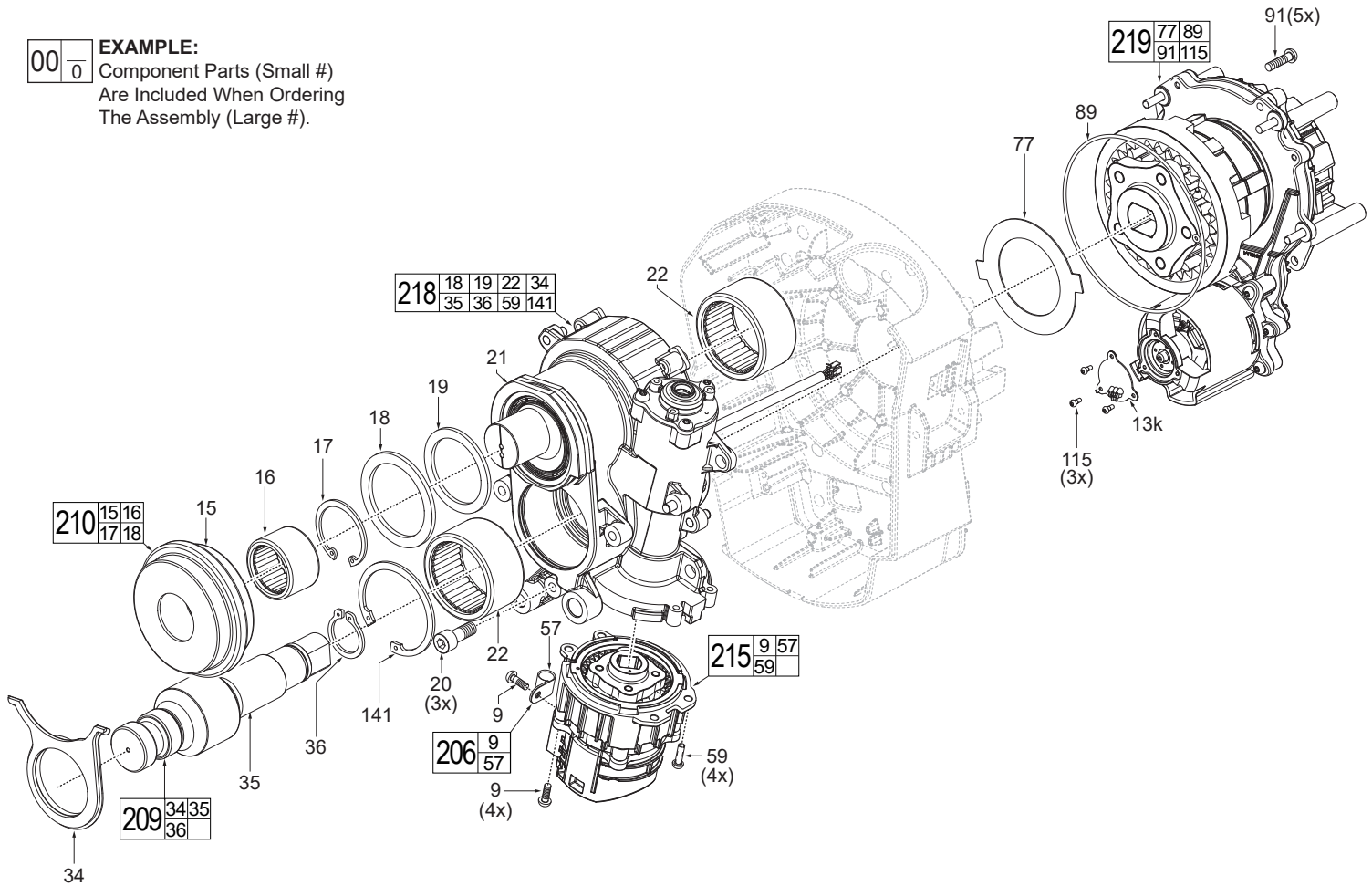


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
9	05-88-1206	M4 x 12mm Pan Hd. T-20 Screw	(5)
13k	-----	Roller Hall Board	(1)
15	-----	Male Roller	(1)
16	-----	Needle Bearing	(1)
17	44-90-8990	C-Ring	(1)
18	05-90-0740	Interior Housing Washer	(1)
19	32-90-0120	Worm Gear Seal	(1)
20	06-82-9672	M8 x 20mm Hex Recess Screw	(3)
21	-----	Interior Housing	(1)
22	02-50-3275	Needle Bearing	(2)
34	31-12-0730	Dust Prevention Rubber	(1)
35	-----	Roller Shaft	(1)
36	34-60-2605	External Bevel Retaining Ring	(1)
57	-----	Wire Clip	(1)
59	05-74-0078	M4 x .7 Pan-Hd. T-20 Screw	(4)
77	31-50-2215	Rear Housing Washer	(1)
89	34-40-3315	Movement Enclosure O-Ring	(1)
91	05-78-0033	M5 x 21mm Machine Screw	(5)
115	-----	M2.5 x 1.058 Pan Head T-8 Screw	(3)
141	-----	Retaining Ring	(1)
206	14-20-5997	Wire Routing Clip Kit	(1)
209	14-20-5995	Movement Roller Kit	(1)
210	14-38-0595	Groover Assembly	(1)
215	14-38-0597	Grooving Gearcase Assembly	(1)
218	14-38-0594	Interior Housing Assembly	(1)
219	14-38-0596	Movement Gearcase Assembly	(1)

SCREW TORQUE SPECIFICATIONS				
FIG.	PART NO.	WHERE USED	SEAT TORQUE	
			(kgf-cm)	(lb-in)
1	05-74-1110	Groover Cover	80±5	69±4
9	05-88-1206	Folding Handle	18±1.8	16±1.6
		Wire Routing Clip	15±1.5	13±1.3
		Grooving Gearcase	18±1.8	16±1.6
		Wire Routing Clip	10±1	9±1
10	05-74-1115	Wear Plate	30±4.5	26±3.9
12	05-81-0132	Front Housing	100±6	87±5
14	05-74-1120	Folding Handle	8±0.8	6±0.6
		Wire Routing Clip	10±1	9±1
20	06-82-9672	Interior Housing	160±10	139±9
30	05-78-0032	Rear Housing	100±6	87±5
59	05-74-0078	Grooving Gearcase	15±1.5	13±1.3
71	06-82-2872	Bump Stop Switch	1.5±0.2	1.3±0.2
91	05-78-0033	Handle	30±4.5	26±3.9
		Movement Gearcase	30±4.5	26±3.9
115	-----	PCBA Assembly	3.5±0.4	3±0.3
		Movement Gearcase	3.5±0.4	3±0.3
117	05-74-1125	Tool Foot	15±1.5	13±1.3
118	06-82-0029	Handle Housing	30±4.5	26±3.9
121	06-82-1080	Bump Switch	5±0.5	4±0.4
124	-----	UI Kit	8±0.8	7±0.7
125	-----	Switch Plate	8±0.8	7±0.7
139	-----	One-Key Door Assy.	5±0.5	4±0.4

2927-20 Electronics & Housing Assemblies

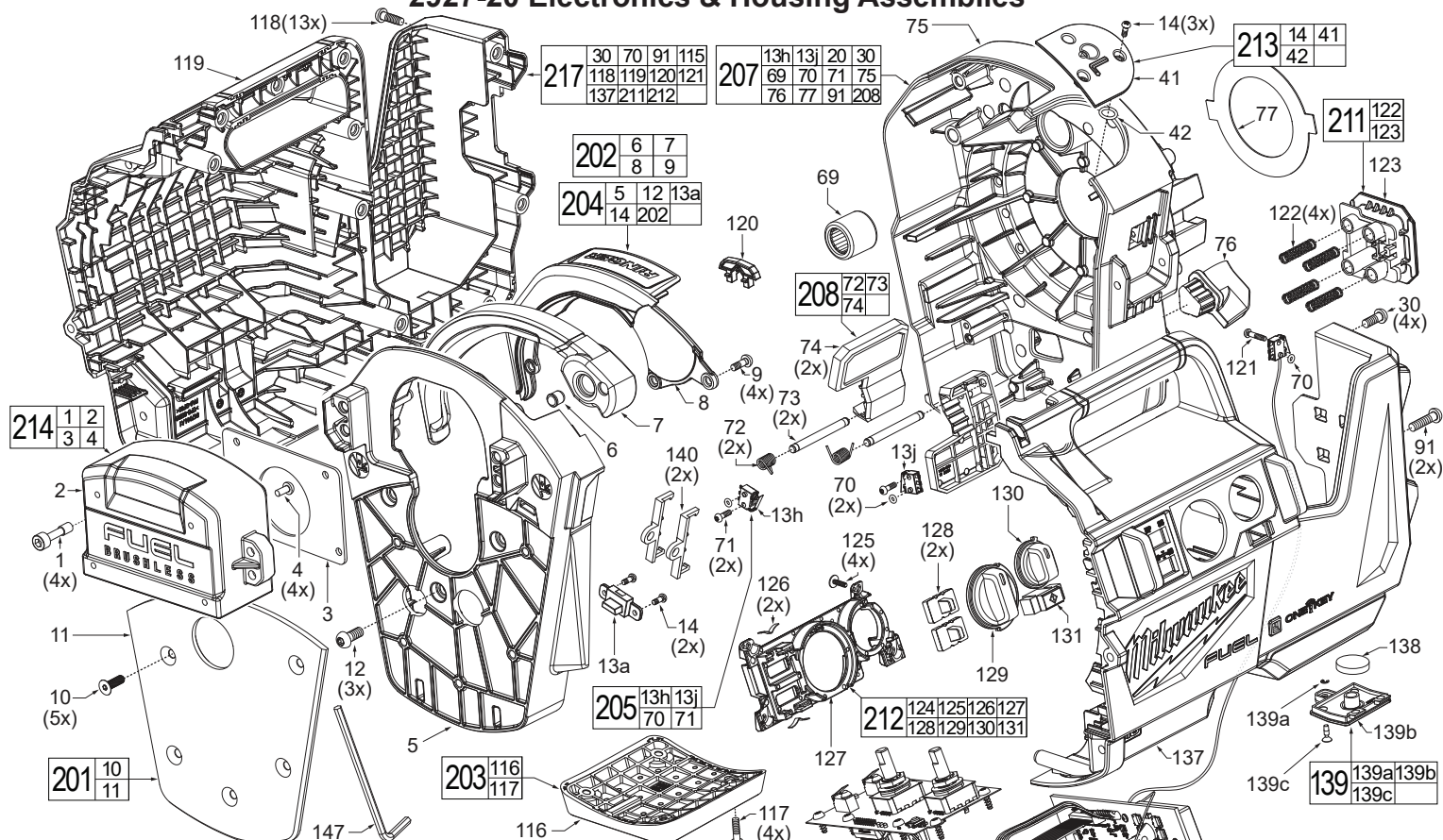
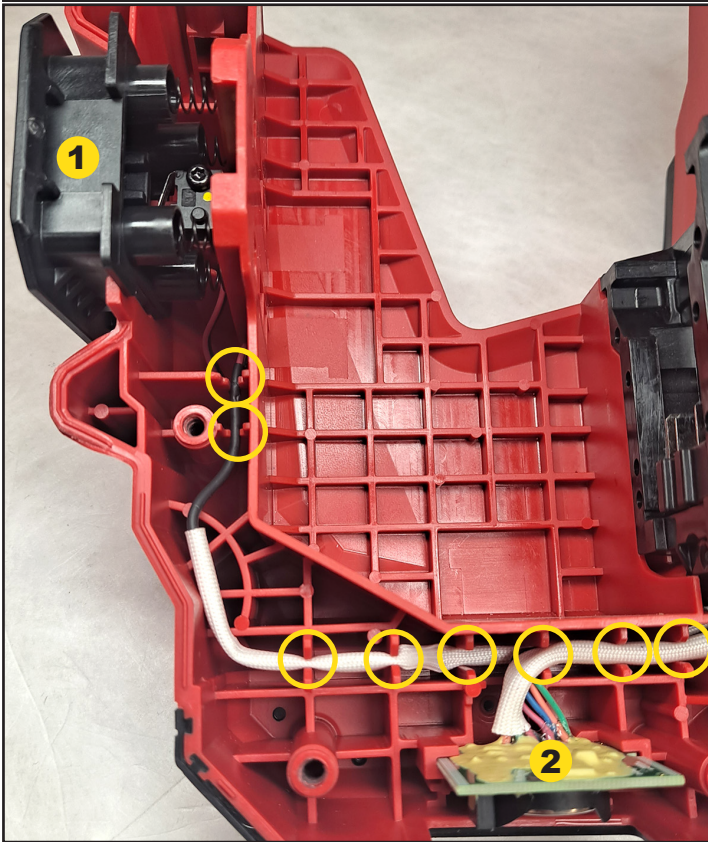


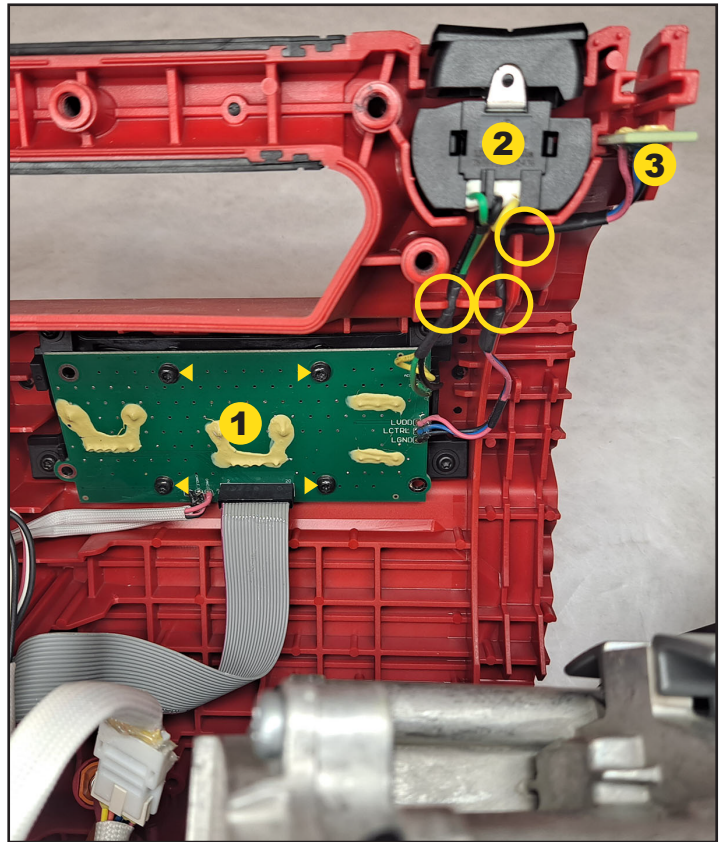
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-74-1110	M6 x 1 T-30 Machine Screw	(4)
2	-----	Groover Cover	(1)
3	14-46-2315	Male Roller Washer	(1)
4	05-81-1030	Pan Hd. Screw	(4)
5	-----	Front Housing	(1)
6	-----	Ball Spring Plunger	(1)
7	-----	Folding Handle	(1)
8	-----	Front Housing Top Handle Cover	(1)
9	-----	M4 x 12mm Pan Hd. T-20 Screw	(4)
10	05-74-1115	M5 x .8-16 Inner Hex Flat Hd. Screw	(5)
11	-----	Pipe Wear Plate	(1)
12	05-81-0132	M6 x 1 Pan Hd. T-30 Screw	(3)
13a	-----	Work Light	(1)
13b	-----	Battery Terminal	(1)
13h	-----	Bump Switch	(1)
13j	-----	Bump Switch	(1)
14	05-74-1120	M3 x .5 Pan Hd. Philips Screw	(5)
20	06-82-9672	M8 x 20mm Hex Recess Screw	(3)
30	05-78-0032	M5 x 13mm Machine Screw	(4)
41	-----	Manual Release Cover	(1)
42	-----	Needle Bearing Holder O-Ring	(1)
69	-----	Needle Bearing	(1)
70	34-40-0089	Trigger Switch O-Ring	(3)
71	06-82-2872	M3 x 10mm Pan Hd. T-10 Screw	(2)
72	-----	Torsion Spring	(2)
73	-----	Bump Stop Pin	(2)
74	-----	Side Bump Stop	(2)
75	-----	Rear Housing	(1)
76	23-94-7710	Wire Holder	(1)
77	31-50-2215	Rear Housing Washer	(1)
91	05-78-0033	M5 x 20mm Machine Screw	(2)
115	-----	M2.5 x 1.058 Pan Hd. T-8 Screw	(2)
116	-----	Front Foot	(1)
117	05-74-1125	M4 x .7 Pan Hd. T-20 Machine Screw	(4)
118	06-82-0029	M5 x 16mm Pan Hd. T-25 Screw	(13)
119	-----	Handle Cover	(1)
120	23-38-0185	LED Lens	(1)
121	06-82-1080	Pan Hd. Torx Single Thread Screw	(1)
122	40-50-8875	Spring	(4)
123	-----	Pause Button	(1)
124	-----	M3 x 1.058 Pan Hd. T-10 Screw	(4)
125	-----	M3 x 10mm T-10 Screw	(4)
126	-----	Switch Plate Spring	(2)
127	-----	Switch Holder	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
124	-----	UI Slider	(2)
125	-----	Size Selector Knob	(1)
126	-----	Gain Knob	(1)
127	-----	Button	(1)
128	05-78-0088	M3 x 1.058 Flat Hd. Philips #2 Screw	(4)
129	42-36-2835	Bracket	(1)
130	14-50-1060	Terminal	(1)
131	45-30-1060	Rubber Slug Isolator	(2)
132	45-30-1070	Rubber Wheel Isolator	(4)
133	-----	Handle Support & LED Lens Assy	(1)
134	-----	Coin Cell Battery (CR2032)	(1)
135	-----	- See local hardware store	
136	31-12-0735	One-Key Door Assembly	(1)
137	-----	C-Ring	(1)
138	-----	One-Key Door	(1)
139	-----	Drop Off Screw	(1)
139a	-----	Connector Clip	(2)
139b	-----	Hex Key	(1)
139c	-----	Service Nameplate (Not Shown)	(1)
140	14-20-5990	Wear Plate Kit	(1)
141	14-20-5991	Folding Handle Kit	(1)
142	14-20-5992	Tool Foot Kit	(1)
143	14-38-0592	Front Housing Assembly	(1)
144	14-20-5994	Bump Stop Switch Kit	(1)
145	14-20-5993	Rear Housing Assembly	(1)
146	14-38-0593	Bump Stop Paddle Kit	(1)
147	14-20-5996	Pause Button Kit	(1)
148	14-20-5999	UI Kit	(1)
149	14-20-6010	Manual Release Cover Kit	(1)
150	14-20-6005	Groover Cover Assembly	(1)
151	14-20-6000	PCBA Assembly	(1)
152	14-20-5998	Handle Kit	(1)

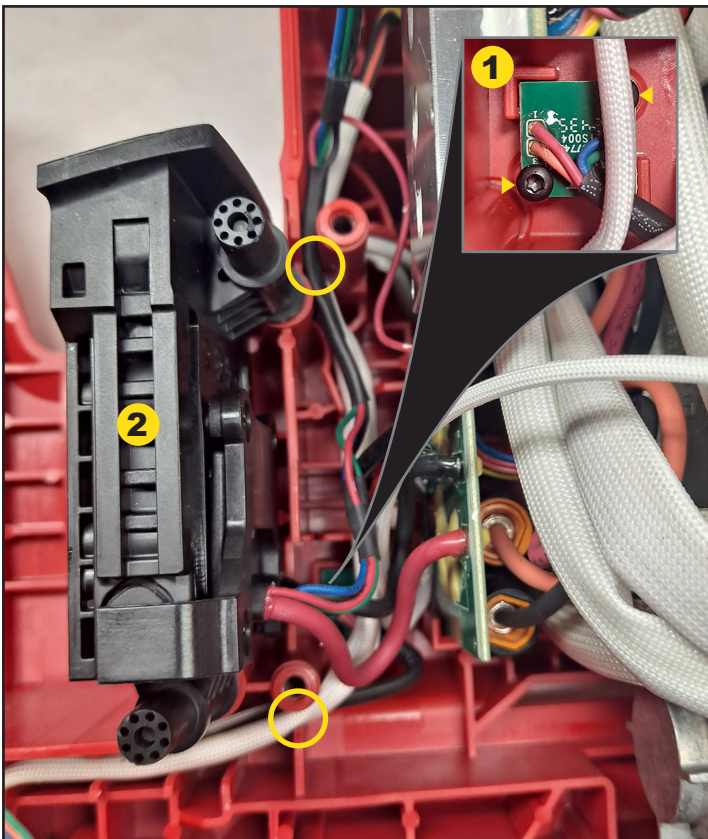
WIRING/ELECTRONICS ASSEMBLY



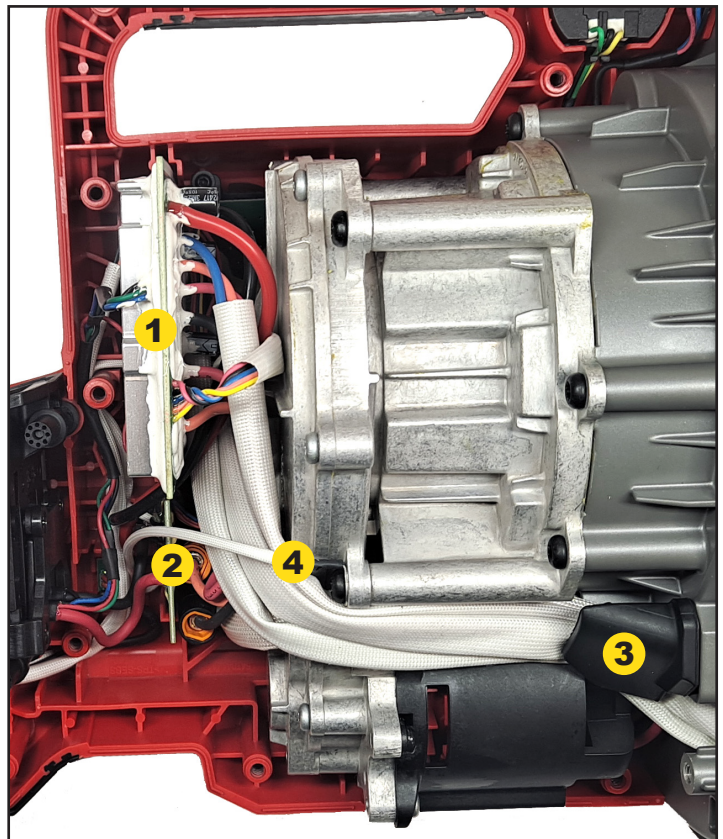
Be sure Pause Button **1** and One-Key Board **2** are firmly seated properly in housing support. Place wiring into traps as shown (circled above).



Fasten UI PCBA assembly **1** with four T-10 screws (fig.124). Place toggle button **2** and LED board **3** firmly into housing slots. Place wiring into traps as shown (circled above).



Place One-Key light board **1** into housing slots. Fasten with two T-8 screws (fig.115). Press battery terminal assembly **2** firmly into slots. Place wiring into traps as shown (circled above).



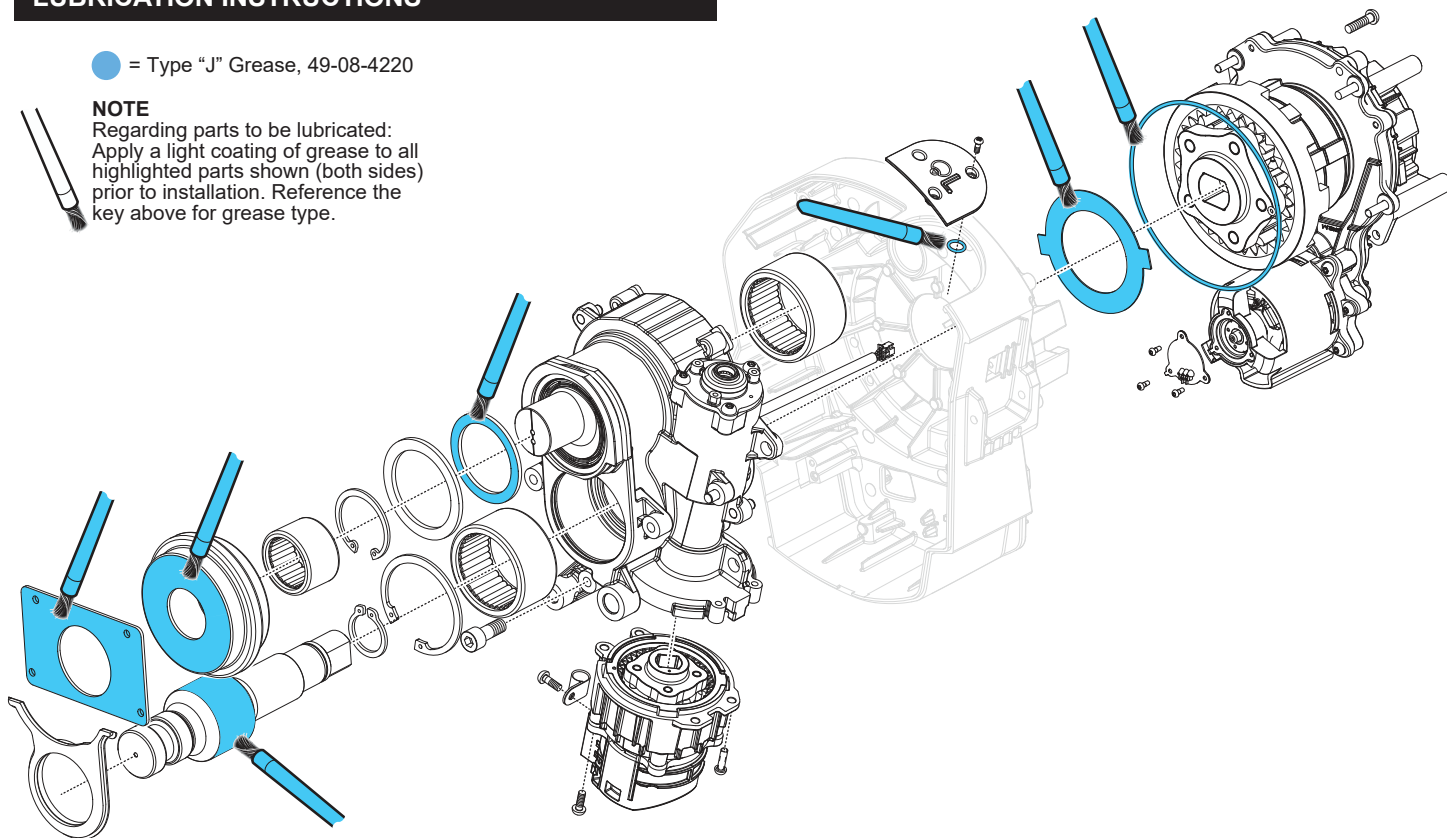
Press main PCBA **1** and secondary PCBA **2** boards firmly into slots. Place Wire Holder **3** in place to hold back braided wires. Attach ground wire **4** to gearcase as shown.

LUBRICATION INSTRUCTIONS

● = Type "J" Grease, 49-08-4220

NOTE

Regarding parts to be lubricated:
Apply a light coating of grease to all highlighted parts shown (both sides) prior to installation. Reference the key above for grease type.



NOTE:

Be sure to remove the plastic retaining sleeve from rear housing assembly before installing the interior housing.

