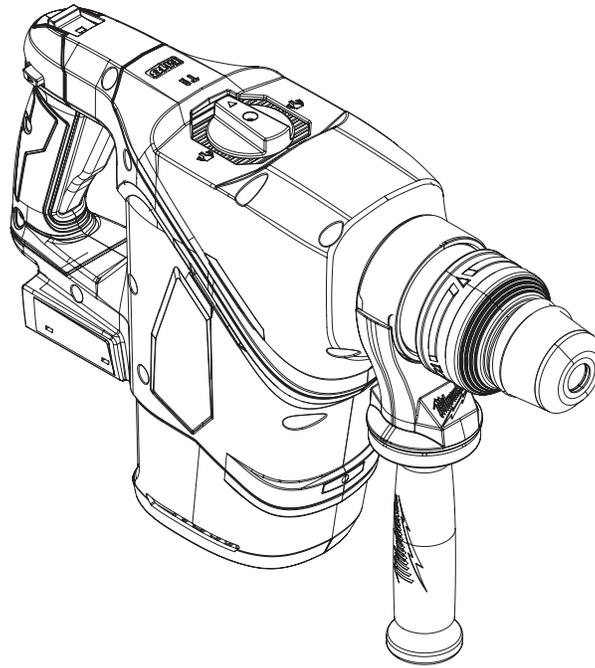




SERVICE PARTS LIST

**BULLETIN NO.
PN0003727**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18 FUEL™ 1-9/16" SDS MAX Rotary Hammer w/ ONE-KEY™			Aug. 2025
		WIRING INSTRUCTION	
CATALOG NO.	2917-20	SERIAL NO.	N23A
		SEE PAGES 6 and 7	



Only maintenance, service, repairs, and replacements of parts as defined in the Operator's Manual can be performed by the user.

All other repairs are to ONLY be performed by personnel authorized by MILWAUKEE TOOL.

Do not attempt to install other parts; this COULD void your tool warranty.

For service, parts, or inquiries, contact us:

- Customer Service at 1.800.SAWDUST (1.800.729.3878)
- E-Service tool repair at: www.milwaukeetool.com/e-service
- Find a local authorized MILWAUKEE service location at Milwaukeetool.com
- Find a MILWAUKEE factory Service Center Location or MILWAUKEE factory Central Repair Center at Milwaukeetool.com. Send the following, prepaid and insured:
 - Your name, address, and phone number
 - Description of the issues
 - Copy of the proof of purchase
 - Tool, charger, and batteries involved with the issues

MILWAUKEE factory Central Repair Centers:

MILWAUKEE TOOL
Central Repair
1401 Sycamore Avenue
Greenwood, MS 38930

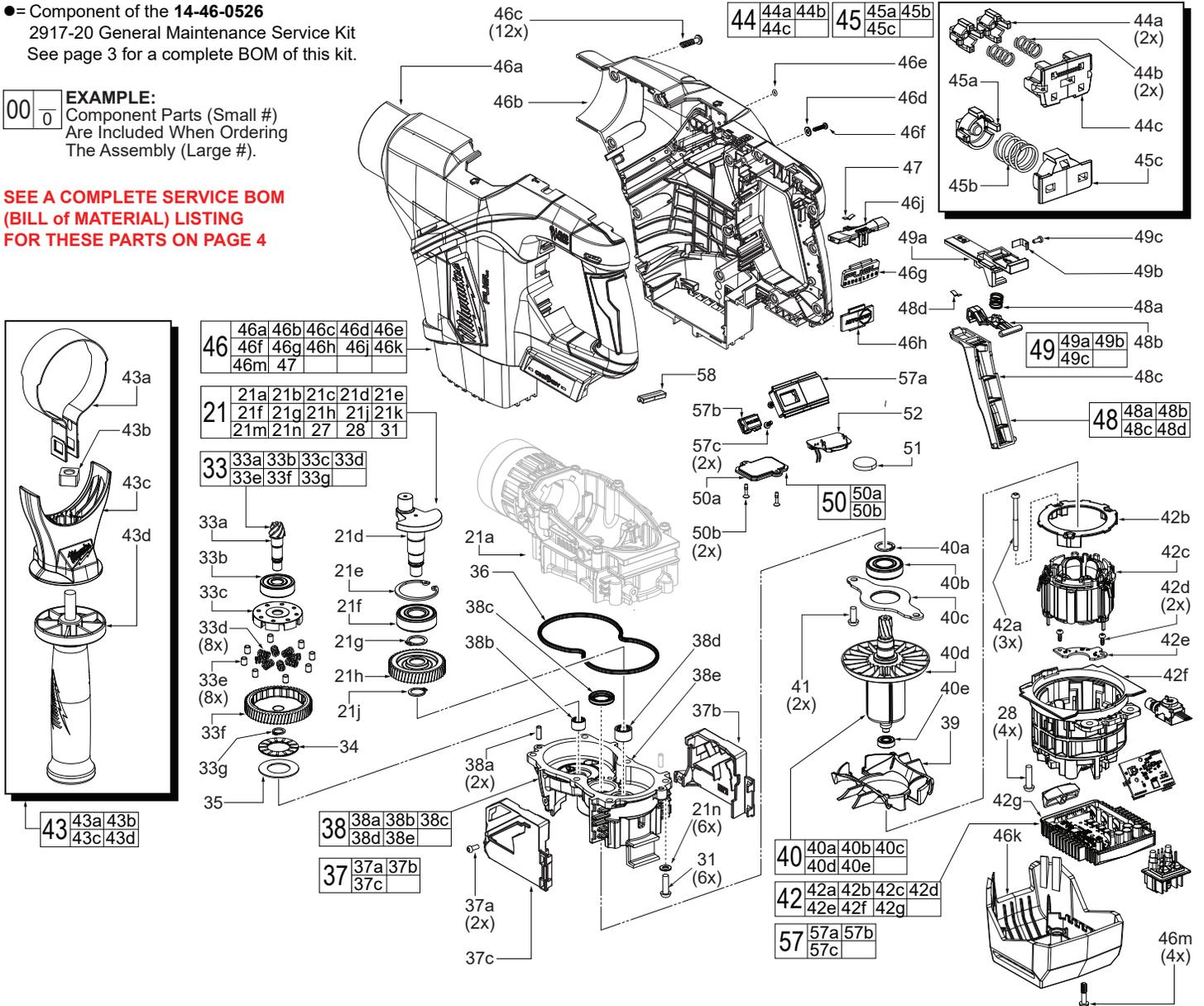
MILWAUKEE TOOL
Central Repair
2198 Southtech Drive
Greenwood, IN 46143

EXPLODED VIEW

● = Component of the **14-46-0526**
 2917-20 General Maintenance Service Kit
 See page 3 for a complete BOM of this kit.

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

**SEE A COMPLETE SERVICE BOM
 (BILL of MATERIAL) LISTING
 FOR THESE PARTS ON PAGE 4**



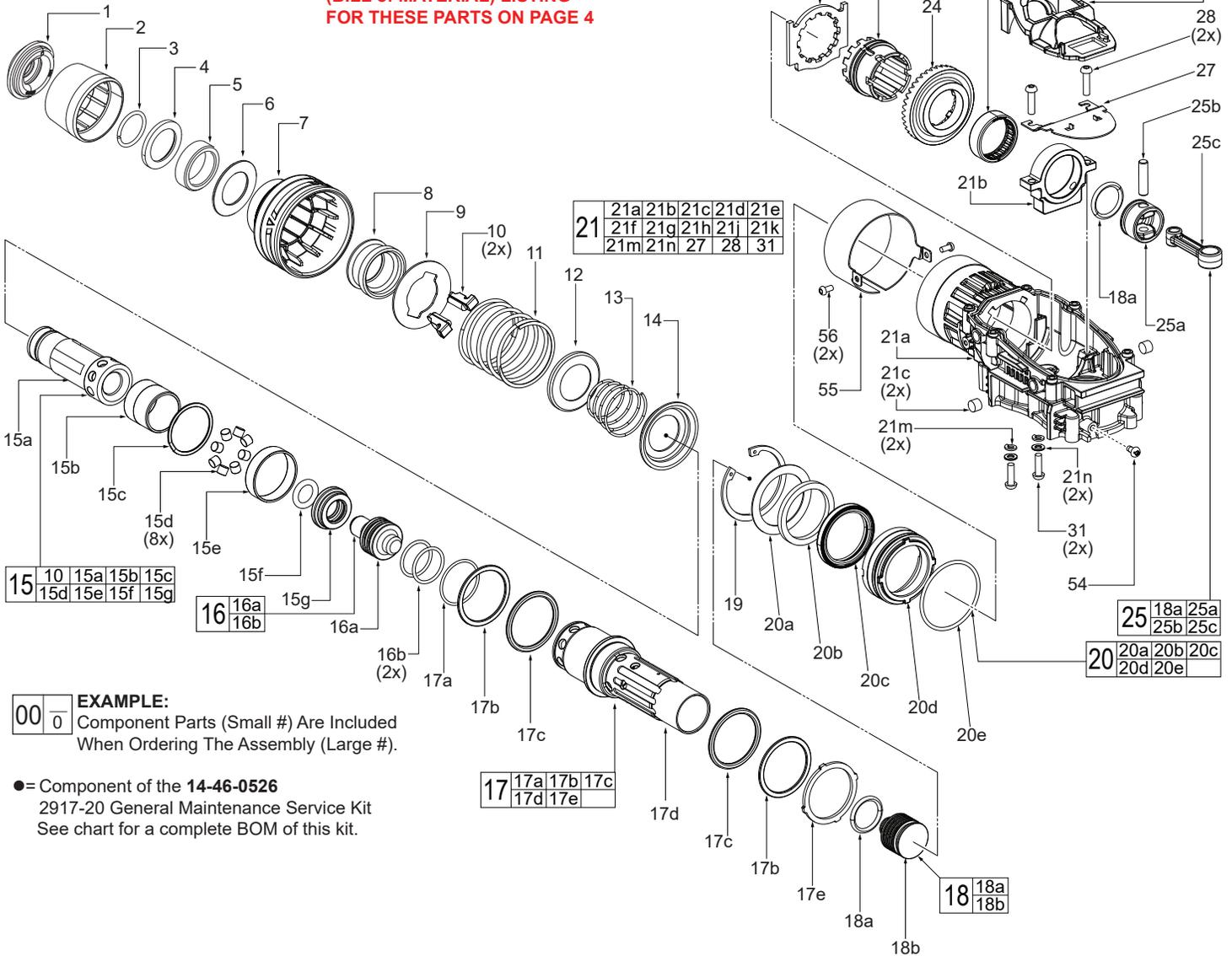
SCREW TORQUE SPECIFICATIONS

FIG.	PART NO.	DESCRIPTION OF FASTENER	WHERE USED	SEAT TORQUE	
				(kgf-cm)	(lb-in)
28	05-78-0033	M5 x 20mm Pan Hd. T-25 Machine Screw	Fork Support Plate Screw	50 +/- 5	43 +/- 4
28	05-78-0033	M5 x 20mm Pan Hd. T-25 Machine Screw	Motor Housing Screw	54 +/- 5	46 +/- 4
31	06-82-2873	M5 x 17mm Pan Hd. T-25 Machine Screw	Gearcase Cover Screw	32.5 +/- 1.5	28 +/- 1.3
31	06-82-2873	M5 x 17mm Pan Hd. T-25 Machine Screw	Mid/Lower Gearcase Screw	70 +/- 7	60 +/- 6
31	06-82-2873	M5 x 17mm Pan Hd. T-25 Machine Screw	Rear Bushing Bottom Screw	80 +/- 8	69 +/- 7
32a	05-81-1210	M4 x 22mm Pan Hd. ST T-20 Screw	Mode Selector Screw	18 +/- 1.5	15 +/- 1
37a	05-74-0109	M3.5 x 8mm Pan Hd. T-15 Machine Screw	Manifold Screw	12 +/- 1	10 +/- 1
41	05-78-0032	M5 x 15mm Pan Hd. T-25 Machine Screw	Rotor Bearing Plate Screw	25 +/- 3	21 +/- 2.3
42a	-----	M4 x 52mm Pan Hd. T-20 ST Screw	Stator Clamper Plate Screw	18 +/- 2	15 +/- 1
42d	-----	M3 x 8mm Pan Hd. T-10 ST Screw	Hall Sensor Screw	8 +/- 1	7 +/- 1
46c	05-78-5311	K50 x 18mm Pan Hd. T-20 PT Screw	Housing/Bottom Cap Screw	32 +/- 3	27 +/- 2.6
46f	05-74-0255	M3 x 12mm Pan Hd. Plastite T-10 Screw	Zippy Switch Screw	4.5 +/- 0.4	3.9 +/- 0.3
46m	-----	M5 x 19.5mm Pan Hd. T-20 ST Screw	Bottom Cap Screw	14 +/- 1	12 +/- 1
49c	-----	M3 x 7mm Pan Hd. T-10 ST Screw	Leaf Spring Screw	8.5 +/- 1	7.4 +/- 1
50b	-----	M2.6 x 12mm Flat Hd. Phillips ST Screw	Bluetooth Battery Screw	4 +/- 1	3 +/- 1
53	-----	M4 x 1.411 Flat Hd. Phillips #2 B ST Screw	LOC Disable Screw	14 +/- 1	12 +/- 1
54	05-74-0108	#8-32 Pan Hd. T-20 Tap. Ground Screw	Ground Screw to Mid-Gearcase	18 +/- 2	15 +/- 1
56	05-74-0104	M4 x 0.7 Pan Hd. Phillips #2 Mach. Screw	Neck Bushing Screw	30 +/- 2	26 +/- 1
57c	-----	M3 x 8mm Pan Hd. T-10 PT Screw	WDC Screw	8 +/- 1	7 +/- 1

General Maintenance Service Kit

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	45-12-5316	Dust Shield	(1)
3	44-90-5286	Retaining Ring	(1)
5	42-38-0004	Chuck Bumper Ring	(1)
9	45-88-0190	Flat Washer	(1)
10	42-68-0071	Latch	(2)
15c	44-90-1002	External Spiral Ring	(1)
15d	44-60-6055	Spindle Pin	(8)
15e	-----	Spindle Pin Cap	(1)
15f	34-40-0446	O-Ring	(1)
16b	34-40-0447	Anvil O-Ring	(2)
17a	34-40-0301	Front Spindle O-Ring	(1)
17c	34-40-0249	Bumper Ring	(2)
18a	34-40-0448	Piston and Striker O-Ring	(2)
20a	45-88-0433	Washer	(1)
20b	45-06-5325	Felt Seal	(1)
20c	43-44-0092	Spindle Lip Seal	(1)
20d	-----	Front Spindle Bushing	(1)
20e	34-40-0333	Front Bushing O-Ring	(1)
21c	31-53-0021	Felt Plug	(2)
30a	43-44-0056	Upper Gearcase Seal	(1)
32h	34-40-0449	Mode Selector O-Ring	(1)
36	43-44-0118	Lower Gearcase Gasket	(1)
38c	45-06-0073	Motor Seal	(1)
	45-00-0230	B118-V2 Grease (50g Tube)	(3)

**SEE A COMPLETE SERVICE BOM
(BILL of MATERIAL) LISTING
FOR THESE PARTS ON PAGE 4**



EXAMPLE:

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

● = Component of the 14-46-0526
 2917-20 General Maintenance Service Kit
 See chart for a complete BOM of this kit.

PAGE TWO SERVICE BOM LISTING

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
21	28-14-0176	Mid-Gearcase Service Assembly	(1)	42e	-----	Hall Board PCBA	(1)
21a	-----	Mid-Gearcase	(1)	42f	-----	Motor Housing	(1)
21b	-----	Rear Bushing	(1)	42g	-----	Main PCBA	(1)
21c	31-53-0021	Felt Plug	(2)	43	14-34-0111	Side Handle Service Assembly	(1)
21d	36-17-0021	● Crank Shaft	(1)	43a	-----	Side Handle Clamp	(1)
21e	-----	Beveled Retaining Ring	(1)	43b	-----	Square Nut	(1)
21f	-----	Ball Bearing	(1)	43c	-----	Side Handle Bracket	(1)
21g	-----	Snap Ring	(1)	43d	-----	Auxiliary Side Handle	(1)
21h	-----	Crank Gear	(1)	44	40-50-0483	Upper Mechanism Isolation Service Assy.	(1)
21j	-----	External Retaining Ring	(1)	44a	-----	Upper Spring Holder Hook	(2)
21k	-----	Needle Bearing	(1)	44b	-----	Upper Spring	(2)
21m	05-90-0105	Spring Washer	(2)	44c	-----	Upper Spring Plate	(1)
21n	45-88-0241	Flat Washer	(2)	45	43-72-0145	Lower Mechanism Isolation Service Assy.	(1)
28	05-78-0033	M5 x 20mm Pan Hd. T-25 Machine Screw	(2)	45a	-----	Lower Spring Holder Hook	(1)
31	06-82-2873	M5 x 17mm Pan Hd. T-25 Machine Screw	(6)	45b	-----	Lower Spring	(1)
33	14-26-0115	M Clutch Service Assembly	(1)	45c	-----	Lower Spring Plate	(1)
33a	-----	Spiral Bevel Pinion	(1)	46	28-14-0182	Housing Service Kit	(1)
33b	-----	Ball Bearing	(1)	46a	-----	Housing Support (Left)	(1)
33c	-----	Clutch	(1)	46b	-----	Housing Cover (Right)	(1)
33d	-----	Long Clutch Spring	(8)	46c	05-78-5311	K50 x 18mm Pan Hd. T-20 PT Screw	(12)
33e	-----	Skinny Clutch Roller	(8)	46d	-----	Plastic Washer	(1)
33f	-----	Thin Rim Clutch Gear	(1)	46e	34-40-0089	Trigger Switch O-Ring	(1)
33g	-----	Retaining Ring	(1)	46f	05-74-0255	M3 x 12mm Pan Hd. Taprite T-10 Screw	(1)
34	02-50-0013	Needle Bearing	(1)	46g	-----	Brushless Logo Plate	(1)
35	45-88-0246	Flat Washer	(1)	46h	-----	Autostop Logo Plate	(1)
36	43-44-0118	● Lower Gearcase Gasket	(1)	46j	-----	Forward/Reverse Shuttle	(1)
37	43-24-0016	Exhaust Manifold Service Kit	(1)	46k	-----	Bottom Cap	(1)
37a	05-74-0109	M3.5 x 8mm Pan Hd. T-15 Machine Screw	(2)	46m	-----	M5 x 19.5mm Pan Hd. T-20 ST Screw	(4)
37b	-----	Exhaust Manifold Plate Cover	(1)	47	40-50-0438	Spring Plate	(1)
37c	-----	Exhaust Manifold Plate Support	(1)	48	42-32-0041	Chisel Lock Service Kit	(1)
38	28-14-0113	Lower Gearcase Service Assembly	(1)	48a	-----	Spring	(1)
38a	-----	Dowel Pin	(2)	48b	-----	Chisel Lock Pilot Bar	(1)
38b	-----	Needle Bearing	(1)	48c	-----	Trigger Cap	(1)
38c	45-06-0073	● Motor Seal	(1)	48d	40-50-0223	Spring Plate	(1)
38d	-----	Needle Bearing	(1)	49	42-32-0043	Chisel Lock Shuttle Service Assembly	(1)
38e	-----	Lower Gearcase	(1)	49a	-----	Chisel Lock Shuttle	(1)
39	31-05-0112	Baffle	(1)	49b	-----	Leaf Spring	(1)
40	16-01-1091	Rotor Service Assembly	(1)	49c	-----	M3 x 7mm Pan Hd. T-10 ST Screw	(1)
40a	-----	C Ring	(1)	50	22-09-0123	Coin Cell Cover Service Assembly	(1)
40b	-----	Ball Bearing	(1)	50a	-----	Coin Cell Door	(1)
40c	-----	Bearing Retaining Plate	(1)	50b	-----	M2.6 x 12mm Flat Hd. Phillips ST Screw	(2)
40d	-----	Rotor	(1)	51	-----	3V Coin Cell Battery (CR2032)	(1)
40e	-----	Ball Bearing	(1)			- See local hardware store	
41	05-78-0032	M5 x 15mm Pan Hd. T-25 Machine Screw	(2)	52	14-20-0583	Coin Cell PCBA	(1)
42	14-20-0451	Electronics Service Assembly	(1)	57	31-92-2917	I/O Board Service Kit	(1)
42a	-----	M4 x 52mm Pan Hd. T-20 ST Screw	(3)	57a	-----	I/O Board Boat	(1)
42b	-----	Stator Clamp	(1)	57b	-----	I/O Button	(1)
42c	-----	Stator	(1)	57c	-----	M3 x 8mm Pan Hd. T-10 PT Screw	(2)
42d	-----	M3 x 8mm Pan Hd. T-10 ST Screw	(2)	58	42-38-0000	Rubber Bumper	(1)

PAGE THREE SERVICE BOM LISTING

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	45-12-5316	● Plastic Dust Shield	(1)	21b	-----	Rear Bushing	(1)
2	42-20-0098	Front Latch Cone	(1)	21c	31-53-0021	● Felt Plug	(2)
3	44-90-5286	● Retaining Ring	(1)	21d	36-17-0021	● Crank Shaft	(1)
4	45-88-0192	Washer	(1)	21e	-----	Retaining Ring	(1)
5	42-38-0004	● Chuck Bumper Ring	(1)	21f	-----	Ball Bearing	(1)
6	45-88-5321	Flat Washer	(1)	21g	-----	Snap Ring	(1)
7	42-76-0105	Sliding Chuck Sleeve	(1)	21h	-----	Crank Gear	(1)
8	45-22-0061	Locking Sleeve	(1)	21j	-----	External Retaining Ring	(1)
9	45-88-0190	● Flat Washer Retaining Plate	(1)	21k	-----	Needle Bearing	(1)
10	42-68-0071	● Latch	(2)	21m	05-90-0105	Spring Washer	(2)
11	40-50-0199	Chuck Spring	(1)	21n	45-88-0241	Flat Washer	(2)
12	45-88-0306	Latch Washer	(1)	22	44-66-0271	Locking Plate	(1)
13	40-50-0466	Spring	(1)	23	31-15-0297	Side Mode Select Collar	(1)
14	44-66-5955	Spring Retaining Plate	(1)	24	32-05-1121	Spiral Bevel Gear	(1)
15	38-50-0071	SDS Max Front Spindle Service Assembly	(1)	25	44-62-0054	Piston Service Assembly	(1)
15a	-----	SDS Max Front Spindle	(1)	25a	-----	Piston	(1)
15b	-----	Anvil Sleeve	(1)	25b	-----	Wrist Pin	(1)
15c	44-90-1002	● External Spiral Ring	(1)	25c	-----	Connecting Rod	(1)
15d	44-60-6055	● Spindle Pin	(8)	27	44-66-0127	Mode Selector Retaining Plate	(1)
15e	-----	● Spindle Pin Cap	(1)	28	05-78-0033	M5 x 20mm Pan Hd. T-25 Machine Screw	(2)
15f	34-40-0446	● O-Ring	(1)	29	14-46-0443	Fork Assembly	(1)
15g	-----	Anvil Guide	(1)	29a	-----	Mode Selector Fork	(1)
16	14-46-0362	Anvil Service Assembly	(1)	29b	-----	Shift Spring	(1)
16a	-----	Anvil	(1)	30	28-20-0233	Gearcase Cover Service Kit	(1)
16b	34-40-0447	● Anvil O-Ring	(2)	30a	43-44-0056	● Upper Gearcase Seal	(1)
17	38-50-0072	Rear Spindle Service Assembly	(1)	30b	-----	Gearcase Cover	(1)
17a	34-40-0301	● Front Spindle O-Ring	(1)	31	06-82-2873	M5 x 17mm Pan Hd. T-25 Machine Screw	(6)
17b	-----	Spindle Bumper Washer	(2)	32	44-10-0101	Mode Selector Service Assembly	(1)
17c	34-40-0249	● Bumper Ring	(2)	32a	05-81-1210	M4 x 22mm Pan Hd. ST T-20 Screw	(1)
17d	-----	Spindle Sleeve	(1)	32b	-----	Mode Selector Knob	(1)
17e	-----	Tabbed Washer	(1)	32c	-----	Rubber Bellow	(1)
18	42-62-0117	Striker Service Assembly	(1)	32d	-----	Plastic Plate	(1)
18a	34-40-0448	● Piston and Striker O-Ring	(2)	32e	-----	Linkage	(1)
18b	-----	Striker	(1)	32f	-----	Selector Detent	(1)
19	34-40-5315	Retaining Ring	(1)	32g	40-50-0224	H Spring	(1)
20	42-40-0016	Front Spindle Bushing Service Kit	(1)	32h	34-40-0449	● Mode Selector O-Ring	(1)
20a	45-88-0433	● Washer	(1)	32j	-----	Mode Selector Cam	(1)
20b	45-06-5325	● Felt Seal	(1)	32k	-----	Magnetic Ring Sleeve	(1)
20c	43-44-0092	● Spindle Lip Seal	(1)	32m	-----	Magnet	(1)
20d	-----	● Front Spindle Bushing	(1)	53	-----	M4 x 1.411 Flat Hd. Phillips #2 B ST Screw	(1)
20e	34-40-0333	● Front Bushing O-Ring	(1)	54	05-74-0108	#8-32 Pan Hd. T-20 Tapt. Ground Screw	(1)
21	28-14-0176	Mid-Gearcase Service Assembly	(1)	55	31-94-0028	Bushing Neck	(1)
21a	-----	Mid-Gearcase	(1)	56	05-74-0104	M4 x 0.7 Pan Hd. Phillips #2 Mach. Screw	(2)

LUBRICATION NOTES:

Type 'B118-V2' Grease, No. 45-00-0230

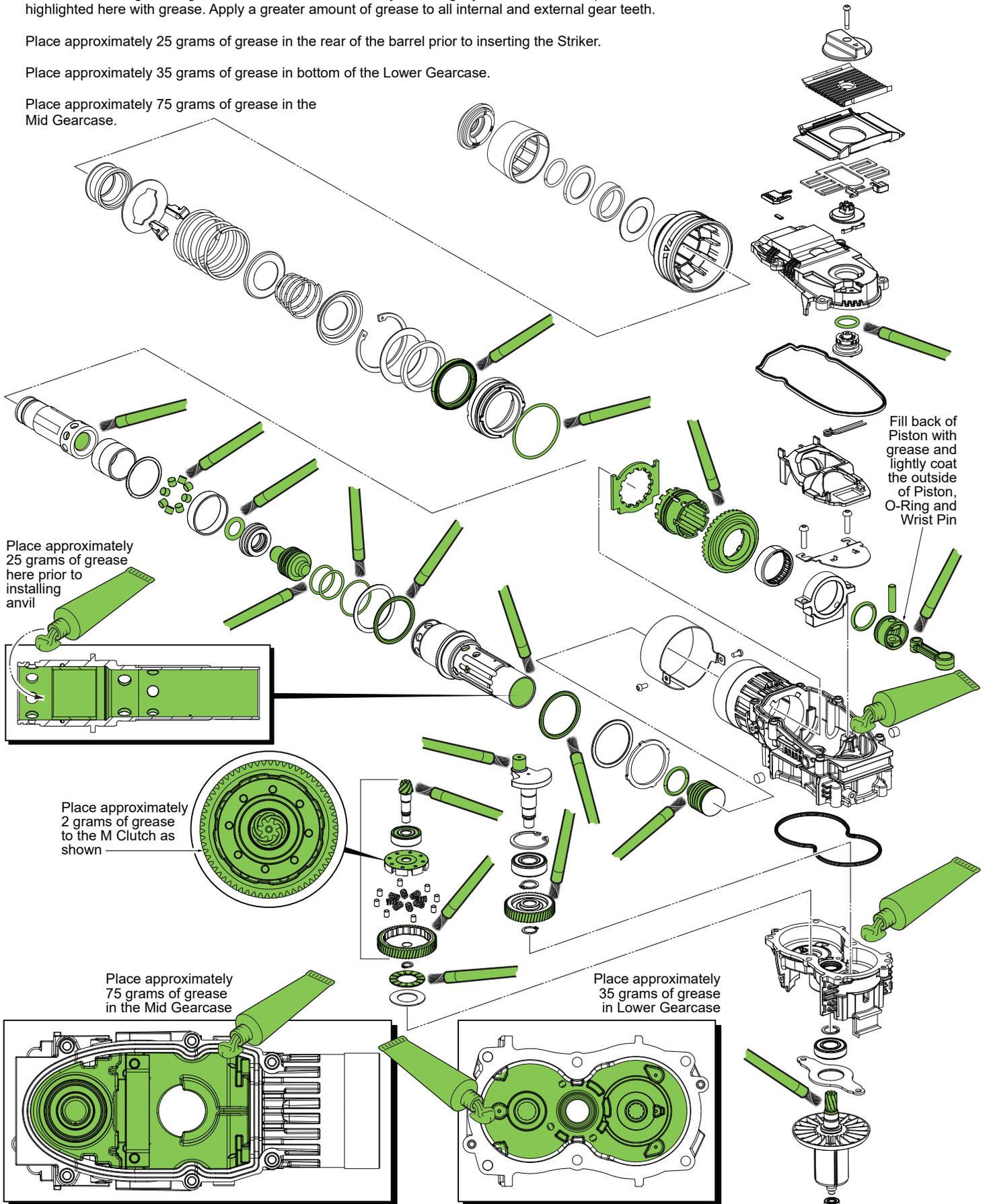
(50g tube, 3 tubes required)

Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all individual parts highlighted here with grease. Apply a greater amount of grease to all internal and external gear teeth.

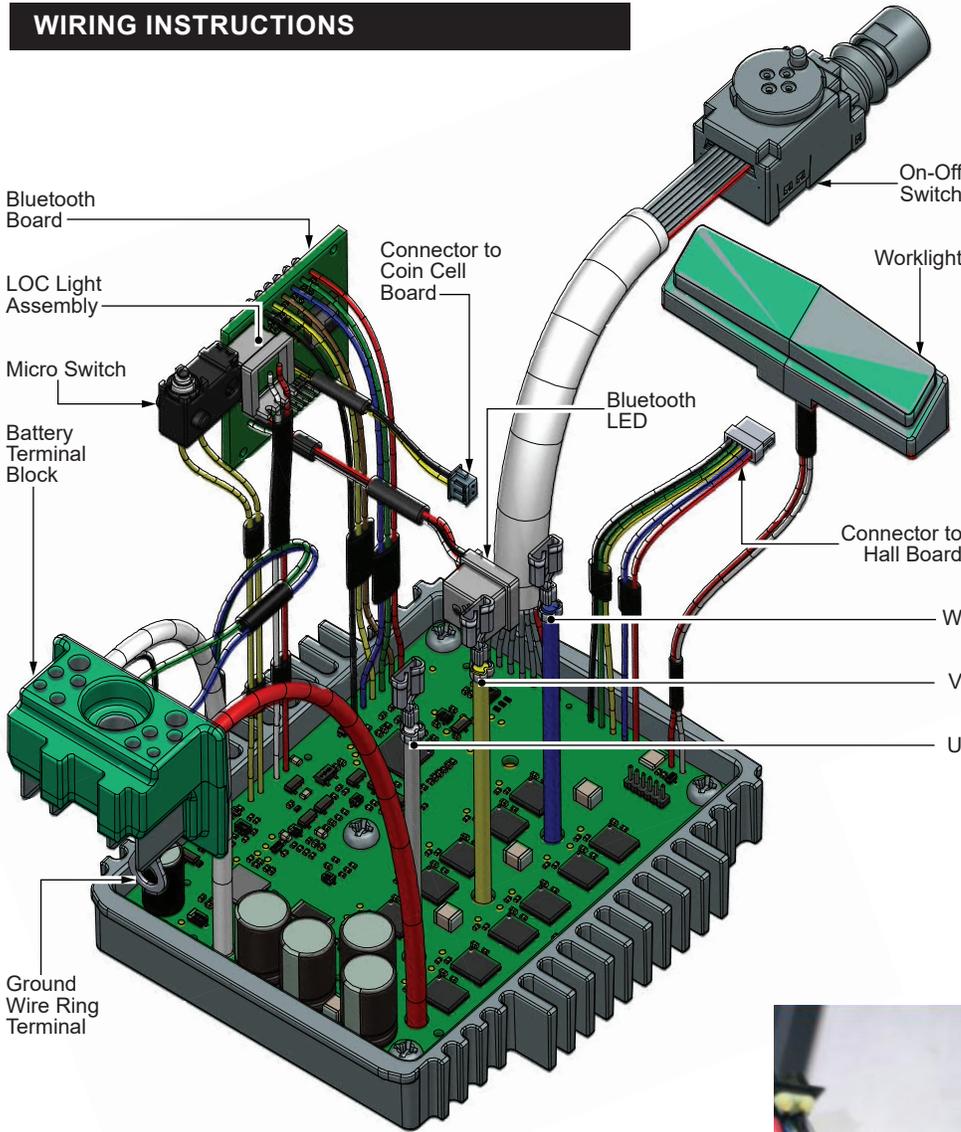
Place approximately 25 grams of grease in the rear of the barrel prior to inserting the Striker.

Place approximately 35 grams of grease in bottom of the Lower Gearcase.

Place approximately 75 grams of grease in the Mid Gearcase.



WIRING INSTRUCTIONS



Photos on this page depict components, wires and wire routing of the electronics package (See illustration to the left).

Install all components firmly and squarely in corresponding cavities of the Motor Housing. Route all wires as shown being sure those placed in wire traps are pressed completely down in bottom of traps. Tuck all excess wires down into Motor Housing cavities to avoid pinching when the housings are reassembled.

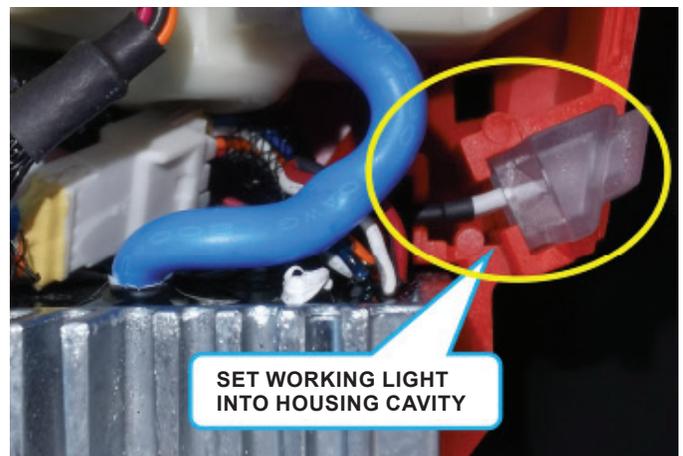
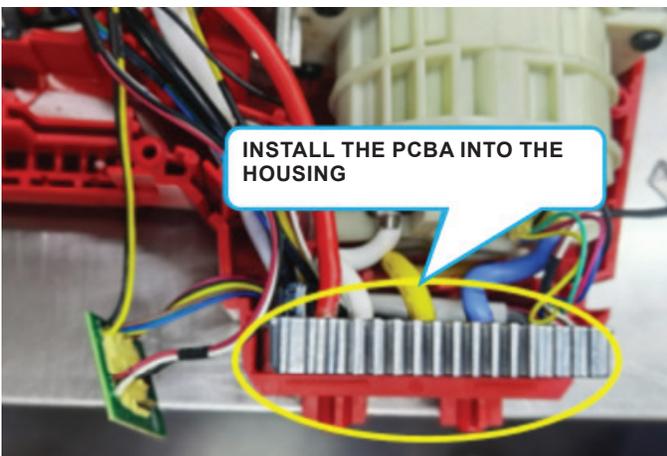
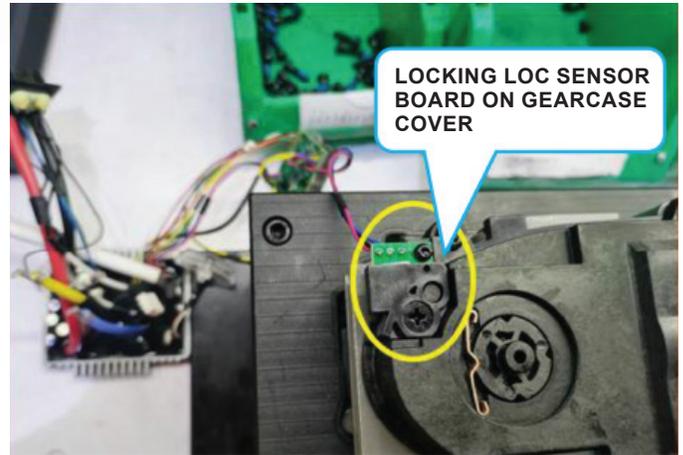
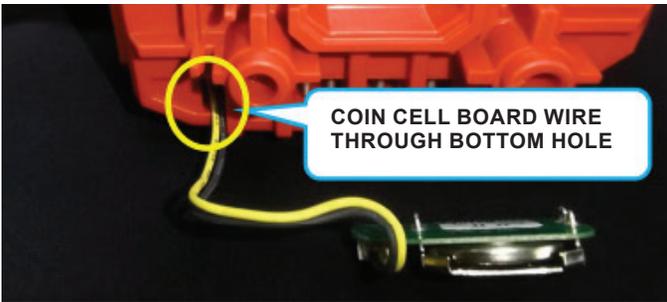
As an aid to reassembly, take notice of wire routings and position in wire guides and traps while dismantling tool.

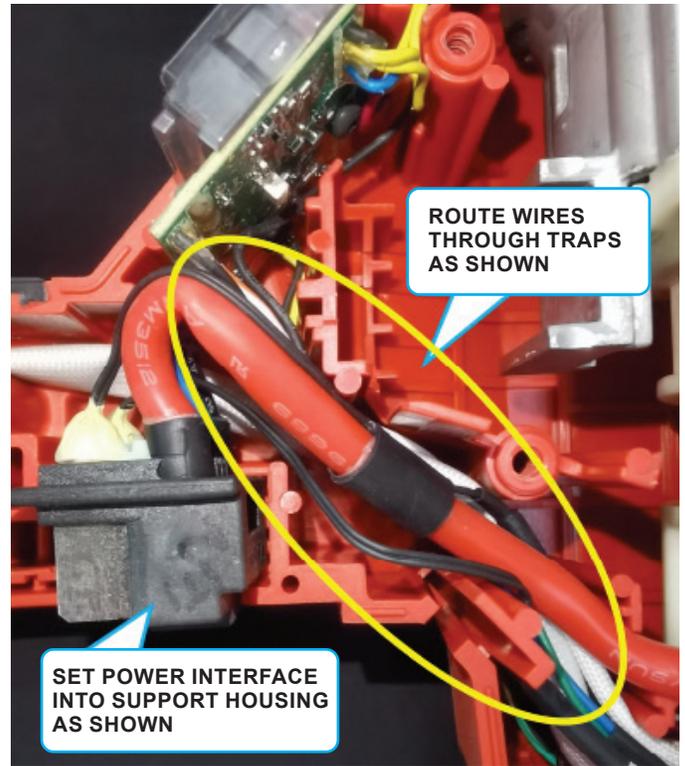
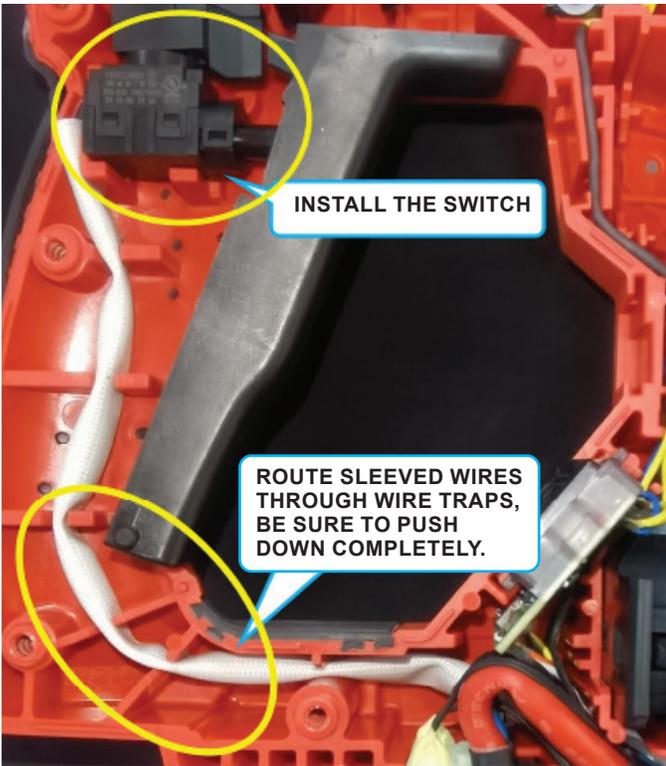
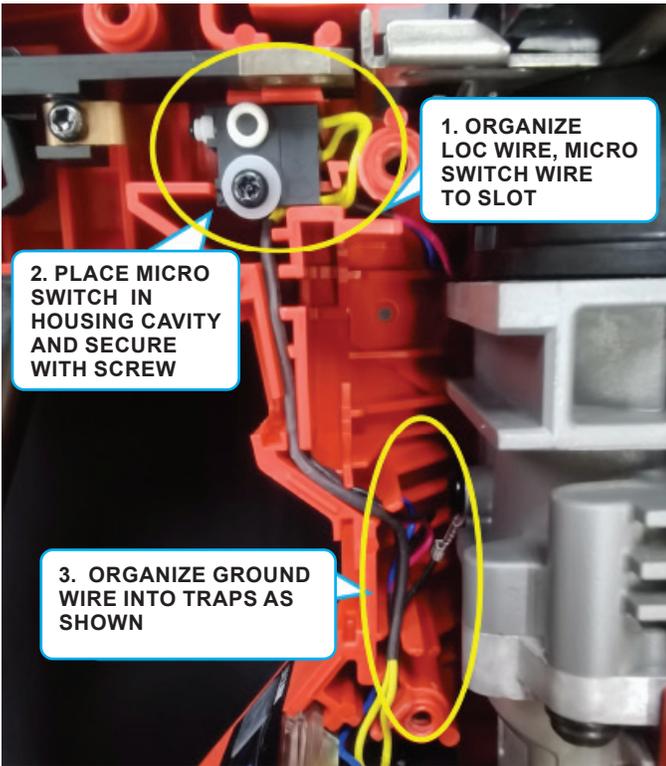
Be sure that all components of the electronics assembly are seated firmly and squarely in housing recesses.

Avoid pinched wires, be sure that all wires and sleeves are pressed completely down in wire traps.

Prior to securing housing Motor Cap onto the Motor Housing, be sure that there are no interferences.

Check for proper functionality of shuttles, buttons and triggers prior to powering tool.





Photos on this page depict components, wires and wire routing of the electronics package (See page 6).

Install all components firmly and squarely in corresponding cavities of the Motor Housing. Route all wires as shown being sure those placed in wire traps are pressed completely down in bottom of traps. Tuck all excess wires down into Motor Housing cavities to avoid pinching when the housings are reassembled.

As an aid to reassembly, take notice of wire routings and position in wire guides and traps while dismantling tool.

Be sure that all components of the electronics assembly are seated firmly and squarely in housing recesses.

Avoid pinched wires, be sure that all wires and sleeves are pressed completely down in wire traps.

Prior to securing housing Motor Cap onto the Motor Housing, be sure that there are no interferences.

Check for proper functionality of shuttles, buttons and triggers prior to powering tool.