

SERVICE PARTS LIST

BULLETIN NO.
55-42-6325

| | | | |
|--|---------------------------------|---|-----------|
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | REVISED BULLETIN | DATE |
| ADJUSTABLE TORQUE SCREWDRIVER | | | Apr. 2002 |
| CATALOG NO. 6581-50 | STARTING SERIAL NO. 200A | WIRING INSTRUCTION 58-03-1805 | |

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

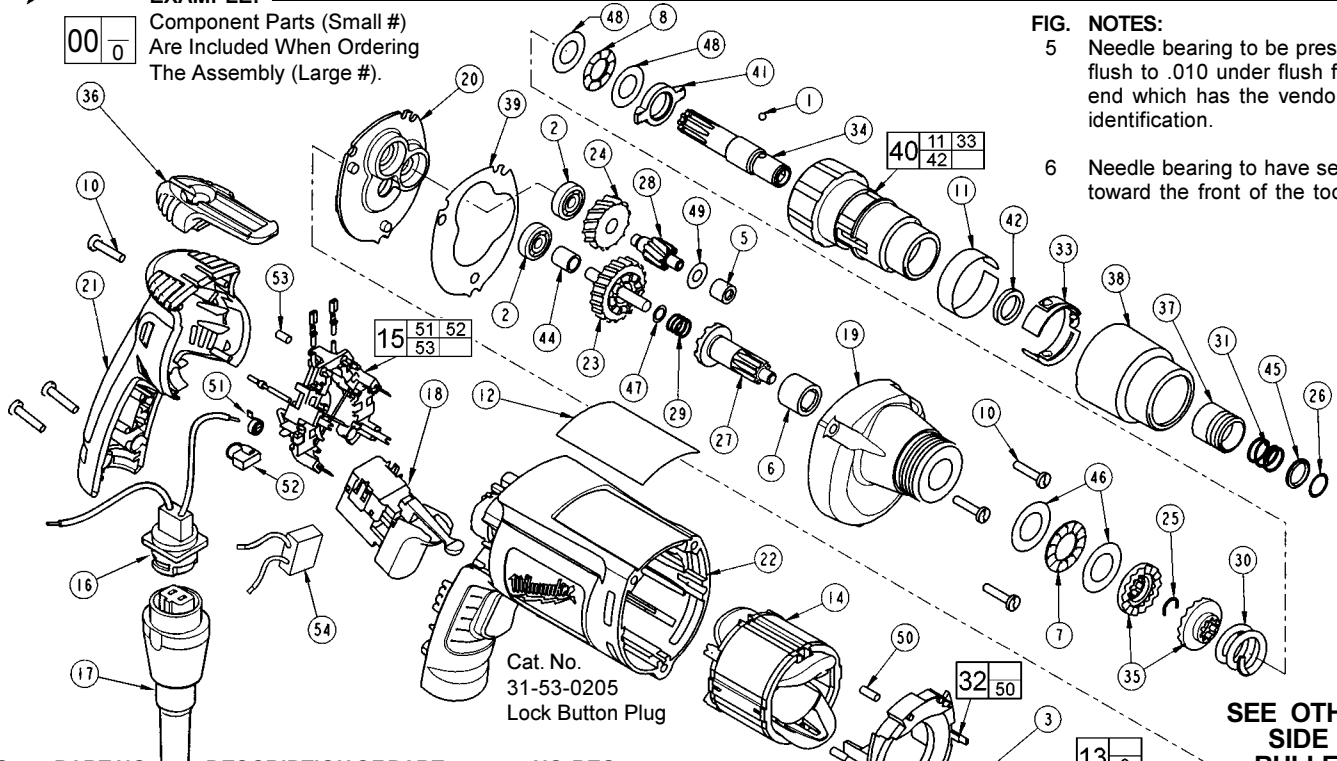


FIG. NOTES:
5 Needle bearing to be pressed flush to .010 under flush from end which has the vendors identification.
6 Needle bearing to have seal toward the front of the tool.

Cat. No.
31-53-0205
Lock Button Plug

**SEE OTHER
SIDE OF
BULLETIN**

**Before assembly,
lightly coat all press fit
areas with lightweight
spindle oil.**

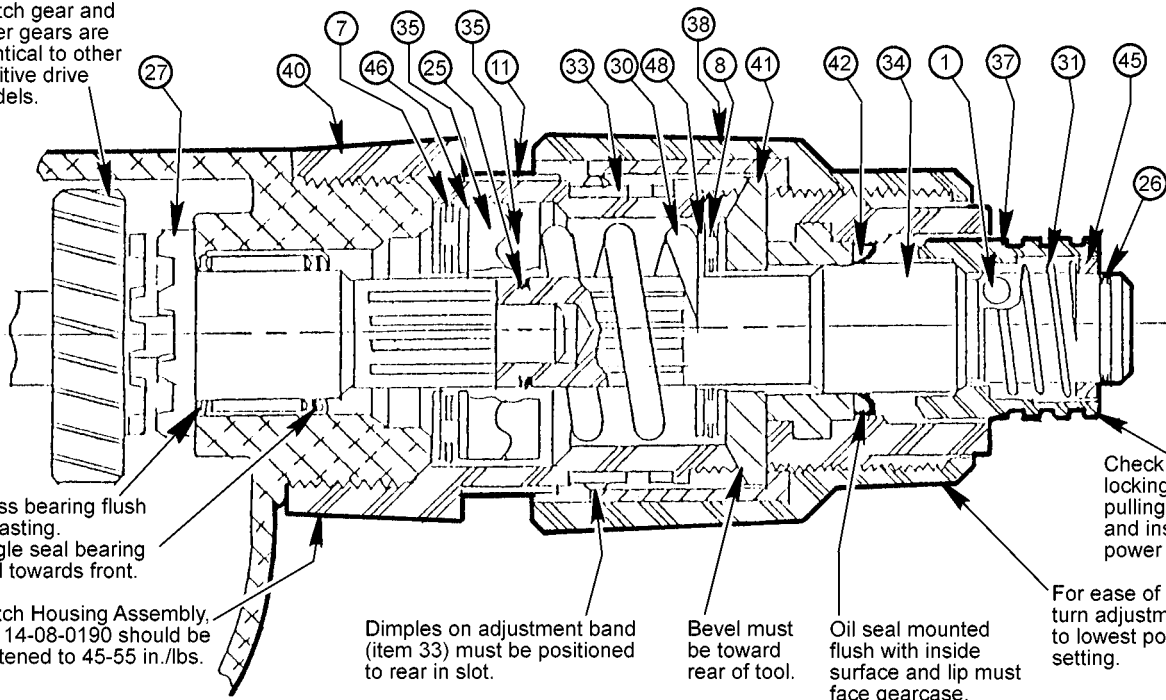
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|---------------------------------------|----------|
| 1 | 02-02-0130 | Steel Ball | (1) |
| 2 | 02-04-0640 | Ball Bearing | (2) |
| 3 | 02-04-0645 | Ball Bearing | (1) |
| 4 | 02-04-0852 | Ball Bearing | (1) |
| 5 | 02-50-2400 | Needle Bearing | (1) |
| 6 | 02-50-3245 | Needle Roller Bearing | (1) |
| 7 | 02-80-1200 | Thrust Needle Bearing | (1) |
| 8 | 02-80-6020 | Thrust Bearing | (1) |
| 9 | 22-84-0845 | Fan Assembly | (1) |
| 10 | 06-82-7275 | 7-18 x 3/4 Slotted Plastite Torx T-20 | (6) |
| 11 | 10-79-3100 | Torque Setting Label | (1) |
| 12 | 12-99-2700 | Service Nameplate | (1) |
| 13 | 16-14-2205 | Armature | (1) |
| 14 | 18-04-2200 | Field | (1) |
| 15 | 22-18-1220 | Brush Card Assembly | (1) |
| 16 | 22-56-1015 | Blade Housing Assembly | (1) |
| 17 | 48-76-5012 | Quik-Lok Cord Set | (1) |
| 17 | 22-64-0684 | Quik-Lok Cord Set (Australia) | (1) |
| 18 | 23-66-2135 | Switch | (1) |
| 19 | 28-14-2405 | Gearcase | (1) |
| 20 | 28-28-2315 | Diaphragm | (1) |
| 21 | 31-15-2030 | Handle Halve | (1) |
| 22 | 31-50-2030 | Motor Housing | (1) |
| 23 | 32-10-4065 | Clutch Gear Assembly | (1) |
| 24 | 32-40-0100 | Intermediate Gear | (1) |
| 25 | 34-60-0545 | Retaining Ring | (1) |
| 26 | 34-60-2390 | Retaining Ring | (1) |
| 27 | 36-14-0665 | Clutch Shaft Assembly | (1) |
| 28 | 36-66-0120 | Intermediate Shaft | (1) |
| 29 | 40-50-6600 | Separator Spring | (1) |
| 30 | 40-50-8000 | Clutch Spring | (1) |
| 31 | 40-50-8005 | Compression Spring | (1) |
| 32 | 42-14-0460 | Baffle Assembly | (1) |
| 33 | 42-16-0140 | Adjustment Band | (1) |
| 34 | 42-66-0676 | Chuck Shaft | (1) |
| 35 | 42-70-5016 | Drive Clutch | (2) |
| 36 | 42-70-5280 | Belt Clip | (1) |
| 37 | 42-76-0390 | Locking Collar | (1) |
| 38 | 42-76-0460 | Adjustment Collar | (1) |
| 39 | 43-44-0985 | Gasket | (1) |
| 40 | 14-08-0190 | Clutch Housing Assembly | (1) |
| 41 | 44-90-4280 | Adjustment Ring | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|-----------------------|----------|
| 42 | 45-06-0106 | Oil Seal | (1) |
| 44 | 45-36-1280 | Spacer | (1) |
| 45 | 45-36-1300 | Spacer | (1) |
| 46 | 45-88-0510 | Thrust Bearing Washer | (2) |
| 47 | 45-88-0712 | Thrust Washer | (1) |
| 48 | 45-88-7150 | Thrust Washer | (2) |
| 49 | 45-88-7990 | Thrust Washer | (1) |
| 50 | 45-30-0030 | Slug | (2) |
| 51 | 23-52-1610 | Brush Spring | (2) |
| 52 | 22-18-1320 | Brush Assembly | (2) |
| 53 | 45-30-0035 | Slug | (1) |
| 54 | 22-33-0550 | Suppressor | (1) |

FIG. LUBRICATION:
7,8 Apply a small amount of "L" Grease, No. 49-08-4170 on the thrust bearings, oil seal and tabs of the adjustment ring.
27 Apply a light film of "L" Grease to the lead chamfer of clutch chuck prior to assembly.
35 Place .07 oz. (1.8 grams) of Type "L" Grease on the clutch faces.
5 Place .12 oz. (3 grams) of Type "Y" Grease, No. 49-08-5270 on top of the inserted intermediate bearing.
19 Place .54 oz. (13.6 grams) of Type "Y" Grease at the armature pinion centerline in the gearcase and fill to slightly above the intermediate gear.

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 2

Clutch gear and other gears are identical to other positive drive models.



Lubrication

Drive clutches must slide back and forth freely on shaft splines. Defective splines that stick will not function properly.

Apply 1/16 oz. Type "L" grease, No. 49-08-4170, on clutch faces of drive clutch (#35). Apply a small amount of "L" grease on thrust bearings (#7 and #8), oil seal lip (#42) and tabs of adjustment ring (#41).

| ORDER OF ASSEMBLY | ITEM NUMBER | PART NUMBER | DESCRIPTION | |
|---|-------------|-------------|--|--------------------------|
| Clutch Housing Assembly No. 14-08-0190 | 1 | 40 | 14-08-0190 | Clutch Sub-Assembly |
| | 2 | 42 | 45-06-0106 | |
| | 3 | 33 | 42-16-0140 | |
| | 4 | 11 | 10-79-3100 | |
| | 5 | 41 | 44-90-4280 | |
| | 6 | 34 | 42-66-0676 | |
| Sub-Assembly | 7 | 1 | 02-02-0130 | |
| | 8 | 37 | 42-76-0390 | |
| | 9 | 31 | 40-50-8005 | |
| | 10 | 45 | 45-36-1300 | |
| | 11 | 26 | 34-60-2390 | |
| | 12 | 48 | 45-88-7150 | |
| | 13 | 8 | 02-80-6020 | |
| | 14 | 30 | 40-50-8000 | |
| | 15 | 35 | 42-70-5016 | |
| | 16 | 25 | 34-60-0545 | |
| | 38 | 42-76-0460 | Adjustment Collar (Includes insert No. 43-84-0740) | Not In Order Of Assembly |
| | 27 | 36-14-0665 | Clutch Shaft Assembly | |
| | 46 | 45-88-0510 | Thrust Bearing Washers (2 each) (Place on each side of Item #7, Thrust Bearing) | |
| | 7 | 02-80-1200 | Thrust Bearing | |
| | 35 | 42-70-5016 | Drive Clutch | |