



SERVICE PARTS LIST

BULLETIN NO.
54-06-2990

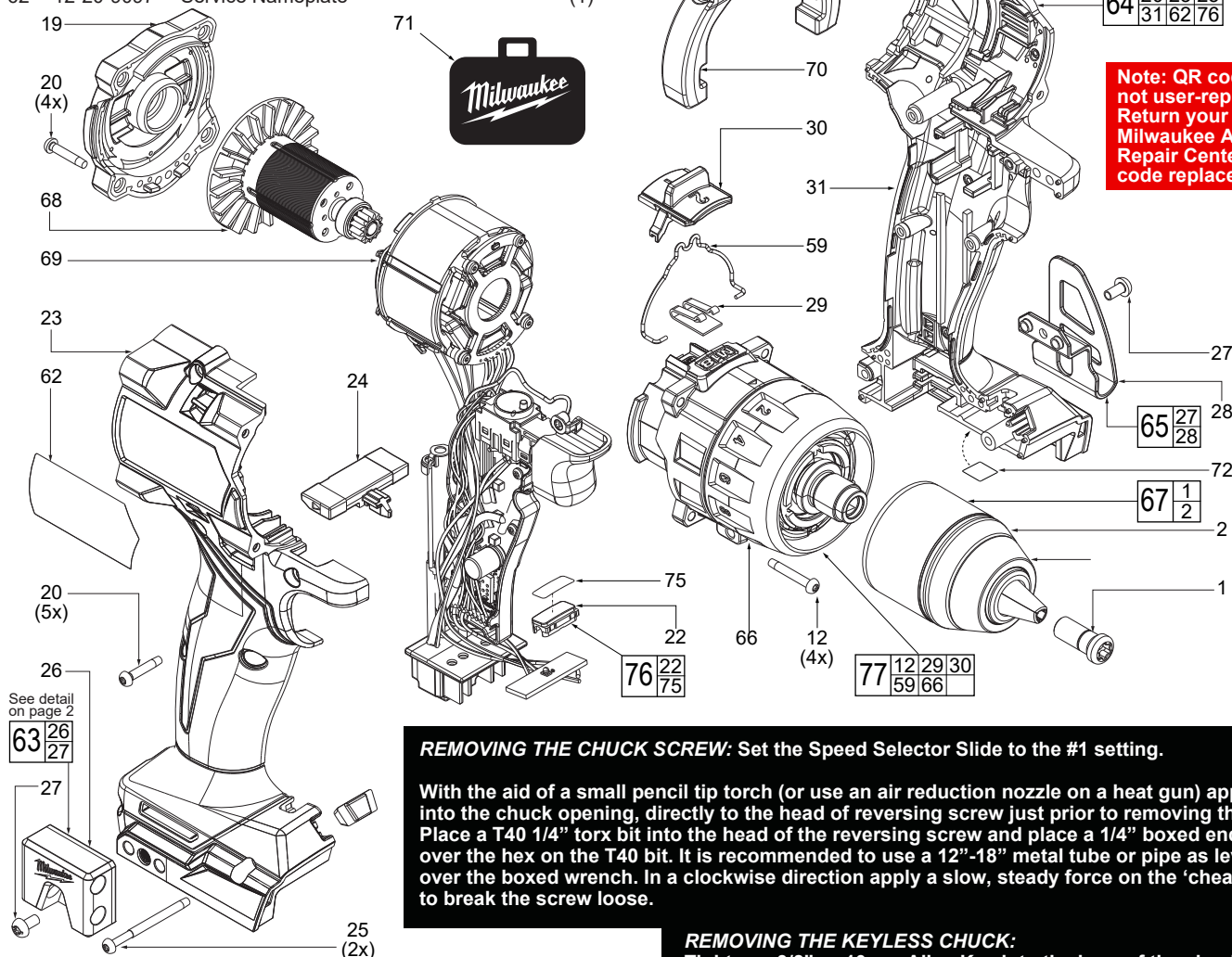
SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS			REVISED BULLETIN	DATE
M18™ FUEL™ Brushless Drill-Driver				Nov. 2023
CATALOG NO.	2903-20	STARTING SERIAL NO.	WIRING INSTRUCTION SEE PAGE 2	
		M63A		

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-88-0019	M8.0 x 1 LH T-40 Chuck Screw	(1)
2	-----	1/2" Keyless Chuck	(1)
12	06-82-7337	M4 x 20mm Pan Hd. ST T-10 w/Washer Scr.	(4)
19	42-92-7012	Back Cap	(1)
20	06-82-6351	M3 x 16mm Pan Hd. ST T-10 Screw	(9)
22	-----	Lens	(1)
23	-----	Right Housing Halve - Cover	(1)
24	42-42-7003	Forward/Reverse Shuttle	(1)
25	06-82-2367	M3 x 38mm Pan Hd. ST T-10 Screw	(2)
26	-----	Bit Holder	(1)
27	06-82-2500	#6-32 x 7mm Pan Hd. Machine Screw	(2)
28	-----	Belt Clip	(1)
29	44-10-0160	Detent Spring	(1)
30	45-24-2670	Speed Selector	(1)
31	-----	Left Housing Halve - Support	(1)
59	44-10-4020	Shift Spring	(1)
62	12-20-9097	Service Nameplate	(1)

EXAMPLE:

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

See page 3 for fastener
tightening procedure and
torque specifications.



REMOVING THE CHUCK SCREW: Set the Speed Selector Slide 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 3/8" 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 79.20 ft/lbs)
Torque Screw to 400 kg/cm (347 in/lbs or 28.93 ft/lbs)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
63	49-16-3697	Bit Holder Kit (Accessory)	(1)
64	31-44-7008	Housing Service Assembly	(1)
65	42-70-0950	Belt Clip Service Kit	(1)
66	-----	Gearbox	(1)
67	42-66-2740	1/2" Keyless Chuck	(1)
68	16-07-2983	Rotor Service Assembly	(1)
69	14-20-6560	Electronic Service Assembly	(1)
70	42-62-0550	Side Handle Service Assembly	(1)
71	42-55-9020	Blow Molded Carrying Case	(1)
72	-----	QR Code Label	(1)
75	-----	Auto-Stop Label	(1)
76	44-06-0049	Lens/Label Assembly	(1)
77	14-29-5010	Gearbox Service Assembly	(1)

MILWAUKEE TOOL • www.milwaukeetool.com
13135 W. Lisbon Rd., Brookfield, WI 53005

Dwg. 4