



SERVICE PARTS LIST

BULLETIN NO.
54-06-2853

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

REVISED BULLETIN

DATE

54-06-2852

Aug. 2022

3/8" PISTOL GRIP DRILL

CATALOG NO. 0200-20

**STARTING
SERIAL NO.**

065D

WIRING INSTRUCTION

See Pages 2 & 3

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

★ = Part number change from
previous service parts list.

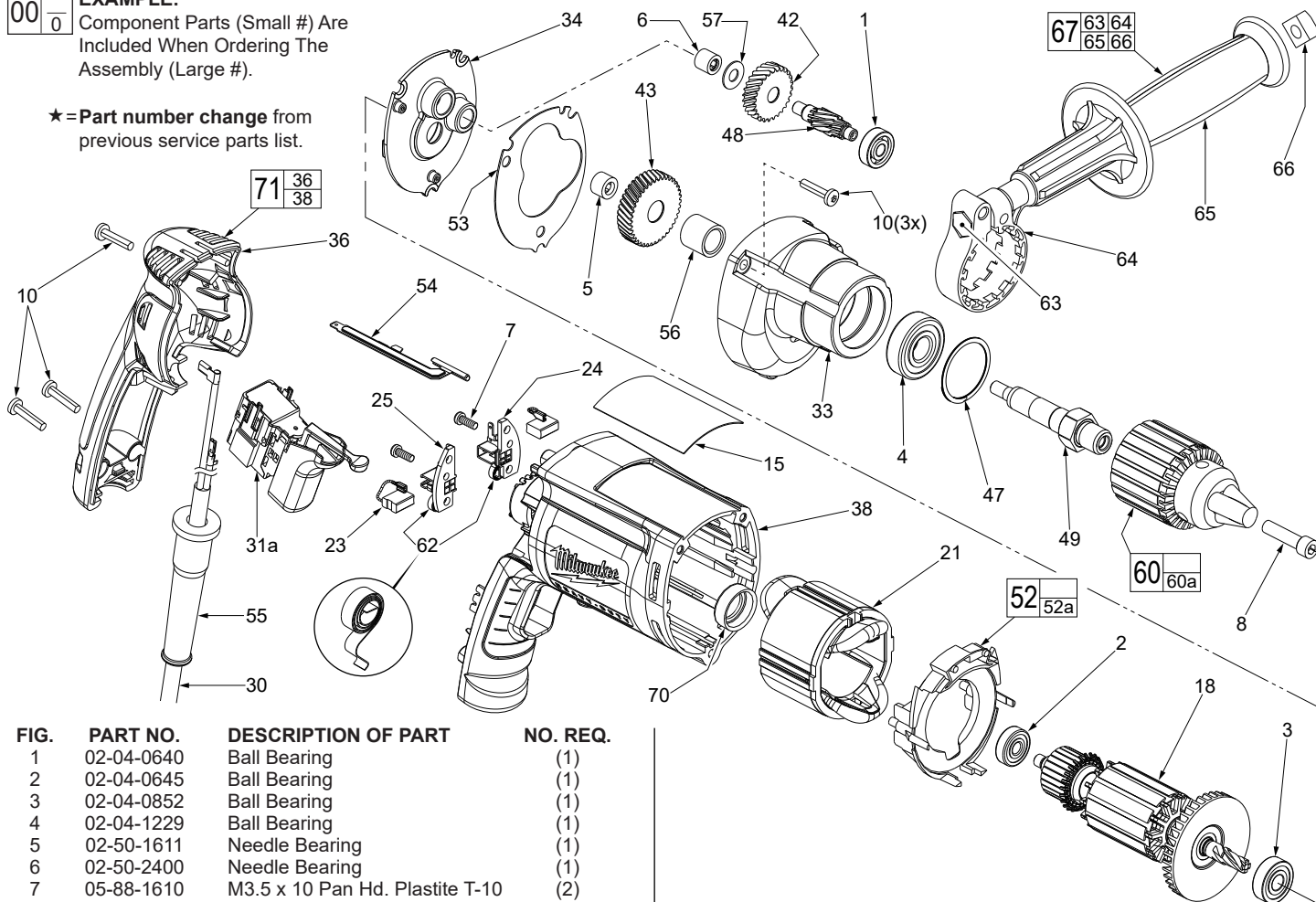


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0640	Ball Bearing	(1)
2	02-04-0645	Ball Bearing	(1)
3	02-04-0852	Ball Bearing	(1)
4	02-04-1229	Ball Bearing	(1)
5	02-50-1611	Needle Bearing	(1)
6	02-50-2400	Needle Bearing	(1)
7	05-88-1610	M3.5 x 10 Pan Hd. Plastite T-10	(2)
8	06-81-2925	1/4-20 x 1-1/8 L.H. Thread Slt. Screw	(1)
10	06-82-7275	7-18 x 3/4 Slotted Plastite T-20	(6)
15	12-99-2565	Service Nameplate	(1)
18	16-10-2215	Armature	(1)
21	18-07-7210	Field	(1)
23	22-18-1310	Brush Assembly	(2)
24	22-20-0090	Left Brush Holder	(1)
25	22-20-0095	Right Brush Holder	(1)
30	22-64-1130	Cord Set	(1)
31a	23-66-2605	Switch (Defond) See page 2 wiring	(1)
31b	23-66-2585	Switch (Marquardt) See page 3 wiring	(1)
33	28-14-2390	Gearcase	(1)
34	28-28-2320	Diaphragm	(1)
36	-----	Handle Halve	(1)
★ 38	-----	Motor Housing	(1)
42	32-40-0100	Intermediate Gear	(1)
43	32-75-0105	Spindle Gear	(1)
47	34-80-2300	Retaining Ring	(1)
48	36-66-0110	Intermediate Shaft	(1)
49	38-50-5735	Spindle	(1)
52	42-14-0460	Baffle Assembly	(1)
52a	45-30-0030	Slug (Not shown)	(2)
53	43-44-0985	Gasket	(1)
54	44-60-1700	Ground Pin	(1)
55	44-76-0210	Cord Protector	(1)
56	45-36-1095	Spindle Spacer	(1)
57	45-88-7990	Thrust Washer	(1)
60	48-66-0806	3/8" Chuck	(1)
60a	48-66-3080	Chuck Key (Not Shown)	(1)
62	23-52-1610	Brush Spring	(2)
63	06-75-2850	3/8-16 x 5-1/2" Hex Cap Screw	(1)
64	42-68-0800	Side Handle Clamp	(1)
65	43-62-0845	Side Handle	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
66	06-54-0325	3/8-16 Square Nut	(1)
67	49-15-0265	Side Handle Assembly	(1)
★ 70	43-86-0125	Bearing Cup	(1)
	23-94-0490	White Leadwire Assy. (See pages 2 & 3)	(1)
	23-94-0495	Red Leadwire Assy. (See pages 2 & 3)	(1)
	48-66-4040	Chuck Key Holder (Not Shown)	(1)
	31-53-0205	Lock Button Plug (Not Shown)	(1)
71	31-15-2010	Handle/Motor Housing Kit	(1)

LUBRICATION (Type "Y" Grease, No. 49-08-5270)

• Place 5 gm. (.02 oz.) of grease on top of the inserted intermediate ball bearing (1) and on the intermediate pinion (48).

• After inserting all gearing, place 13 gm. (.46 oz.) of grease at the armature pinion location in the gearcase (33) and fill to the top of the intermediate gear (42). Grease must contact at least 25% of the intermediate gear teeth.

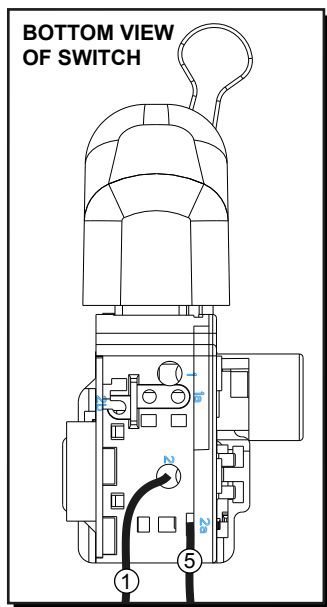
Before assembly, lightly coat all press fit areas with lightweight spindle oil.

FIG. NOTES:

4,43 Support the output ball bearing inside the gearcase before pressing off the spindle gear.

5,6 Needle bearings to be pressed flush to .010 under flush from the end which has the vendors identification.

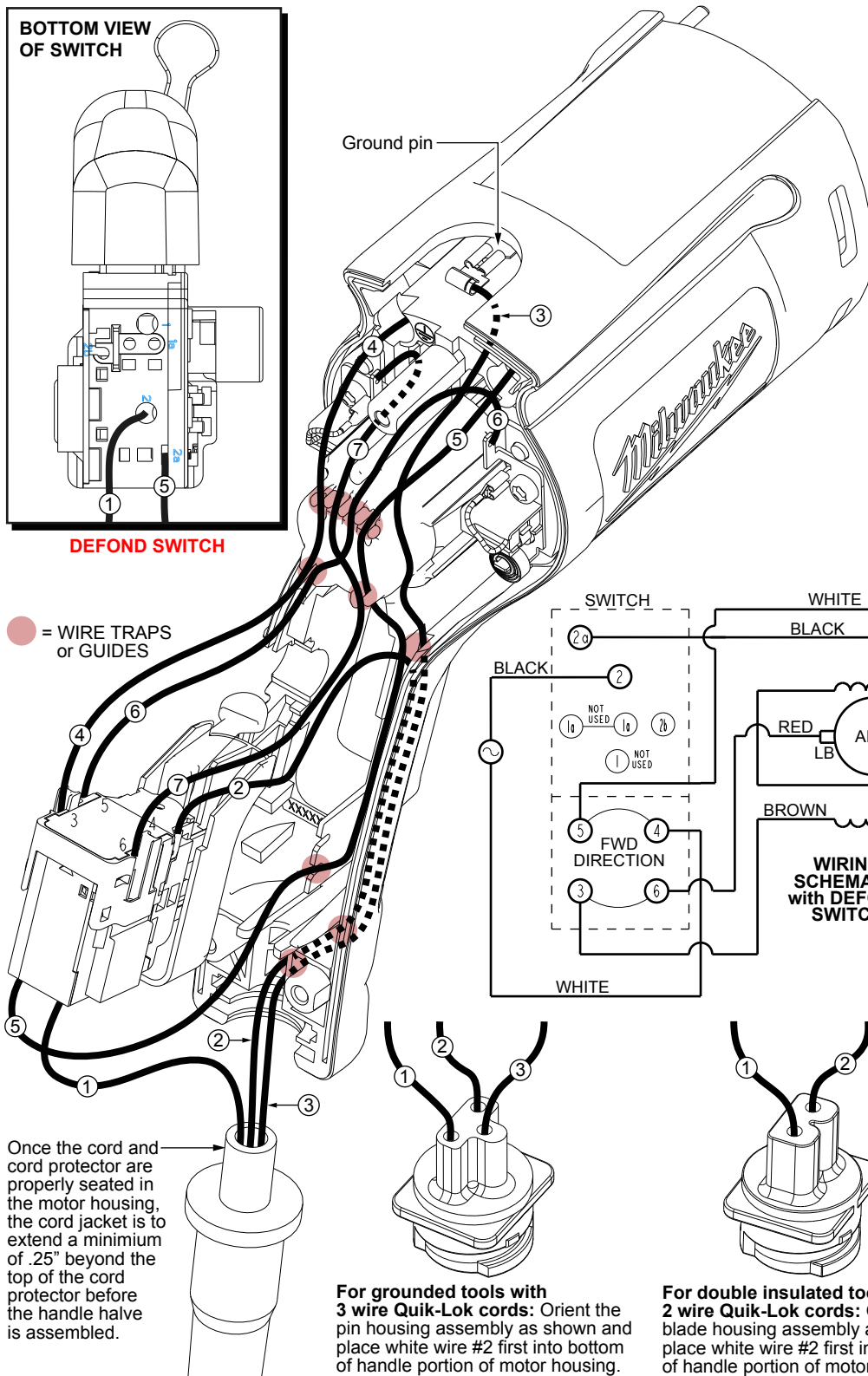
MILWAUKEE TOOL • www.milwaukeetool.com
13135 W. LISBON RD., BROOKFIELD, WI 53005
Drwg. 2



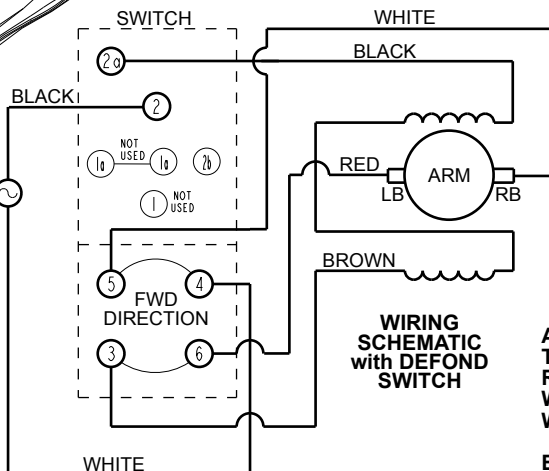
BOTTOM VIEW OF SWITCH

DEFOND SWITCH

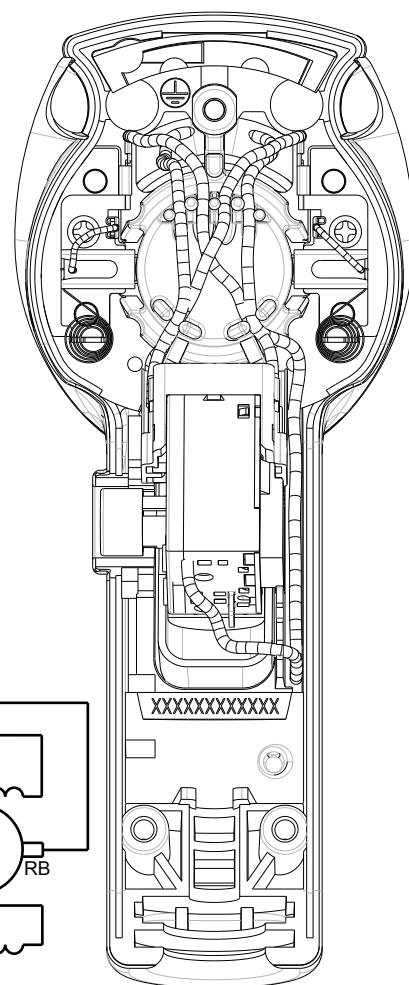
● = WIRE TRAPS or GUIDES



Once the cord and cord protector are properly seated in the motor housing, the cord jacket is to extend a minimum of .25" beyond the top of the cord protector before the handle half is assembled.



WIRING SCHEMATIC with DEFOND SWITCH



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

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.

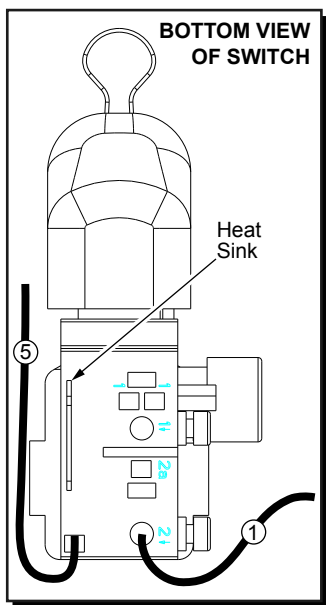
FOR DOUBLE INSULATED TOOLS DISREGARD GREEN GROUND WIRE #3 AND GROUND PIN.

For grounded tools with 3 wire Quik-Lok cords: Orient the pin housing assembly as shown and place white wire #2 first into bottom of handle portion of motor housing.

For double insulated tools with 2 wire Quik-Lok cords: Orient the blade housing assembly as shown and place white wire #2 first into the bottom of handle portion of motor housing.

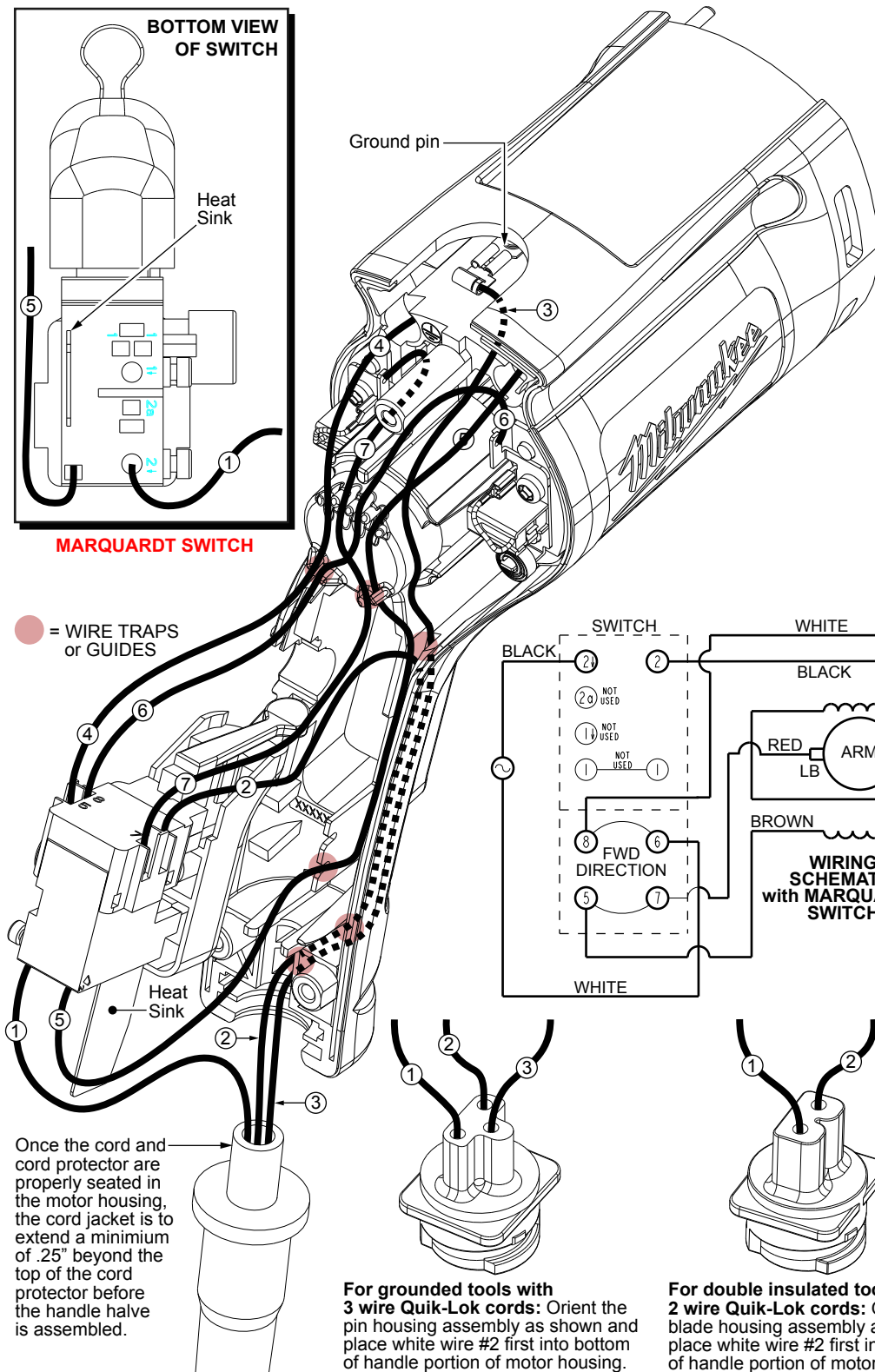
WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #2 on switch bottom.
2	White	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #4 on switch top.
3	Green	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to male tab on ground terminal.
4	Brown	Field	-----	Component of field. Connect to #3 on switch top.
5	Black	Field	-----	Component of field. Connect to #2a on switch bottom.
6	White	23-94-0490	-----	Leadwire assembly. Connect to right brush holder and #5 on switch top.
7	Red	23-94-0495	-----	Leadwire assembly. Connect to left brush holder and #6 on switch top.

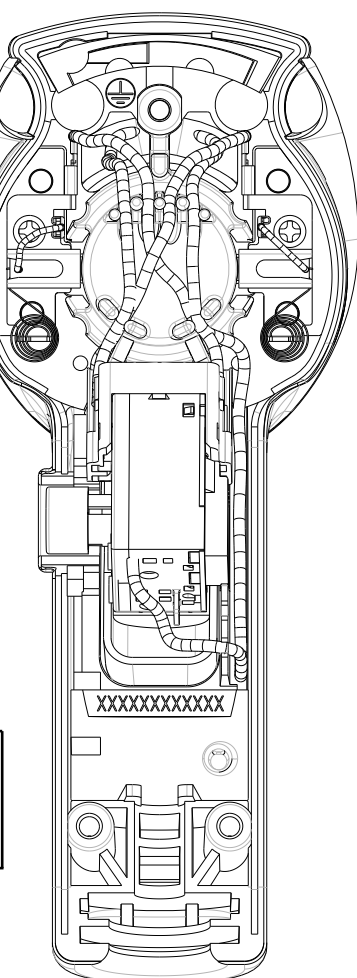
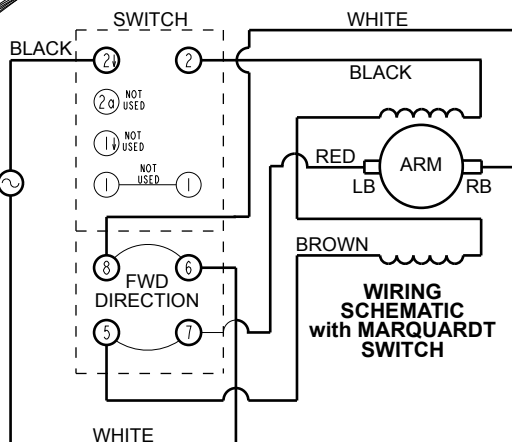


MARQUARDT SWITCH

● = WIRE TRAPS or GUIDES



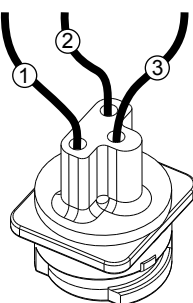
Once the cord and cord protector are properly seated in the motor housing, the cord jacket is to extend a minimum of .25" beyond the top of the cord protector before the handle half is assembled.



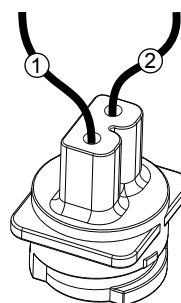
AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.

FOR DOUBLE INSULATED TOOLS DISREGARD GREEN GROUND WIRE #3 AND GROUND PIN.



For grounded tools with 3 wire Quik-Lok cords: Orient the pin housing assembly as shown and place white wire #2 first into bottom of handle portion of motor housing.



For double insulated tools with 2 wire Quik-Lok cords: Orient the blade housing assembly as shown and place white wire #2 first into the bottom of handle portion of motor housing.

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, pin hsg. assy. or blade hsg. assy. Connect to #2 on switch bottom.
2	White	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to #6 on switch top.
3	Green	*	-----	*Component of cord set, pin hsg. assy. or blade hsg. assy. Connect to male tab on ground terminal.
4	Brown	Field	-----	Component of field. Connect to #5 on switch top.
5	Black	Field	-----	Component of field. Connect to #2 on switch bottom.
6	White	23-94-0490	-----	Leadwire assembly. Connect to right brush holder and #8 on switch top.
7	Red	23-94-0495	-----	Leadwire assembly. Connect to left brush holder and #7 on switch top.