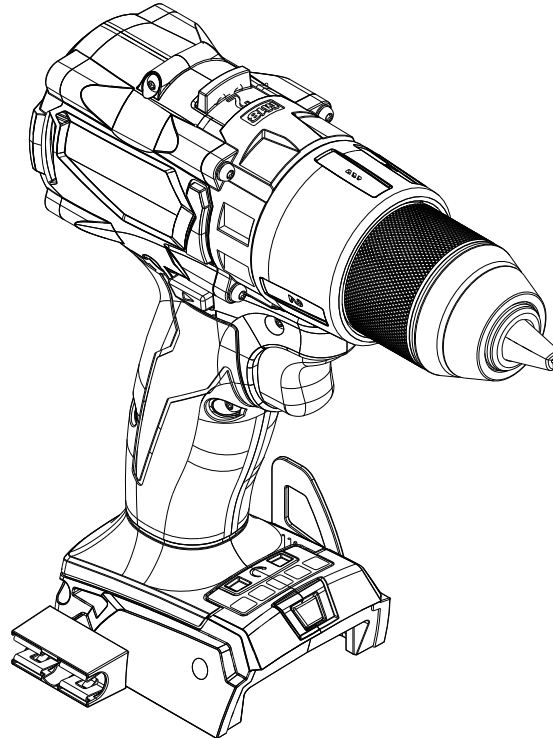




## SERVICE PARTS LIST

BULLETIN NO.  
54-00-2805

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS				REVISED BULLETIN	DATE
<b>M18™ FUEL™ ONE KEY DRIVER-DRILL</b>					Aug 2021
CATALOG NO.	2805-20	STARTING SERIAL NO.	J78A & J78B	WIRING INSTRUCTION	



**Service for Milwaukee Tool ONE KEY Products  
can only be performed at this  
Milwaukee factory Central Repair Center:**

**MILWAUKEE TOOL Central Repair  
1401 Sycamore Avenue • Greenwood, MS 38930-7277**

Please send your tool directly to this location for service.

Or

**Via e-Service at: [www.milwaukeetool.com/e-service](http://www.milwaukeetool.com/e-service)**  
questions, please call 1.800.SAWDUST (1.800.729.3878)

Or

Return it to a MILWAUKEE *factory* Service Center location, freight prepaid and insured.  
A copy of the proof of purchase should be included with the return product.

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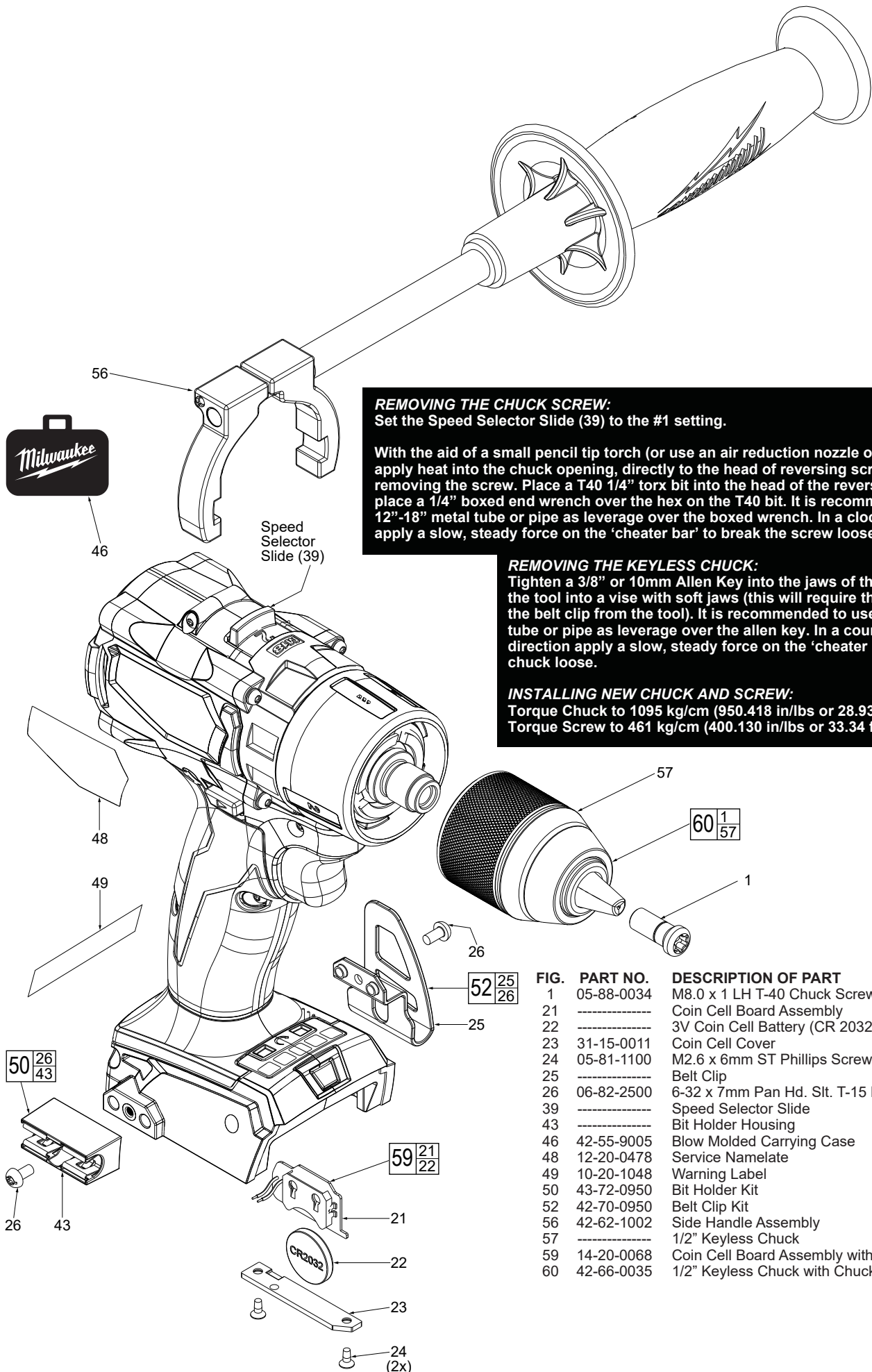
If you have questions please contact Milwaukee Product Service at:

**Product Technical Support via phone at: 262.783.8642**

Or

**Via email at: [METProductSupport@milwaukeetool.com](mailto:METProductSupport@milwaukeetool.com)**

**Disassembly is not recommended and could void the warranty.**



**REMOVING THE CHUCK SCREW:**  
Set the Speed Selector Slide (39) to the #1 setting.

With the aid of a small pencil tip torch (or use an air reduction nozzle on a heat gun) apply heat into the chuck opening, directly to the head of reversing screw just prior to removing the screw. Place a T40 1/4" torx bit into the head of the reversing screw and place a 1/4" boxed end wrench over the hex on the T40 bit. It is recommended to use a 12"-18" metal tube or pipe as leverage over the boxed wrench. In a clockwise direction apply a slow, steady force on the 'cheater bar' to break the screw loose.

**REMOVING THE KEYLESS CHUCK:**

Tighten a 3/8" or 10mm Allen Key into the jaws of the chuck. Place the tool into a vise with soft jaws (this will require that you remove the belt clip from the tool). It is recommended to use a 12"-18" metal tube or pipe as leverage over the allen key. In a counter-clockwise direction apply a slow, steady force on the 'cheater bar' to break the chuck loose.

**INSTALLING NEW CHUCK AND SCREW:**

Torque Chuck to 1095 kg/cm (950.418 in/lbs or 28.93 ft/lbs)  
Torque Screw to 461 kg/cm (400.130 in/lbs or 33.34 ft/lbs)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-88-0034	M8.0 x 1 LH T-40 Chuck Screw	(1)
21	-----	Coin Cell Board Assembly	(1)
22	-----	3V Coin Cell Battery (CR 2032)	(1)
23	31-15-0011	Coin Cell Cover	(1)
24	05-81-1100	M2.6 x 6mm ST Phillips Screw	(2)
25	-----	Belt Clip	(1)
26	06-82-2500	6-32 x 7mm Pan Hd. Slit. T-15 Mach. Screw	(2)
39	-----	Speed Selector Slide	(1)
43	-----	Bit Holder Housing	(1)
46	42-55-9005	Blow Molded Carrying Case	(1)
48	12-20-0478	Service Namelate	(1)
49	10-20-1048	Warning Label	(1)
50	43-72-0950	Bit Holder Kit	(1)
52	42-70-0950	Belt Clip Kit	(1)
56	42-62-1002	Side Handle Assembly	(1)
57	-----	1/2" Keyless Chuck	(1)
59	14-20-0068	Coin Cell Board Assembly with Battery	(1)
60	42-66-0035	1/2" Keyless Chuck with Chuck Screw	(1)