

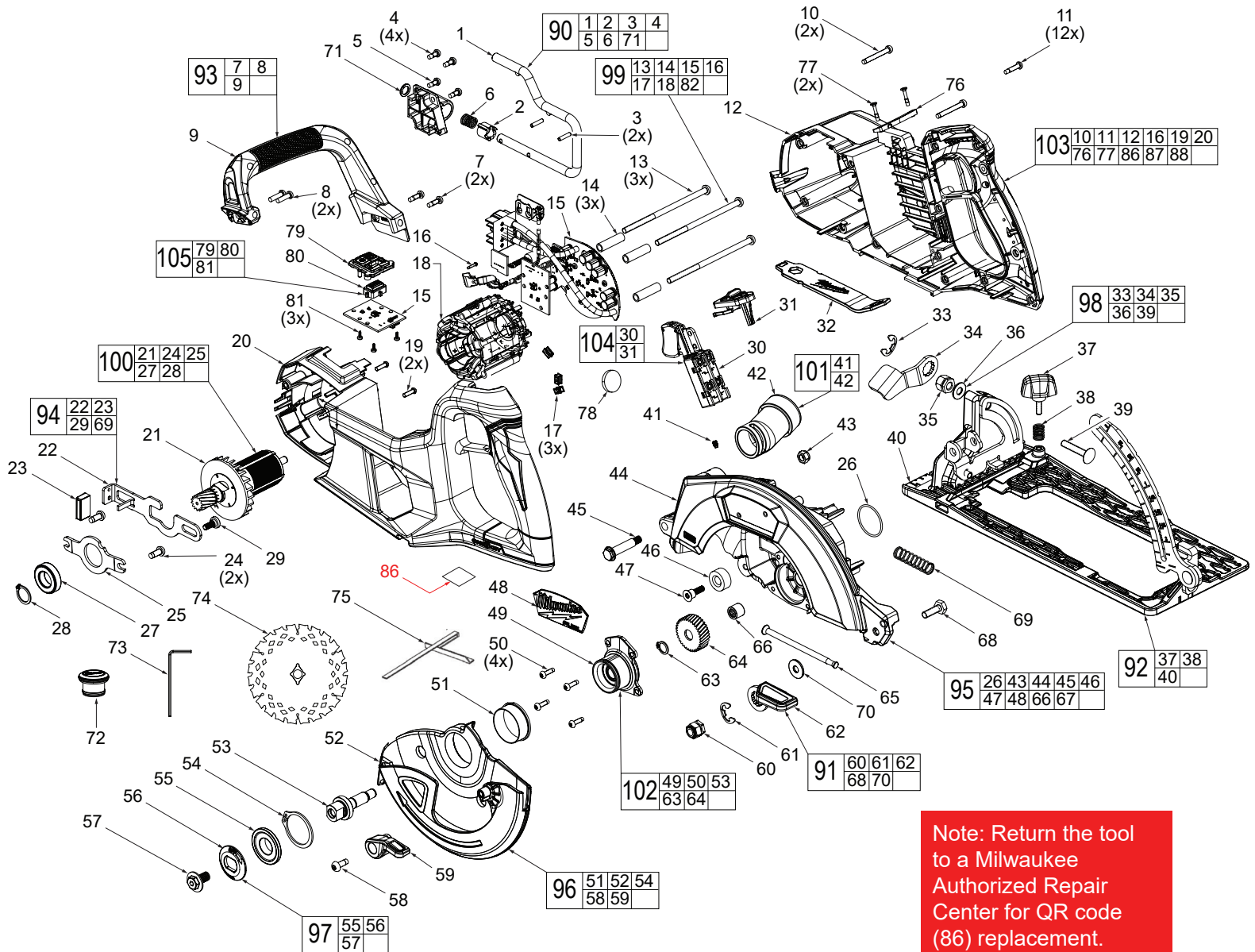


# SERVICE PARTS LIST

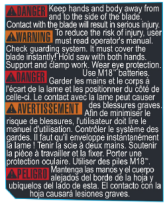
**BULLETIN NO.**  
**PN0008601**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>M18 FUEL™ One-Key™ Rear Handle Circular Saw (7-1/4")</b>			Feb. 2026
CATALOG NO.	2931-20	SERIAL NO.	R55A
		WIRING INSTRUCTION <b>See Page 5</b>	

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



**Note: Return the tool to a Milwaukee Authorized Repair Center for QR code (86) replacement.**



**DETAILED SERVICE BILL OF MATERIAL (BOM) ON PAGE 2**

## SERVICE BILL OF MATERIAL (BOM) LISTING

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	-----	Rafter Hook	(1)
2	-----	Detent Sleeve	(1)
3	-----	Spring Pin	(2)
4	05-88-1220	M4 x 10mm Steel PH Torx T-20 Screw	(4)
5	-----	Rafter Hook Base Plate	(1)
6	-----	Detent Spring	(1)
7	05-88-5375	M4 x 13.5mm PH Torx T-20 Screw	(2)
8	05-74-0986	M4 Screw	(2)
9	-----	Secondary Handle	(1)
10	05-74-0023	M4 x 32mm PH Torx T-20 Screw	(2)
11	-----	#6-19 Torx T-15 Screw	(12)
12	-----	Handle Cover	(1)
13	-----	M5 x 0.8 PH Torx T-25 Screw	(3)
14	-----	Spacer, Heat Sink	(3)
15	-----	PCB Assembly	(1)
16	45-88-0229	M2 x 0.635 PH Torx T-6 Screw	(1)
17	-----	Isolator	(3)
18	-----	Stator	(1)
19	05-78-1010	M3.5 x 0.6 PH Torx T-10 Screw	(2)
20	-----	Handle Support	(1)
21	-----	Rotor	(1)
22	-----	Spindle Lock	(1)
23	-----	Spindle Lock Lever Cover	(1)
24	05-74-1030	M5 x 0.8 PH Torx T-25 Screw	(2)
25	-----	Retaining Plate	(1)
26	02-02-0137	O-Ring	(1)
27	-----	Ball Bearing	(1)
28	-----	C-Ring	(1)
29	45-04-1224	Arbor Plate Screw	(1)
30	-----	Switch	(1)
31	-----	Lock Slider	(1)
32	45-88-9320	Blade Bolt Wrench	(1)
33	-----	Bowed E-Ring	(1)
34	-----	Bevel Adjust Level	(1)
35	-----	Hexagon Nut	(1)
36	-----	Washer, SPCC	(1)
37	43-30-5581	Rip Fence Knob	(1)
38	23-52-0100	Spring	(1)
39	-----	M6 x 1 Bevel Screw	(1)
40	-----	Shoe Assembly	(1)
41	-----	M4 Set Screw for Framer	(1)
42	-----	Dust Collection Outlet Nozzle	(1)
43	06-04-8412	Hexagon Nut M6 x 1	(1)
44	-----	Upper Guard Gearcase	(1)
45	06-14-0036	Pivot Shoulder Bolt	(1)
46	42-38-0224	Rubber Bumper	(1)
47	45-04-0485	M4 x 19mm PH Torx T-20 Screw	(1)
48	-----	Logo Plate w/ Adhesive	(1)
49	-----	Output Hub	(1)
50	06-82-5285	#6-32 PH Torx T-15 Screw	(4)
51	-----	Plastic Sleeve Ring	(1)
52	-----	Lower Guard	(1)
53	-----	Output Shaft	(1)
54	34-60-0177	Retaining Ring	(1)
55	-----	Inner Blade Flange	(1)
56	-----	Outer Blade Flange	(1)
57	-----	Blade Bolt	(1)
58	06-82-5314	#10-24 PH Torx T-25 Taptite Screw	(1)
59	-----	Lower Guard Lever	(1)
60	-----	Hexagon Nut	(1)
61	-----	E-Ring	(1)
62	-----	Depth Adjust Lever	(1)
63	-----	Snap Ring	(1)
64	-----	Gear – Crowning Version	(1)
65	49-68-5212	Spring	(1)
66	-----	Needle Bearing	(1)
68	05-85-0056	M6 x 19mm Hex Head Screw	(1)
69	-----	Spindle Lock Spring	(1)
70	-----	Washer	(1)
71	-----	Flat Washer Steel	(1)
72	06-67-4624	Dust Port Rubber Plug	(1)
73	45-96-6334	M2 Hex Wrench	(1)
74	48-40-0740	Blade	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
75	49-22-1005	Rip Fence	(1)
76	31-21-5540	Battery Cover	(1)
77	06-82-0248	M3 x 1.058 FH Phillips Screw	(2)
78	-----	Coin Cell Battery (CR2032) - See local hardware store	(1)
79	-----	VacLink ONE-KEY UI Panel	(1)
80	-----	Rubber – VacLink Button	(1)
81	05-88-0106	M2 x 0.89 PT Screw	(3)
86	10-15-9730	ID Label	(1)
87	12-20-0460	Service Nameplate	(1)
88	10-22-0000	Warning Label	(1)
90	14-36-5887	Rafter Hook Assembly	(1)
91	14-46-1233	Depth Adjust Kit	(1)
92	14-74-5227	Shoe Kit	(1)
93	14-46-1213	Secondary Handle Kit	(1)
94	14-46-9841	Spindle Lock Kit	(1)
95	14-32-8334	Upper Guard Assembly	(1)
96	14-32-8348	Lower Guard Assembly	(1)
97	43-34-6229	Blade Nut & Flange Kit	(1)
98	14-46-1219	Bevel Adjustment Kit	(1)
99	14-20-0000	Electronics Assembly	(1)
100	14-73-0001	Inner Rotor Assembly	(1)
101	14-46-1228	Dust Kit	(1)
102	14-73-9876	Output Shaft Assembly	(1)
103	14-34-0000	Handle Cover Kit	(1)
104	23-66-0120	Switch Kit	(1)
105	14-06-5078	UI Service Kit	(1)

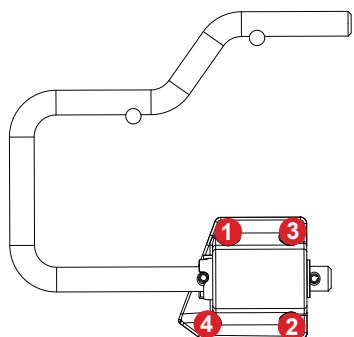
### FIG. NOTES

86-88 A clean, dry surface is essential for proper performance for any adhesive system. The area intended for application of any adhesive label or nameplate must be prepared by cleaning with isopropyl alcohol. The solvent is to be applied with a clean, lint free applicator and the surface allowed to dry before applying the label or nameplate.

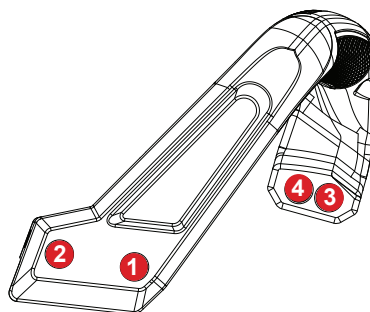
### SCREW TORQUE SPECIFICATIONS

FIG.	PART NO.	WHERE USED	SEAT TORQUE	
			(kgf-cm)	(lb-in)
4	05-88-1220	Rafter Hook Base Plate (5)	12 ± 1	10 ± 1
7	05-88-5375	Secondary Handle (9)	12 ± 1	10 ± 1
8	05-74-0986	Secondary Handle (9)	11 ± 1	9.5 ± 1
10	05-74-0023	Handle Cover (12)	15 ± 1	13 ± 1
NOTE – Screw driver speed is lower than 800RPM				
11	06-82-7470	Handle Cover (12)	13 ± 2	11 ± 1
13	-----	Stator (18)	18 ± 2	16 ± 1
16	45-88-0229	Stator (18)	2.5 ± 0.2	2.2 ± 0.2
19	05-78-1010	Handle Support (20)	10 ± 1	9 ± 1
24	05-74-1030	Rotor Retaining Plate (25)	30 ± 3	26 ± 3
29	45-04-1224	Spindle Lock (22)	21 ± 2	18 ± 2
35	-----	Shoe Assembly (40) – Bevel Adjustment	22 ± 1	19 ± 1
41	05-74-0143	Upper Guard Gearcase (44)	15 ± 1	13 ± 1
NOTE – Use corner screwdriver, only travel 4 rotations				
45	06-14-0036	Upper Guard Gearcase (44)	22 ± 2	19 ± 2
47	45-04-0485	Upper Guard Gearcase (44)	35 ± 3	30 ± 3
50	06-82-5285	Output Hub (49)	17 ± 3	15 ± 3
57	-----	Output Shaft (53)	10 ± 1	9 ± 1
58	06-82-5314	Lower Guard(52)	35 ± 3	30 ± 3
60	-----	Upper Guard Gearcase (44)	40 ± 4	35 ± 3
77	-----	Battery Cover (76)	4.5 ± 0.3	3.9 ± 0.3
81	05-88-0106	PCB Assembly (15)	2.4 ± 0.3	2.1 ± 0.3

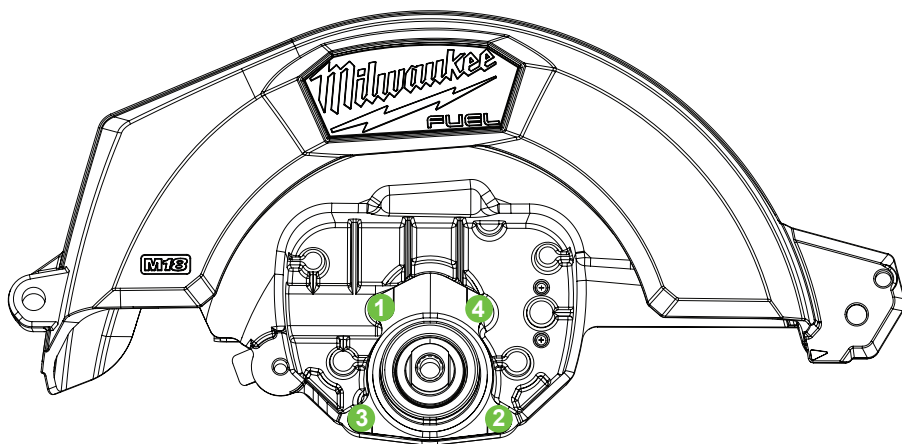
# HOUSING SCREWS - FASTENING ORDER



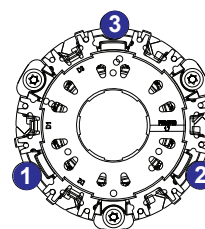
Rafter Hook (1)



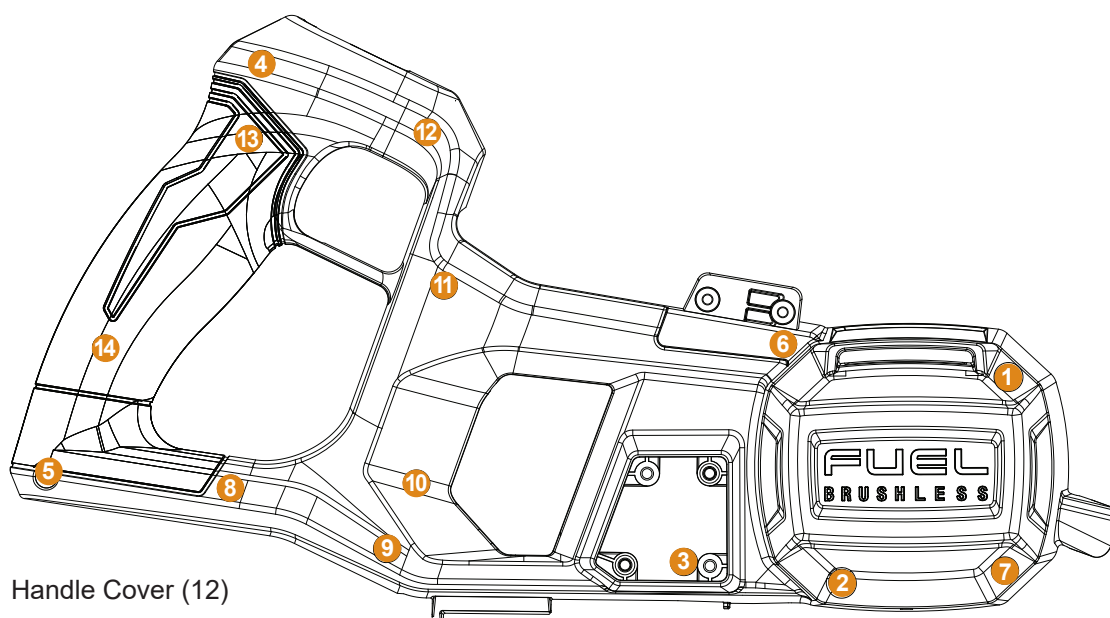
Secondary Handle (9)



Upper Guard Gearcase (44)

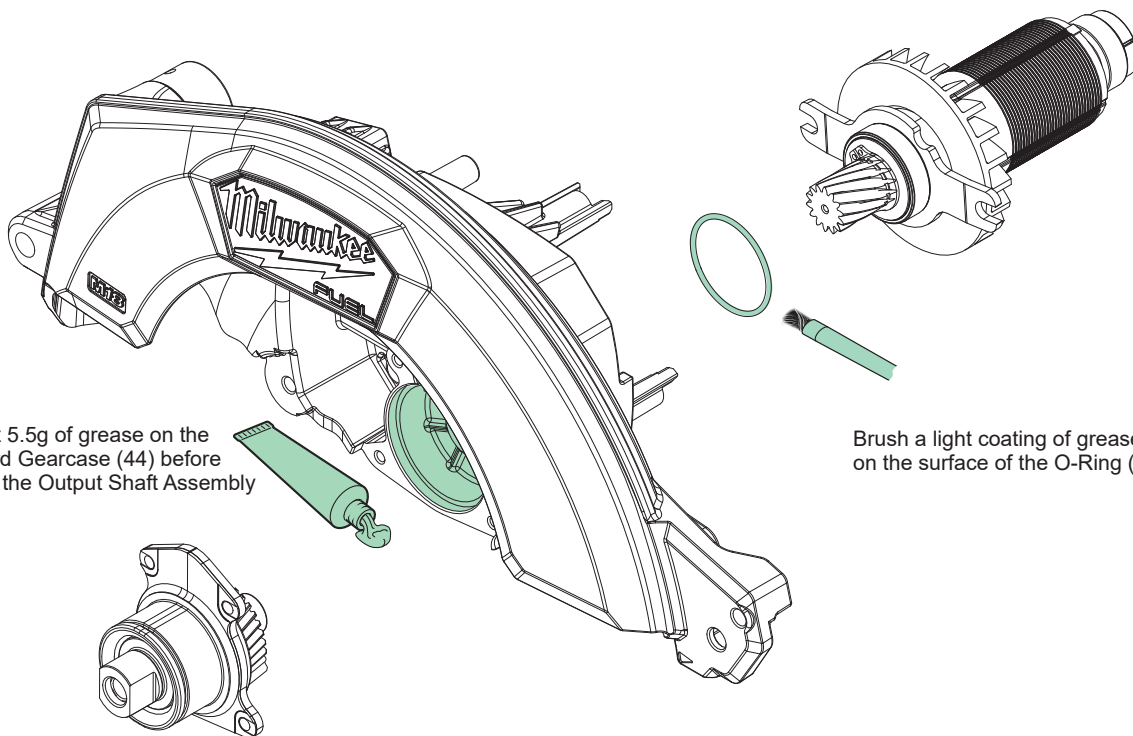


Stator (18)



Handle Cover (12)

## LUBRICATION INSTRUCTIONS



Apply about 5.5g of grease on the Upper Guard Gearcase (44) before assembling the Output Shaft Assembly

Brush a light coating of grease (about 0.05g) on the surface of the O-Ring (26)

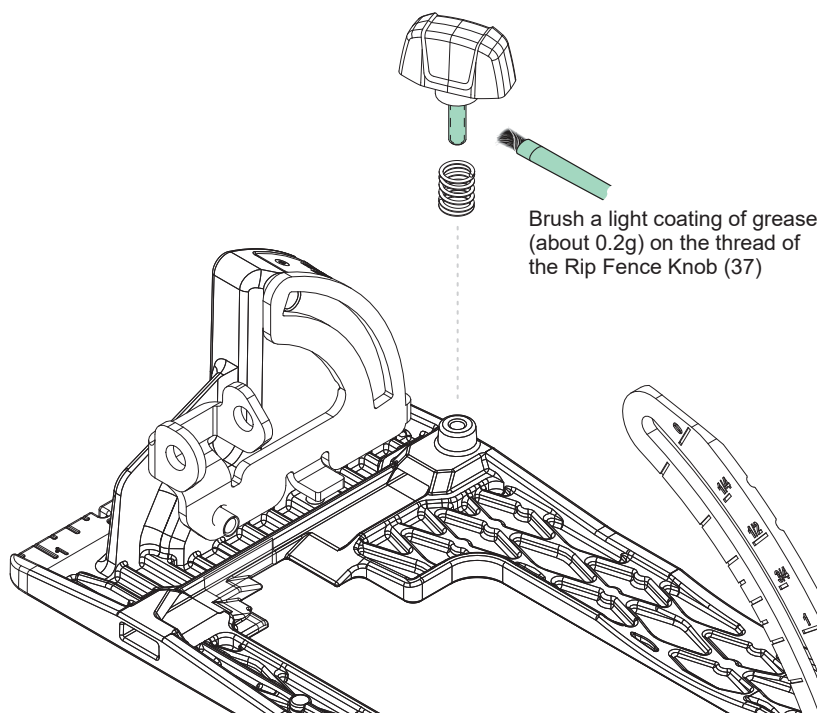
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### ► Type "J" Grease

**No. 49-08-4220, 1 lb can**

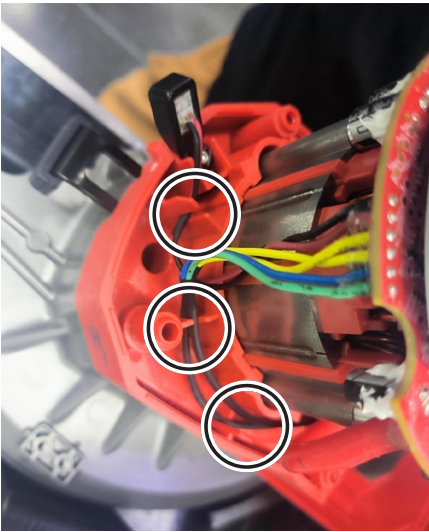
Apply thin coat of grease to areas indicated.

NOTE: When servicing, remove 90-95% of the existing grease prior to installing Type "J". Original grease may be similar in color but not compatible with "J".



Brush a light coating of grease (about 0.2g) on the thread of the Rip Fence Knob (37)

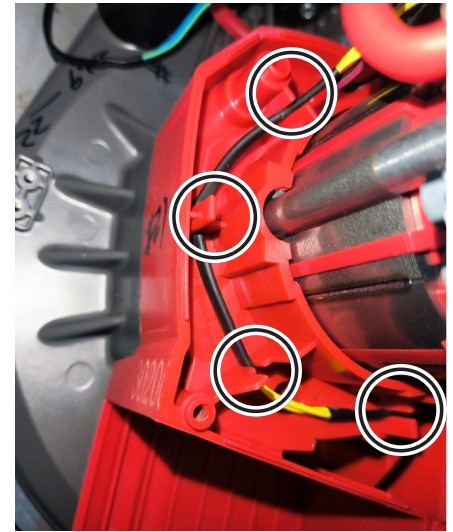
## WIRING INSTRUCTIONS



1) Press the **LED wire** into the housing traps and grooves.



2) Press the **switch wire** into the housing traps and grooves.



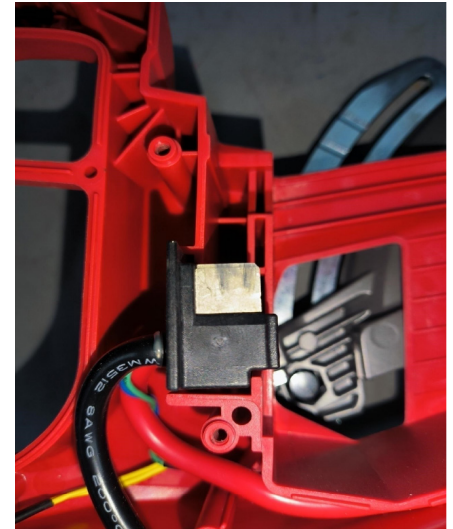
3) Press the **switch wire** into the housing traps and grooves around the stator.



4) Press the **colored wire** into the housing traps and grooves around the stator.



5) Press the **colored wire** into the housing traps and grooves as shown above.



6) Closeup of Battery Terminal Block and wires.



7) Press **red wire** into housing groove (on top of colored wires).



8) Press **black wire** into housing groove (on top of the red wire).

## WARNING

- Take notice of wire routing and position in wire guides and traps while dismantling tool.
- Be sure that all components of the electronics kit are seated firmly and squarely in housing recesses.
- Avoid pinched wires, be sure all wires and sleeves are pressed completely down in wire guides and traps.
- Prior to installing housing cover onto handle support, be sure that there are no interferences.
- Be sure to check for functionality of switches and buttons after housing halves have been secured.