Milwaukee®

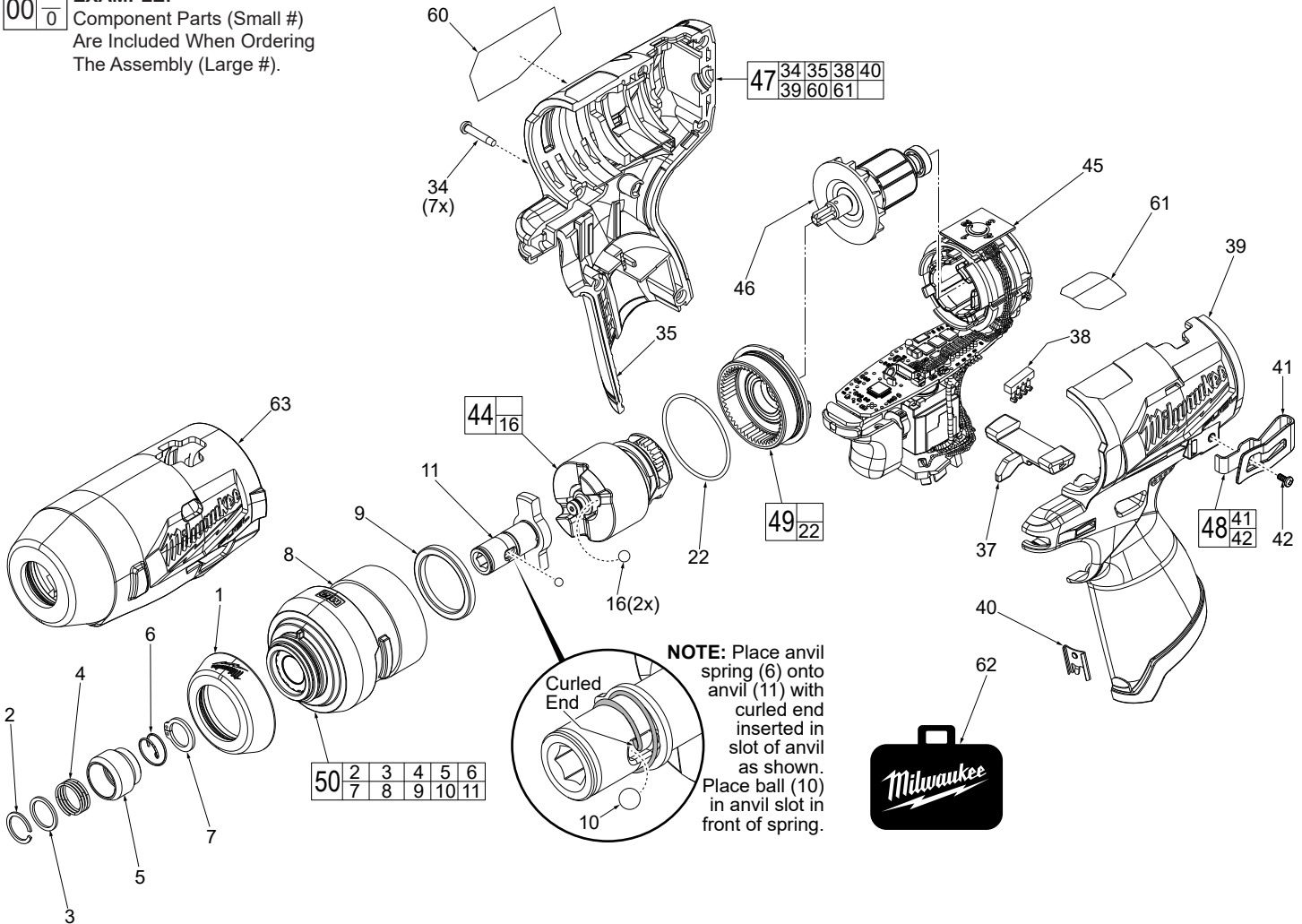# SERVICE PARTS LIST

BULLETIN NO.
54-26-2550

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | REVISED BULLETIN | DATE Oct. 2017

M12™ FUEL™ 1/4" Hex Impact Driver

| CATALOG NO. | **2553-20** | STARTING SERIAL NO. | **J10PA** |

WIRING INSTRUCTION
SEE PAGE 2

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

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NOTE: Place anvil spring (6) onto anvil (11) with curled end inserted in slot of anvil as shown. Place ball (10) in anvil slot in front of spring.

Curled End

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	31-12-0053	Rubber Cap	(1)
2	34-60-0725	Retaining Ring	(1)
3	45-88-1880	Washer	(1)
4	40-50-1470	Spring	(1)
5	45-22-2643	Sleeve	(1)
6	40-50-0012	Anvil Spring	(1)
7	34-60-0002	Retaining Ring	(1)
8	28-50-2553	Front Gear Case	(1)
9	45-88-2135	Nylon Ring	(1)
10	02-02-0170	3.5mm Steel Ball	(1)
11	42-06-2553	Anvil	(1)
16	02-02-0180	3/16" Steel Ball	(2)
22	34-40-0302	O-Ring	(1)
34	06-82-6351	M3 x 16mm Pan Hd. ST T-10 Screw	(7)
35	---------------	Housing Cover - Right Housing	(1)
37	45-24-2553	Forward/Reverse Shuttle	(1)
38	23-28-0012	Light Pipe	(1)
39	---------------	Housing Support - Left Housing	(1)
40	42-70-0058	Housing Clip	(1)
41	---------------	Belt Clip	(1)
42	05-88-1015	M2.5 x 6mm Pan Hd. Phillips Mach. Sc	(1)
44	14-30-2553	Impacting Assembly	(1)
45	14-20-2553	Electronics Assembly	(1)
46	16-01-1045	Rotor Assembly	(1)
47	31-44-2553	Housing Kit	(1)
48	42-70-0495	Belt Clip Kit	(1)
49	44-66-0875	Ring Gear End Cap Assy. with Bearing	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
50	14-30-2500	Gear Case Assembly	(1)
60	12-20-2553	Service Nameplate	(1)
61	10-20-2553	Spanish/French Warning Label	(1)
62	42-55-2553	Blow Molded Carrying Case	(1)
63	49-16-2553	Rubber Boot (Optional, Accessory)	(1)

When servicing, remove 90-95% of the existing grease prior to installing Type 'J'. Original grease maybe similar in color but not compatible with 'J'.

FIG. **LUBRICATION**
(Type 'J' Grease, No. 49-08-4220):

8 Coat anvil opening in the front of the gear case with grease.

10,11 Lightly coat front washer surface of anvil (11) with grease, place a dab in the ball slot of anvil.

44,49 Lightly coat the inside gear teeth of ring gear end cap (49) and the gear teeth of the planet gears of impacting assembly (44) with grease.

46 Coat pinion of rotor assembly (46) with grease.
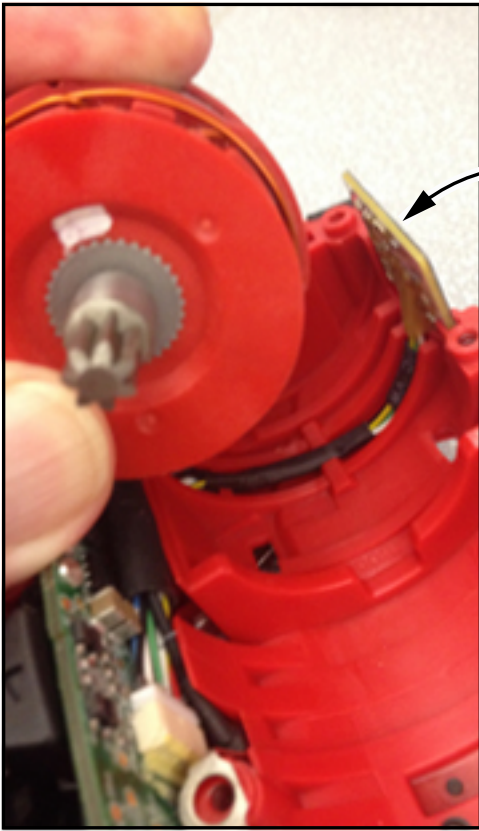
Prior to installing Stator/Rotor Assemblies, place the Selector PCBA into the slotted Housing Support cavity. Press wires into channel as shown. Carefully place Stator/Rotor Assemblies into Housing Support, being sure all components are firmly and squarely seated.

Selector PCBA

Rotor

Gear Case Assembly

Main PCBA

LED Assembly

Forward/Reverse Shuttle

Stator

On-Off Switch

Battery Terminal Block Connector

Ground Terminal

Housing Support

Housing Clip to be placed here
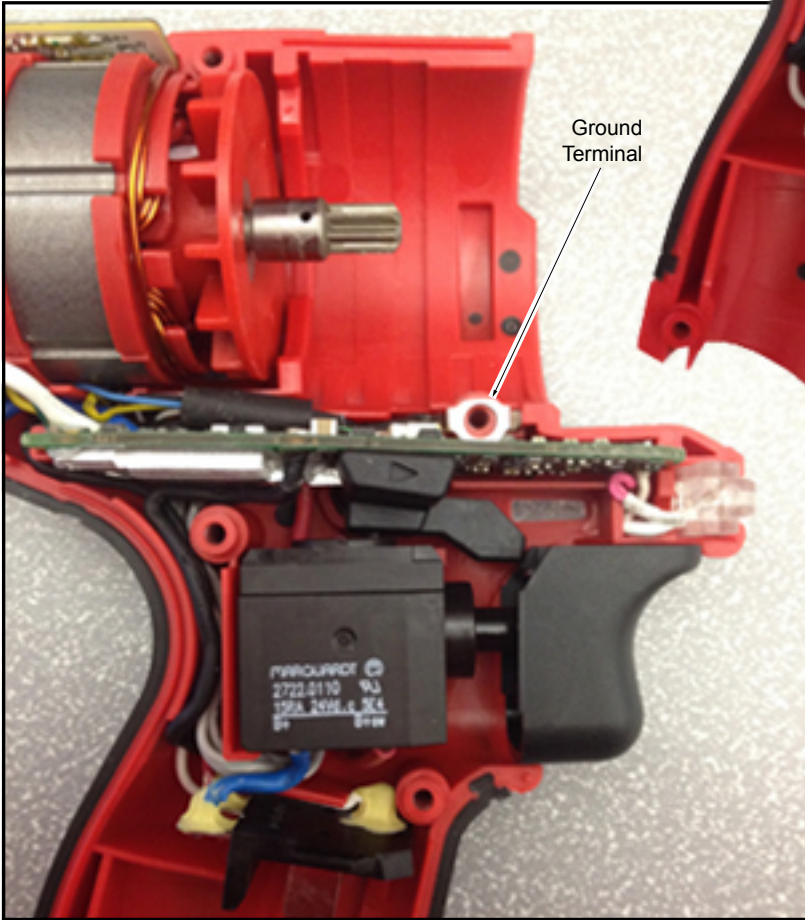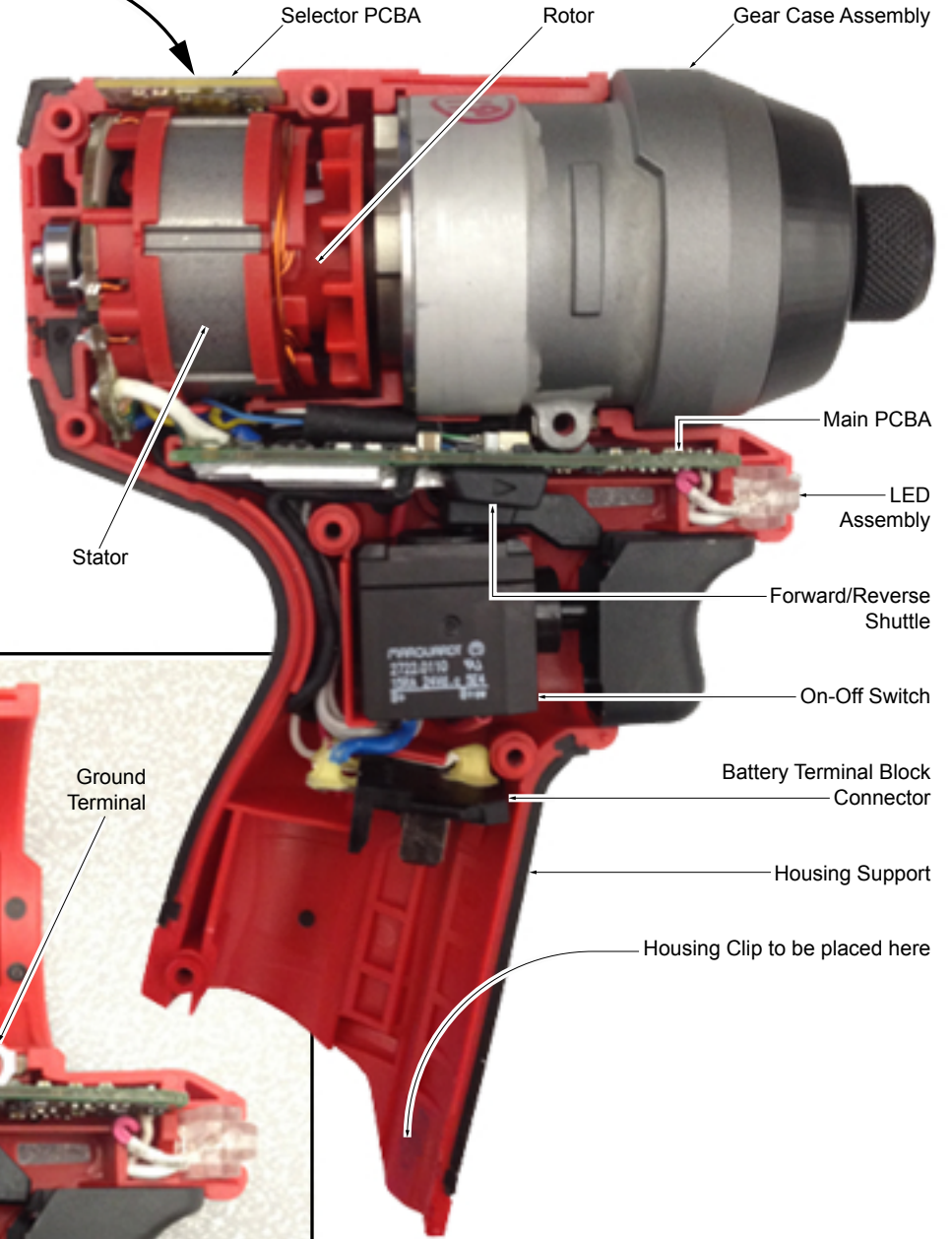
Prior to installing the Gear Case Assembly, be sure all elements of the Electronics Assembly are seated properly (Stator, Main PCBA, Selector PCBA, On-Off Switch, LED Assembly and Battery Terminal Block Connector). Be sure the Grounding Terminal is in place and that all wires are pressed down into all wire traps and channels. Check to assure that wires will not interfere with moving parts.

Prior to installing the Housing Cover, place Forward/Reverse Shuttle onto On-Off Switch and through Housing Support opening. Check to assure that wires will not be pinched.

Secure the Housing Cover to the Housing Support with seven M3 x 16mm ST T-10 Screws. Be sure to replace the Housing Clip at the bottom of the battery opening.