

To remove Electronics Assy. (8) in the 2503-20 and 2504-20:

Use a T-10 bit to remove six handle screws (9b) and four gear case screws (3) from housing halves (9e and 9f). Remove housing clip (13). Remove left housing half (9e).

Use a T-10 bit to remove ground screw.

Gently wiggle front end to separate gear case assembly (4) from pinion of rotor assembly (6). Carefully disconnect male/female wire 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 half, paying attention to wire routing and trapping.

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

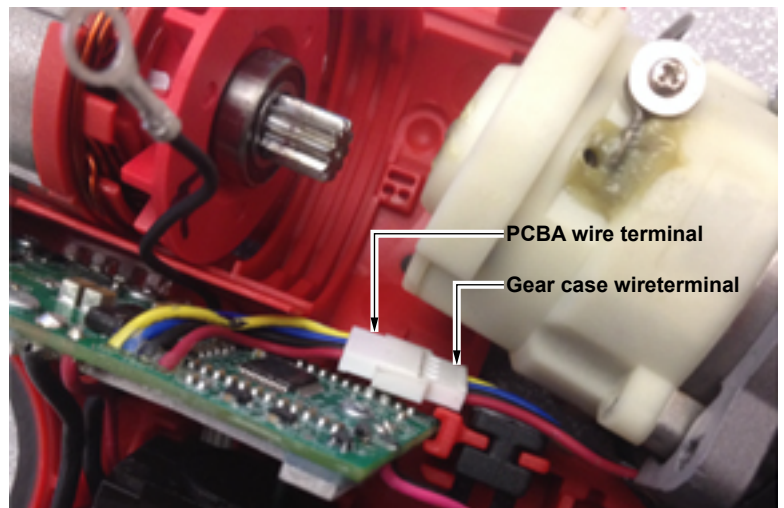
Carefully place existing rotor (6) into stator of new electronics assembly.

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 half (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 half (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 half.

Place LED assembly, on-off switch and battery terminal block firmly and squarely into the corresponding channels and cavities of the left housing half. 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 half onto left handle half. 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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