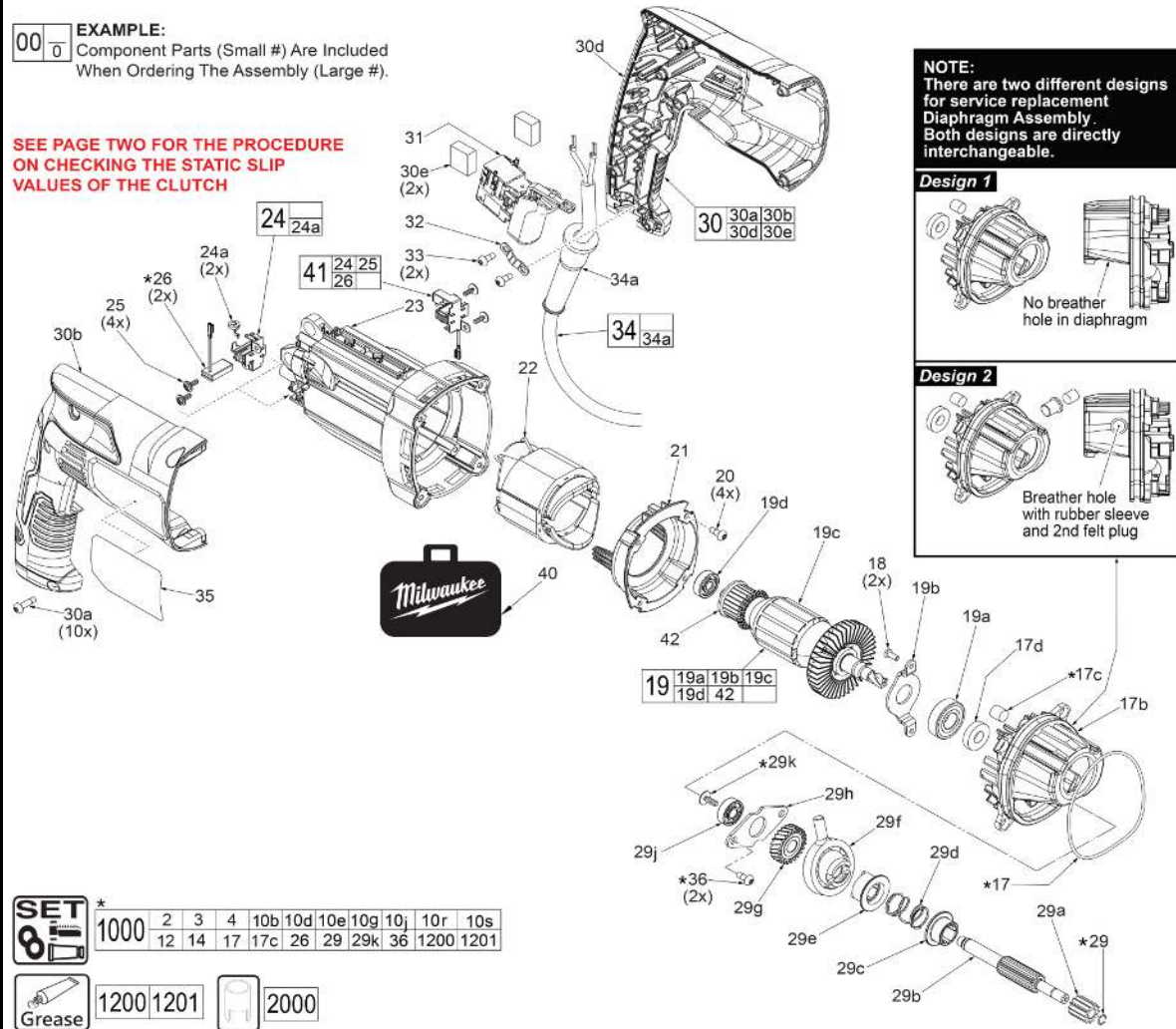
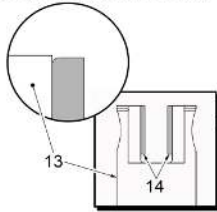


EXAMPLE:
Component Parts (Small #) Are Included
When Ordering The Assembly (Large #).

**SEE PAGE TWO FOR THE PROCEDURE
ON CHECKING THE STATIC SLIP
VALUES OF THE CLUTCH**



IMPORTANT:
Rounded side of Washers (14) must be placed facing the inside surface of Piston (13) as shown.



To check the static slip values of the clutch you must do the following:

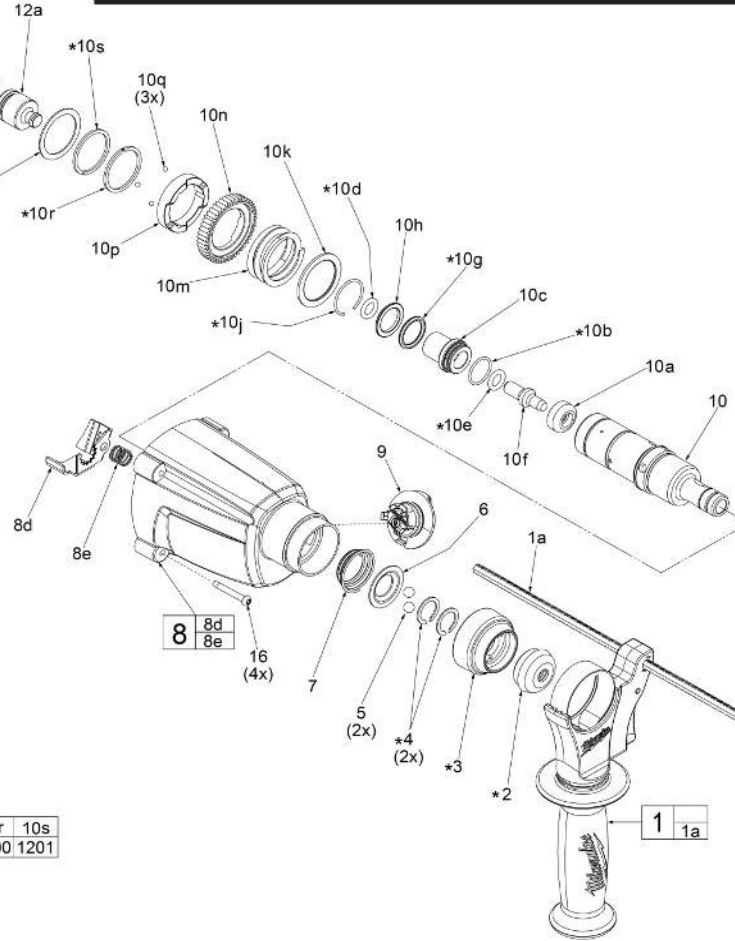
- Position Red spring loaded shifting lever at the **hammer only icon**.
- Lock motor housing of tool into the jaws of a vise having brass jaws or the equivalent.
- Insert a SDS Plus adaptor* into spindle.
- Turn torque wrench clockwise as viewed from the front of the tool until the single slip cycle has been accomplished. Observe the torque reading. Slip clutch a minimum of three times for the most accurate reading.

*SDS Plus Adaptor being used is made by threading a 1/2" x 20 hex nut onto the threads of SDS adaptor No. 48-03-3005.
Note: Apply RED Loctite to threads of hex nut prior to tightening.

Max = 240in/lbs or 27.1 Nm • Min = 150in/lbs or 16.95 Nm

Item 1000
Rotary Hammer Service Kit

2	Dust Cap	(1)
3	Chuck Sleeve	(1)
4	C-Ring	(2)
10b	O-Ring	(1)
10d	O-Ring	(1)
10e	O-Ring	(1)
10g	O-Ring	(1)
10j	Snap Ring	(1)
10r	C-Ring (Thicker)	(1)
10s	C-Ring (Thinner)	(1)
12	O-Ring	(1)
14	Washer	(2)
17	Gasket	(1)
17c	Felt Plug	(1)
26	Carbon Brush	(2)
29	C-Ring	(1)
29k	M4.0 x 0.7 Screw	(1)
36	Taprite Screw	(2)
1200	'02 Grease 80g.	(1)
1201	S2 Grease 40g.	(1)



SET 8

*1000	2	3	4	10b	10d	10e	10g	10j	10r	10s
	12	14	17	17c	26	29	29k	36	1200	1201

Grease

1200	1201	2000
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	<h1>PH 27</h1> <p>SERVICE PARTS LIST</p>	Bulletin Date: <h2>Oct-17</h2>
	<p>TTI Model Number: 038 138 018</p> <p>SDS-PLUS ROTARY HAMMER 26MM (3-MODE)</p>	Starting Serial Number: <p>VERSION A - D2015</p>

ITEM	PART NUMBER	PART DISCRIPTION	QTY (PCS)
1	201739001	AUXILARY SIDE HANDLE ASSEMBLY	1
1a	620448002	DEPTH GAGE ROD	1
2	561993001	RUBBER CAP	1
3	-	CHUCK SLEEVE	1
4	-	C-RING	2
5	681154001	STEEL BALL	2
6	635043001	BALL PLATE	1
7	672799001	CONICAL SPRING	1
8	203443001	GEAR CASE ASSEMBLY	1
8d	635156001	LOCK PLATE	1
8e	692732001	LOCK PLATE SPRING	1
9	306972002	SHIFT KNOB ASSEMBLY	1
10	621637001	SDS SPINDLE	1
10a	692724004	BRAKE RING	1
10b	-	O-RING	1
10c	694882001	ANVIL SLEEVE	1
10d	-	O-RING	1
10e	-	O-RING	1
10f	694880001	ANVIL	1
10g	-	O-RING	1
10h	612244001	WASHER	1
10j	-	SNAP RING	1
10k	633517001	WASHER	1
10m	692735002	CLUTCH SPRING	1
10n	612126002	2ND STAGE GEAR	1
10p	612145002	CLUTCH PLATE	1
10q	611405001	STEEL BALL	3
10r	-	C-RING (THICKER THAN 10T)	1
10s	-	C-RING	1
11	635147001	WASHER	1
12	-	O-RING	1
12a	-	RAM	1
13	693984001	PISTON	1
14	-	WASHER	2

	<h1>PH 27</h1> <p>SERVICE PARTS LIST</p>	Bulletin Date: <h2>Oct-17</h2>
	<p>TTI Model Number: 038 138 018</p> <p>SDS-PLUS ROTARY HAMMER 26MM (3-MODE)</p>	<p>Starting Serial Number:</p> <p>VERSION A - D2015</p>

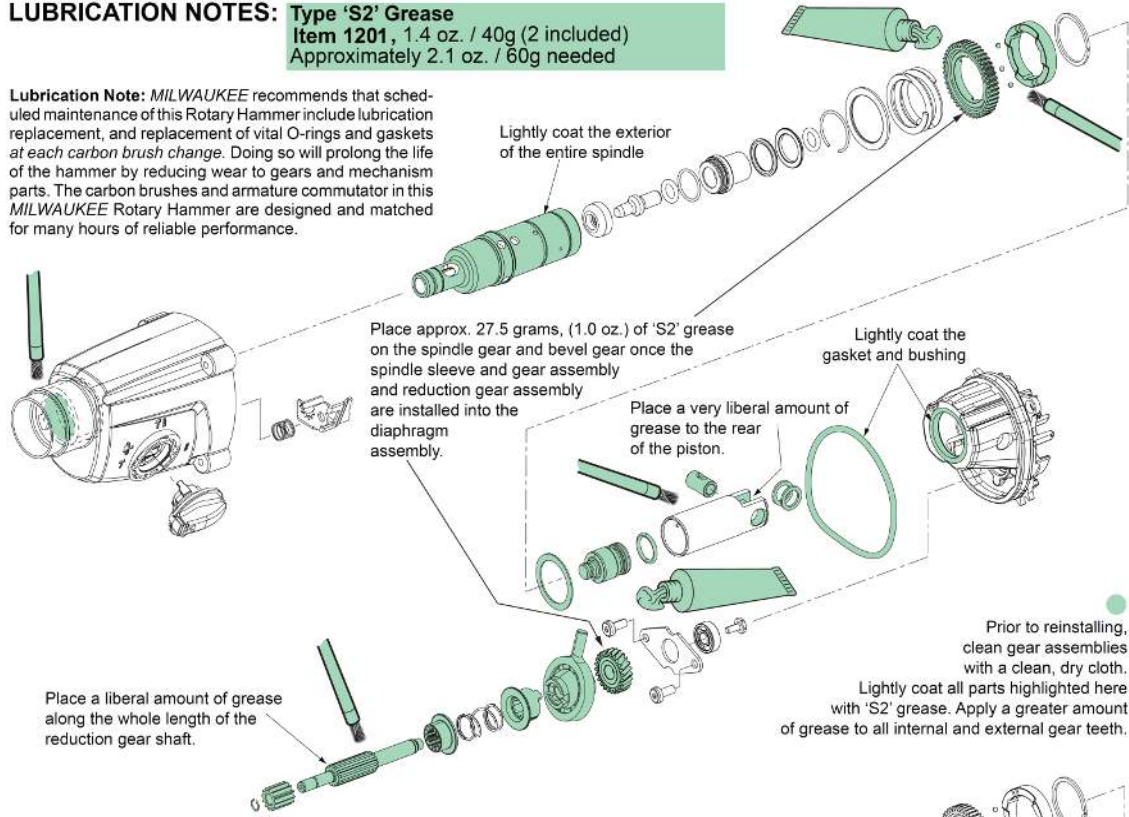
ITEM	PART NUMBER	PART DISCRIPTION	QTY (PCS)
15	692719001	WRIST PIN	1
16	660436009	M4 X 35MM SCREW	4
17	-	GASKET	1
17a	642216002	DIAPHRAGM WITH BUSHING	1
17c	-	FELT PLUG	2
17d	902075002	SEAL RING	1
18	660165015	M4 X 10MM SCREW	2
19	203448001	230V ARMATURE ASSEMBLY	1
19a	681999001	BALL BEARING	1
19b	634848001	BEARING RETAINING PLATE	1
19c	298002026	ARMATURE	1
19d	681400001	BALL BEARING	1
20	661189001	M4 X 9MM SCREW	4
21	527036001	FAN BAFFLE	1
22	203450001	230V FIELD ASSEMBLY	1
23	527909001	MOTOR HOUSING	1
24	303952005	BRUSH HOLDER	2
24a	-	BRUSH SPRING	2
25	660960002	M3 X 8.5MM SCREW	4
26	-	230V CARBON BRUSH	2
27	291167009	LEADWIRE ASSEMBLY-RED (NOT SHOWN)	1
28	291167010	LEADWIRE ASSEMBLY-BLACK (NOT SHOWN)	1
29	-	C-RING	1
29a	612130002	2ND STAGE PINION	1
29b	612127003	REDUCTION GEAR SHAFT	1
29c	612129002	COUPLER	1
29d	694889001	SHIFT SPRING	1
29e	612128003	WOBBLE COUPLER	1
29f	681236008	WOBBLE BEARING	1
29g	612125001	1ST STAGE GEAR	1
29h	635148001	RETAINING PLATE	1
29j	681383001	BALL BEARING	1
29k	-	M4 X 10MM SCREW	1
30	203452001	HOUSING ASSEMBLY	1
30a	660024018	M4 X 16MM SCREW	6

	<h1>PH 27</h1> <p>SERVICE PARTS LIST</p>	Bulletin Date: <h2>Oct-17</h2>
	<p>TTI Model Number: 038 138 018</p> <p>SDS-PLUS ROTARY HAMMER 26MM (3-MODE)</p>	<p>Starting Serial Number:</p> <p>VERSION A - D2015</p>

ITEM	PART NUMBER	PART DISCRIPTION	QTY (PCS)
30b	-	HOUSING HALVE - RIGHT	1
30d	-	HOUSING HALVE - LEFT	1
30e	902926001	FOAM PAD	2
31	760251035	230V SWITCH	1
32	661189001	CORD CLAMP	2
33	632823001	M4 X 9MM SCREW	1
34	730352086	POWER CORD - MSH PLUG	1
34a	-	STRAIN RELIEF	1
35	941046082	SERVICE NAMEPLATE	1
36	-	M5 X 8MM SCREW	2
40	302863008	BLOW MOLDED CARRYING CASE	1
41	203307001	BRUSH SERVICE KIT (SET OF 2)	1
42	525759001	COMMUTATOR INSULATOR	1
1000	203617003	BRUSH ASSY SERVICE PARTS KIT\ 038138\ ASIA	1
1200	-	TYPE Q2 GREASE 2.8oz/80g TUBE	1
1201	-	TYPE S2 GREASE 1.4oz/40g TUBE	2
2000	61-30-0290	SPINDLE SERVICE FIXTURE	1

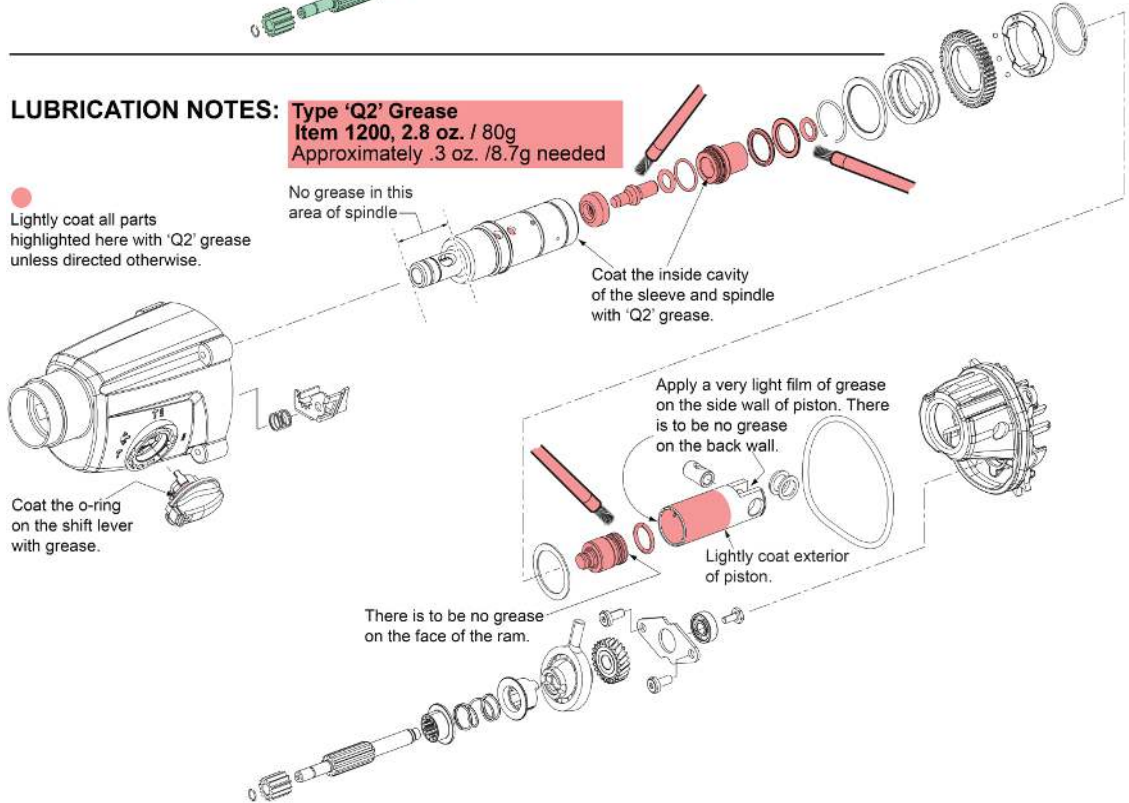
LUBRICATION NOTES: Type 'S2' Grease
Item 1201, 1.4 oz. / 40g (2 included)
Approximately 2.1 oz. / 60g needed

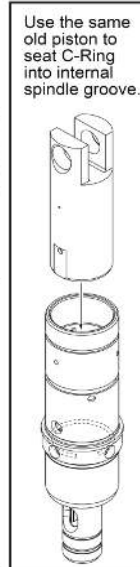
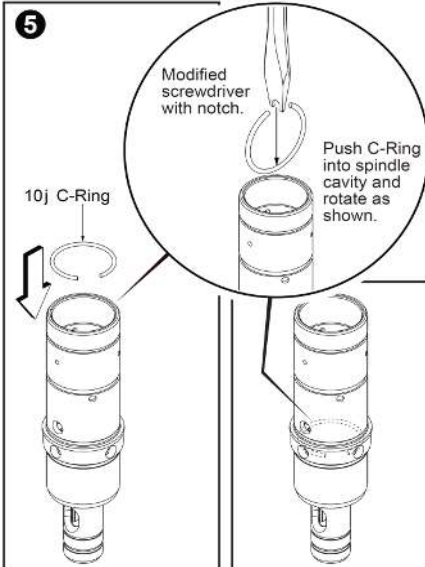
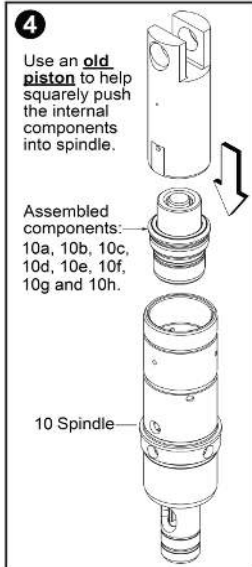
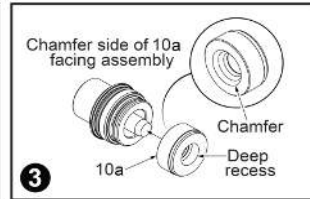
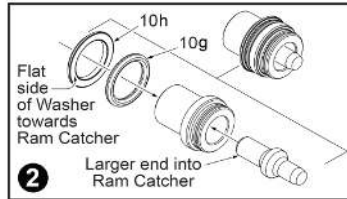
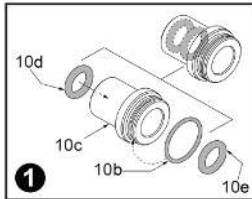
Lubrication Note: MILWAUKEE recommends that scheduled maintenance of this Rotary Hammer include lubrication replacement, and replacement of vital O-rings and gaskets at each carbon brush change. Doing so will prolong the life of the hammer by reducing wear to gears and mechanism parts. The carbon brushes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



LUBRICATION NOTES: Type 'Q2' Grease
Item 1200, 2.8 oz. / 80g
Approximately .3 oz. / 8.7g needed

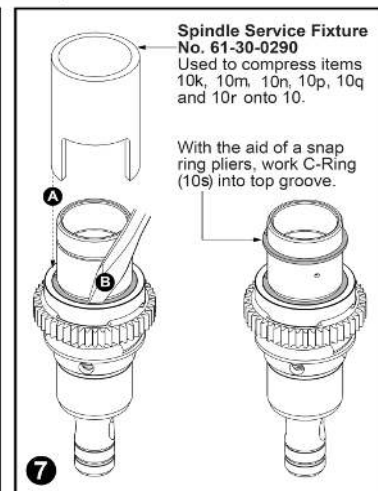
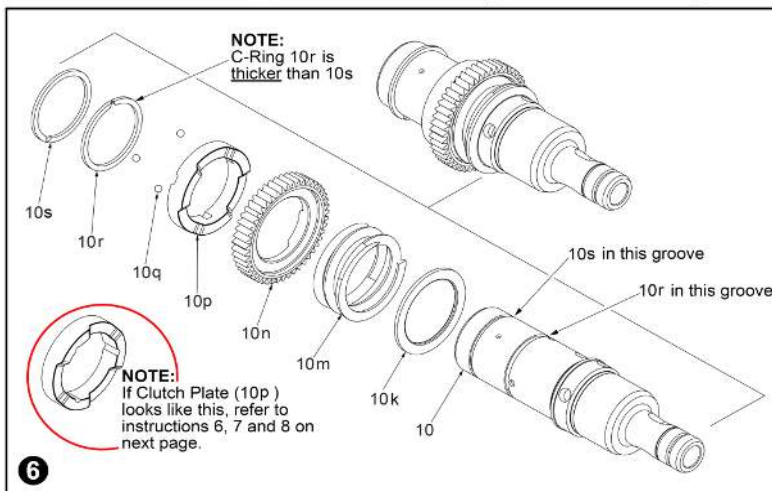
Lightly coat all parts highlighted here with 'Q2' grease unless directed otherwise.





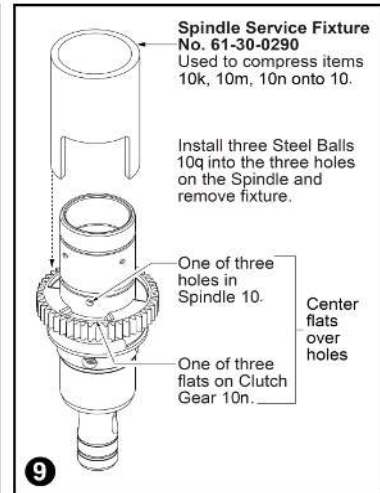
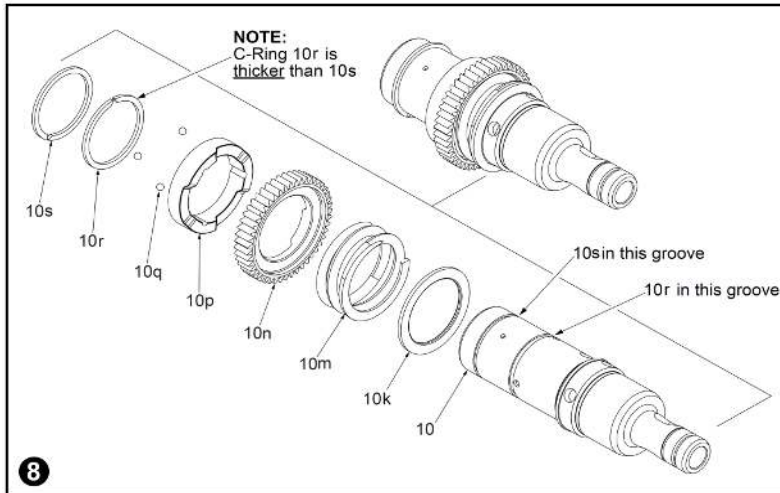
Assembly of internal Spindle components:

1. Lubricate Ram Catcher and O-Rings. Assemble O-Rings onto and into Ram Catcher.
2. Assemble Anvil Assembly into Ram Catcher Assembly (large end into Ram Catcher as shown).
3. Place the chamfered end of the Stop Washer over the small end of the Anvil.
4. Place the assembled components from step 4 into the cavity of an old piston as shown. Use the old piston as an aid to push the assembled components deep into the Spindle cavity.
5. C-Ring (10j) will be used to secure internal components inside the spindle. It is recommended to modify a flat blade screwdriver by filing or grinding a notch into the blade. Place the C-Ring upright as shown with the opening of the ring straight up. Use the modified screwdriver to push the C-Ring down into the Spindle cavity. Rotate the C-Ring in the spindle cavity as shown. Place the old piston into the Spindle cavity and tap the piston with a mallet to secure the C-Ring in the groove.



Assembly of external Spindle components:

6. Install Washer 10k and Spring 10m onto spindle. Lubricate and install the Clutch Gear 10n and Clutch Plate 10p onto the Spindle. Be sure to orient the part as shown and position with the three notches on the back of the plate over the holes in the spindle.
Place C-Ring 10r onto Spindle. (C-Ring 10r has a thicker cross section than C-Ring 10s.) With the aid of a snap ring pliers, work the C-Ring past the first spindle groove down to the other parts assembled onto spindle.
7. Place Spindle Service Fixture 61-30-0290 over the assembled parts and the Spindle. Position so the fixture rests on Clutch Plate 10p. Be sure the three notches are not covered. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the three holes in the Spindle. As an aid, put a dab of grease on your finger to pick up and place the three Steel Balls 10q into the three small holes on the Spindle just above Clutch Plate. Ensure the notches in the Clutch Plate are aligned with the Steel Balls.
While compressed **A**, use a screwdriver **B** to work C-Ring 10r into the Spindle groove. Ensure the Steel Balls are in place and slowly retract the arbor press. The Clutch Plate should slide over the Steel Balls until it is in contact with the C-Ring.
Place C-Ring 10s onto Spindle. With the aid of a snap ring pliers, work the C-Ring into the first spindle groove and snap into place.



Assembly of external Spindle components:

- Install Washer 10k and Spring 10m onto spindle. Lubricate and install the Clutch Gear 10n onto the Spindle 10. Be sure to orient the part as shown with the three flats on the Clutch Gear centered over the holes in the spindle.
- Place Spindle Service Fixture 61-30-0290 over the assembled parts and the Spindle. Position so the fixture rests on the Clutch Gear 10n. Be sure the three holes on the Spindle are not covered. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the three holes in the Spindle.

As an aid, put a dab of grease on your finger to pick up and place the three steel balls 10q into the three small holes on the Spindle just above the Clutch Gear.

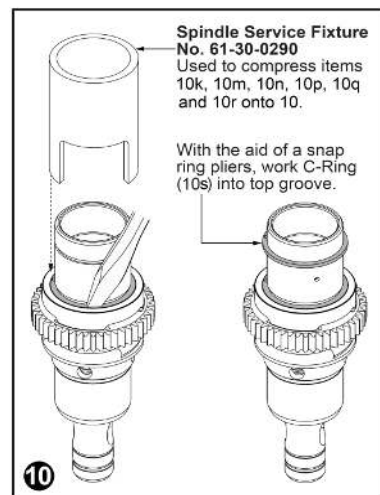
Remove the Spindle from the arbor press.

- Lubricate and install the Clutch Plate 10p onto the Spindle. Be sure to orient the part such that three inside notches on the plate cover the Steel Balls in the Spindle. Place the C-Ring 10r onto the Spindle. (**NOTE:** C-Ring 10r has a thicker cross-section than C-Ring 10s). With the aid of a snap ring pliers, work the C-Ring past the first spindle groove, down to the other parts assembled onto the spindle.

Place Spindle Service Fixture 61-30-0290 over the assembled parts and the Spindle. Place the fixture and spindle assembly in an arbor press and carefully compress the Clutch Spring enough to expose the C-Ring groove in the Spindle.

While compressed, use a flat blade screwdriver to work C-Ring 10q into the spindle groove. Ensure that the Steel Balls are still in the spindle. Slowly retract the arbor press. The Clutch Plate should slide over the Steel Balls until it is in contact with the C-Ring.

With the aid of a snap ring pliers, work C-Ring 10s into top groove of Spindle.

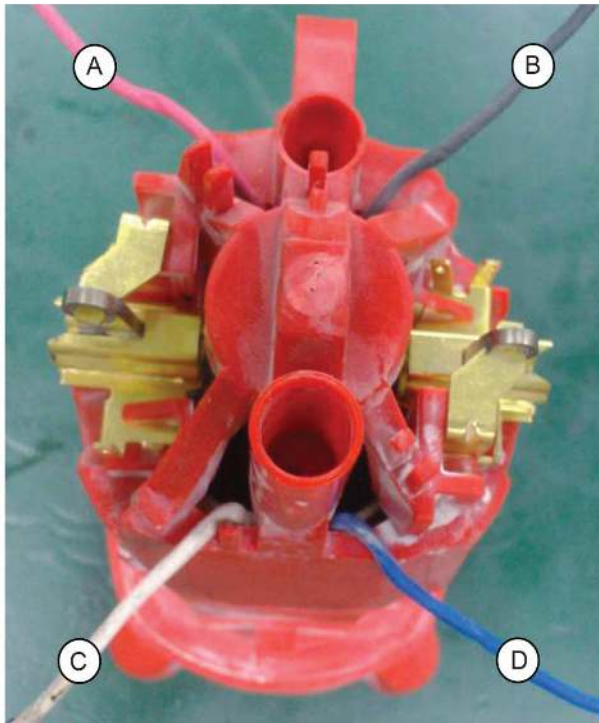
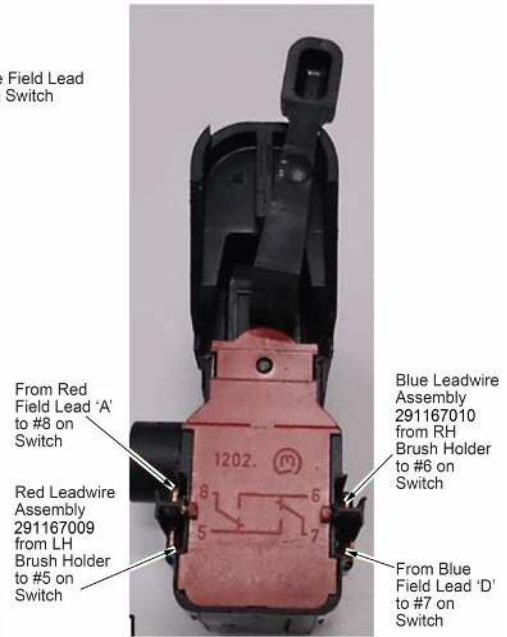
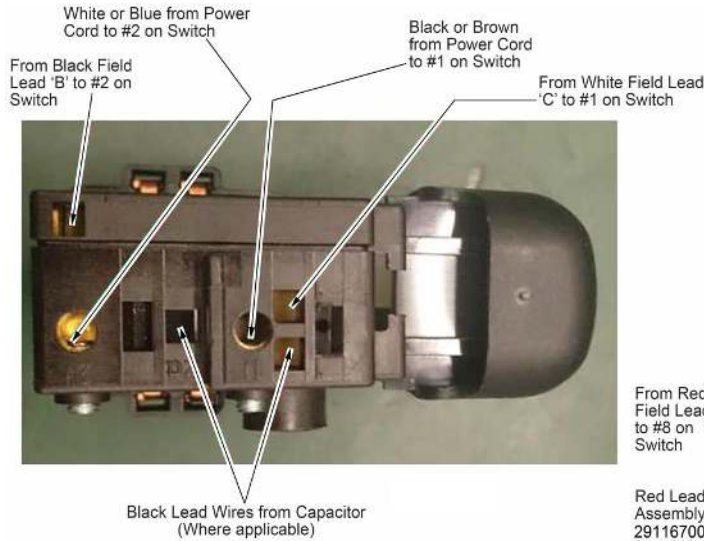


TTI Model Number: 038 138 018

Starting Serial Number:

SDS-PLUS ROTARY HAMMER 26MM (3-MODE)

VERSION A - D2015



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.

