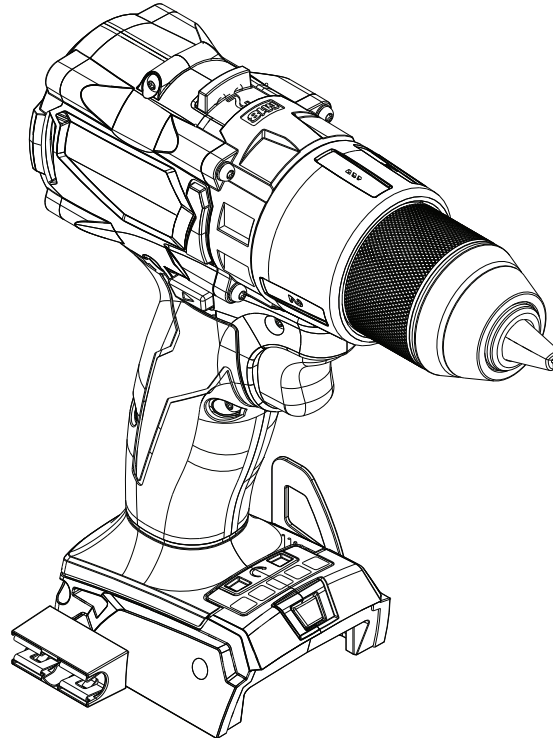




SERVICE PARTS LIST

BULLETIN NO.
54-00-2805

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | | REVISED BULLETIN | DATE |
|--|----------------|---------------------|-------------|--------------------|-----------|
| M18™ FUEL™ ONE KEY DRIVER-DRILL | | | | | Oct. 2019 |
| CATALOG NO. | 2805-20 | STARTING SERIAL NO. | J78A | WIRING INSTRUCTION | |



**Service for Milwaukee Tool ONE KEY Products
can only be performed at this
Milwaukee factory Central Repair Center:**

**MILWAUKEE TOOL Central Repair
1401 Sycamore Avenue • Greenwood, MS 38930-7277**

Please send your tool directly to this location for service.

Or

Via e-Service at: www.milwaukeetool.com/e-service
questions, please call 1.800.SAWDUST (1.800.729.3878)

Or

Return it to a MILWAUKEE *factory* Service Center location, freight prepaid and insured.
A copy of the proof of purchase should be included with the return product.

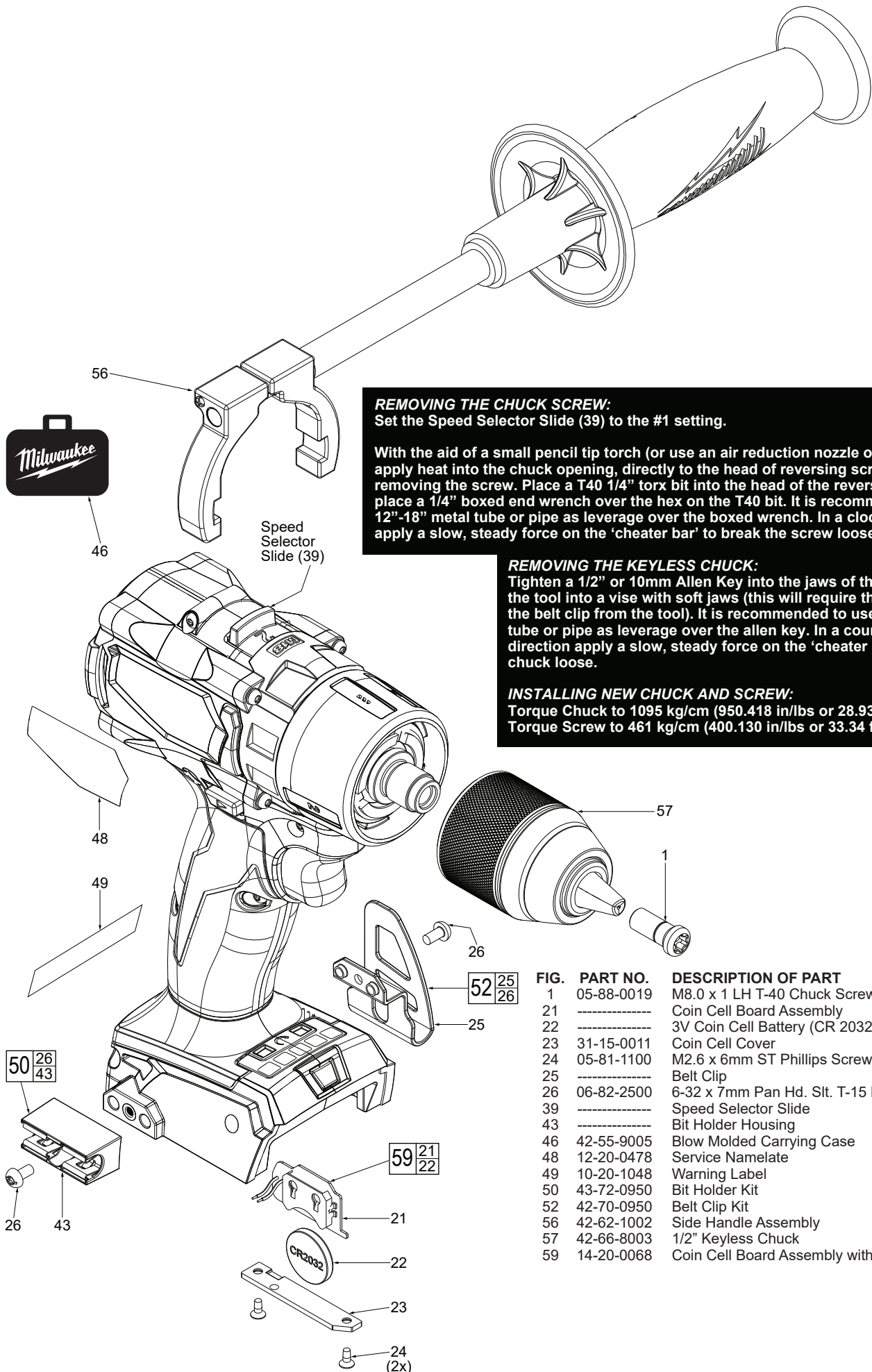
If you have questions please contact Milwaukee Product Service at:

Product Technical Support via phone at: 262.783.8642

Or

Via email at: METProductSupport@milwaukeetool.com

Disassembly is not recommended and could void the warranty.



REMOVING THE CHUCK SCREW:
Set the Speed Selector Slide (39) to the #1 setting.

With the aid of a small pencil tip torch (or use an air reduction nozzle on a heat gun) apply heat into the chuck opening, directly to the head of reversing screw just prior to removing the screw. Place a T40 1/4" torx bit into the head of the reversing screw and place a 1/4" boxed end wrench over the hex on the T40 bit. It is recommended to use a 12"-18" metal tube or pipe as leverage over the boxed wrench. In a clockwise direction apply a slow, steady force on the 'cheater bar' to break the screw loose.

REMOVING THE KEYLESS CHUCK:

Tighten a 1/2" or 10mm Allen Key into the jaws of the chuck. Place the tool into a vise with soft jaws (this will require that you remove the belt clip from the tool). It is recommended to use a 12"-18" metal tube or pipe as leverage over the allen key. In a counter-clockwise direction apply a slow, steady force on the 'cheater bar' to break the chuck loose.

INSTALLING NEW CHUCK AND SCREW:

Torque Chuck to 1095 kg/cm (950.418 in/lbs or 28.93 ft/lbs)
Torque Screw to 461 kg/cm (400.130 in/lbs or 33.34 ft/lbs)

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|--|----------|
| 1 | 05-88-0019 | M8.0 x 1 LH T-40 Chuck Screw | (1) |
| 21 | ----- | Coin Cell Board Assembly | (1) |
| 22 | ----- | 3V Coin Cell Battery (CR 2032) | (1) |
| 23 | 31-15-0011 | Coin Cell Cover | (1) |
| 24 | 05-81-1100 | M2.6 x 6mm ST Phillips Screw | (2) |
| 25 | ----- | Belt Clip | (1) |
| 26 | 06-82-2500 | 6-32 x 7mm Pan Hd. Sit. T-15 Mach. Screw | (2) |
| 39 | ----- | Speed Selector Slide | (1) |
| 43 | ----- | Bit Holder Housing | (1) |
| 46 | 42-55-9005 | Blow Molded Carrying Case | (1) |
| 48 | 12-20-0478 | Service Namelate | (1) |
| 49 | 10-20-1048 | Warning Label | (1) |
| 50 | 43-72-0950 | Bit Holder Kit | (1) |
| 52 | 42-70-0950 | Belt Clip Kit | (1) |
| 56 | 42-62-1002 | Side Handle Assembly | (1) |
| 57 | 42-66-8003 | 1/2" Keyless Chuck | (1) |
| 59 | 14-20-0068 | Coin Cell Board Assembly with Battery | (1) |