



SERVICE PARTS LIST

BULLETIN NO.
55-24-5390

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
3/4" (19mm) SDS ROTARY HAMMER			May 2014
CATALOG NO.	5385-59B	SERIAL NUMBER	G08A
			WIRING INSTRUCTION See page 4



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

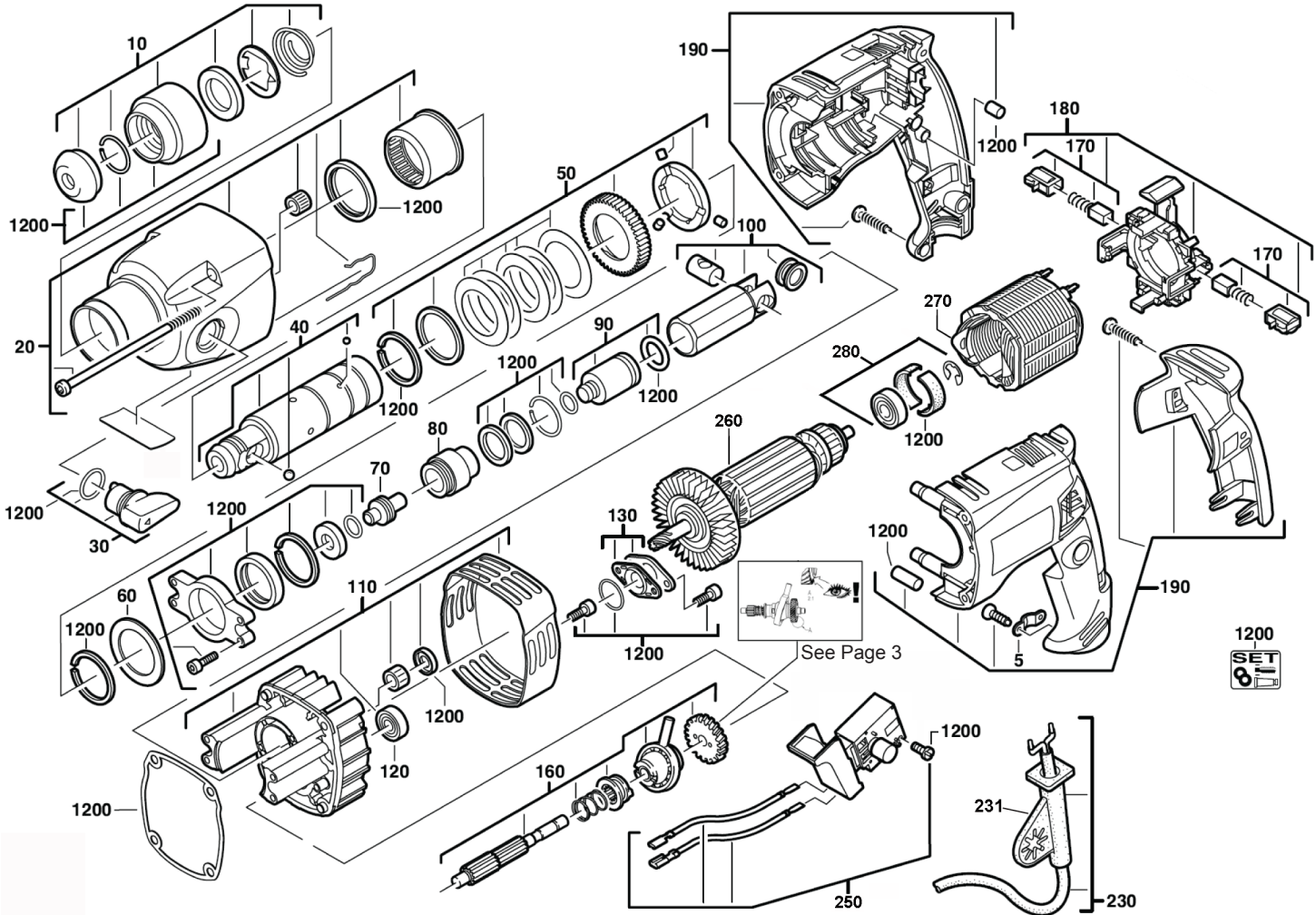


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
5	42-68-0601	Cord Clamp	(1)
10	44-20-5385	Bit Lock Assembly	(1)
20	14-30-5385	Gearcase Assembly	(1)
30	43-98-5385	Shift Knob Assembly	(1)
40	32-40-5385	Gear Assembly	(1)
50	42-70-5385	Gear and Clutch Assembly	(1)
60	45-88-5386	Steel Washer	(1)
70	45-56-5385	Hammer Striker	(1)
80	31-58-5385	Striker Sleeve	(1)
90	44-82-5385	Ram Assembly	(1)
100	14-12-5385	Cylinder Assembly	(1)
110	42-24-5385	Bearing Bracket Assembly	(1)
120	02-04-5385	Ball Bearing	(1)
130	42-24-5386	Bearing Cover Assembly	(1)
160	45-08-5385	Countershaft Assembly	(1)
170	-----	Carbon Brush and Tube (Set of 2)	(1)
180	44-90-5386	110V Brush Card	(1)
190	31-44-5385	Handle Housing Assembly	(1)
230	22-64-5263	120V Power Cord	(1)
231	44-76-5385	Strain Relief	(1)
250	23-66-5386	110V Switch	(1)
260	16-10-5385	Service Armature	(1)
270	18-10-5385	Service Field	(1)
280	14-46-5386	Bearing Kit	(1)
1200	14-46-5385	Maintenance Set	(1)

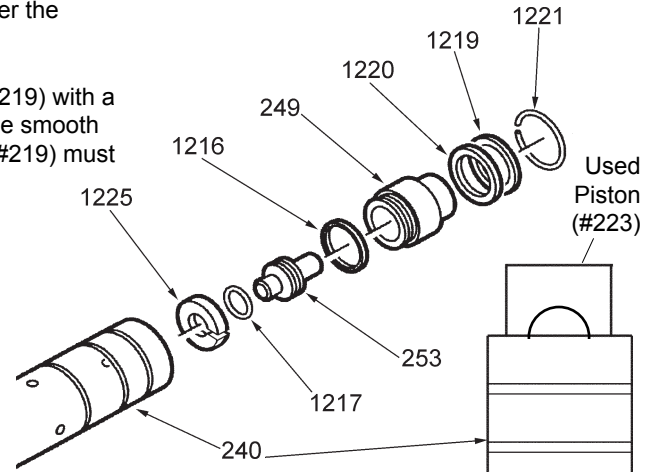
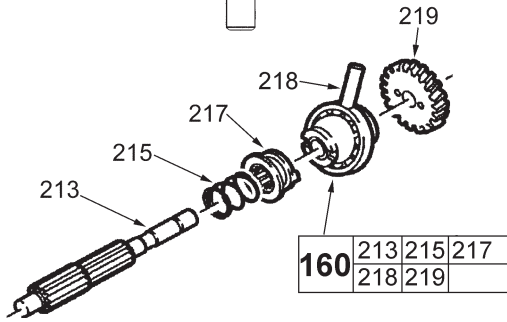
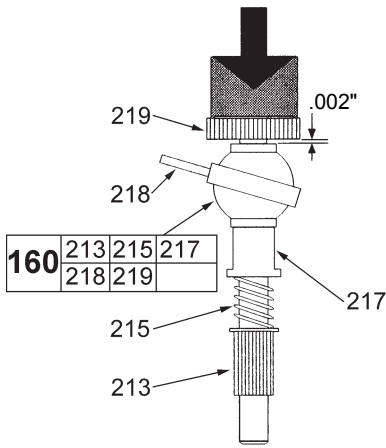
**SEE PAGES 2 & 3 OF THIS BULLETIN
FOR ADDITIONAL SERVICE NOTES**

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 1

ASSEMBLING THE WOBBLE ASSEMBLY

1. Push the Spring (#215) the Sleeve (#217) and the Wobble Plate (#218) over the Reduction Gear Shaft (#213).

2. Press on the Reduction Gear (#219) with a distance of .002", as shown. The smooth surface of the Reduction Gear (#219) must face the Wobble Plate (#218).

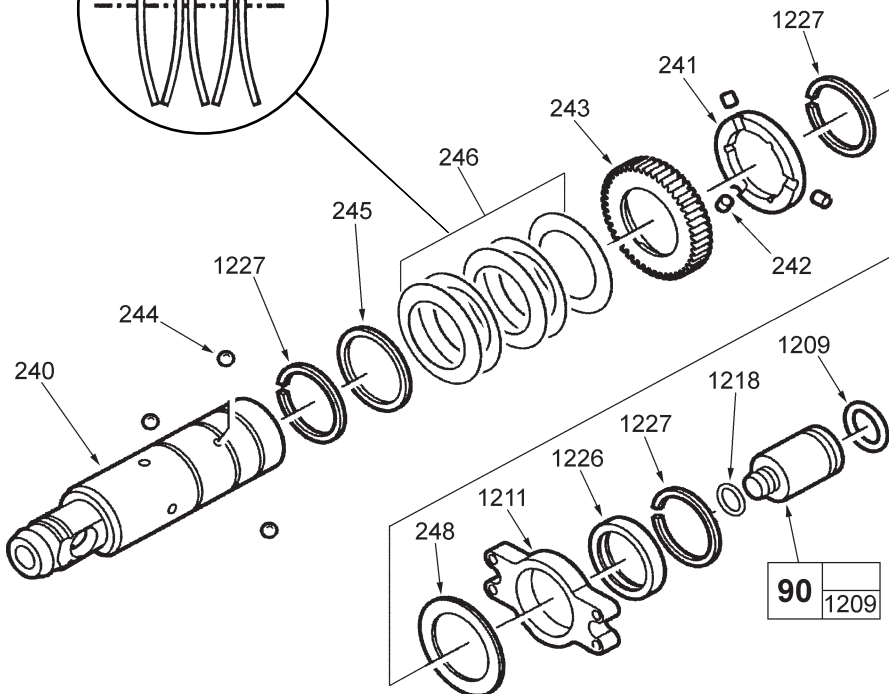
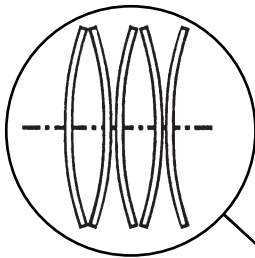


SPINDLE ASSEMBLY (Inner Parts)

1. Insert the following parts into the Spindle (#240):

- Stop Washer (#1225)
- O-Ring (#1217)
- Striker (#253)
- O-Ring (#1216)
- Ram Catcher (#249)
- O-Ring (#1220)
- Washer (#1219)

2. Insert the External Snap Ring (#1221) into the Spindle (#240) with the aid of a used piston (#223), as shown, until the External Snap Ring (#1219) engages.



SPINDLE ASSEMBLY (Outer Parts)

1. Assemble the following parts to the Spindle (#240):

- External Snap Ring (#1227)
- Damping Ring (#1226)
- Spindle Guide Plate (#1211)
(With smooth side facing the Spindle)
- Washer (#248)
- External Snap Ring (#1227)

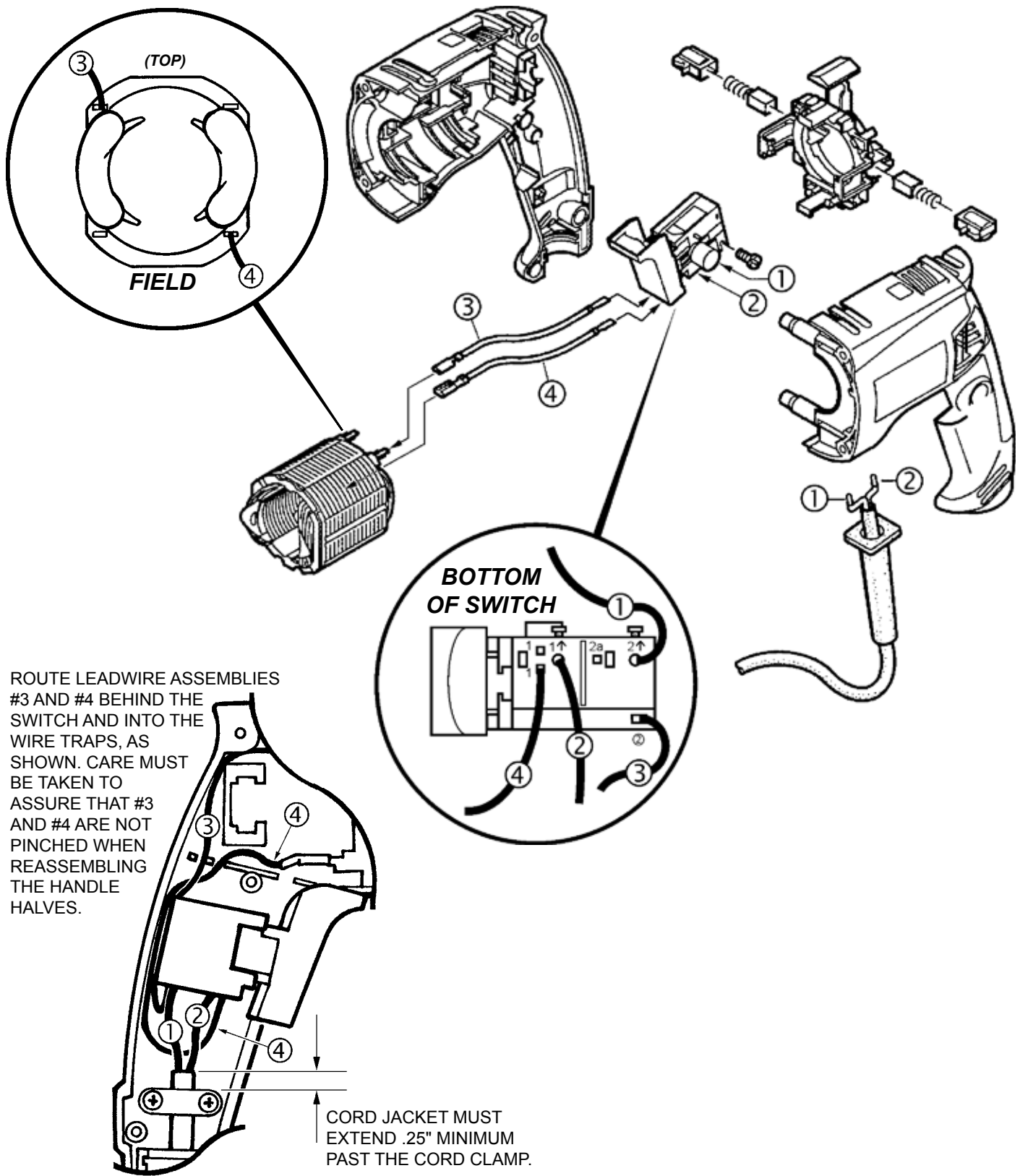
2. Assemble the clutch to the Spindle (#240):

- Clutch Disc (#241)
- Clutch Rollers (#242)
- Spindle Gear (#243)
- Belleville Springs (#246)
- Washer (#245)
(Use a press to compress the belleville springs in order to assemble #1227).
- External Snap Ring (#1227)

3. With O-Rings (#1209 and #1218), insert the Ram (#222) into the Spindle (#240).

SCREW TORQUE SPECIFICATIONS:

- Housing screws
in plastic: #119, #120 & #126 13.2 In/lbs. (1.5 Nm)
- Screws in metal: #1212, #1214 & #1215 22.1 In/lbs. (2.5 Nm)
- Gearcase screws: #2 17.7 In/lbs. (2.0 Nm)



ROUTE LEADWIRE ASSEMBLIES #3 AND #4 BEHIND THE SWITCH AND INTO THE WIRE TRAPS, AS SHOWN. CARE MUST BE TAKEN TO ASSURE THAT #3 AND #4 ARE NOT PINCHED WHEN REASSEMBLING THE HANDLE HALVES.

CORD JACKET MUST EXTEND .25" MINIMUM PAST THE CORD CLAMP.

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	-----	-----	Component of cord set.
2	White	-----	-----	Component of cord set.
3	Black	-----	-----	Leadwire assembly.
4	Black	-----	-----	Leadwire assembly.

BULK LEAD WIRE - BULLETIN 58-01-0003

NOTE:

All leads must be held to $\pm 1/16"$.
All lead lengths are before stripping.

TERMINAL DESCRIPTION

Code	Part No.	Qty.