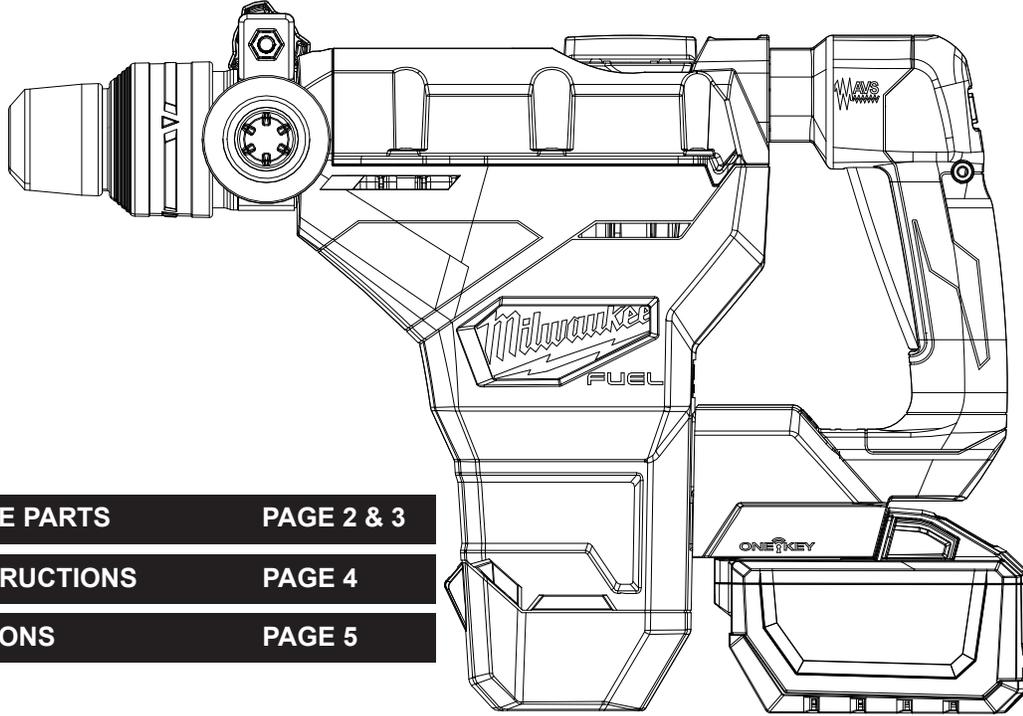




# SERVICE PARTS LIST

BULLETIN NO.  
54-00-2718

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ FUEL™ 1-3/4" SDS-Max Rotary Hammer with One-Key			Apr. 2022
CATALOG NO.	2718-20	SERIAL NUMBER	J97A & J97B
WIRING INSTRUCTION			



EXTERNAL SERVICE PARTS	PAGE 2 & 3
LUBRICATION INSTRUCTIONS	PAGE 4
WIRING INSTRUCTIONS	PAGE 5

**Service** for the **ELECTRONICS** on Milwaukee Tool **ONE KEY** Products **can only be performed at this Milwaukee factory Central Repair Center:**

**MILWAUKEE TOOL Central Repair**  
**1401 Sycamore Avenue • Greenwood, MS 38930-7277**

Please send your tool directly to this location for service.

Or

**Via e-Service at: [www.milwaukeetool.com/e-service](http://www.milwaukeetool.com/e-service)**  
 questions, please call 1.800.SAWDUST (1.800.729.3878)

Or

Return it to a MILWAUKEE *factory* Service Center location, freight prepaid and insured. A copy of the proof of purchase should be included with the return product.

If you have questions please contact Milwaukee Product Service at:  
**Product Technical Support via phone at: 262.783.8642**

Or

**Via email at: [METProductSupport@milwaukeetool.com](mailto:METProductSupport@milwaukeetool.com)**

**Disassembly is not recommended and could void the warranty.**



# SERVICE PARTS LIST

BULLETIN NO.  
54-00-2718

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M18™ FUEL™ 1-3/4" SDS-Max Rotary Hammer with One-Key™			Apr. 2022
CATALOG NO.	2718-20	WIRING INSTRUCTION SEE PAGE 4	
STARTING SERIAL	J97A & J97B		

**EXAMPLE:**  
00 0 Component Parts (Small #)  
Are Included When Ordering  
The Assembly (Large #).

★ = Part number change from  
previous service parts list.

● = Component of the  
14-46-2718 Service  
Maintenance Kit

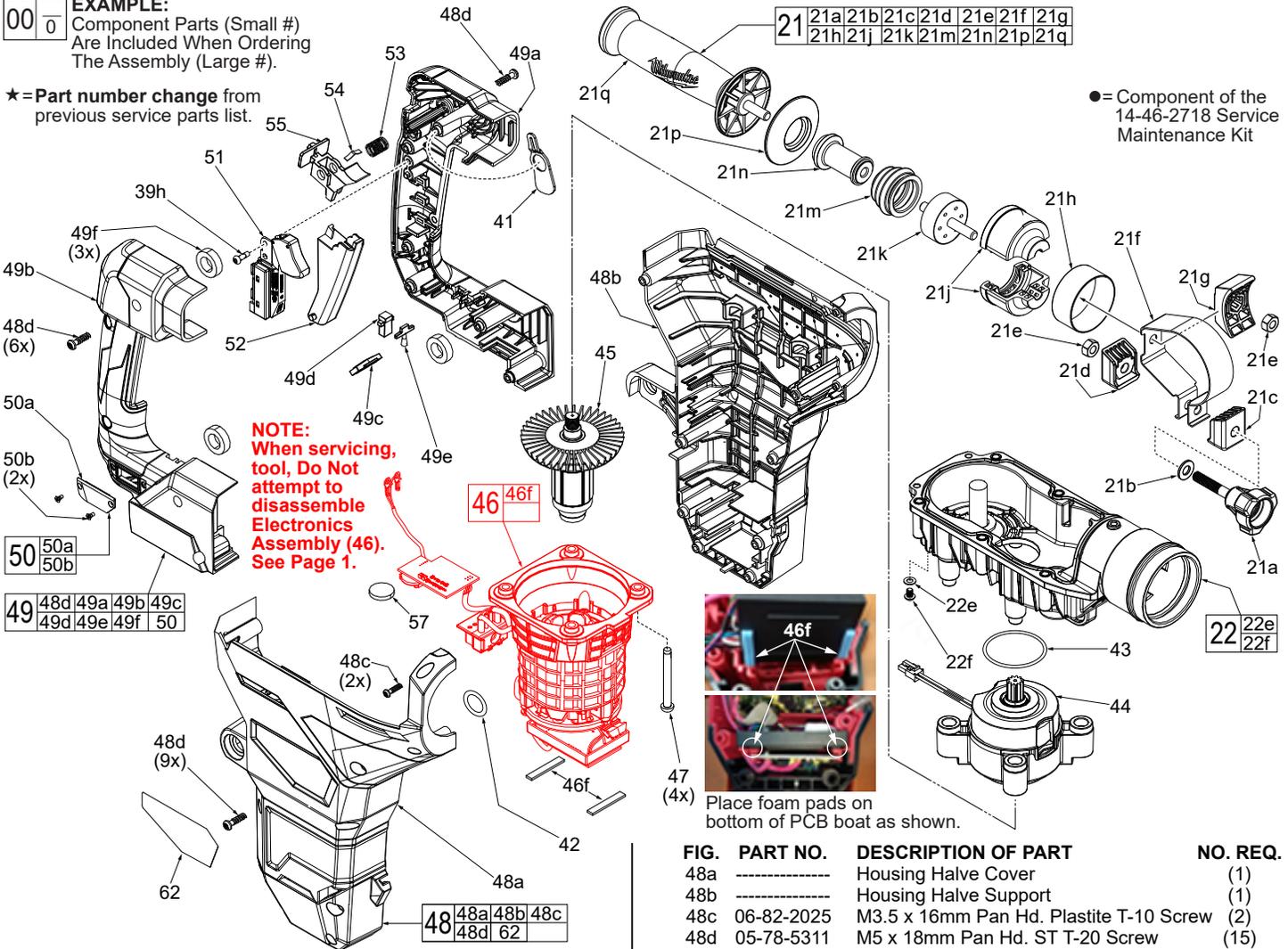


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
21	42-62-0013	Side Handle Assembly	(1)
21a	05-89-0015	Fixing Screw	(1)
21b	45-88-0103	Flat Washer	(1)
21c	43-72-0002	Holder 1	(1)
21d	43-72-0003	Holder 2	(1)
21e	06-55-0018	Hex Nut	(1)
21f	31-05-0011	Clamping Ring	(1)
21g	44-66-0049	Support Plate	(1)
21h	44-90-0046	Ring	(1)
21j	43-76-0012	Absorber Housing	(2)
21k	44-52-0013	Absorber	(1)
21m	43-87-0015	Bellows	(1)
21n	43-24-0010	Extension	(1)
21p	42-52-0031	Side Handle Cap	(1)
21q	43-98-5316	Side Handle	(1)
★22	14-29-0014	Gearcase Assembly	(1)
22e	-----	Flat Washer	(1)
22f	-----	M6 x 10mm BUH Hex Recess Screw	(1)
39h	06-82-0032	M4 x 12mm Pan Hd. ST T-20 Screw	(1)
41	44-50-0013	Lock Cam	(1)
42	34-40-5308●	O-Ring	(1)
43	34-40-0088	O-Ring	(1)
44	42-70-0028	EM-Clutch Assembly	(1)
45	16-01-0010	Rotor Assembly	(1)
46	-----	Electronics Assembly	(1)
46f	44-52-0066	Foam Pad (Set of two)	(1)
47	05-88-0028	M6 x 55mm Pan Hd. Taptite T-30 Screw	(4)
48	31-44-0118	Housing Assembly	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
48a	-----	Housing Halve Cover	(1)
48b	-----	Housing Halve Support	(1)
48c	06-82-2025	M3.5 x 16mm Pan Hd. Plastite T-10 Screw	(2)
48d	05-78-5311	M5 x 18mm Pan Hd. ST T-20 Screw	(15)
49	43-62-0038	Handle Kit	(1)
49a	-----	Handle Support	(1)
49b	-----	Handle Cover	(1)
49c	44-66-0057	Auto Stop Plate	(1)
49d	44-06-0014	Bluetooth Indicator Lens	(1)
49e	44-06-0018	Bluetooth Working Lens	(1)
49f	42-42-0054●	Foam Bushing	(3)
50	31-21-0066	Coin Cell Cover Kit	(1)
50a	-----	Coin Cell Cover	(1)
50b	05-81-1100	M2.6 x 6mm ST Phillips Screw	(2)
51	23-66-5027	On-Off Switch	(1)
52	45-72-0012	Switch Trigger	(1)
53	40-50-0059	Spring	(1)
54	40-50-0027	Spring Plate	(1)
55	44-60-0089	Lock Button	(1)
57	-----	3V Coin Cell Battery (CR2032H)	(1)
62	12-20-0138	Service Nameplate	(1)

- See page 2 for the exploded view and parts listing of the mechanical portion of the tool and service fixtures.
- See page 3 for lubrication instructions, torques chart, maintenance instructions and service kits.
- See Page 4 for wiring instructions.

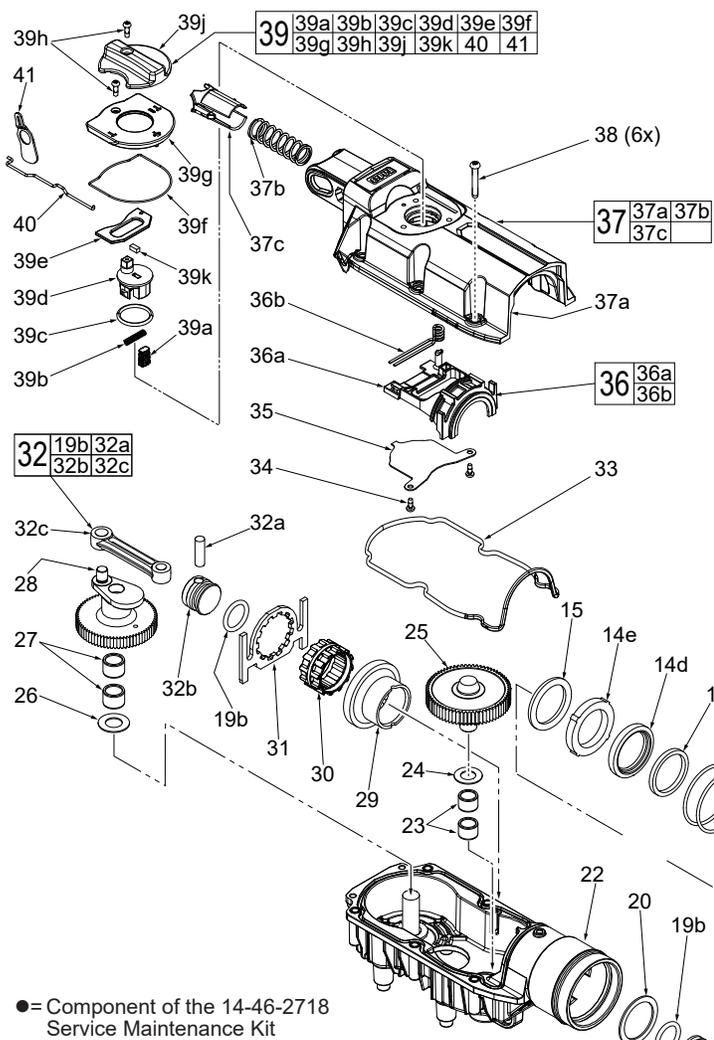
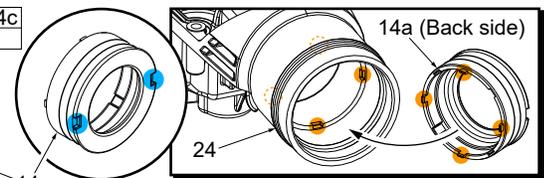


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
23	02-50-0018	Needle Bearing	(2)
24	45-88-0074	Washer	(1)
25	32-10-0012	Clutch Assembly	(1)
26	45-88-5327	Washer	(1)
27	02-50-5315	Needle Bearing	(2)
28	32-62-0010	Crank Shaft	(1)
29	32-05-0016	Spindle Bevel Gear	(1)
30	42-76-0014	Drive Sleeve	(1)
31	44-66-0048	Locking Plate	(1)
32	14-09-0012	Piston and Connecting Rod Assembly	(1)
32a	-----	Wrist Pin	(1)
32b	-----	Piston	(1)
32c	44-94-0016	Connecting Rod	(1)
33	43-44-0012	Rubber Gasket	(1)
34	05-78-5313	M4 x 14mm Pan Hd. Taptite T-20	(2)
35	42-36-0024	Selector Bracket Clamp Plate	(1)
36	14-46-0100	Fork Assembly	(1)
36a	-----	Fork	(1)
36b	-----	Fork Assembly Spring	(1)
37	31-15-0037	Gearcase Cover Kit	(1)
37a	31-15-0028	Gearcase Cover	(1)
37b	40-50-0149	Spring	(1)
37c	43-56-0011	Spring Carrier	(1)
38	05-78-5315	M5 x 33mm Pan Hd. Taptite T-25 Screw	(6)
39	23-66-0071	Selector Knob Assembly	(1)
39a	31-53-0010	Rubber Plug	(1)

● = Component of the 14-46-2718 Service Maintenance Kit

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	45-12-5316	Rubber Dust Shield	(1)
2	45-22-5317	Front Latch Sleeve	(1)
3	34-60-5316	Retaining Ring	(1)
4	45-88-5316	Washer	(1)
5	34-40-5316	Spindle O-Ring	(2)
6	45-88-5321	Washer	(1)
7	45-22-5319	Sliding Collar	(1)
8	45-22-5321	Locking Sleeve	(1)
9	45-88-5371	Washer	(1)
10	44-66-5316	Front Spring Retainer	(1)
11	40-50-5318	Spring	(1)
12	44-66-5314	Rear Spring Retainer	(1)
13	34-40-5315	Retaining Ring	(1)
14	14-46-0099	Bearing Shield Assembly	(1)
14a	-----	Bearing Shield	(1)
14b	34-40-5321	O-Ring	(2)
14c	45-06-5170	Felt Seal	(1)
14d	45-06-0012	Rotary Seal	(1)
14e	02-50-5316	Bearing Ring	(1)
15	45-88-5323	O-Ring	(1)
16	44-20-5316	Key	(1)
17	38-50-0012	SDS-Max Spindle Assembly	(2)
17a	44-82-5317	SDS-Max Spindle	(1)
17b	44-90-0037	Brake Ring	(1)
17c	44-90-0039	Rebound Ring	(1)
17d	34-60-0072	Back Press Ring	(1)
17e	44-60-5316	Spindle Sleeve Pin	(6)
17f	44-90-5317	Steel Ring	(1)
17g	44-90-5319	Spring Ring	(1)
17h	45-22-0013	Barrel	(1)
18	42-06-0028	Anvil Assembly	(1)
18a	-----	Anvil	(1)
18b	34-60-5319	O-Ring	(2)
18c	45-06-5317	Turcon Seal	(2)
19	45-56-0018	Striker Assembly	(1)
19a	45-22-0016	Striker	(1)
19b	34-40-0078	O-Ring	(2)
20	45-88-0073	Washer	(1)
★22	14-29-0014	Gearcase Assembly	(1)



Be sure to orient front notches of bearing shield #14a at the 12:00/6:00 position or at the 9:00/3:00 position prior to installing in gearcase #22. Doing so will allow tabs in rear of bearing shield to seat in corresponding notches in gear case cavity. This must be done to allow for proper seating of retaining ring #13.

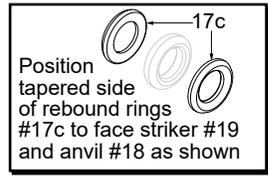
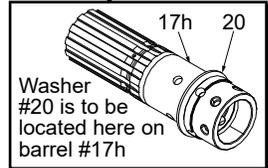
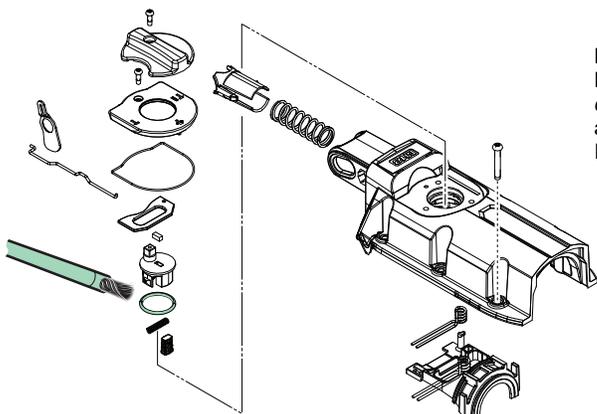
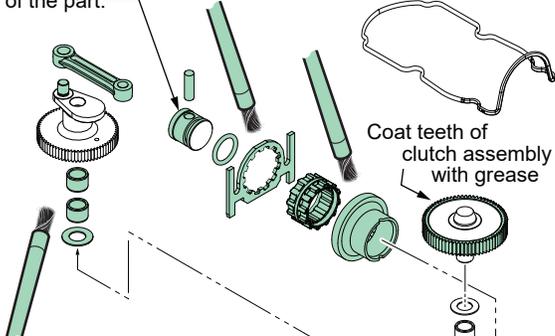


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
39b	40-50-5320	Spring	(1)
39c	34-40-5309	O-Ring	(1)
39d	44-60-0067	Selector Knob with Knob Pin Insert	(1)
39e	44-20-0018	Chisel Lock Arm	(1)
39f	43-44-0014	Selector Knob Gasket	(1)
39g	43-56-0012	Selector Guide	(1)
39h	06-82-0032	M4 x 12mm Pan Hd. ST T-20 Screw	(2)
39j	43-98-0014	Selector Knob	(1)
39k	31-53-0011	Felt Plug	(1)
40	44-94-0014	Lock Rod	(1)
41	42-50-0013	Lock Cam	(1)
	50-08-5317	Bit Grease	(1)

**Lubrication Note:** MILWAUKEE recommends that scheduled maintenance of this Rotary Hammer include lubrication replacement, and replacement of vital O-rings and gaskets *at each carbon brush change*. Doing so will prolong the life of the hammer by reducing wear to gears and mechanism parts. The carbon brushes and armature commutator in this MILWAUKEE Rotary Hammer are designed and matched for many hours of reliable performance.



Pack the rear of the piston with grease. There is to be no lubrication on the face of the part.



Coat teeth of clutch assembly with grease

Place 6-5/16 oz. (180g) of grease in the bottom of the gearcase

Place 5/8 oz. (18g) of grease in the rear of the barrel before installing the striker

1. Place washer #20 onto backside of barrel.
2. Place 18 grams of 'Q2' grease inside barrel.
3. Coat o-ring groove on ram and o-ring with grease prior to installing o-ring on ram.  
  
Coat the assembled ram and o-ring with grease as shown below.
4. When placing ram assembly into barrel, **slowly** apply pressure to ram assembly.
5. Push the ram assembly until rear face is just below small hole in the barrel. **DO NOT** wipe off any excess grease that oozes out of holes.

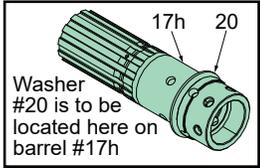
No grease on rear face of ram (striker) #19a

Washer #20

Small hole in barrel

Fig. 1

**LUBRICATION NOTES:**  
**Type 'Q2' Grease, No. 49-08-5355 (2.8oz, 80g tube) 3 tubes needed**  
 Prior to reinstalling, clean gear assemblies with a clean, dry cloth. Lightly coat all individual parts highlighted here with grease. Apply a greater amount of grease to all internal and external gear teeth. Place 18 grams of grease in the rear of the barrel prior to inserting the ram. Place the remaining grease in the bottom of the gearcase.



Washer #20 is to be located here on barrel #17h

**NOTE:**  
 Be sure that the shank of the bit is clean. For best performance, be sure the shank is lightly greased prior to installation. Use Bit Grease No. 50-08-5317.

● 14-46-2718 MAINTENANCE SERVICE KIT

THIS KIT CONTAINS:

1	45-12-5316	Rubber Dust Shield
1	34-60-5316	Retaining Ring
2	34-40-5316	Spindle O-Ring
2	34-60-5319	O-Ring
2	45-06-5317	Turcon Seal
2	34-40-5308	O-Ring
2	42-42-0054	Foam Bushing
1	14-46-0099	Bearing Shield Assembly
1	34-60-0072	Back Press Ring
2	34-60-0078	O-Ring
1	43-44-0012	Rubber Gasket
1	34-40-5309	O-Ring
1	44-90-5319	Spring Ring
3	49-08-5355	'Q2' Grease (2.8oz/80g tube)

FASTENER TORQUE SPECIFICATIONS (IN./LBS.)

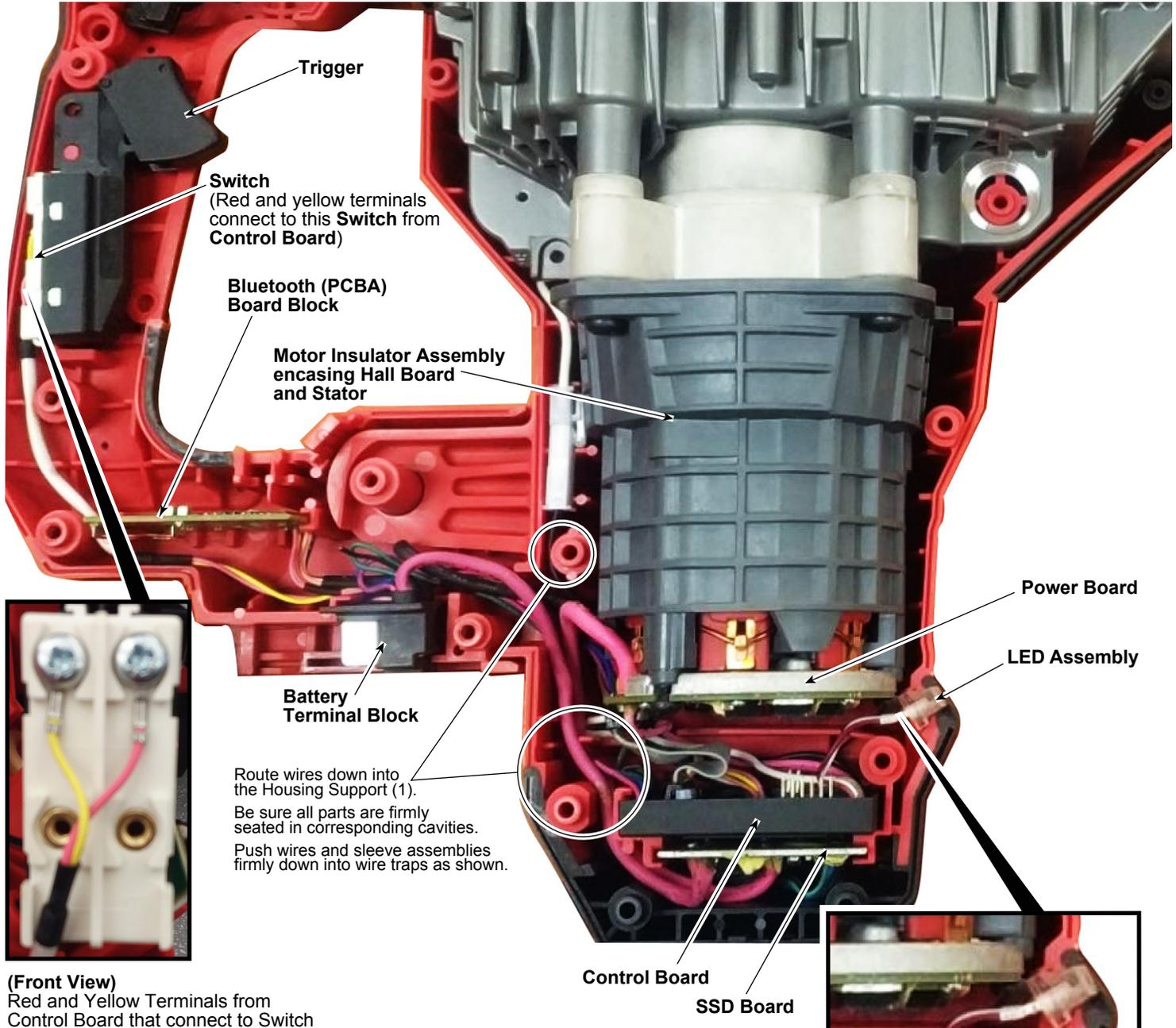
FIG. NO.	WHERE USED	SEATING TORQUE		
		in/lbs	kgf/cm	Nm
34	Selector Bracket Clamp Plate	11	13	1.3
38	Gearcase Cover	44±3	51±4	5.0
47	Motor Housing	56	65	6.4
48d	Housing Halve Cover	25	29	2.9
48c	Housing Halve Cover	11	13	1.3
50b	Coin Cell Cover	2.6	3.05	0.3
39h	Selector Knob	16	18	1.8
39h	On-Off Switch	11	13	1.3
	Switch Termination Screws	8	10	1.0
	Ground Screw-Gearcase	44	50	5.0

# ELECTRICAL SPECIFICATIONS

## Handle and Base Cutaway

Model 2718-20

Cordless Rotary Hammer shown



AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE SURE THAT ALL COMPONENTS OF THE ELECTRONICS KIT ARE SEATED FIRMLY AND SQUARELY IN THE HANDLE RECESSES.

AVOID PINCHED WIRES, BE SURE THAT ALL WIRES AND SLEEVES ARE PRESSED COMPLETELY DOWN IN WIRE GUIDES AND TRAPS.

PRIOR TO INSTALLING THE HANDLE COVER ONTO THE HANDLE SUPPORT, BE SURE THAT THERE ARE NO INTERFERENCES.