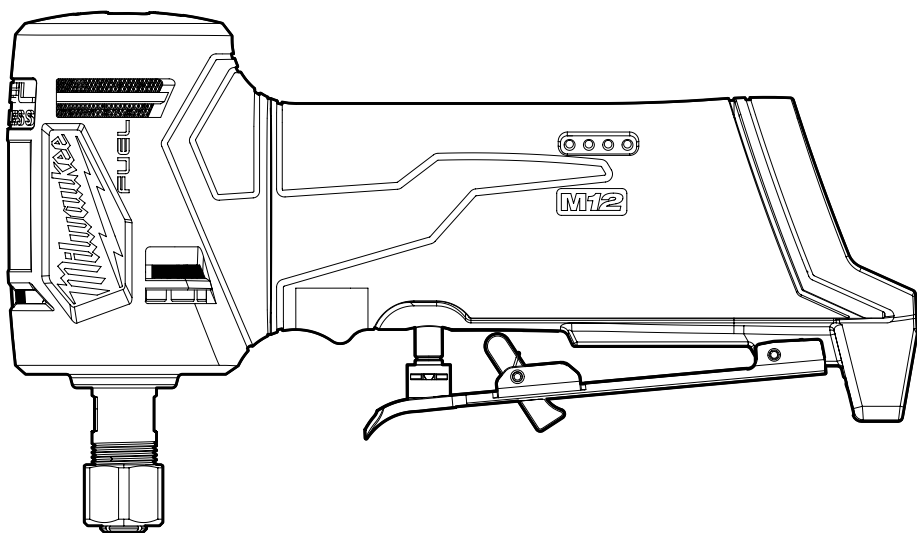




## OPERATOR'S MANUAL



Cat. No.  
2485-20

### M12 FUEL™ DIE GRINDERS



**WARNING** To reduce the risk of injury, user must read and understand operator's manual.

## GENERAL POWER TOOL SAFETY WARNINGS

**⚠WARNING** Read all safety warnings, instructions, illustrations and specifications provided with this power tool. Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury. **Save all warnings and instructions for future reference.** The term "power tool" in the warnings refers to your mains-operated (corded) power tool or battery-operated (cordless) power tool.

### WORK AREA SAFETY

- **Keep work area clean and well lit.** Cluttered or dark areas invite accidents.
- **Do not operate power tools in explosive atmospheres, such as in the presence of flammable liquids, gases or dust.** Power tools create sparks which may ignite the dust or fumes.
- **Keep children and bystanders away while operating a power tool.** Distractions can cause you to lose control.

### ELECTRICAL SAFETY

- **Power tool plugs must match the outlet.** Never modify the plug in any way. Do not use any adapter plugs with earthed (grounded) power tools. Unmodified plugs and matching outlets will reduce risk of electric shock.
- **Avoid body contact with earthed or grounded surfaces, such as pipes, radiators, ranges and refrigerators.** There is an increased risk of electric shock if your body is earthed or grounded.
- **Do not expose power tools to rain or wet conditions.** Water entering a power tool will increase the risk of electric shock.
- **Do not abuse the cord.** Never use the cord for carrying, pulling or unplugging the power tool. **Keep cord away from heat, oil, sharp edges or moving parts.** Damaged or entangled cords increase the risk of electric shock.
- **When operating a power tool outdoors, use an extension cord suitable for outdoor use.** Use of a cord suitable for outdoor use reduces the risk of electric shock.
- **If operating a power tool in a damp location is unavoidable, use a ground fault circuit interrupter (GFCI) protected supply.** Use of an GFCI reduces the risk of electric shock.

### PERSONAL SAFETY

- **Stay alert, watch what you are doing and use common sense when operating a power tool. Do not use a power tool while you are tired or under the influence of drugs, alcohol or medication.** A moment of inattention while operating power tools may result in serious personal injury.
- **Use personal protective equipment. Always wear eye protection.** Protective equipment such as a dust mask, non-skid safety shoes, hard hat or hearing protection used for appropriate conditions will reduce personal injuries.
- **Prevent unintentional starting. Ensure the switch is in the off-position before connecting to power source and/or battery pack, picking up or carrying the tool.** Carrying power tools with your finger on the switch or energizing power tools that have the switch on invites accidents.
- **Remove any adjusting key or wrench before turning the power tool on.** A wrench or a key left attached to a rotating part of the power tool may result in personal injury.

- **Do not overreach. Keep proper footing and balance at all times.** This enables better control of the power tool in unexpected situations.
- **Dress properly. Do not wear loose clothing or jewelry. Keep your hair and clothing away from moving parts.** Loose clothes, jewelry or long hair can be caught in moving parts.
- **If devices are provided for the connection of dust extraction and collection facilities, ensure these are connected and properly used.** Use of dust collection can reduce dust-related hazards.
- **Do not let familiarity gained from frequent use of tools allow you to become complacent and ignore tool safety principles.** A careless action can cause severe injury within a fraction of a second.

### POWER TOOL USE AND CARE

- **Do not force the power tool. Use the correct power tool for your application.** The correct power tool will do the job better and safer at the rate for which it was designed.
- **Do not use the power tool if the switch does not turn it on and off.** Any power tool that cannot be controlled with the switch is dangerous and must be repaired.
- **Disconnect the plug from the power source and/or remove the battery pack, if detachable, from the power tool before making any adjustments, changing accessories, or storing power tools.** Such preventive safety measures reduce the risk of starting the power tool accidentally.
- **Store idle power tools out of the reach of children and do not allow persons unfamiliar with the power tool or these instructions to operate the power tool.** Power tools are dangerous in the hands of untrained users.
- **Maintain power tools and accessories. Check for misalignment or binding of moving parts, breakage of parts and any other condition that may affect the power tool's operation.** If damaged, have the power tool repaired before use. Many accidents are caused by poorly maintained power tools.
- **Keep cutting tools sharp and clean.** Properly maintained cutting tools with sharp cutting edges are less likely to bind and are easier to control.
- **Use the power tool, accessories and tool bits etc. in accordance with these instructions, taking into account the working conditions and the work to be performed.** Use of the power tool for operations different from those intended could result in a hazardous situation.
- **Keep handles and grasping surfaces dry, clean and free from oil and grease.** Slippery handles and grasping surfaces do not allow for safe handling and control of the tool in unexpected situations.

### BATTERY TOOL USE AND CARE

- **Recharge only with the charger specified by the manufacturer.** A charger that is suitable for one type of battery pack may create a risk of fire when used with another battery pack.
- **Use power tools only with specifically designated battery packs.** Use of any other battery packs may create a risk of injury and fire.
- **When battery pack is not in use, keep it away from other metal objects, like paper clips, coins, keys, nails, screws or other small metal objects, that can make a connection from one terminal to another.** Shorting the battery terminals together may cause burns or a fire.
- **Under abusive conditions, liquid may be ejected from the battery; avoid contact. If contact acci-**

dentally occurs, flush with water. If liquid contacts eyes, additionally seek medical help. Liquid ejected from the battery may cause irritation or burns.

- **Do not use a battery pack or tool that is damaged or modified.** Damaged or modified batteries may exhibit unpredictable behavior resulting in fire, explosion or risk of injury.
- **Do not expose a battery pack or tool to fire or excessive temperature.** Exposure to fire or temperature above 265°F (130°C) may cause explosion.
- **Follow all charging instructions and do not charge the battery pack or tool outside the temperature range specified in the instructions.** Charging improperly or at temperatures outside the specified range may damage the battery and increase the risk of fire.

## SERVICE

- **Have your power tool serviced by a qualified repair person using only identical replacement parts.** This will ensure that the safety of the power tool is maintained.
- **Never service damaged battery packs.** Service of battery packs should only be performed by the manufacturer or authorized service providers.

## SPECIFIC SAFETY RULES FOR DIE GRINDERS

**Safety Warnings Common for Grinding, Sanding, Wire Brushing, Polishing, Carving or Abrasive Cutting-Off Operations:**

- **This power tool is intended to function as a grinder, sander, wire brush, polisher, carving or cut-off tool. Read all safety warnings, instructions, illustrations and specifications provided with this power tool.** Failure to follow all instructions listed below may result in electric shock, fire and/or serious injury.
- **Do not use accessories which are not specifically designed and recommended by the tool manufacturer.** Just because the accessory can be attached to your power tool, it does not assure safe operation.
- **The rated speed of the grinding accessories must be at least equal to the maximum speed marked on the power tool.** Grinding accessories running faster than their rated speed can break and fly apart.
- **The outside diameter and the thickness of your accessory must be within the capacity rating of your power tool.** Incorrectly sized accessories cannot be adequately controlled.
- **The arbour size of wheels, sanding drum or any other accessory must properly fit the spindle or collet of the power tool.** Accessories that do not match the mounting hardware of the power tool will run out of balance, vibrate excessively and may cause loss of control.
- **Mandrel mounted wheels, sanding drums, cutters or other accessories must be fully inserted into the collet or chuck.** If the mandrel is insufficiently held and/or the overhang of the wheel is too long, the mounted wheel may become loose and be ejected at high velocity.
- **Do not use a damaged accessory. Before each use inspect the accessory such as abrasive wheels for chips and cracks, sanding drum for cracks, tear or excess wear, wire brush for loose or cracked wires. If power tool or accessory is dropped, inspect for damage or install an undamaged accessory. After inspecting and installing an accessory, position yourself and bystanders away from the plane of the rotating accessory and run the power tool at maximum no-load speed**

for one minute. Damaged accessories will normally break apart during this test time.

- **Wear personal protective equipment. Depending on application, use face shield, safety goggles or safety glasses. As appropriate, wear dust mask, hearing protectors, gloves and workshop apron capable of stopping small abrasive or workpiece fragments.** The eye protection must be capable of stopping flying debris generated by various operations. The dust mask or respirator must be capable of filtering particles generated by your operation. Prolonged exposure to high intensity noise may cause hearing loss.
  - **Keep bystanders a safe distance away from work area. Anyone entering the work area must wear personal protective equipment.** Fragments of workpiece or of a broken accessory may fly away and cause injury beyond immediate area of operation.
  - **Hold power tool by insulated gripping surfaces only, when performing an operation where the cutting accessory may contact hidden wiring.** Cutting accessory contacting a "live" wire may make exposed metal parts of the power tool "live" and could give the operator an electric shock.
  - **Always hold the tool firmly in your hand(s) during the start-up.** The reaction torque of the motor, as it accelerates to full speed, can cause the tool to twist.
  - **Use clamps to support workpiece whenever practical. Never hold a small workpiece in one hand and the tool in the other hand while in use.** Clamping a small workpiece allows you to use your hand(s) to control the tool. Round material such as dowel rods, pipes or tubing have a tendency to roll while being cut, and may cause the bit to bind or jump toward you.
  - **Never lay the power tool down until the accessory has come to a complete stop.** The spinning accessory may grab the surface and pull the power tool out of your control.
  - **After changing the bits or making any adjustments, make sure the collet nut, chuck or any other adjustment devices are securely tightened.** Loose adjustment devices can unexpectedly shift, causing loss of control, loose rotating components will be violently thrown.
  - **Do not run the power tool while carrying it at your side.** Accidental contact with the spinning accessory could snag your clothing, pulling the accessory into your body.
  - **Regularly clean the power tool's air vents.** The motor's fan will draw the dust inside the housing and excessive accumulation of powdered metal may cause electrical hazards.
  - **Do not operate the power tool near flammable materials.** Sparks could ignite these materials.
  - **Do not use accessories that require liquid coolants.** Using water or other liquid coolants may result in electrocution or shock.
- ### Kickback and Related Warnings
- Kickback is a sudden reaction to a pinched or snagged rotating wheel, sanding band, brush or any other accessory. Pinching or snagging causes rapid stalling of the rotating accessory which in turn causes the uncontrolled power tool to be forced in the direction opposite of the accessory's rotation. For example, if an abrasive wheel is snagged or pinched by the workpiece, the edge of the wheel that is entering into the pinch point can dig into the surface of the material causing the wheel to climb out or kick out. The wheel may either jump toward or away from the operator, depending on direction of the wheel's movement at

the point of pinching. Abrasive wheels may also break under these conditions. Kickback is the result of power tool misuse and/or incorrect operating procedures or conditions and can be avoided by taking proper precautions as given below.

- **Maintain a firm grip on the power tool and position your body and arm to allow you to resist kickback forces.** The operator can control kickback forces, if proper precautions are taken.
- **Use special care when working corners, sharp edges etc. Avoid bouncing and snagging the accessory.** Corners, sharp edges or bouncing have a tendency to snag the rotating accessory and cause loss of control or kickback.
- **Do not attach a toothed saw blade.** Such blades create frequent kickback and loss of control.
- **Always feed the bit into the material in the same direction as the cutting edge is exiting from the material (which is the same direction as the chips are thrown).** Feeding the tool in the wrong direction causes the cutting edge of the bit to climb out of the work and pull the tool in the direction of this feed.
- **When using rotary files, cut-off wheels, high-speed cutters or tungsten carbide cutters, always have the work securely clamped.** These wheels will grab if they become slightly canted in the groove, and can kickback. When a cut-off wheel grabs, the wheel itself usually breaks. When the rotary file, high-speed cutter or tungsten carbide cutter grabs, it may jump from the groove and you could lose control of the tool.

**Safety Warnings Specific for Grinding and Abrasive Cutting-Off Operations:**

- **Use only wheel types that are recommended for your power tool and only for recommended applications. For example: do not grind with the side of a cut-off wheel.** Abrasive cut-off wheels are intended for peripheral grinding, side forces applied to these wheels may cause them to shatter.
- **For threaded abrasive cones and plugs use only undamaged wheel mandrels with an unrelieved shoulder flange that are of correct size and length.** Proper mandrels will reduce the possibility of breakage.
- **Do not “jam” a cut-off wheel or apply excessive pressure. Do not attempt to make an excessive depth of cut.** Overstressing the wheel increases the loading and susceptibility to twisting or snagging of the wheel in the cut and the possibility of kickback or wheel breakage.
- **Do not position your hand in line with and behind the rotating wheel.** When the wheel, at the point of operation, is moving away from your hand, the possible kickback may propel the spinning wheel and the power tool directly at you.
- **When wheel is pinched, snagged or when interrupting a cut for any reason, switch off the power tool and hold the power tool motionless until the wheel comes to a complete stop. Never attempt to remove the cut-off wheel from the cut while the wheel is in motion otherwise kickback may occur.** Investigate and take corrective action to eliminate the cause of wheel binding.
- **Do not restart the cutting operation in the workpiece. Let the wheel reach full speed and carefully reenter the cut.** The wheel may bind, walk up or kickback if the power tool is restarted in the workpiece.
- **Support panels or any oversized workpiece to minimize the risk of wheel pinching and kickback.** Large workpieces tend to sag under their own weight. Supports must be placed under the workpiece near the line of cut and near the edge of the workpiece on both sides of the wheel.

• **Use extra caution when making a “pocket cut” into existing walls or other blind areas.** The protruding wheel may cut gas or water pipes, electrical wiring or objects that can cause kickback.

**Safety Warnings Specific for Wire Brushing Operations:**

- **Be aware that wire bristles are thrown by the brush even during ordinary operation. Do not overstress the wires by applying excessive load to the brush.** The wire bristles can easily penetrate light clothing and/or skin.
- **Allow brushes to run at operating speed for at least one minute before using them.** During this time no one is to stand in front or in line with the brush. Loose bristles or wires will be discharged during the run-in time.
- **Direct the discharge of the spinning wire brush away from you.** Small particles and tiny wire fragments may be discharged at high velocity during the use of these brushes and may become imbedded in your skin.

**Additional Safety Warnings**

**▲WARNING** To reduce the risk of injury in applications that produce a considerable amount of dust, use an OSHA compliant dust extraction solution in accordance with the solution’s operating instructions.

• **Always use common sense and be cautious when using tools.** It is not possible to anticipate every situation that could result in a dangerous outcome. Do not use this tool if you do not understand these operating instructions or you feel the work is beyond your capability; contact Milwaukee Tool or a trained professional for additional information or training.

• **Maintain labels and nameplates.** These carry important information. If unreadable or missing, contact a MILWAUKEE service facility for a free replacement.

• **▲WARNING** Some dust created by power sanding, sawing, grinding, drilling, and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:

- lead from lead-based paint
  - crystalline silica from bricks and cement and other masonry products, and
  - arsenic and chromium from chemically-treated lumber.
- Your risk from these exposures varies, depending on how often you do this type of work. To reduce your exposure to these chemicals: work in a well ventilated area, and work with approved safety equipment, such as those dust masks that are specially designed to filter out microscopic particles.

• **Do not use this tool to work on asbestos-containing products.** Determine the composition of the workpiece before beginning work. Asbestos should only be removed by a qualified professional.

**SPECIFICATIONS**

Cat. No.....	2485-20
Volts.....	12 DC
Battery Type.....	M12™
Charger Type.....	M12™
Recommended Ambient Operating Temperature.....	0°F to 125°F
Rated RPM.....	24,500
1/4" Collet.....	48-66-0974
1/8" Accessory Collet.....	42-77-0405
Max Accessory Ø.....	2" / 55 mm

## SYMBOLOLOGY



Volts



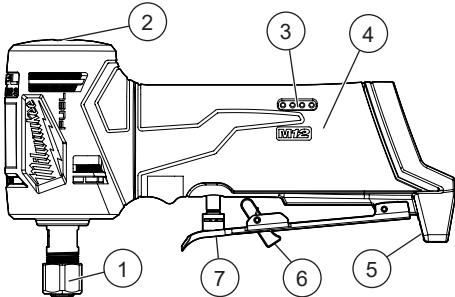
Direct Current

n XXXX min<sup>-1</sup> Rated Revolutions per Minute (RPM)



UL Listing for Canada and U.S.

## FUNCTIONAL DESCRIPTION



1. Collet nut
2. Mode selector
3. Fuel gauge
4. Handle
5. LED
6. Switch lock-off
7. Paddle switch
8. 11/16" wrench (not shown)
9. 1/2" wrench (not shown)

## ASSEMBLY

**WARNING** Recharge only with the charger specified for the battery. For specific charging instructions, read the operator's manual supplied with your charger and battery.

### Removing/Inserting the Battery

To **remove** the battery, push in the release buttons and pull the battery pack away from the tool.

**WARNING** Always remove battery pack before changing or removing accessories.

To **insert** the battery, slide the pack into the body of the tool. Make sure it latches securely into place.

**WARNING** Only use accessories specifically recommended for this tool. Others may be hazardous.

Only use accessories with Maximum Safe Operating Speed rated at least equal to the maximum speed marked on the power tool. This speed is based on the strength of the accessory, allowing for a reasonable measure of safety. It is not meant to imply a best or most efficient operating speed. Do not exceed the Maximum Safe Operating Speed.

### Accessories

Points, cones, plugs, grinding wheels and cut-off wheels should be protected from:

- wetness and extreme humidity
- any type of solvent
- extreme changes in temperature
- dropping and bumping

Points, cones, plugs, grinding wheels and cut-off wheels should be stored:

- in an organized way so points, cones, plugs or wheels can be removed without disturbing or damaging other points, cones, plugs or wheels
  - with their safety information
- Points, cones, plugs, grinding wheels and cut-off wheels should NOT be dropped, rolled or bumped. Discard points, cones, plugs, or wheels that have been dropped, rolled, bumped, subjected to extreme changes in temperature, or come into contact with solvents or wetness.

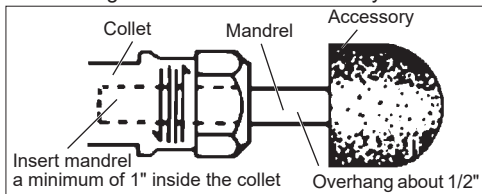
### Installing Collets

The collet must be attached to the collet nut before installing the collet assembly to the tool. Be sure that the collet size matches the size of the mandrel you will use, otherwise the collet may break.

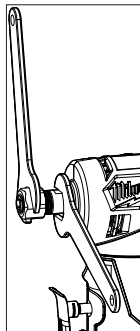
1. To **assemble**, place collet on an even surface, and place the nut over the collet.
2. Press down on the nut to snap the nut and collet together.
3. To **disassemble**, use a rod to push the collet out of the nut.

### Installing Accessories

1. Remove dust and debris from the collet body before inserting accessory.
2. Insert the collet with the collet nut attached into the collet body. Thread the collet nut onto the spindle but do not tighten it yet.
3. Clean the accessory mandrel, then insert it a minimum of 1" into the collet. The mandrel will overhang the collet and the accessory about 1/2".



4. Hold the spindle shaft steady with a 1/2" open end wrench and securely tighten the collet nut with an 11/16" open end wrench.
5. Reverse the procedure when removing the accessory.



**WARNING** To reduce the risk of injury, always securely tighten the collet to the grinders and clean mandrels before inserting them into the collet. Otherwise the high-speed rotation of the tool could force the accessory to fly out of the collet.

## OPERATION

**⚠WARNING** To reduce the risk of injury, always wear proper eye protection marked to comply with ANSI Z87.1.

When working in dusty situations, wear appropriate respiratory protection or use an OSHA compliant dust extraction solution.

### Fuel Gauge

To determine the amount of charge left in the battery, turn the tool **ON**. The Fuel Gauge will light up for 2-3 seconds. When less than 10% of charge is left, 1 light on the fuel gauge will flash 4 times.

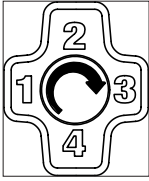
To signal the end of charge, 1 light on the fuel gauge will flash 8 times and the tool will not run. Charge the battery pack.

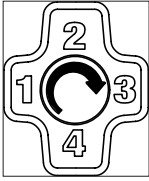
If the battery becomes too hot, the fuel gauge lights will flash in an alternating pattern and the tool will not run. Allow the battery to cool down.

### Using the Mode Selector

The mode selector button is used to adjust the rotation speed (RPM) for the application.

To select the mode:

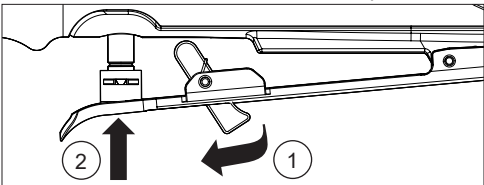
1. Push the switch lock-off forward then squeeze and release the paddle switch. The current mode indicator number is lit.
2. Press the mode selector button  to cycle through the 4 modes. When the desired mode indicator number is lit, begin work.



Mode	1	2	3	4
RPM	0 - 10,000	0 - 15,000	0 - 20,000	0 - 24,500

### General Operation

1. If you have just installed an accessory or are beginning a period of work, test it by letting it spin for one minute before applying it to the workpiece. **WARNING!** Never use an accessory that has been dropped. Out-of-balance or damaged accessories can mar workpiece, damage the tool, and cause stress that may cause accessory failure.
2. Use a clamp, vise or other practical means to hold your work.
3. To start the tool, push the switch lock-off forward (1) and squeeze the paddle switch (2). **NOTE:** An LED is turned on when the switch is pulled.



4. Allow accessory to come to full speed before beginning work.
5. To vary the speed, increase or decrease pressure on the switch. The further the switch is pulled, the greater the speed.
6. Control pressure and surface contact between ac-

cessory and workpiece. **WARNING!** Never bang accessories onto work. Too much pressure causes accessory failure or slows speed.

7. To stop the tool, release the switch. Make sure the tool comes to a complete stop before laying the tool down.

If the grinder begins vibrating, immediately stop the motor and check to see if the accessory is dull. Dull accessories will cause the tool to vibrate and could force the collet to fly off the tool. Always replace or sharpen dull accessories. Accessories are design for specific uses. Only use points, cones, plugs, grinding wheels and cut-off wheels for applications for which they were designed. Follow manufacturer's care and use instructions.

## MAINTENANCE

**⚠WARNING** To reduce the risk of injury, always unplug the charger and remove the battery pack from the charger or tool before performing any maintenance. Never disassemble the tool, battery pack or charger. Contact a MILWAUKEE service facility for ALL repairs.

### Maintaining Tool

Keep your tool, battery pack and charger in good repair by adopting a regular maintenance program. Inspect your tool for issues such as undue noise, misalignment or binding of moving parts, breakage of parts, or any other condition that may affect the tool operation. Return the tool, battery pack, and charger to a MILWAUKEE service facility for repair. After six months to one year, depending on use, return the tool, battery pack and charger to a MILWAUKEE service facility for inspection.

If the tool does not start or operate at full power with a fully charged battery pack, clean the contacts on the battery pack. If the tool still does not work properly, return the tool, charger and battery pack, to a MILWAUKEE service facility for repairs.

**⚠WARNING** To reduce the risk of personal injury and damage, never immerse your tool, battery pack or charger in liquid or allow a liquid to flow inside them.

### Cleaning

Clean dust and debris from vents. Keep handles clean, dry and free of oil or grease. Use only mild soap and a damp cloth to clean, since certain cleaning agents and solvents are harmful to plastics and other insulated parts. Some of these include gasoline, turpentine, lacquer thinner, paint thinner, chlorinated cleaning solvents, ammonia and household detergents containing ammonia. Never use flammable or combustible solvents around tools.

### Repairs

For repairs, return the tool, battery pack and charger to the nearest service center.

## ACCESSORIES

**⚠WARNING** Use only recommended accessories. Others may be hazardous.