

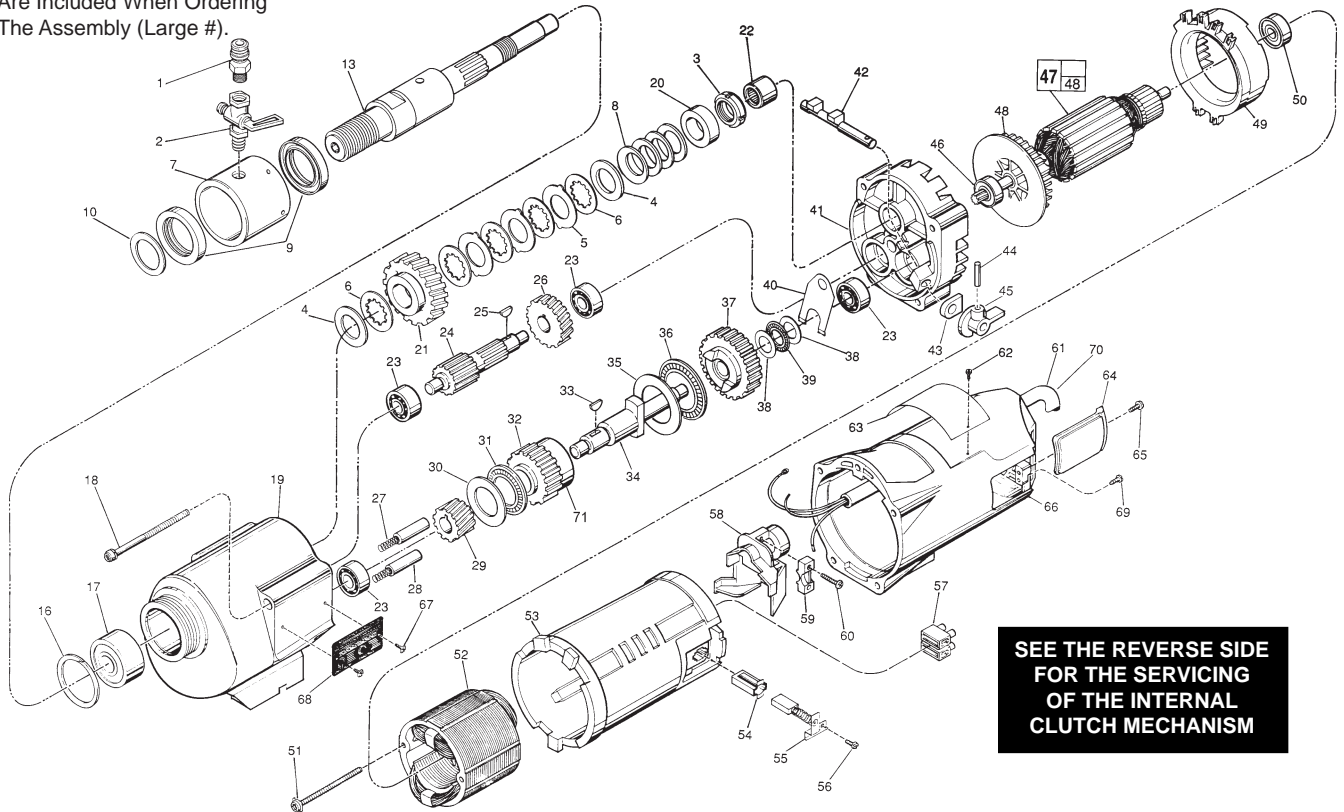


# SERVICE PARTS LIST

**BULLETIN NO.**  
**55-16-5061**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS |               | REVISED BULLETIN                               | DATE      |
|--|---------------|--|-----------|
| <b>DYMODRILL with INTERNAL CLUTCH</b>                  |               | 55-16-5060                                     | Mar. 2008 |
| <b>CATALOG NO.</b>                                     | <b>4096-4</b> | <b>WIRING INSTRUCTION</b><br><b>58-03-0020</b> |           |
| <b>STARTING SERIAL NO.</b>                             | <b>798B</b>   |  |           |

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



**SEE THE REVERSE SIDE  
FOR THE SERVICING  
OF THE INTERNAL  
CLUTCH MECHANISM**

| FIG. | PART NO.   | DESCRIPTION OF PART                  | NO. REQ. |
|------|------------|--------------------------------------|----------|
| 1    | 42-90-0210 | Water Hose Fitting                   | (1)      |
| 2    | 45-80-0060 | Shut Off Valve                       | (1)      |
| 3    | 06-57-1050 | Retaining Nut                        | (1)      |
| 4    | 45-88-1140 | Thrust Washer                        | (2)      |
| 5    | 43-06-0160 | Clutch Disc-Outer                    | (3)      |
| 6    | 43-06-0150 | Clutch Disc-Inner                    | (5)      |
| 7    | 43-76-0051 | Water Swivel Hsg. w/ 06-83-2430 Scr. | (1)      |
| 8    | 40-50-2150 | Disc Spring                          | (4)      |
| 9    | 45-06-0635 | Seal                                 | (2)      |
| 10   | 45-88-8565 | Washer (Bag of 2)                    | (1)      |
| 13   | 38-50-6020 | Spindle                              | (1)      |
| 16   | 34-80-3800 | Retaining Ring                       | (1)      |
| 17   | 02-20-2515 | Ball Bearing                         | (1)      |
| 18   | 06-82-9202 | 1/4-20 x 4-1/4" Taptite T-30         | (4)      |
| 19   | 28-14-1870 | Gear Case Assy.(Inc. 06-65-1535 Pin) | (1)      |
| 20   | 45-36-1520 | Spindle Spacer                       | (1)      |
| 21   | 32-75-3420 | Spindle Gear                         | (1)      |
| 22   | 02-50-4830 | Needle Bearing                       | (1)      |
| 23   | 02-04-1205 | Ball Bearing                         | (4)      |
| 24   | 36-66-3751 | Pinion Shaft Assy.                   | (1)      |
| 25   | 06-42-1600 | Woodruff Key                         | (1)      |
| 26   | 32-40-1581 | Intermediate Gear                    | (1)      |
| 27   | 40-50-6300 | Shifting Spring                      | (2)      |
| 28   | 44-70-0100 | Shifting Plunger                     | (2)      |
| 29   | 32-60-1041 | Pinion Gear                          | (1)      |
| 30   | 45-88-0520 | Thrust Bearing Washer                | (1)      |
| 31   | 02-80-1800 | Thrust Bearing                       | (1)      |
| ★ 32 | 32-10-0060 | Clutch Gear                          | (1)      |
| 33   | 06-42-2000 | Woodruff Key                         | (1)      |
| 34   | 36-14-0061 | Clutch Shaft                         | (1)      |
| 35   | 45-88-0530 | Thrust Bearing Washer                | (1)      |
| 36   | 02-80-5000 | Thrust Bearing                       | (1)      |
| 37   | 32-10-0051 | Clutch Gear Assembly                 | (1)      |
| 38   | 45-88-0510 | Thrust Bearing Washer                | (2)      |
| 39   | 02-80-1200 | Thrust Bearing                       | (1)      |
| 40   | 45-98-0090 | Shifting Yoke                        | (1)      |
| 41   | 14-13-0210 | Diaphragm Assy.(Inc. 06-65-1155 Pin) | (1)      |
| 42   | 30-15-0272 | Shift Cam                            | (1)      |
| 43   | 43-44-0580 | Foam Gasket                          | (2)      |
| 44   | 06-65-0840 | 1/8 x 3/4" Groove Pin                | (1)      |
| 45   | 25-60-0056 | Shifting Knob                        | (1)      |
| 46   | 02-04-1229 | Ball Bearing                         | (1)      |

| FIG. | PART NO.   | DESCRIPTION OF PART                    | NO. REQ. |
|------|------------|--|----------|
| 47   | 16-76-0325 | 230 V Armature                         | (1)      |
| 48   | 22-84-0790 | Fan                                    | (1)      |
| 49   | 42-14-0291 | Baffle                                 | (1)      |
| 50   | 02-04-1041 | Ball Bearing                           | (1)      |
| 51   | 06-82-9152 | 10-24 x 2-3/4" Pan Hd. Sem. T-25       | (2)      |
| 52   | 18-74-0120 | 220 V. Field                           | (1)      |
| 53   | 23-16-1410 | Motor Insulator                        | (1)      |
| 54   | 22-20-0680 | Brush Tube                             | (2)      |
| 55   | 22-18-0706 | Carbon Brush Assembly                  | (2)      |
| 56   | 06-82-8835 | 8-32 x 5/16" Pan Hd. Sem.T-20          | (2)      |
| 57   | 22-56-0470 | Terminal Block                         | (1)      |
| 58   | 22-38-0140 | Wire Trap                              | (1)      |
| 59   | 31-17-0200 | Cord Clamp                             | (1)      |
| 60   | 06-82-7326 | 8-16 x 1" Pan Hd. Plastite T-20        | (2)      |
| 61   | 23-37-0150 | Control Assy. (See Bull. 58-03-0020)   | (1)      |
| 62   | 06-72-1720 | Service Rivet                          | (2)      |
| ★ 63 | 12-99-1823 | Service Nameplate                      | (1)      |
| 64   | 22-32-0350 | Brush Cover                            | (2)      |
| 65   | 06-82-5316 | 8-32 x 1/2" Pan Hd. Slit. Taptite T-20 | (2)      |
| 66   | 28-50-6363 | Motor Housing                          | (1)      |
| 67   | 06-82-5266 | 4-40 x 1/4" Pan Hd. Taptite T-10       | (2)      |
| 68   | 12-98-3060 | Instruction Plate                      | (1)      |
| ★ 69 | 06-95-5200 | 8-32 x 5/16" Slit. Hex Hd. Screw       | (1)      |
| 70   | 22-36-0090 | PRCD (See Bulletin No. 58-03-0020)     | (1)      |
| ★ 71 | 45-36-0225 | Gear Spacer                            | (1)      |
|      | 49-96-4700 | 1-3/8" Open End Wrench                 | (1)      |
|      | 49-96-0050 | 3/32" Hex Socket Wrench                | (1)      |
|      | 49-96-0085 | 3/16" Hex Socket Wrench                | (1)      |
|      | 45-56-0210 | Strap And Buckle                       | (1)      |
|      | 61-10-0660 | Retaining Nut Spanner Tool             | (1)      |
|      | 61-30-0061 | Water Seal Jig                         | (1)      |

**FOR MOUNTING DRILL MOTOR USE:**

|            |                                |     |
|------------|--------------------------------|-----|
| 06-75-3090 | 1/4-20 x 7/8" Socket Hd. Screw | (4) |
| 06-97-4050 | 1/4" Split Ring Lock Washer    | (4) |

**FIG. LUBRICATION**

19 18 Oz. Type "J" Grease, No. 49-08-4220.

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
13135 W. LISBON RD., BROOKFIELD, WI 53005

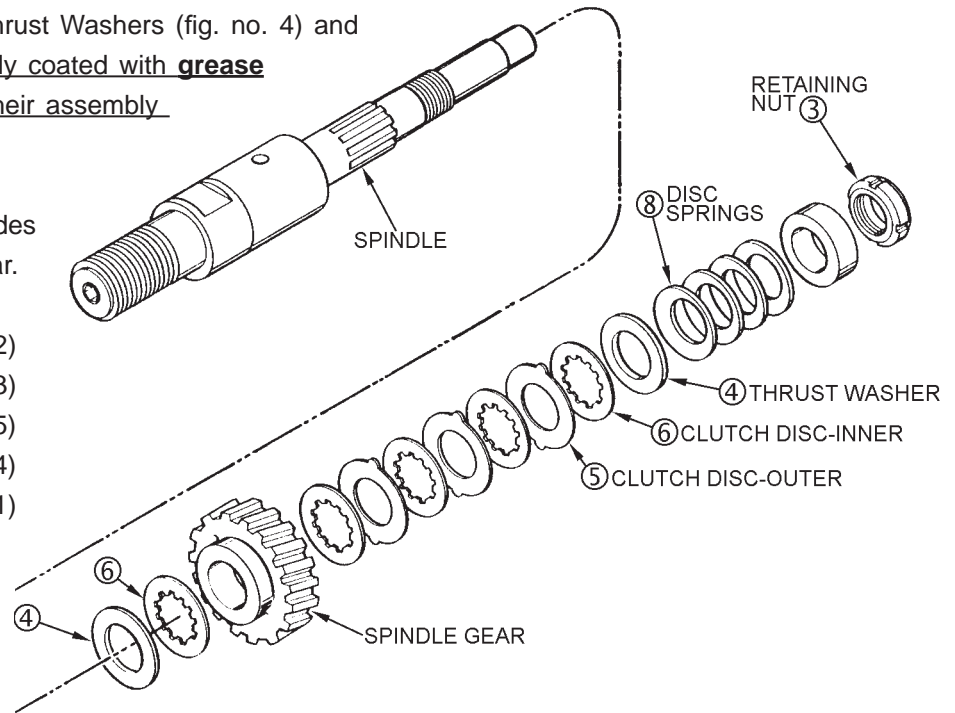
## Servicing the Clutch Mechanism-

Torque Value for the Clutch Mechanism Retaining Nut (fig. no. 3).

**Grease / Lubrication** — when assembling the internal clutch component parts: the Clutch Discs (fig. nos. 5 and 6), Thrust Washers (fig. no. 4) and Disc Springs (fig. no. 8) are to be lightly coated with grease (Cat. No. 49-08-4220 type 'J') during their assembly into the spindle gear.

Grease / Lubrication specification includes coating internal bore of the spindle gear.

|   |            |                    |     |
|---|------------|--------------------|-----|
| 4 | 45-88-1140 | Thrust Washers     | (2) |
| 5 | 43-06-0160 | Clutch Discs-Outer | (3) |
| 6 | 43-06-0150 | Clutch Discs-Inner | (5) |
| 8 | 40-50-2150 | Spring Discs       | (4) |
|   | 32-75-3430 | Spindle Gear       | (1) |



**Service note:** the assembly torque for the Clutch Mechanism Retaining Nut, No. 06-57-1050 (fig. no. 3), which insures the static torque required to slip the clutch mechanism, as lubricated, should be **40-45 ft-lbs (54-61 Nm).**

With the gear case separated from the diaphragm & motor housing of the Clutch Dymo-Drill motor —

- insert & engage a **61-10-0660** retaining nut spanner with the notches in the **06-57-1050** clutch adjustment retaining nut.
- with a **1/2" hex socket bit driver** attached to a torque wrench, interlock the male hex with the female hex found in the threaded end of the dymo-drill spindle.
- turn the torque wrench clockwise ⤵, observing the torque reading and tighten the clutch adjustment retaining nut on the rear of the spindle shaft until a value of **40-45 ft-lbs (54-61 Nm)** is obtained.

