



# SERVICE PARTS LIST

**BULLETIN NO.**  
**55-24-5385**

<b>SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS</b>		REVISED BULLETIN	DATE
<b>3/4" (19mm) SDS ROTARY HAMMER</b>			May 2013
<b>CATALOG NO.</b>	<b>5385-59</b>	<b>SERIAL NUMBER</b>	<b>C36A</b>
			<b>WIRING INSTRUCTION</b> <b>See page 4</b>



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

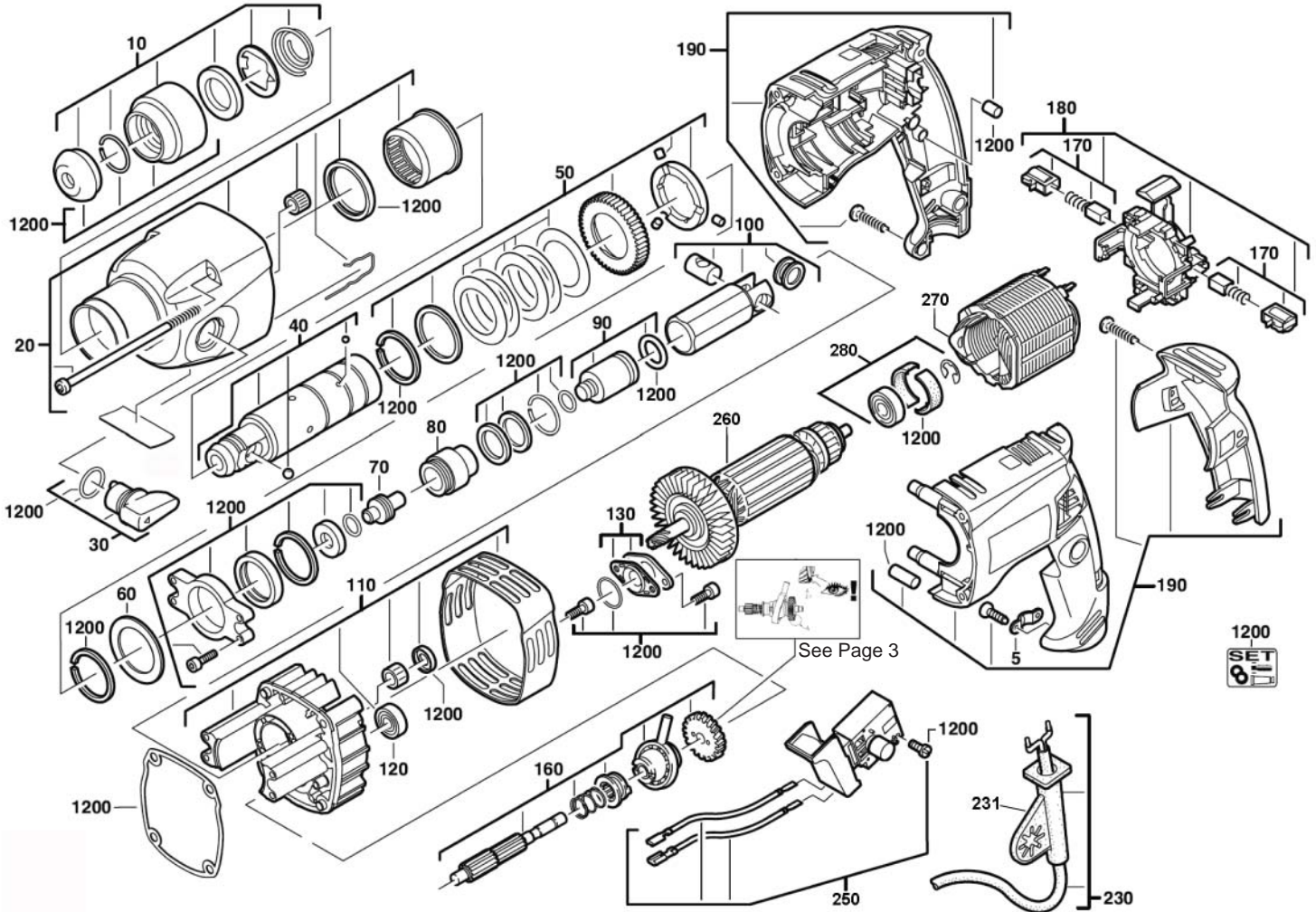


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
5	42-68-0601	Cord Clamp	(1)
10	44-20-5385	Bit Lock Assembly	(1)
20	14-30-5385	Gearcase Assembly	(1)
30	43-98-5385	Shift Knob Assembly	(1)
40	32-40-5385	Gear Assembly	(1)
50	42-70-5385	Gear and Clutch Assembly	(1)
60	45-88-5386	Steel Washer	(1)
70	45-56-5385	Hammer Striker	(1)
80	31-58-5385	Striker Sleeve	(1)
90	44-82-5385	Ram Assembly	(1)
100	14-12-5385	Cylinder Assembly	(1)
110	42-24-5385	Bearing Bracket Assembly	(1)
120	02-04-5385	Ball Bearing	(1)
130	42-24-5386	Bearing Cover Assembly	(1)
160	45-08-5385	Countershaft Assembly	(1)
170	-----	Carbon Brush and Tube (Set of 2)	(1)
180	44-90-5385	220V-240V Brush Card	(1)
190	31-44-5385	Handle Housing Assembly	(1)
230	22-64-5386	230V Power Cord	(1)
231	44-76-5385	Strain Relief	(1)
250	23-66-5385	220V-240V Switch	(1)
260	16-34-5385	Service Armature	(1)
270	18-34-5385	Service Field	(1)
280	14-46-5386	Bearing Kit	(1)
1200	14-46-5385	Maintenance Set	(1)

**SEE PAGES 2 & 3 OF THIS BULLETIN  
FOR ADDITIONAL SERVICE NOTES**

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
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Drwg. 3

## LUBRICATION NOTES:

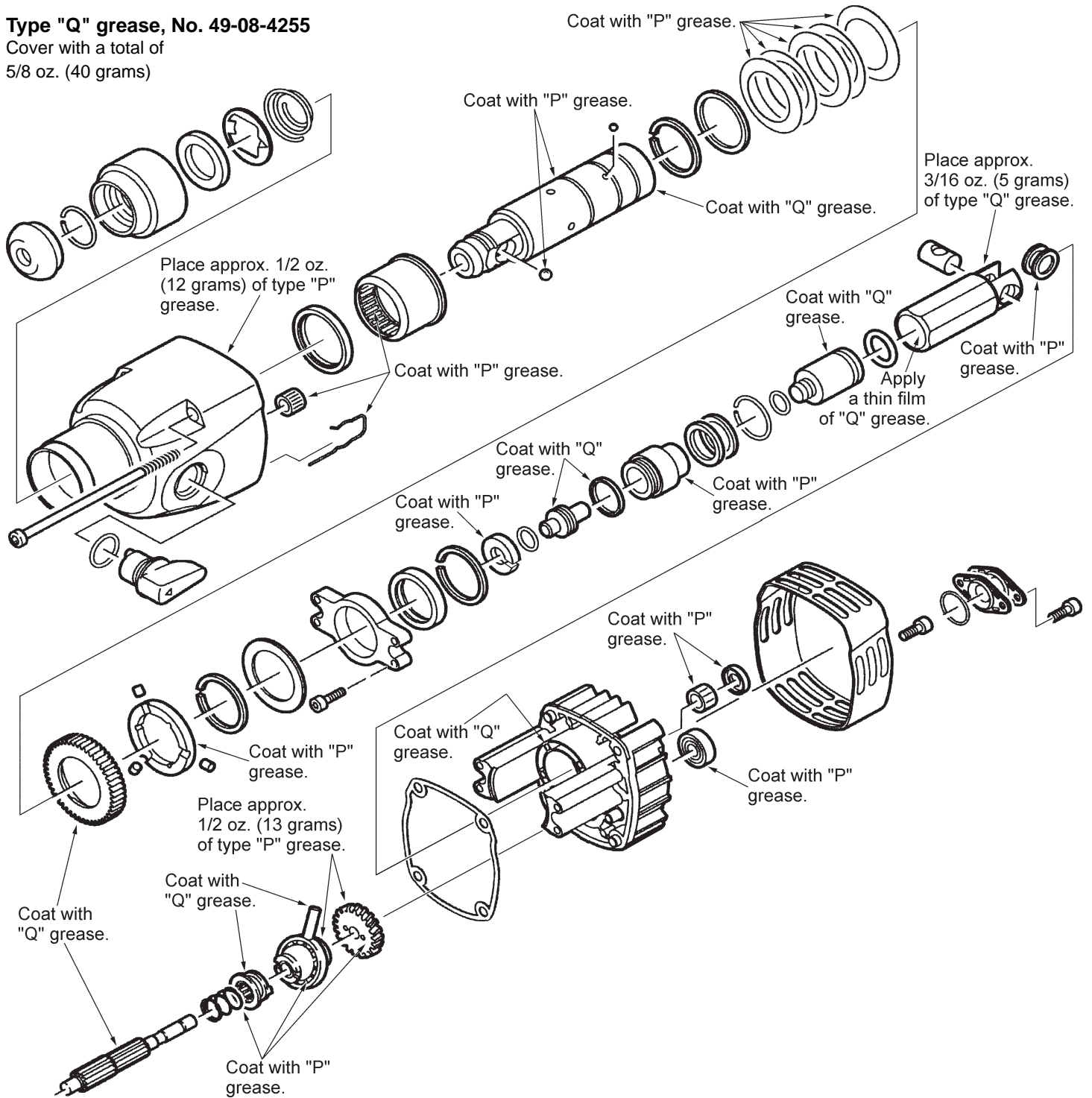
### Type "P" grease, No. 49-08-4250

Cover with a total of 1-5/8 oz. (40 grams)

### Type "Q" grease, No. 49-08-4255

Cover with a total of

5/8 oz. (40 grams)

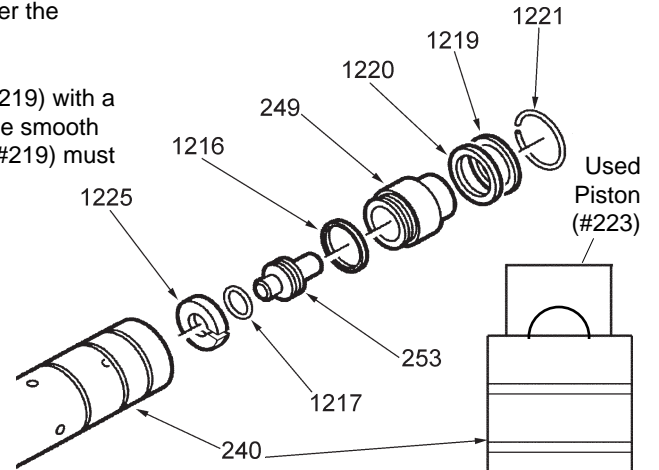
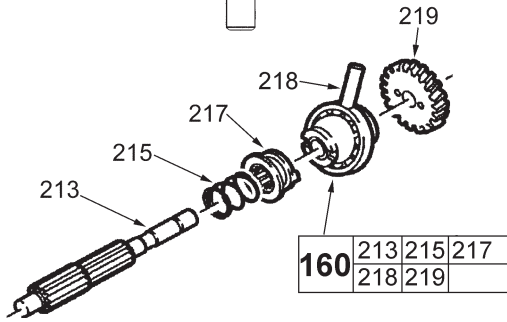
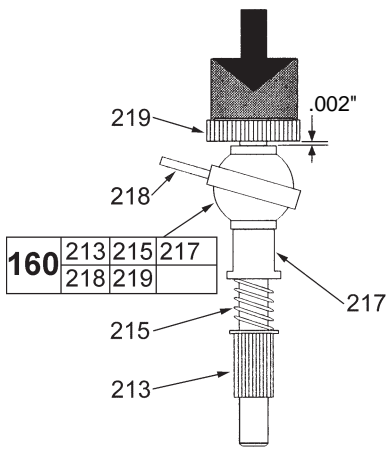


**SEE PAGE 3 OF THIS BULLETIN  
FOR ADDITIONAL SERVICE NOTES**

### ASSEMBLING THE WOBBLE ASSEMBLY

1. Push the Spring (#215) the Sleeve (#217) and the Wobble Plate (#218) over the Reduction Gear Shaft (#213).

2. Press on the Reduction Gear (#219) with a distance of .002", as shown. The smooth surface of the Reduction Gear (#219) must face the Wobble Plate (#218).

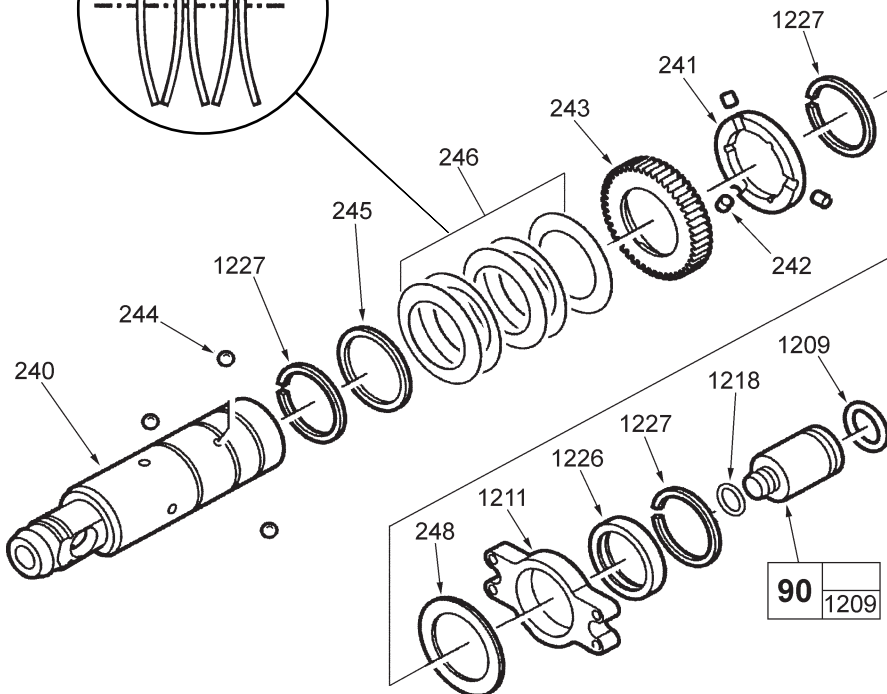
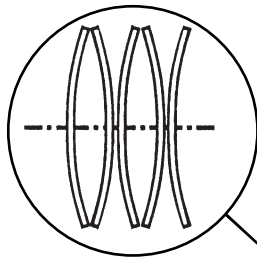


### SPINDLE ASSEMBLY (Inner Parts)

1. Insert the following parts into the Spindle (#240):

- Stop Washer (#1225)
- O-Ring (#1217)
- Striker (#253)
- O-Ring (#1216)
- Ram Catcher (#249)
- O-Ring (#1220)
- Washer (#1219)

2. Insert the External Snap Ring (#1221) into the Spindle (#240) with the aid of a used piston (#223), as shown, until the External Snap Ring (#1219) engages.



### SPINDLE ASSEMBLY (Outer Parts)

1. Assemble the following parts to the Spindle (#240):

- External Snap Ring (#1227)
- Damping Ring (#1226)
- Spindle Guide Plate (#1211)  
(With smooth side facing the Spindle)
- Washer (#248)
- External Snap Ring (#1227)

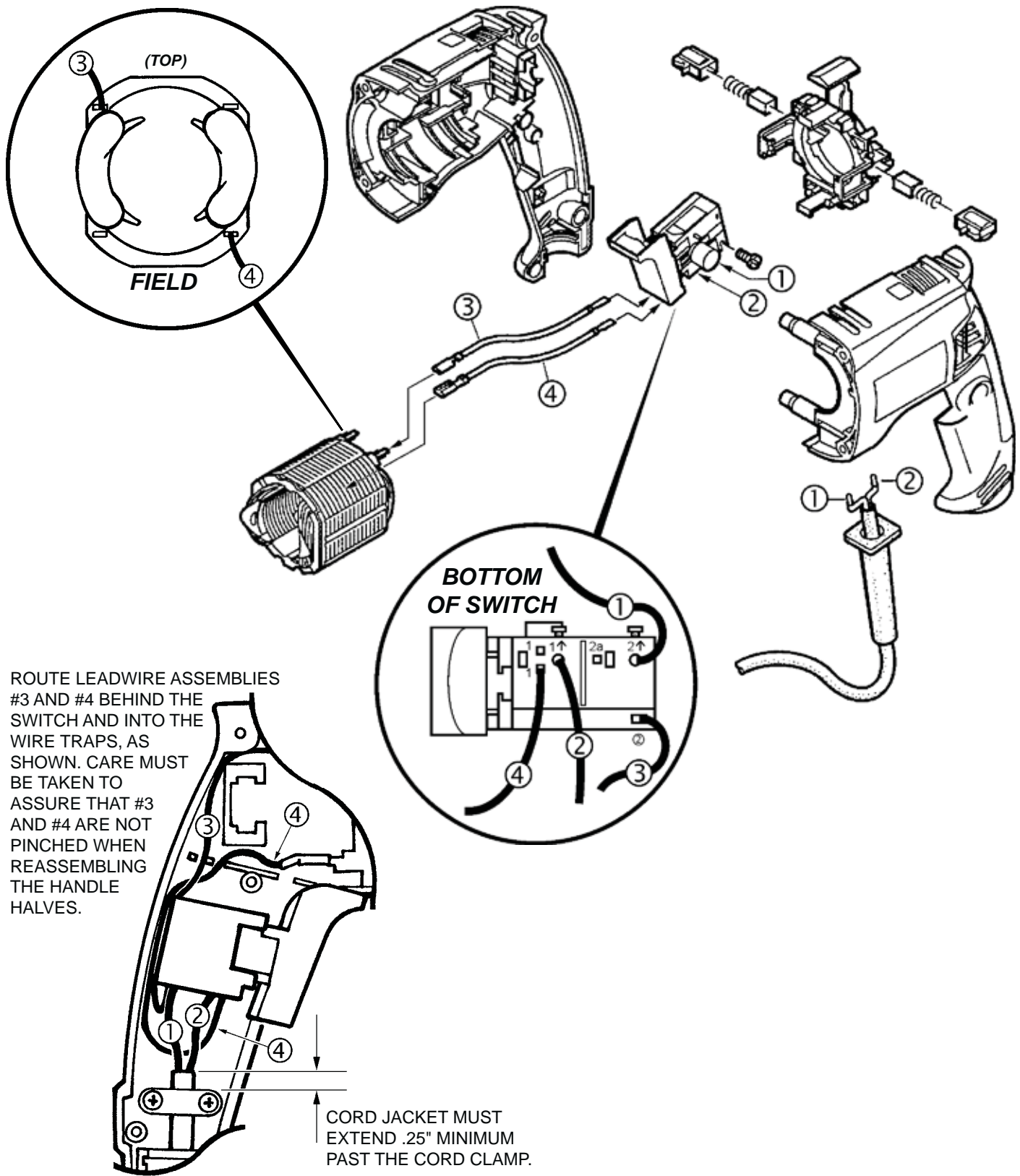
2. Assemble the clutch to the Spindle (#240):

- Clutch Disc (#241)
- Clutch Rollers (#242)
- Spindle Gear (#243)
- Belleville Springs (#246)
- Washer (#245)  
(Use a press to compress the belleville springs in order to assemble #1227).
- External Snap Ring (#1227)

3. With O-Rings (#1209 and #1218), insert the Ram (#222) into the Spindle (#240).

### SCREW TORQUE SPECIFICATIONS:

- Housing screws  
in plastic: #119, #120 & #126 13.2 In/lbs. (1.5 Nm)
- Screws in metal: #1212, #1214 & #1215 22.1 In/lbs. (2.5 Nm)
- Gearcase screws: #2 17.7 In/lbs. (2.0 Nm)



ROUTE LEADWIRE ASSEMBLIES #3 AND #4 BEHIND THE SWITCH AND INTO THE WIRE TRAPS, AS SHOWN. CARE MUST BE TAKEN TO ASSURE THAT #3 AND #4 ARE NOT PINCHED WHEN REASSEMBLING THE HANDLE HALVES.

CORD JACKET MUST EXTEND .25" MINIMUM PAST THE CORD CLAMP.

**WIRING SPECIFICATIONS**

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	-----	-----	Component of cord set.
2	White	-----	-----	Component of cord set.
3	Black	-----	-----	Leadwire assembly.
4	Black	-----	-----	Leadwire assembly.

**BULK LEAD WIRE - BULLETIN 58-01-0003**

**NOTE:**

All leads must be held to  $\pm 1/16"$ .  
All lead lengths are before stripping.

**TERMINAL DESCRIPTION**

Code	Part No.	Qty.