



## OPERATOR'S MANUAL



Cat. No. / No de cat.

6580-20, 6740-20, 6742-20, 6780-20,  
6790-20, 6791-20, 6791-21, 6792-20

**HEAVY-DUTY SCREWDRIVER  
EXTRA ROBUSTE TOURNEVIS  
DESTORNILLADORES HEAVY-DUTY**



**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 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.

### 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.

## SPECIFIC SAFETY RULES FOR SCREWDRIVER

- **Hold power tool by insulated gripping surfaces, when performing an operation where the fastener may contact hidden wiring or its own cord.** Fasteners contacting a "live" wire may make exposed metal parts of the power tool "live" and could give the operator an electric shock.
- **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.

### EXTENSION CORDS

Grounded tools require a three wire extension cord. Double insulated tools can use either a two or three wire extension cord. As the distance from the supply outlet increases, you must use a heavier gauge extension cord. Using extension cords with inadequately sized wire causes a serious drop in voltage, resulting in loss of power and possible tool damage. Refer to the table shown to determine the required minimum wire size.

The smaller the gauge number of the wire, the greater the capacity of the cord. For example, a 14 gauge cord can carry a higher current than a 16 gauge cord. When using more than one extension cord to make up the total length, be sure each cord contains at least the minimum wire size required. If you are using one extension cord for more than one tool, add the nameplate amperes and use the sum to determine the required minimum wire size.

#### Guidelines for Using Extension Cords

- If you are using an extension cord outdoors, be sure it is marked with the suffix "W-A" ("W" in Canada) to indicate that it is acceptable for outdoor use.
- Be sure your extension cord is properly wired and in good electrical condition. Always replace a damaged extension cord or have it repaired by a qualified person before using it.
- Protect your extension cords from sharp objects, excessive heat and damp or wet areas.

Nameplate Amps	Recommended Minimum Wire Gauge For Extension Cords*				
	Extension Cord Length				
	25'	50'	75'	100'	150'
0 - 2.0	18	18	18	18	16
2.1 - 3.4	18	18	18	16	14
3.5 - 5.0	18	18	16	14	12
5.1 - 7.0	18	16	14	12	12
7.1 - 12.0	16	14	12	10	--
12.1 - 16.0	14	12	10	--	--
16.1 - 20.0	12	10	--	--	--

\* Based on limiting the line voltage drop to five volts at 150% of the rated amperes.

## GROUNDING

**WARNING** Improperly connecting the grounding wire can result in the risk of electric shock. Check with a qualified electrician if you are in doubt as to whether the outlet is properly grounded. Do not modify the plug provided with the tool. Never remove the grounding prong from the plug. Do not use the tool if the cord or plug is damaged. If damaged, have it repaired by a MILWAUKEE service facility before use. If the plug will not fit the outlet, have a proper outlet installed by a qualified electrician.

### Grounded Tools (Three-Prong Plugs)

Tools marked "Grounding Required" have a three wire cord and three prong grounding plug. The plug must be connected to a properly grounded outlet (See Figure A). If the tool should electrically malfunction or break down, grounding provides a low resistance path to carry electricity away from the user, reducing the risk of electric shock. The grounding prong in the plug is connected through the green wire inside the cord to the grounding system in the tool. The green wire in the cord must be the only wire connected to the tool's grounding system and must never be attached to an electrically "live" terminal.

Your tool must be plugged into an appropriate outlet, properly installed and grounded in accordance with all codes and ordinances. The plug and outlet should look like those in Figure A.

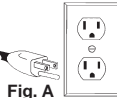


Fig. A

### Double Insulated Tools (Two-Prong Plugs)

Tools marked "Double Insulated" do not require grounding. They have a special double insulation system which satisfies OSHA requirements and complies with the applicable standards of Underwriters Laboratories, Inc., the Canadian Standard Association and the National Electrical Code. Double Insulated tools may be used in either of the 120 volt outlets shown in Figures Fig. B Fig. C B and C.

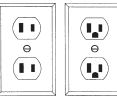








Fig. B Fig. C

## SYMBOLOLOGY

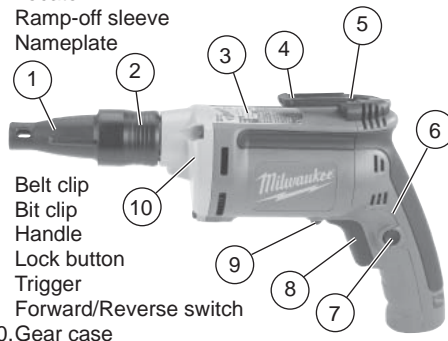
-  Double Insulated
-  Volts
-  Alternating Current
-  Amps
- $n_0$  XXXX min<sup>-1</sup> No Load Revolutions per Minute (RPM)
-  UL Listing for Canada and U.S.
-  Approval Mark for Mexico

## SPECIFICATIONS

Volts.....	120 AC
Amps.....	6.5
<b>Cat. No.</b> .....	<b>6580-20</b>
RPM.....	0 - 1200
<b>Cat. No.</b> .....	<b>6740-20</b>
RPM.....	0 - 2500
<b>Cat. No.</b> .....	<b>6742-20</b>
RPM.....	0 - 4300
<b>Cat. No.</b> .....	<b>6780-20</b>
RPM.....	0 - 2900
<b>Cat. No.</b> .....	<b>6790-20</b>
RPM.....	0 - 2500
<b>Cat. No.</b> .....	<b>6791-20</b>
RPM.....	0 - 2500
<b>Cat. No.</b> .....	<b>6791-20</b>
RPM.....	0 - 2500
<b>Cat. No.</b> .....	<b>6792-20</b>
RPM.....	0 - 2500

## FUNCTIONAL DESCRIPTION

1. Locator
2. Ramp-off sleeve
3. Nameplate



4. Belt clip
5. Bit clip
6. Handle
7. Lock button
8. Trigger
9. Forward/Reverse switch
10. Gear case

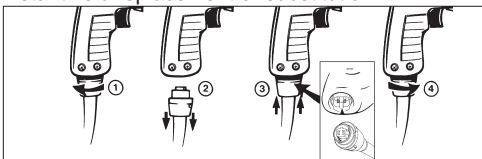
## ASSEMBLY

**WARNING** To reduce the risk of injury, always unplug tool before changing or removing accessories. Only use accessories specifically recommended for this tool. Others may be hazardous.

### Removing and Replacing Quik-Lok® Cords

(Cat. No. 6580-20, 6791-20)

MILWAUKEE's exclusive Quik-Lok® Cords provide instant field replacement or substitution.

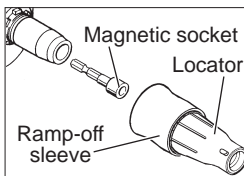


1. To remove the Quik-Lok® Cord, turn the cord nut 1/4 turn to the left and pull it out.
2. To replace the Quik-Lok® Cord, align the connector keyways and push the connector in as far as it will go. Turn the cord nut 1/4 turn to the right to lock.

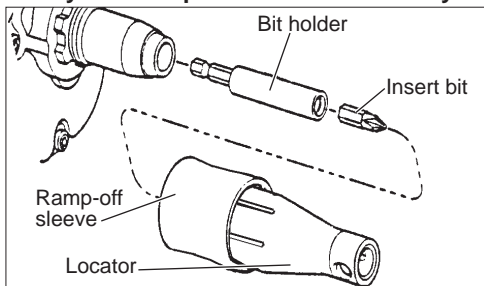
### Installing and Removing Bits TEKS Ramp-Off Locator Assembly

The locator assembly must be removed when changing bit sizes.

1. Unplug tool. To remove the locator assembly, turn the ramp-off sleeve while pulling it away from the tool.
2. Pull out the magnetic socket and replace it with a new socket.
3. Push the locator assembly onto the nose of the tool until it snaps into place.



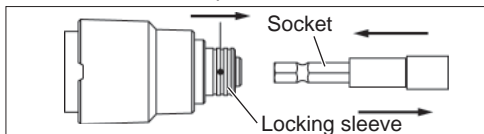
### Installing and Removing Bits Drywall Ramp-Off Locator Assembly



1. Unplug tool. To remove the locator assembly, turn the ramp-off sleeve while pulling it away from the tool.
2. Push insert bit into bit holder until it snaps into place. Push the bit holder into the nose of the tool until it snaps into place.
3. Push the locator assembly onto the nose of the tool until it snaps into place.

### Installing and Removing Magnetic Sockets on Adjustable Screwdrivers For Cat. No. 6580-20

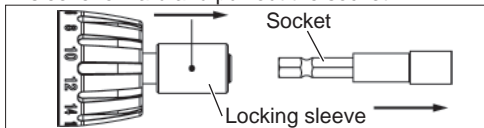
1. Unplug tool.
2. To remove the magnetic socket, slide the locking sleeve forward and pull out the socket.



3. To install the magnetic socket, slide the locking sleeve forward and push in the socket until it is fully seated.

### For Cat. No. 6780-20

1. Unplug tool.
2. To remove the magnetic socket, slide the locking sleeve forward and pull out the socket.



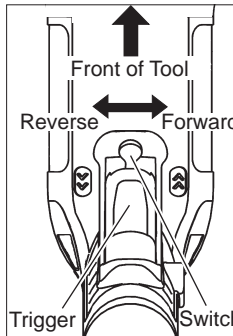
3. To install the magnetic socket, simply push in the socket until it snaps into place.

## OPERATION

**WARNING** To reduce the risk of injury, always wear safety goggles or glasses with side shields.

### Using Forward/Reverse Switch

1. For forward (clockwise) rotation, push the forward/reverse switch to the left position as shown.
2. For reverse (counterclockwise) rotation, push the forward/reverse switch to the right position as shown. Although an interlock prevents reversing the tool while the motor is running, allow it to come to a full stop before reversing.



**WARNING** To reduce the risk of injury, keep hands and cord away from the bit and all moving parts.

### Starting, Stopping and Controlling Speed

1. To start the tool, pull the trigger.
2. To stop the tool, release the trigger.
3. To vary the drilling speed, simply increase or decrease pressure on the trigger. The further the trigger is pulled, the greater the speed.

### Locking Trigger

The lock button holds the trigger in the ON position for continuous full speed use.

1. To lock the trigger, hold the lock button in while pulling the trigger. Release the trigger.
2. To unlock the trigger, pull the trigger and release. The lock button will pop out.

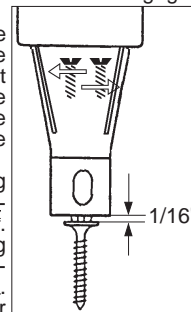
### Adjusting Locator Assembly

The locator assembly controls the tool's driving depth. These screwdrivers feature a locator assembly with one-handed depth adjustment. Depth adjustments can be made easily and quickly by turning the locator with one hand. Detents inside the sleeve "lock" the selected depth.

For the drywall ramp-off locator assembly, start with about 1/16" clearance between the head of the screw and nose with the snap-action clutch disengaged as shown.

For both locator assemblies, the detents on the inside of the sleeve represent different depths. Every two clicks of the locator equal 1/64". Continue adjusting the locator to the desired depth.

1. To increase the driving depth, simply rotate the locator in the direction labeled "MAX".
2. To decrease the driving depth, simply rotate the locator in the direction labeled "MIN". The detents "lock" the locator in place, ensuring an accurate depth setting.
3. To remove the locator assembly, turn the ramp-off sleeve while pulling it away from the tool. Reattaching the locator assembly will not change the depth setting.



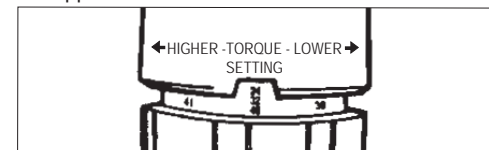
## Adjusting Torque Setting

These screwdrivers have a torque setting adjustment collar for driving different types of screws into different materials. When properly adjusted, the clutch will slip at a preset torque to prevent driving the screw too deep and to prevent damage to the screw or tool.

### For Cat. Nos. 6580-20

The 6580-20 Screwdriver has a torque setting adjustment collar that may be adjusted to one of forty-four settings. The torque is adjustable from 10 to 140 inch-pounds.

To select a setting, turn the adjustment collar in the direction indicated on the tool. The selected setting will appear in the window as shown.



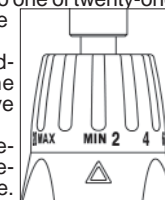
**NOTE:** Use a piece of scrap material to test the different settings before driving screws into workpiece. To determine a specific setting for your application, use a torque wrench to check the correct torque at any particular setting.

### For Cat. No. 6780-20

The 6780-20 Screwdriver has a torque setting adjustment collar that may be adjusted to one of twenty-one settings. The torque is adjustable from 10 to 140 inch-pounds.

To select a setting, turn the adjustment collar on the tool. The selected setting will appear above the arrow as shown.

**NOTE:** Use a piece of scrap material to test the different settings before driving screws into workpiece. To determine a specific setting for your application, use a torque wrench to check the correct torque at any particular setting.

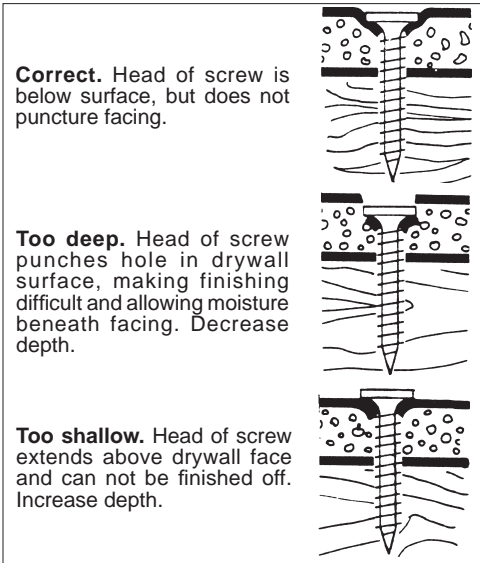


## APPLICATIONS

**WARNING** To reduce the risk of electric shock, check work area for hidden pipes and wires before drilling or driving screws.

### Driving Drywall Screws For Screwdrivers Rated up to 4300 RPM

Standard drywall screws are generally designed for attaching drywall to wood studs and 26 through 20-gauge steel studs. MILWAUKEE Screwdrivers are ideal for driving these types of drywall screws. The depth setting is very important. Refer to the guide below for the correct depth setting.



**Correct.** Head of screw is below surface, but does not puncture facing.

**Too deep.** Head of screw punches hole in drywall surface, making finishing difficult and allowing moisture beneath facing. Decrease depth.

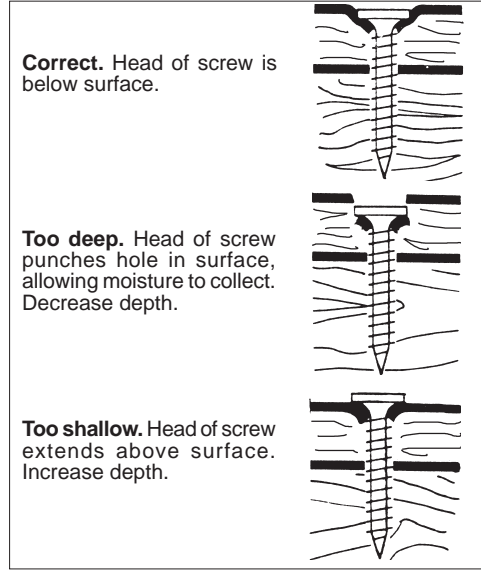
**Too shallow.** Head of screw extends above drywall face and can not be finished off. Increase depth.

1. Select the proper drywall screw for each job. Pilot holes are not needed. To insert screws, place the screw onto the insert bit, then align the screw against the work surface, making sure to hold the tool and screw square to the work surface. If the tool or screw are misaligned, the screw will not drive into the work surface or it will not drive straight.
2. Pull the trigger and push the tool forward with a "punching" motion to sink the screw into the drywall. A punching motion will engage the snap-action clutch, cause the screw to start rotating, sink the screw and disengage the snap-action clutch within a fraction of a second. If pressure is not maintained on the tool after engaging the snap-action clutch, the screw will not properly seat. The snap-action clutch will automatically disengage and the insert bit will stop rotating once the screw has been driven to the selected depth. These screwdrivers feature a snap-action clutch, which may ratchet slightly when the screw is sunk to the selected depth.  
**NOTE:** Practice driving screws into pieces of scrap material to become familiar with the tool and the snap-action clutch action before attempting to drive screws into the workpiece.

3. To remove screws, remove the locator assembly and switch the forward/reverse switch to the reverse position. Reattaching the locator assembly will not change the depth setting.

### Driving Decking Screws For Screwdrivers with Depth Locators Rated up to 2900 RPM

Standard decking screws are generally designed for attaching wood to wood studs. MILWAUKEE Screwdrivers are ideal for driving these types of decking screws. The depth setting is very important. Refer to the guide below for the correct depth setting.



**Correct.** Head of screw is below surface.

**Too deep.** Head of screw punches hole in surface, allowing moisture to collect. Decrease depth.

**Too shallow.** Head of screw extends above surface. Increase depth.

1. Select the proper decking screw for each job. Pilot holes are not needed. To insert screws, place the screw onto the insert bit, then align the screw against the work surface, making sure to hold the tool and screw square to the work surface. If the tool or screw are misaligned, the screw will not drive into the work surface or it will not drive straight. Wood screws have sharp points or drill points, and coarse threads that help the screw through the wood.
2. Pull the trigger and push the tool forward to sink the screw into the wood. A quick motion will engage the snap-action clutch, cause the screw to start rotating, sink the screw and disengage the snap-action clutch within a fraction of a second. If pressure is not maintained on the tool after engaging the snap-action clutch, the screw will not properly seat. The snap-action clutch will automatically disengage and the insert bit will stop rotating once the screw has been driven to the selected depth. These screwdrivers feature a snap-action clutch, which may ratchet slightly when the screw is sunk to the selected depth.  
**NOTE:** Practice driving screws into pieces of scrap material to become familiar with the tool and the snap-action clutch action before attempting to drive screws into the workpiece.

3. To remove screws, remove the locator assembly and switch the forward/reverse switch to the reverse position. Reattaching the locator assembly will not change the depth setting.

### Driving Self-Drilling Screws into Cold-Formed Steel Framing For Adjustable Torque Screwdrivers Rated up to 2900 RPM

Follow this procedure when working with light gauge sheet metal, 20 gauge and thicker. The screw may hesitate slightly when it finishes breaking through the first layer of material and starts to penetrate the sheet metal. This is normal. Keep firm pressure on the tool until the screw is fully seated.

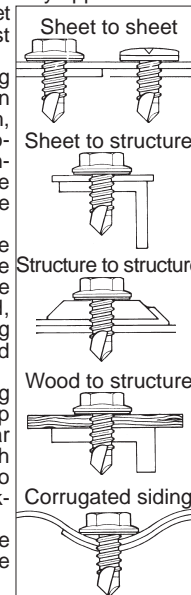
Self-drilling and self-tapping screws drill, tap and fasten in one quick, easy motion without a separate drilling operation. Their unique design works in metal up to 1/2" thick, giving a strong, reliable hold. The drill point ensures rapid drilling and consistently low drilling pressure while the drill flutes remove drilling chips. The pilot section ensures that drilling is completed before the first thread engages the material. These screws can be used in many applications.

1. Insert screw into the hex socket and align the screw against the work surface.

2. Pull the trigger while pushing the tool forward. This motion will engage the drive clutch, causing the screw to start rotating. If pressure is not maintained on the tool, the drive clutch will disengage and the screw will stop rotating.

When the selected torque is fully reached, the torque clutch will ratchet. If the screw is not fully seated, increase the torque setting number until the desired torque is obtained.  
**NOTE:** Practice driving screws into pieces of scrap material to become familiar with the tool and the clutch action before attempting to drive screws into the workpiece.

3. To remove screws, switch the forward/reverse switch to the reverse position.



### Driving Wood Screws

When driving wood screws, a pilot hole is recommended to make driving easier and to prevent splitting the wood. As a general rule, the pilot hole should have a diameter of approximately 70% the size of the screw diameter. Hardwood pilot holes should have a diameter of approximately 90% the size of the screw diameter. The depth of the pilot hole should be shorter than the length of the screw by at least one screw diameter. This allows the tip of the screw to bite into the wood for extra holding power. Counterbore the top portion of the hole for a free fit of the shank between the screw head and the threads. When using flat head screws, countersink the top of the hole to allow the screw head to be driven flush with the work surface. Use soap or wax for easier screw insertion if necessary.

## MAINTENANCE

**WARNING** To reduce the risk of injury, always unplug the tool before performing any maintenance. Never disassemble the tool. Contact a MILWAUKEE service facility for ALL repairs.

### Maintaining Tools

Keep your tool 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 to a MILWAUKEE service facility for repair. After six months to one year, depending on use, return the tool to a MILWAUKEE service facility for inspection.

**WARNING** To reduce the risk of personal injury, electric shock and damage, never immerse your tool in liquid or allow a liquid to flow inside it.

### 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 to the nearest service center.

## ACCESSORIES

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