SERVICE PARTS LIST

Milwaukee

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

M12™ FUEL™ 1/2" (13mm) HAMMER-DRILL

CATALOG NO. 2504-20 STARTING SERIAL NO.

NG J17A

REVISED BULLETIN

WIRING INSTRUCTION
See Reverse Side

Apply Blue Loctite® thread locking sealant or the equivalent to the threads of the chuck screw (1)

before securing chuck to the gearcase spindle.

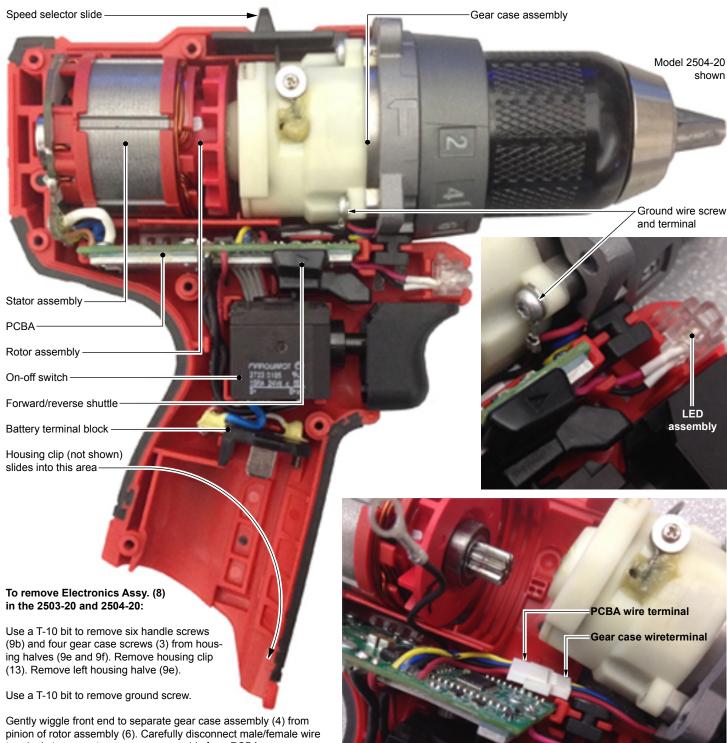
					SERIAL NO.	<u> </u>	See Reverse Side
00 -	EXAMPLE:						
00 0	Component	Parts (Small #)) Are Included				11
	─ When Order	ing The Assem	ıbly (Large #).				
		•	, , ,				
FIG.	PART NO.	DESCRIPTION	ON OF PART	NO. REQ.		The Theorem	12
1	05-88-0202	Chuck Screw		(1)			7 P12
				(1)			
2	42-66-0020		Keyless Chuck	(1)	9f		
3	06-82-6351	M3 x 16mm l	Pan Hd. ST T-10 Screw		01		
4	14-29-2504	Gear Case A	ssembly	(1)			
4a	05-81-0542		m Phillips Washer Scre				
4b	44-10-0195	Speed Selec	tor Lover	(1)			
					9d ———		
5	45-24-0230		tor Slide Assembly	(1)			\sim 10 8
6	16-01-2503	Rotor		(1)			10 8 9
7	42-42-0355	Forward/Rev	erse Shuttle	(1)		///	
8	14-20-2500	Electronics A		(1)			
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9b —			/ /13	/اح	•	3	

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
9	31-44-2503	Housing Kit	(1)
9a	45-30-0066	Sealing Pad	(1)
9b	06-82-1080	M3 x 14mm Pan Hd. ST T-10 Screw	(6)
9c	12-20-2500	Service Nameplate	(1)
9d	23-28-0165	Light Pipe	(1)
9e		Housing Cover - Right Housing Halve	(1)
9f		Housing Support - Left Housing Halve	(1)
10	14-20-2501	Electronics/Housing Assembly	(1)
11	05-88-1015	M2.5 x 6mm Pan Hd. Phillips Mach. Sc	r. (1)
12	42-70-0117	Belt Clip	(1)
13	42-70-0058	Housing Clip	(1)
14	42-55-2503	Blow Molded Carrying Case	(1)

(6x)

SCREW TORQUE SPECIFICATION CHART									
			SEATING TORQUE						
FIG.	PART NO.	DESCRIPTION	(IN-LBS)						
1	05-88-0202	Chuck Screw	33±2.5						
3	06-82-6351	Gearcase Assembly Screw	7.0±2.5						
4a	05-81-0542	Speed Selector Lever Screw	3.5±1						
9b	06-82-1080	Right Housing Halve Screw	7.0±2.5						
11	05-88-1015	Belt Clip	Hand Tighten						

(4x)



terminals to separate gear case assembly from PCBA.

Lift stator from left housing cavity and carefully remove rotor assembly from the stator.

Lift old electronics assembly out of left housing halve, paying attention to wire routing and trapping.

To install new Electronics Assembly (8) in the 2503-20 and 2504-20:

Carefully place existing rotor (6) into stator of new electronics assembly.

Connect female wire terminal of gear case assembly (4) with male wire terminal of the PCBA.

Place stator/rotor and PCBA firmly and squarely into corresponding channels and cavities of left housing halve (9e).

Insert the rotor pinion into rear of gear case assembly, meshing the gears and seating the rotor bearing. At this point install two gear case screws (3), partially securing electronics assembly and gear case assembly.

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Be sure connected wire terminals are trapped between a small tab in the housing halve (above the PCBA) and below the gear case. Put ground screw through ground wire terminal and install onto gear case. Be sure terminal connector wires and ground wire are tucked back into left housing halve.

Place LED assembly, on-off switch and battery terminal block firmly and squarely into the corresponding channels and cavities of the left housing halve. Be sure all wires are routed and tucked down in channels and traps as illustrated above.

Re-install speed selector slide (5) and forward/reverse shuttle (7).

Carefully place right handle halve onto left handle halve. Check for any component interference or pinched wires. Re-install remaining screws and housing clip. Check for proper functionality of on-off switch, forward/ reverse shuttle and speed selector.

Install battery and check for the proper operation of tool.

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