



## SERVICE PARTS LIST

BULLETIN NO.  
54-47-0330

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>M18™ FORCELOGIC™ 6T Utility Crimper</b>			Mar. 2021
CATALOG NO. <b>2977-20</b>	STARTING SERIAL NO. <b>L33A</b>	WIRING INSTRUCTION <b>SEE PAGE 5</b>	





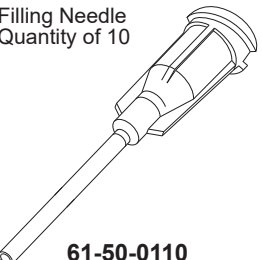
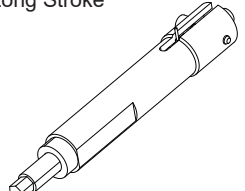
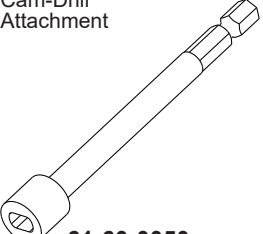

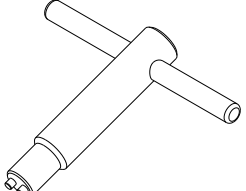

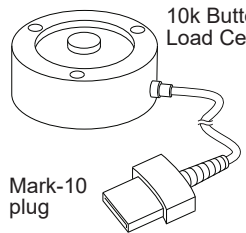
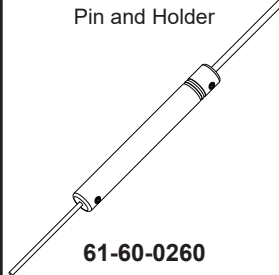
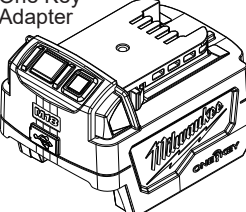
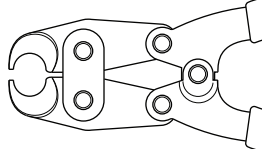
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### BEST PRACTICES when Servicing FORCELOGIC™ Tools

- **Caution:** Always assume Hydraulic tool is under pressure, before starting any repair procedures, manually engage the relief valve. Confirm no hydraulic pressure remains.
- **Important!** The pressure sensor is a monitoring device that is calibrated with the electronics assembly. **Always** replace pressure sensor and electronics assembly **as a set!**
- **Always** wear P.P.E. (Personal Protective Equipment) when working with hydraulic fluid.
- **Do not** use Hammers or Impact tools.
- **Do not** use sharp metal objects on seals or sealing surfaces.
- **Always** use recommended service tools and fixtures.
- **Always** ensure new hydraulic parts are free of burrs or defects.
- **Always** establish a clean work area free of dirt and debris.
- **Always** insure that clean parts are used prior to assembly.
- **Always** follow proper torque specifications.
- **Always** confirm repair by testing on verification fixtures.
- **Always** use appropriate hydraulic oil, MILWAUKEE FORCELOGIC™ Hydraulic Oil, No. 49-32-0110.
- **Always** remove battery pack before changing or removing accessories. Only use accessories specifically recommended for this tool. Others may be hazardous. For a complete listing of accessories, go online to [www.milwaukeetool.com](http://www.milwaukeetool.com) or contact a local MILWAUKEE distributor.

### SERVICE TOOLS / FIXTURES

Indicator  <b>61-50-0020</b>	Fill Bottle  <b>61-50-0040</b>	Seal Pick Tool  <b>61-50-0050</b>	Filling Syringe Quantity of 5  <b>61-50-0100</b>	Filling Needle Quantity of 10  <b>61-50-0110</b>
Manual Load Assembly Long Stroke  <b>61-60-0040</b>	Cam-Drill Attachment  <b>61-60-0050</b>	Pressure Sensor Crowfoot Wrench  <b>61-60-0070</b>	Relief Valve Wrench  <b>61-60-0090</b>	Main Stage Release Valve Tool  <b>61-60-0100</b>
10k Button Load Cell  Mark-10 plug <b>61-60-0210</b>	Pin and Holder  <b>61-60-0260</b>	One Key™ Adapter  <b>2700-20</b>	Crimping Service Tool  <b>61-60-0265</b>	



Service Videos are available to aid in repair and maintenance of M18™ FORCELOGIC™ Tools.



Repair Guides are available that illustrate/explain any special assembly, settings or procedures.



Verification Procedures are covered in service videos as well as repair guides.

MILWAUKEE TOOL • [www.milwaukeetool.com](http://www.milwaukeetool.com)  
13135 W. Lisbon Road, Brookfield, WI 53005  
Drwg. 1

## SERVICE PARTS EXPLODED VIEW

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

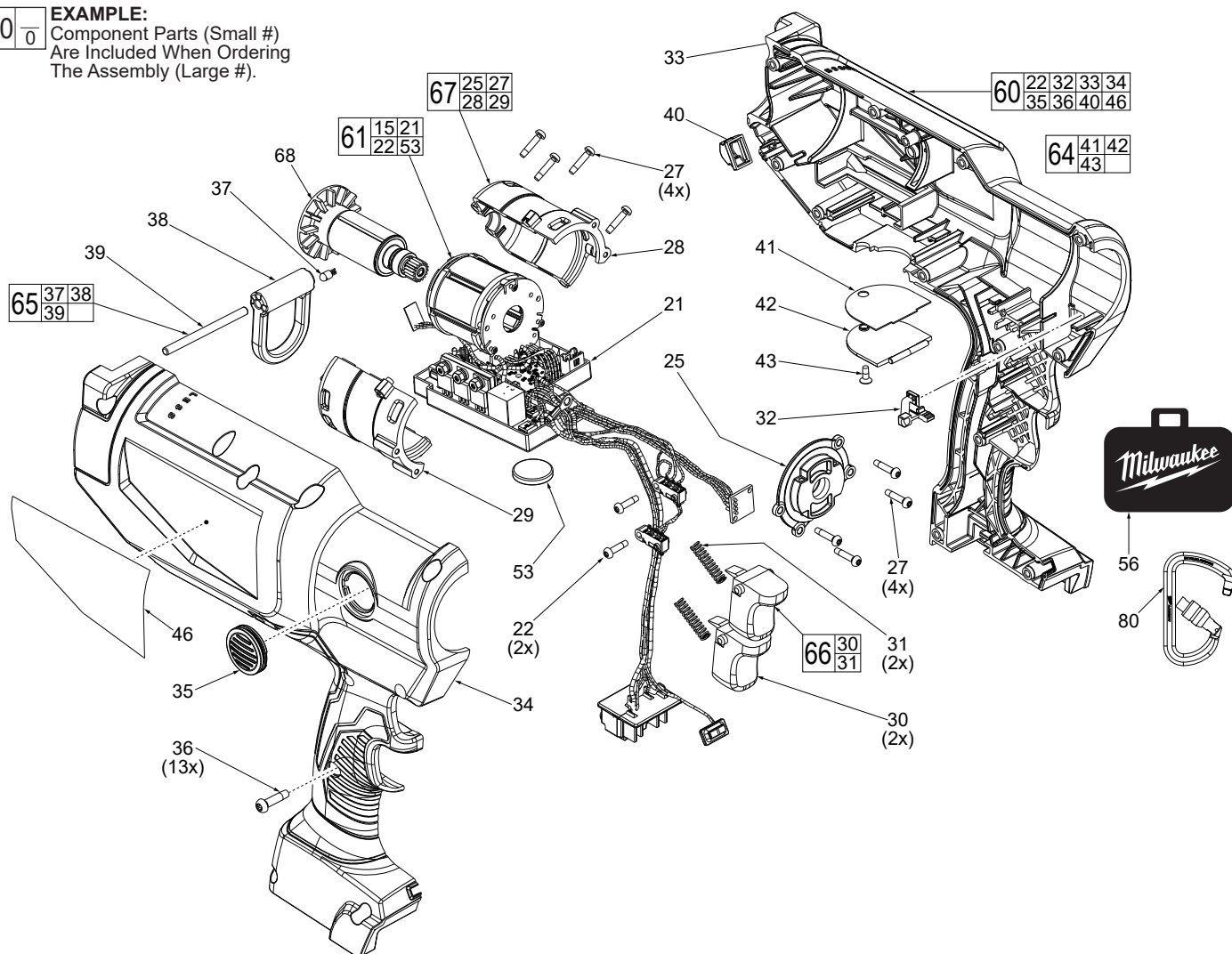


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
21	-----	PCBA/Stator Assembly	(1)
22	06-82-1087	M3 x 12mm Pan Hd. ST T-10 Screw	(2)
25	-----	Motor Plate	(1)
27	06-82-1080	M3 x 16mm Pan Hd. ST T-10 Screw	(8)
28	-----	Motor Insulator Cover	(1)
29	-----	Motor Insulator Support	(1)
30	-----	Trigger	(2)
31	-----	Spring	(2)
32	-----	Bluetooth Lens	(1)
33	-----	Handle Support	(1)
34	-----	Handle Cover	(1)
35	42-42-0016	Manual Return Button	(1)
36	06-82-4003	M4 x 16mm Pan Hd. ST T-20 Screw	(13)
37	-----	Steel Cap Assembly	(1)
38	-----	Lifting Ring	(1)
39	-----	Lift Pin	(1)
40	-----	Indicator LED Window	(1)
41	-----	Anti-Static Seal	(1)
42	-----	Coin Cell Door	(1)
43	05-78-0088	M3 x 8mm Flat Hd. ST Phillips Screw	(1)
46	12-20-0237	Service Nameplate	(1)
53	-----	3 V Coin Cell Battery (CR 2032)	(1)
56	48-22-8279	Utility Bag	(1)
60	14-34-0136	Service Handle Kit	(1)
61	14-20-0466	Service Electronics Assembly	(1)
64	42-92-0091	Service Coin Cell Door Kit	(1)
65	14-47-0222	Service Lift Ring Kit	(1)
66	31-92-0032	Service Trigger Kit	(1)
67	31-50-0732	Service Motor Insulator Kit	(1)
68	16-07-0023	Service Rotor Assembly	(1)
80	42-70-0027	Carabiner	(1)

### TORQUE SPECIFICATIONS \*Red denotes Critical Torque

FIG.	PART NO.	PART or WHERE USED	SEAT TORQUE	
			(KG/CM)	(IN/LBS)
2a	06-82-0041	Screw, Roller/Carrier Assembly	9-10	7.8-8.6
2g	06-82-0050	Screw, Lock Pin Cap	40*-80**	35*-69**
2k	06-87-0010	Thumb Screw, Clevis Pin	4	3.4
2m	06-83-0012	Socket Set Screw, Clevis Assembly	4	3.4
5e	-----	Release Valve Seat	80*-100**	69*-87**
12f	-----	Fill Plug Screw	15	13
13c	-----	Pump Sleeve	15*-50**	13*-43**
13f	-----	Intake Seat	45	39
15	-----	Pressure Sensor	204	177
19	-----	Screw, Gearcase	7-10	6-8.6
20	05-81-0015	Screw, Gearbox Assembly	12	10.4
22	06-82-1087	Screw, Micro Switches	5	4.3
23	05-88-0051	Screw, Pump Body/Cam Shaft Assy.	15*-135**	13*-117**
24	05-88-0031	Screw, Pump Body/Cam Shaft Assy.	42-45	36-39
27	06-82-1080	Screw, Motor Insulator	3.5	3
27	06-82-1080	Screw, Motor Plate	7	6.8
36	06-82-4003	Screw, Handle Cover	17	14
43	-----	Screw, Coin Cell Door	4	3.4
44	05-88-0041	Ground Screw, Pump Body	15	13

\* = Pre-tighten with hand screw driver

\*\* = Tighten with torque wrench



Service Verification Specification 4350-4850 lbs



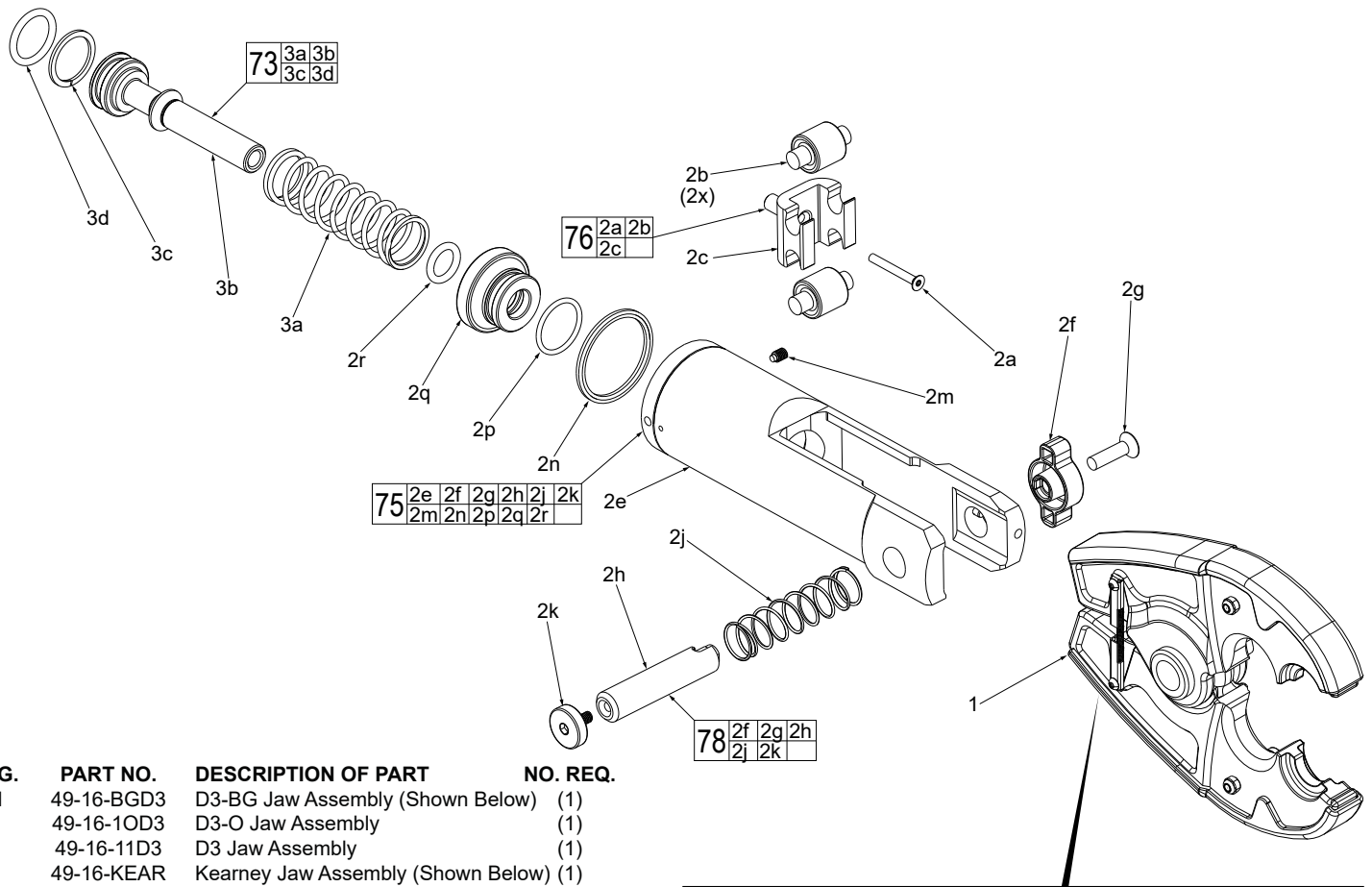
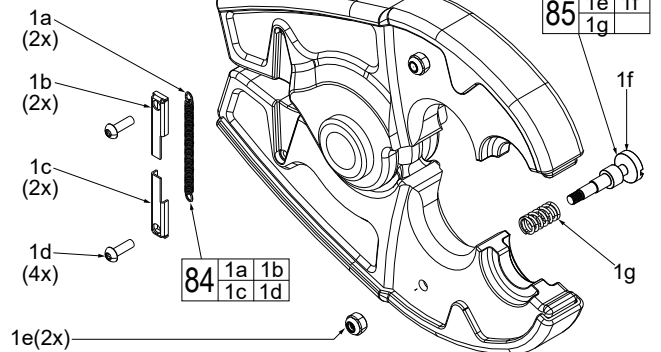


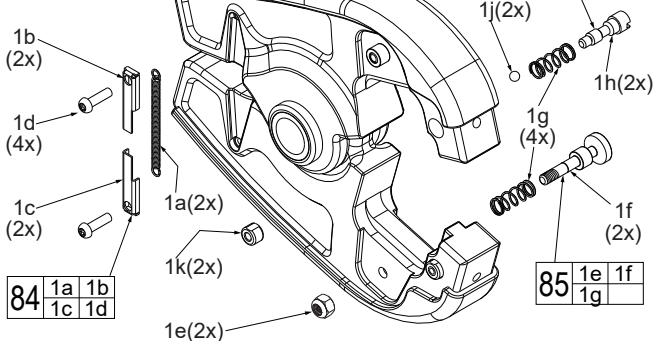
FIG. PART NO. DESCRIPTION OF PART NO. REQ.

1	49-16-BGD3	D3-BG Jaw Assembly (Shown Below)	(1)
	49-16-1OD3	D3-O Jaw Assembly	(1)
	49-16-11D3	D3 Jaw Assembly	(1)
	49-16-KEAR	Kearney Jaw Assembly (Shown Below)	(1)
	49-16-2772	McM CU/AL Cutting Jaw Assembly	(1)
	49-16-2773	477 ACSR Cutting Jaw Assembly	(1)
	49-16-2777	EHS Guy Wire Cutting Jaw Assembly	(1)
	49-16-2778	Fine Strand Wire Cutting Jaw Assembly	(1)
1a	-----	Outer Spring	(2)
1b	-----	Left Spring Cover	(2)
1c	-----	Right Spring Cover	(2)
1d	-----	Spring Mount Sprow	(4)
1e	-----	Lock Nut	(2)
1f	-----	Die Pin Post	(2)
1g	-----	Die Pin Spring	(2)
1h	-----	Kearney Die Pin	(2)
1j	-----	Kearney Detent Ball	(2)
1k	-----	Kearney Die Pin Cap	(2)
2a	06-82-0041	M3 x 25mm Flat Hd. T-8 Machine Scr.	(1)
2b	-----	Roller	(2)
2c	-----	Roller Carrier	(1)
2e	-----	Clevis with Pin	(1)
2f	31-12-0018	Lock Pin Cap	(1)
2g	06-82-0050	Clevis Pin Cap Screw	(1)
2h	44-60-0042	Lock Pin	(1)
2j	40-50-0036	Lock Pin Spring	(1)
2k	06-87-0010	Thumb Screw	(1)
2m	06-83-0012	Socket Set Screw	(1)
2n	34-40-0053	Quad Ring	(1)
2p	34-40-0011	O-Ring	(1)
2q	-----	Bushing Ram	(1)
2r	34-40-0034	O-Ring	(1)
3a	-----	Ram Spring	(1)
3b	-----	Plunger	(1)
3c	45-88-0029	Back Up Washer	(1)
3d	34-40-0036	O-Ring	(1)
73	44-82-0015	Service Ram Kit	(1)
75	28-25-0010	Service Clevis Kit	(1)
76	44-96-0050	Service Roller and Carrier Assembly	(1)
78	44-60-0043	Service Clevis Pin Kit	(1)
84	43-90-0250	Jaw Spring and Cover Kit (Set of 1)	(2)
85	44-60-0071	W Die Pin Kit (Set of 1)	(2)
86	44-60-0016	Kearney Die Pin Kit (Set of 1)	(2)

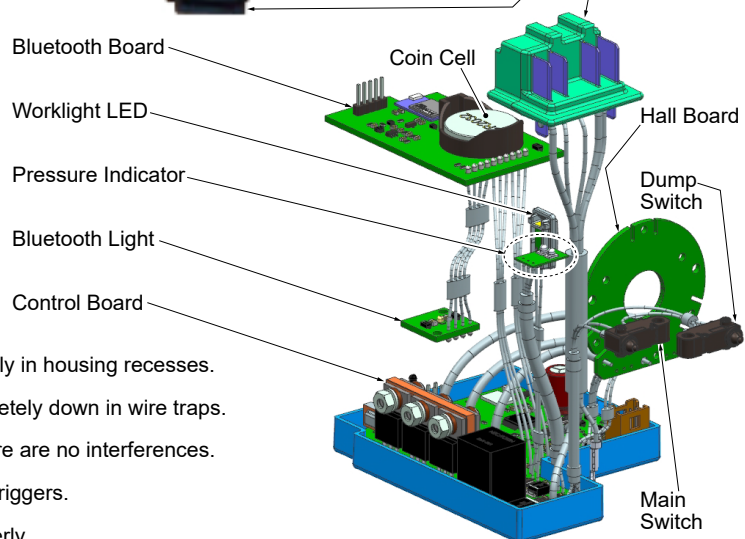
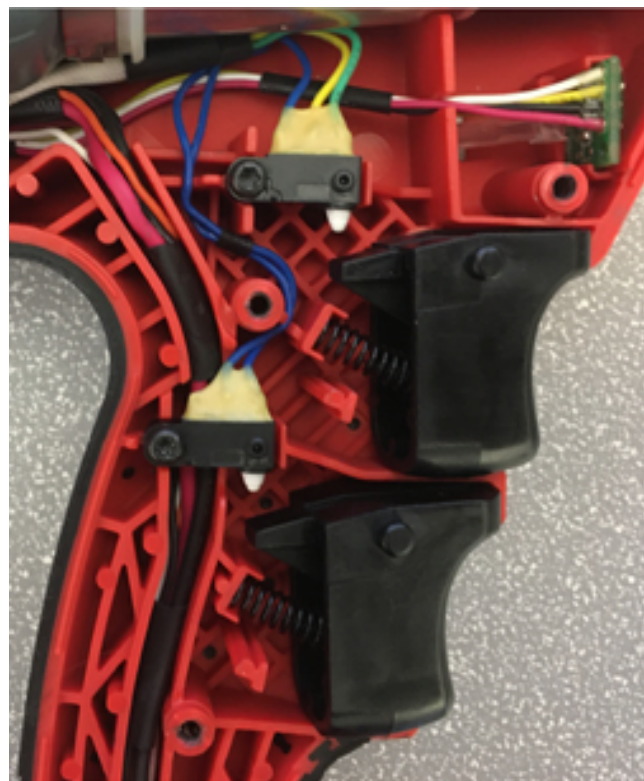
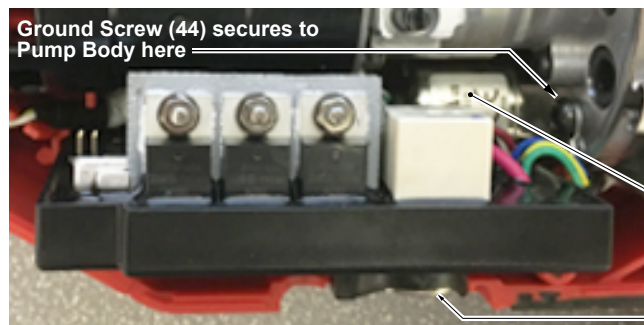
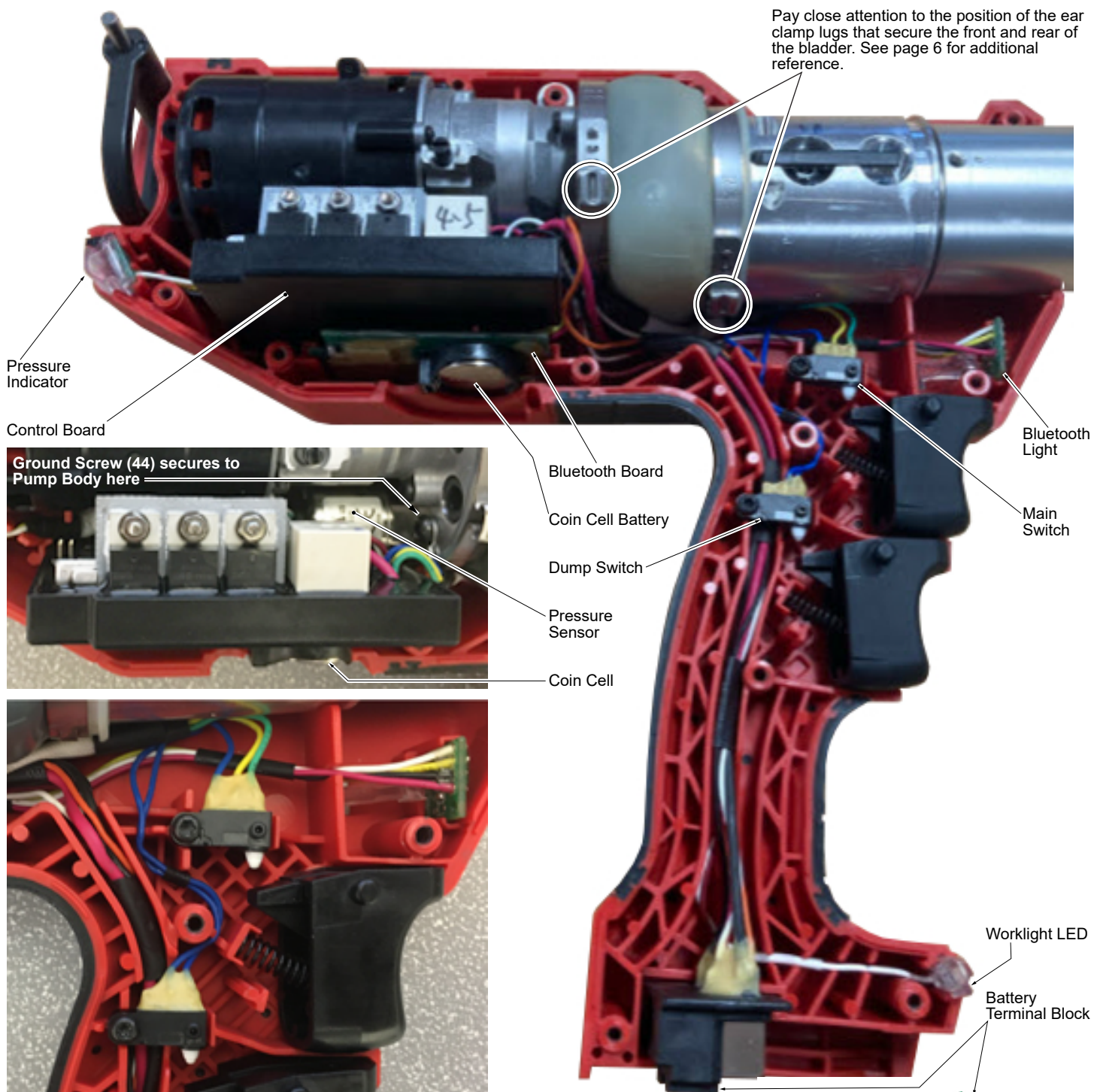
**49-16-BGD3**  
D3-BG Jaw Assembly



**49-16-KEAR**  
Kearney Jaw Assembly







As an aid to reassembly, take notice of wire routings and position in wire guides and traps while dismantling tool.

Be sure that all components of electronics kit are seated firmly and squarely in housing recesses.

Avoid pinched wires, be sure that all wires and sleeves are pressed completely down in wire traps.

Prior to securing housing cover onto the housing support, be sure that there are no interferences.

Before installing the battery, check for proper functionality of shuttles and triggers.

Install battery and depress switch triggers to assure tool is operating properly.

## LUBRICATION INSTRUCTIONS

