



SERVICE PARTS LIST

BULLETIN NO.
54-24-6075

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
SDS MAX ROTARY HAMMER			Mar. 2013
CATALOG NO.	5342-20	SERIAL NUMBER	A50A
		WIRING INSTRUCTION 58-01-0195	

SEE PAGES 2 AND 3 FOR TORQUE AND LUBRICATION SPECIFICATIONS

Place bearing cup (1209) into rear bearing bore of motor housing (100) prior to installing armature (106).

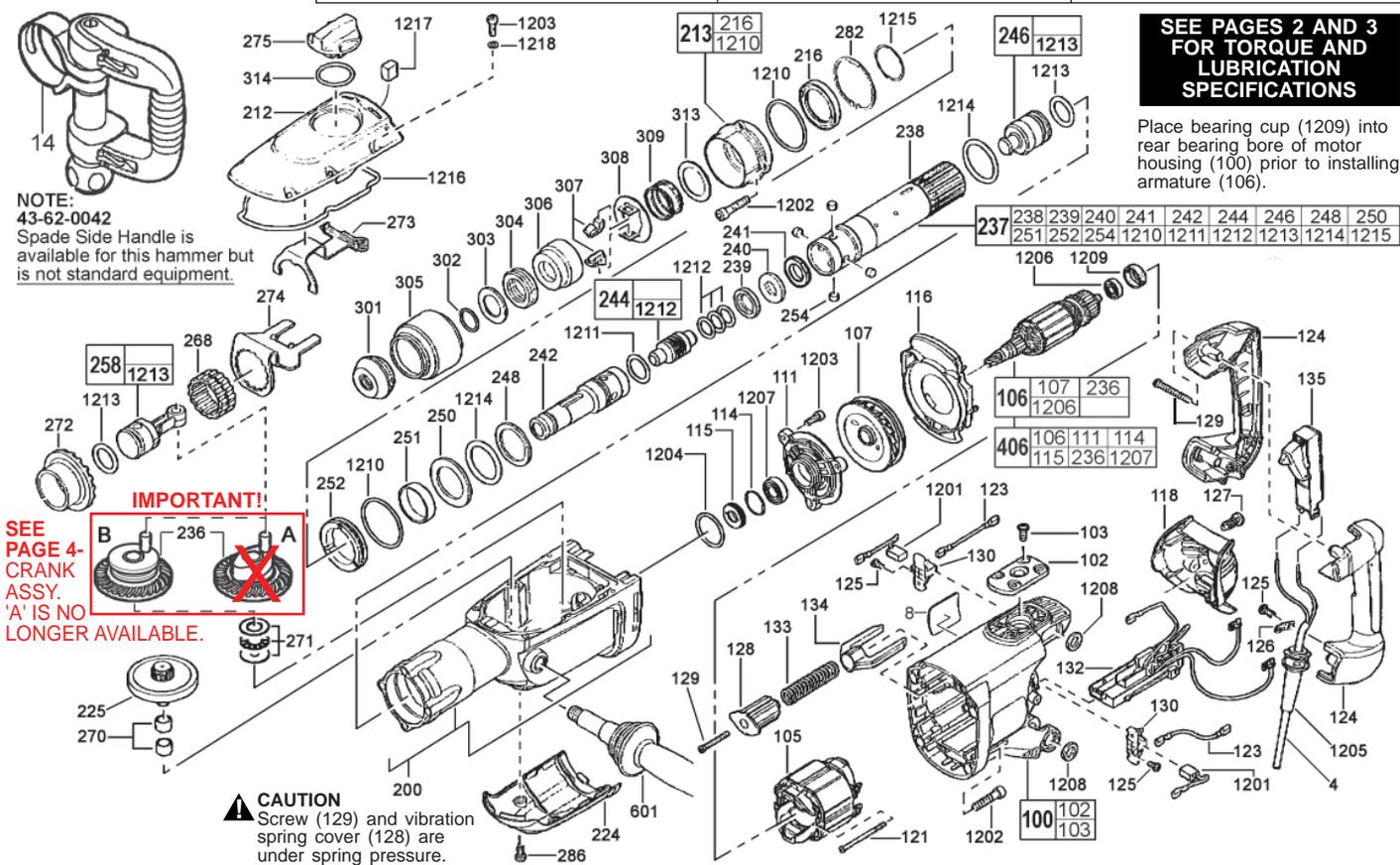


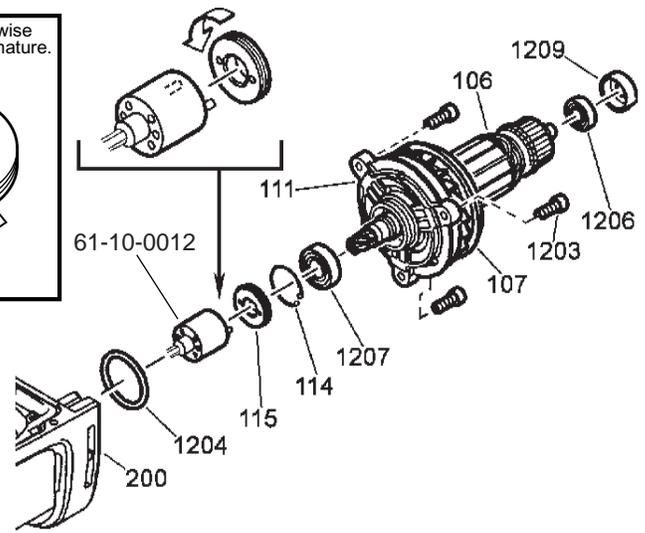
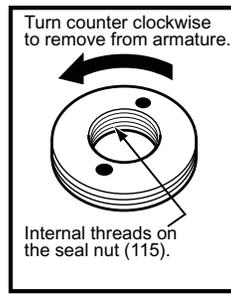
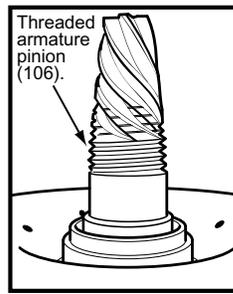
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
4	22-64-0022	CORD SET	1
8	12-20-5342	SERVICE NAMEPLATE KIT	1
100	31-50-0033	MOTOR HOUSING	1
102	42-92-0106	SIDE HANDLE PLATE	1
103	05-78-0070	SCREW - SIDE HANDLE PLATE	4
105	18-11-0050	FIELD	1
106	16-10-0137	ARMATURE WITH CRANK ASSEMBLY	1
107	22-84-0442	FAN	1
111	28-28-0118	BEARING END PLATE	1
114	44-90-0019	RETAINING RING	1
115	44-40-0042	SEAL NUT	1
116	42-14-0105	AIR DEFLECTION RING	1
118	31-15-0051	SERVICING LID	1
121	05-78-0071	SCREW - FIELD	2
123	23-94-0031	WIRE - RED	2
124	31-15-0052	D-HANDLE SET	1
125	05-78-0072	SCREW	4
126	31-17-0110	STRAIN RELIEF CLAMP	1
127	05-78-0073	SCREW - SERVICING LID	2
128	31-15-0053	COVER - VIBRATION SPRING	1
129	05-78-0074	SCREW	5
130	22-20-0027	BRUSH HOLDER	2
132	22-75-0080	DIAL SWITCH	1
133	40-50-0041	SPRING - VIBRATION	1
134	31-10-0130	VIBRATION LEVER	1
135	23-66-0033	SWITCH - ON/OFF	1
200	31-40-0033	GEAR BOX WITH SPINDLE SLEEVE BEARING	1
212	31-15-0064	COVER - UPPER GEAR BOX	1
213	30-60-0031	SEAL RETAINER	1
216	43-44-0062	SEAL RING	1
224	31-15-0062	COVER - LOWER GEAR BOX	1
225	32-75-0107	GEAR CLUTCH	1
236	-----	CRANK WHEEL	1
237	38-50-0047	SPINDLE ASSEMBLY	1
238	38-50-0044	SPINDLE SLEEVE	1
239	45-88-0052	THRUST COLLAR	1
240	34-40-0061	BACK PRESSURE O-RING	1
241	45-88-0185	WASHER	1
242	44-82-0076	STRIKER GUIDE	1
244	45-56-2528	STRIKER	1
246	44-82-0074	RAM	1
248	45-88-0053	ATTACHMENT WASHER (.118 THICK)	1
250	45-88-0054	WASHER (.154 THICK)	1
251	44-96-0132	ROLLER RACE	1
252	44-90-0018	THRUST COLLAR	1
254	44-96-0133	ROLLER	4
258	44-62-0053	PISTON	1

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
268	42-76-0015	SET COLLAR	1
270	02-50-1213	NEEDLE BEARING	2
271	02-80-0117	THRUST BEARING WITH WASHERS	1
272	32-75-0109	SPINDLE BEVEL GEAR	1
273	44-66-0016	ADJUSTING PLATE ASSEMBLY	1
274	44-66-0017	LOCKING PLATE	1
275	44-10-0012	LEVER	1
282	44-90-0016	RETAINING RING	1
286	05-81-0703	SCREW - LOWER GEAR BOX COVER	2
301	42-52-0058	END COVER CAP	1
302	44-90-0022	RETAINING RING	1
303	45-88-0058	DAMPING ELEMENT	1
304	44-90-0009	DAMPING RING	1
305	45-22-0052	SLEEVE	1
306	45-22-0053	INTERLOCK SLEEVE	1
307	44-55-0015	INTERLOCK ELEMENT	2
308	44-66-0018	INTERLOCK PLATE	1
309	40-50-0043	PRESSURE SPRING	1
313	45-88-0062	WASHER	1
314	34-40-0066	O-RING	1
406	16-10-0138	ARMATURE ASSEMBLY WITH BEARING	1
601	43-62-0043	END PLATE AND CRANK ASSEMBLY	1
1201	22-16-0026	AUXILIARY SIDE HANDLE	2
1202	05-81-0701	CARBON BRUSH SET PKG. (2)	8
1203	05-81-0702	SCREW M8 x 40	9
1204	34-40-0062	SCREW M5 x 16	1
1205	44-76-0051	O-RING - GEAR BOX	1
1206	02-04-0061	CORD PROTECTOR	1
1207	02-04-0062	BALL BEARING	1
1208	02-04-0063	BALL BEARING	1
1209	34-40-0063	O-RING - MOTOR HOUSING	4
1210	22-72-0200	BEARING CUP	1
1211	34-40-0064	O-RING	2
1212	34-40-0071	O-RING - STRIKER GUIDE	1
1213	34-40-0072	O-RING - STRIKER	3
1214	34-40-0073	O-RING	2
1215	34-40-0074	O-RING - SPINDLE SLEEVE	1
1216	44-90-0017	RETAINING RING	1
1218	43-44-0063	GASKET - GEAR BOX COVER	1
	45-88-0056	WASHER - GEAR BOX COVER	6
	48-55-5337	CARRYING CASE (NOT SHOWN)	1

◆=Component of the 14-46-0041 MAINTENANCE SET (NOT SHOWN)

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 6

Service fixture No. **61-10-0012** is required to remove seal nut (115) from armature shaft (106)/ bearing end plate (111). Secure armature, insert pins of service fixture into holes located in seal nut and turn counter clockwise to remove. When reassembling seal nut to bearing plate, tighten to 141 in.-lbs. (16Nm).



Use forcing disc service fixture No. **61-10-0011** when removing the armature fan (107) from the armature (106).

End of armature shaft

6.29" / 6.22° (159mm)

Face of fan

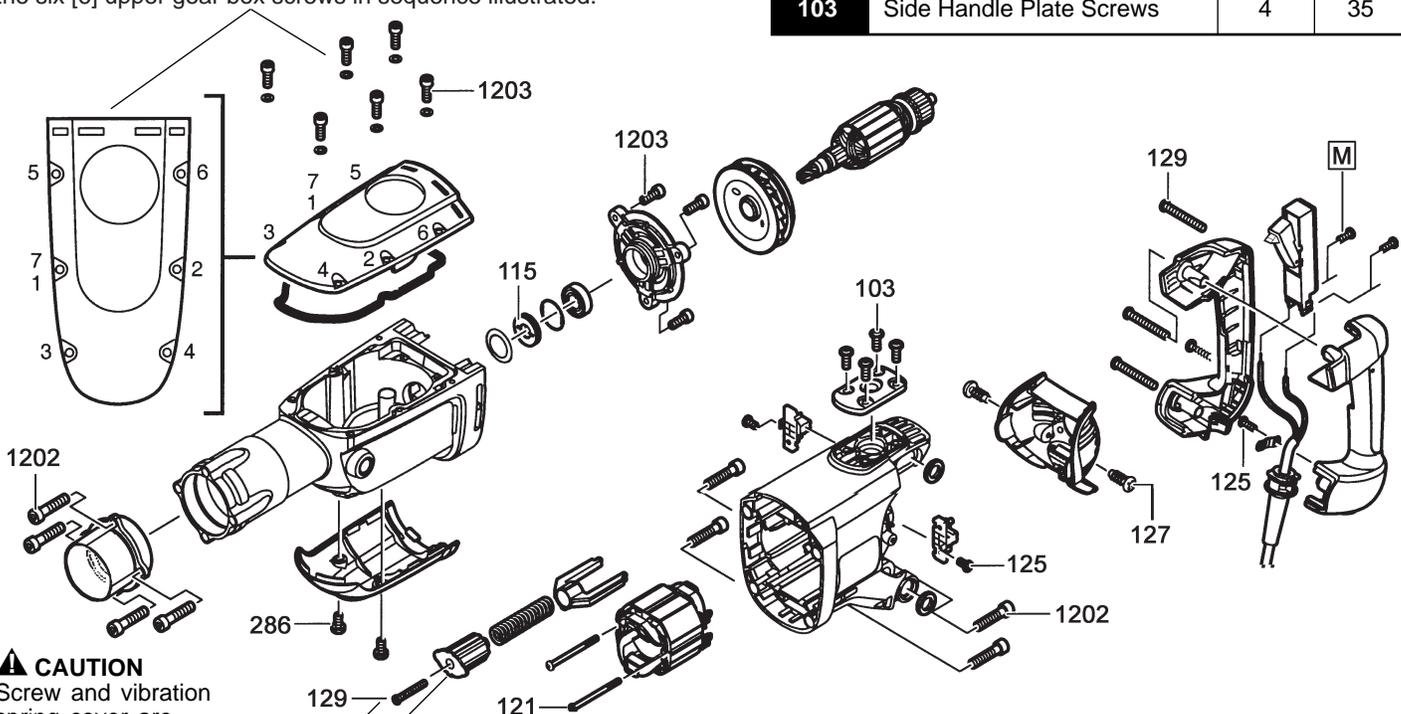
Place Loctite® 401 here.

Press armature fan onto armature shaft to specifications shown. Apply Loctite® 401 Porous Material Bonding Adhesive around the entire base of fan (360°).

SEQUENCE AND TORQUES OF SCREWS			
Callout	Fastener/Part Description	Torque (Nm)	Torque (Lbs-In)
1203	Bearing End Plate Screws	4	35
1203	Upper Gear Box Cover Screws	4.5	40
286	Lower Gear Box Cover Screws	3	27
1202	Nose Piece Screws	18	159
1202	Motor Housing Screws	13	115
127	Servicing Lid Screws	1.3	12
129	D-Handle Screws	3	27
121	Field Screws	2	18
129	Anti-Vibration Mechanism Scr.	3	27
115	Seal Nut	16	141
125	Strain Relief Clamp Screws	1.3	12
125	Carbon Brush Holders	1.3	12
M	Switch Screws	0.5	4
103	Side Handle Plate Screws	4	35

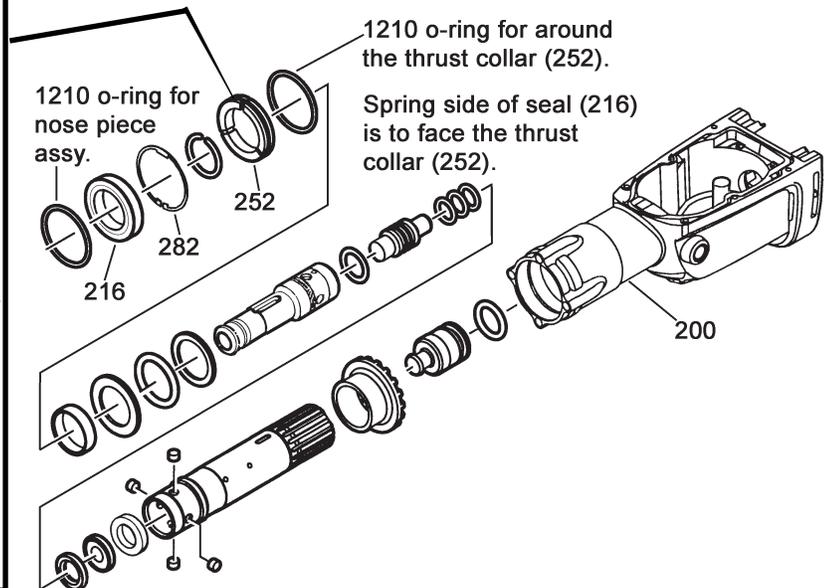
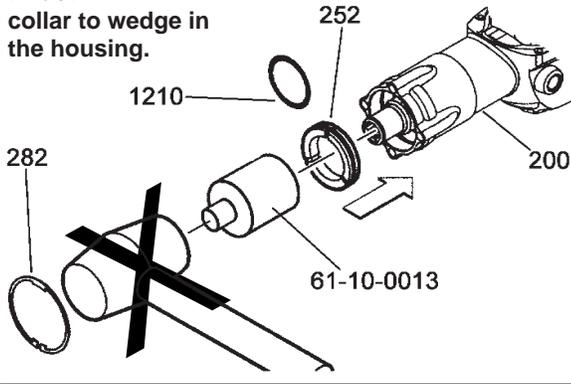
Apply blue Loctite® ThreadLocker 242 adhesive, or the equivalent, to ALL #1202 and #1203 screws prior to reassembly.

When securing upper gear box cover to gear box, tighten the six [6] upper gear box screws in sequence illustrated.



CAUTION
Screw and vibration spring cover are under spring pressure.

Place o-ring (1210) onto the thrust collar (252). Lightly grease the O.D. of the thrust collar. Insert the thrust collar assembly into gear box (200) until the outside face of the thrust collar assembly is flush with the face of the gear box. Place the open end of the service fixture 61-10-0013 over the spindle assembly and gently push the thrust collar assembly into the gearcase prior to installing the retaining ring (282). **Striking the service fixture with a hammer is not recommended, doing so may cause the thrust collar to wedge in the housing.**



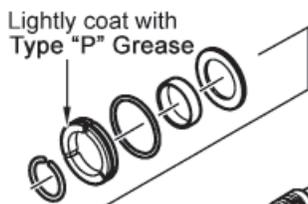
MAINTENANCE KIT CONTAINING "Q"/"Q2" GREASE, FOLLOW THESE INSTRUCTIONS

Lubrication of this tool should be performed at regular intervals or when the carbon brushes switch off at the latest.

After the tool is completely disassembled, remove all of the old grease and replace with the new grease as indicated.

Do not wash-up clutch assembly. Wipe old lubrication off with a clean, dry cloth.

**FOR
5342-20
HAMMERS**



Place 5 grams (.175 oz) Type "Q"/"Q2" Grease

Lightly coat with Type "Q"/"Q2" Grease

Place 80 grams (2.8 oz) Type "P" Grease

Place 50 grams (1.75 oz) Type "P" Grease

Apply 2 grams (.07 oz) Type "Q"/"Q2" Grease

Apply 20 g (.70 oz) with "P" Grease

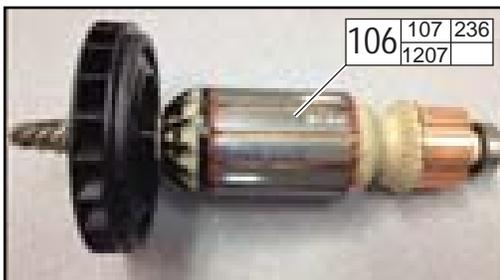
Lightly coat with "P" Grease

Apply 30 grams (1.05 oz) Type "Q"/"Q2" Grease

Approximately 150 grams (5.3 oz) of Type "P" Grease and 37 grams (1.32 oz) of Type "Q" or Type "Q2" Grease will be needed in total.

LUBRICATION CHART		
LUBRICATION DESCRIPTION	CATALOG NO.	QTY. REQ.
◆ Type "P" Grease (100 g tube)	49-08-5350	2
◆ Type "Q" Grease (45 g tube)	49-08-4255	1
◆ Type "Q2" Grease (45 g tube)	49-08-5345	1
◆ Hammer Bit Grease (20 g tube)	49-08-5383	1

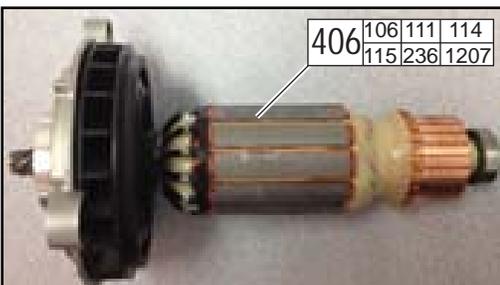
◆=Component of the 14-46-0041 Maintenance Set. **Note:** Maintenance Set includes either "Q" or "Q2" grease, not both!



#106, No. 16-10-0137
Armature Assembly
(Armature, fan and rear
ball bearing) with
Crank Assembly #236



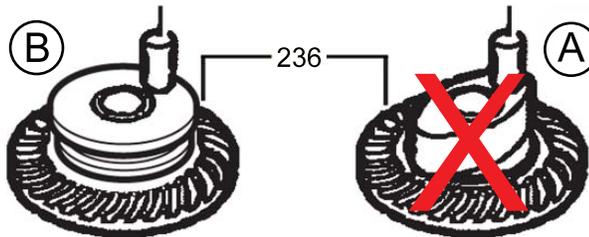
236 (Crank Assembly)



#406, No. 16-10-0138
Armature Assembly
(Armature, fan, rear ball
bearing, bearing end
plate, retaining ring, seal
nut and front ball
bearing) with Crank
Assembly #236



236 (Crank Assembly)



The 'A' profile of Crank Assembly #236 was manufactured into the hammer models listed below. The 'A' design is no longer available. The 'B' profile of Crank Assembly #236 is the direct replacement.

3/4" Hex Demolition Hammer 5337-20, serial break A47A
SDS Max Demolition Hammer 5339-20, serial break A48A
2" Spline Rotary Hammer 5340-20, serial break A49A
SDS Max Rotary Hammer 5342-20, serial break A50A

The 'B' Crank Assembly is not available as an individual part but is a component of #106, Armature Assembly 16-10-0137 and #406, Armature Assembly 16-10-0138. **When installing any of these two armature assemblies, the new 'B' crank assembly that is supplied must be used.**

DISCARD 'A' profile Crank Assemblies. DO NOT attempt to utilize an old crank assembly with the 'A' profile with a new service armature assembly! This may cause extensive damage to the tool.