



# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-37-0250**

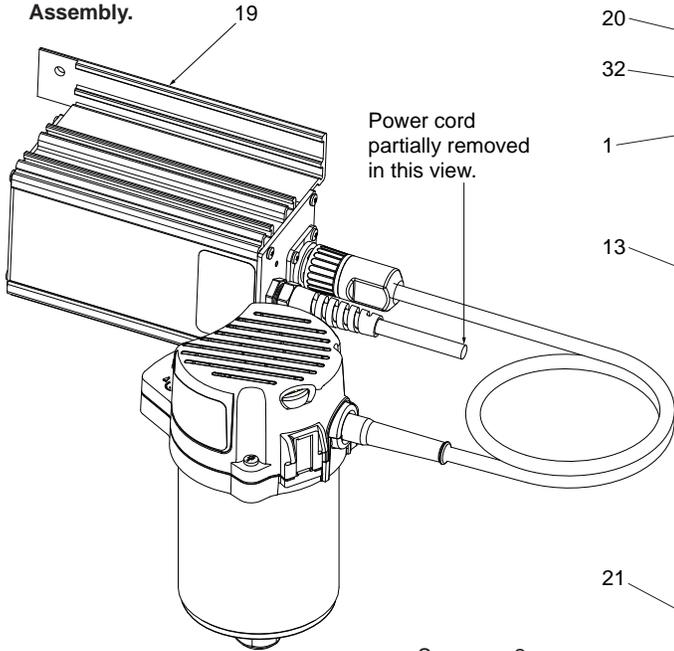
SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>MOTOR UNIT (ROUTER)</b>			Apr. 2010
<b>CATALOG NO.</b>	<b>5626-68</b>	<b>SERIAL NUMBER</b>	<b>A72A</b>
			<b>WIRING INSTRUCTION</b> <b>58-01-0718</b>

**EXAMPLE:**  

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

See Bulletin No. 54-30-0460 to service #19, the Power Control Box Assembly.



Power cord partially removed in this view.

See page 2 for collet shank removal and installation

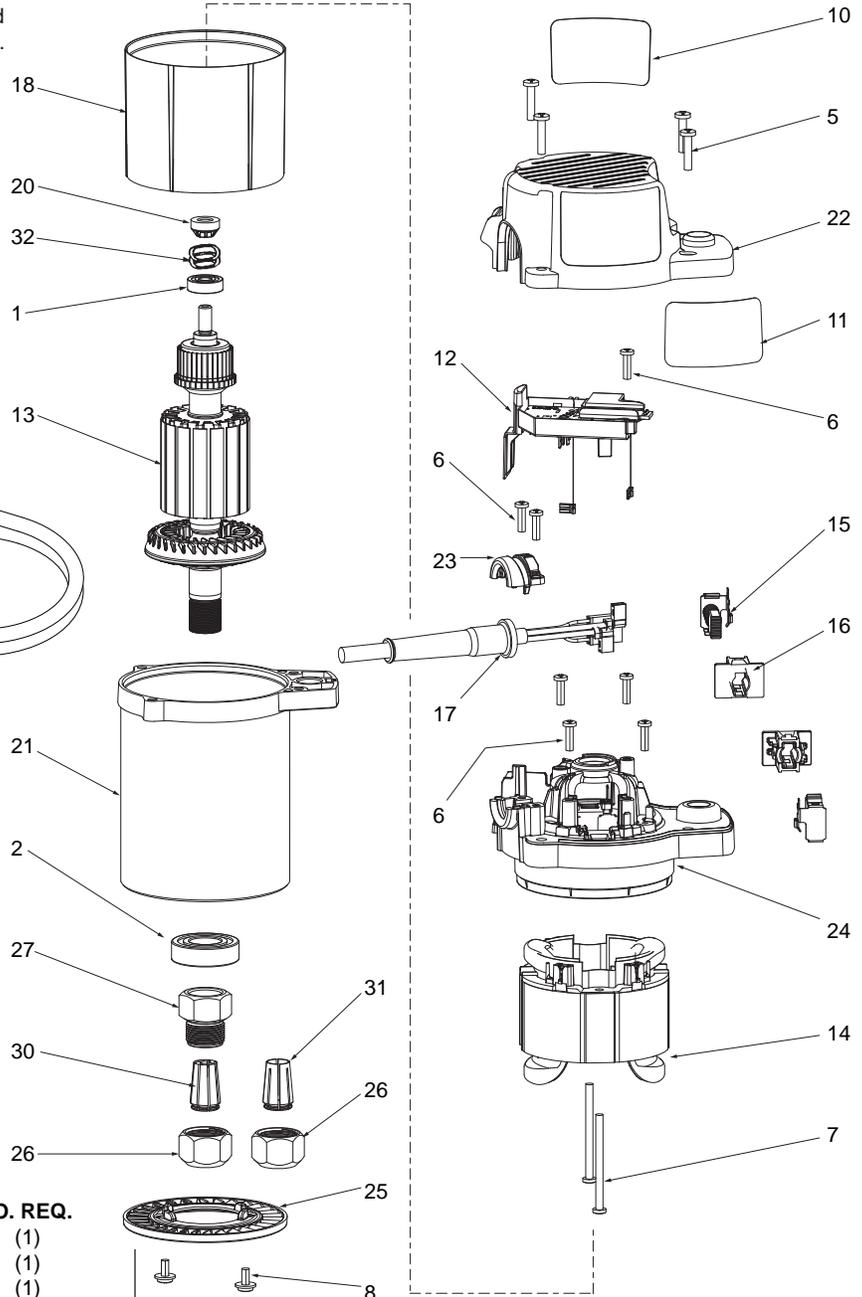
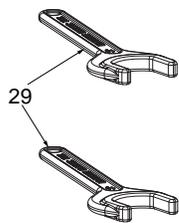


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0852	Ball Bearing	(1)
2	02-04-2006	Ball Bearing	(1)
3	06-55-1525	Hex Nut	(1)
4	06-75-5860	1/4-20 x 3/4" Screw	(1)
5	06-82-5574	#10-24 x .875 Taptite T-25 Screw	(4)
6	06-82-7270	8-16 x .625 Slit. Plastite T-20 Screw	(7)
7	06-82-7455	8-16 x 2.38 Slit. Plastite T-20 Screw	(2)
8	06-82-8865	10-32 x 7/16" Slit. Taptite T-25 Screw	(2)
9	06-97-4000	1/4 Split Ring Lock Washer	(1)
10	10-25-0010	Dial Position Label	(1)
11	12-20-5626	Service Nameplate	(1)
12	14-20-0095	Electronic Feedback Module	(1)
13	16-70-0005	Armature	(1)
14	18-70-1005	Field	(1)
15	22-18-0075	Brush Assembly	(2)
16	22-22-0030	Brush Tube Assembly	(2)
17	22-64-0400	Power Control Cable	(1)
18	23-16-0415	Field Insulator	(1)
19	23-37-0175	Power/Control Box Assembly	(1)
20	23-38-0200	Tachometer	(1)
21	28-50-0110	Motor Housing	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
22	31-15-0085	Motor Cover	(1)
23	31-17-0075	Cord Clamp	(1)
24	31-50-0120	Motor Frame	(1)
25	31-55-0015	Contamination Shield	(1)
26	44-40-0095	Collet Nut	(2)
27	45-10-0081	Collet Shaft	(1)
28	45-88-1515	Washer	(2)
29	49-96-0365	1-1/8" Open End Wrench	(2)
30	48-66-0985	1/4" Collet	(1)
31	48-66-1010	1/2" Collet	(1)
32	45-88-0577	Wave Spring Washer	(2)

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
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# Repair Instructions for the 5626-68 Motor Unit (Router)

## 45-10-0081 Collet Shank – removal / installation

### Removal of the Collet Shank from the Armature shaft...

**Note:** The Armature shaft has a 3/8" internal hex; The Collet Shank threads onto the Armature shaft.

**Step 1** applied at the time of assembly, mild heat to the Collet Shank will soften Loctite® Threadlocker and will aide in the disassembly. Care should be taken with a heat gun, not to damage the seal of the Ball Bearing or Contamination Shield.

**Step 2** to hold the Armature **securely from turning**, pass a 3/8" t-handle Hex Key through the Collet Shank and into the Armature's 3/8" internal hex.



3/8" t-handle Hex Key

**Step 3** using the Router's standard equipment Forged 1-1/8" Open End Wrench on the external hex of the Collet Shank, turn the Collet Shank counter-clockwise ⤵ to remove.

### Installation of the Collet Shank to the Armature shaft...

torque specification of the Collet shank to the Armature shaft is **16.5 ft-lbs** [*vigorously hand-tight*]...

Installation of the Collet Shank [45-10-0081] for a 5626-68 Motor Unit (Router) can best be accomplished by using a 3/8" t-handle Hex Key, a 1-1/8" Crowfoot Wrench and a Torque Wrench.

**Step 1** apply two drops of Loctite® 'Blue' 242® or 243 Oil Tolerant, Threadlocker or equivalent, 180° apart, to threads of the Armature shaft before threading the Collect Shank onto the Armature... care should be taken not to get thread locking sealant on the ball bearing journal of the Armature shaft.

**Step 2** pass a 3/8" t-handle Hex Key through the Collect Shank and into the Armature's 3/8" internal hex to hold the Armature securely from turning.

**Step 3** using a 1-1/8" Crowfoot Wrench and a Torque Wrench combination turn the 1-1/8" hex of the Collet Shank in a clockwise ⤵ direction until tight and the specified minimum of **16.5 ft-lbs** of torque is reached.



1-1/8"  
Crowfoot Wrench

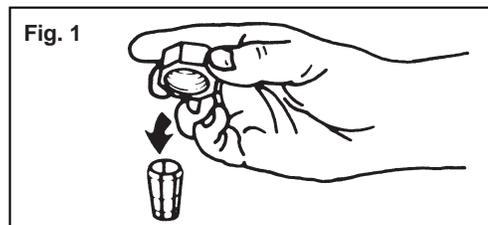


ft/lb Torque Wrench

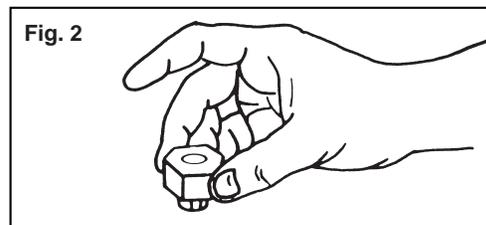
### Collets

The collet must be attached to the collet nut before it is put into the collet shaft. Be sure that the size of the collet matches the size of the bit shank being used. If the wrong size bit shank is used, the collet may break. For attaching or detaching the collet nut to the collet, follow the illustrated instructions.

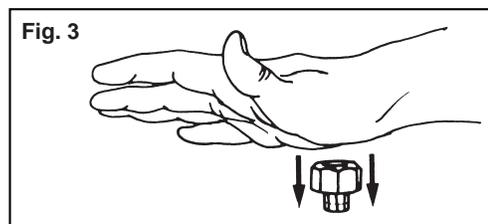
### Attaching Collet to Collet Nut



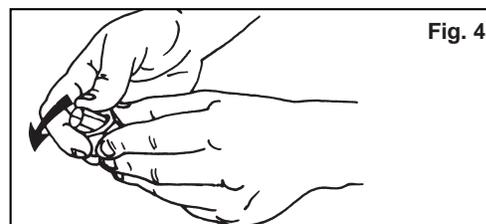
To assemble, place the narrow end of the collet on an even surface. Take the nut and place it over the collet (Fig. 1).



Position nut squarely over collet with the smaller opening of the nut facing up (Fig. 2).



Snap nut and collet together by firmly applying downward pressure into assembly with palm of hand (Fig. 3).



To remove collet from nut, hold nut firmly with one hand and press the collet to one side with the other hand (Fig. 4).