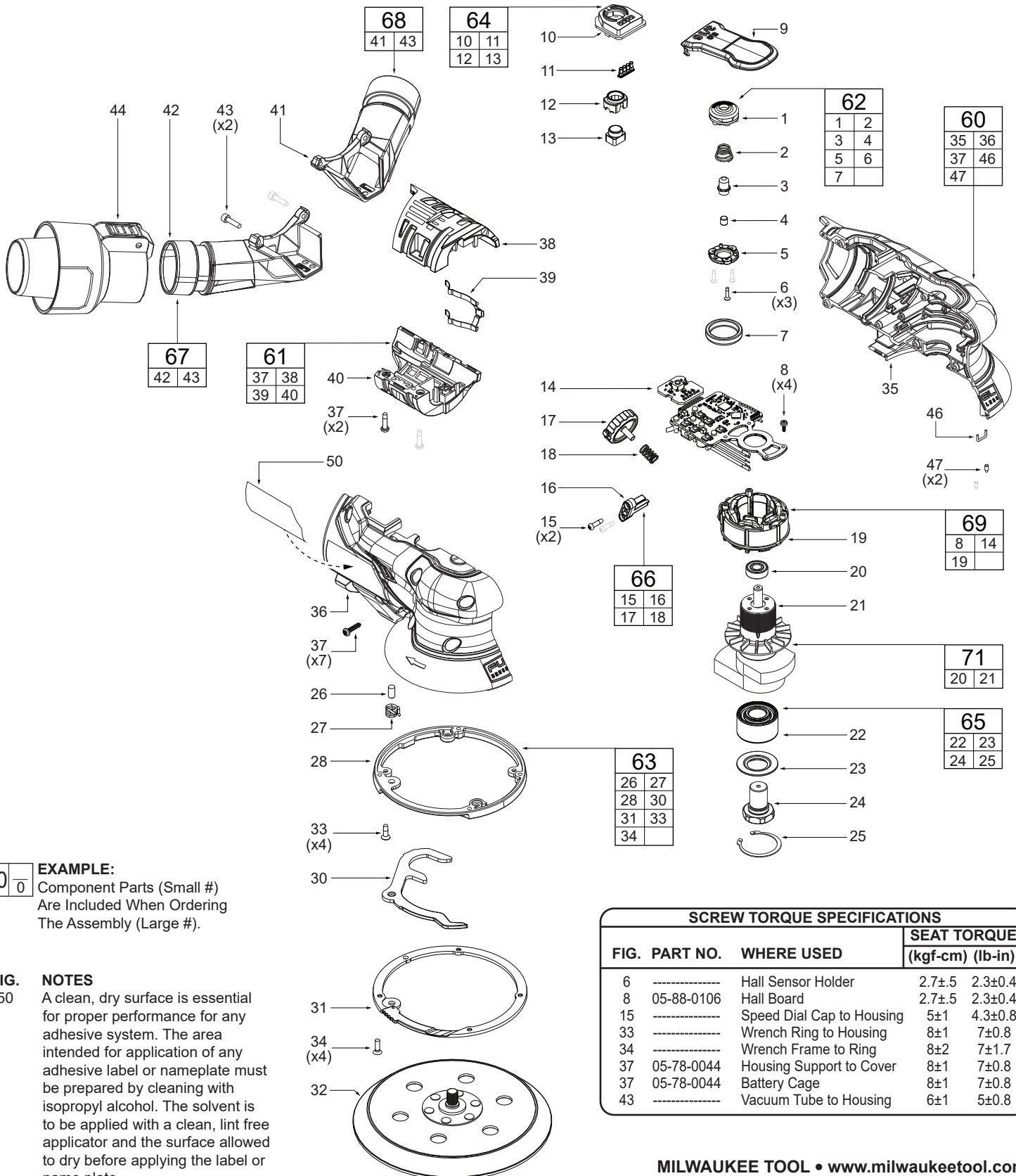




SERVICE PARTS LIST

BULLETIN NO.
54-38-2700

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
M12 FUEL™ 6" Random Orbital SANDER (3/16")			Jan. 2024
CATALOG NO.	2585-20	SERIAL NO.	P16A
		WIRING INSTRUCTION See Page 3	



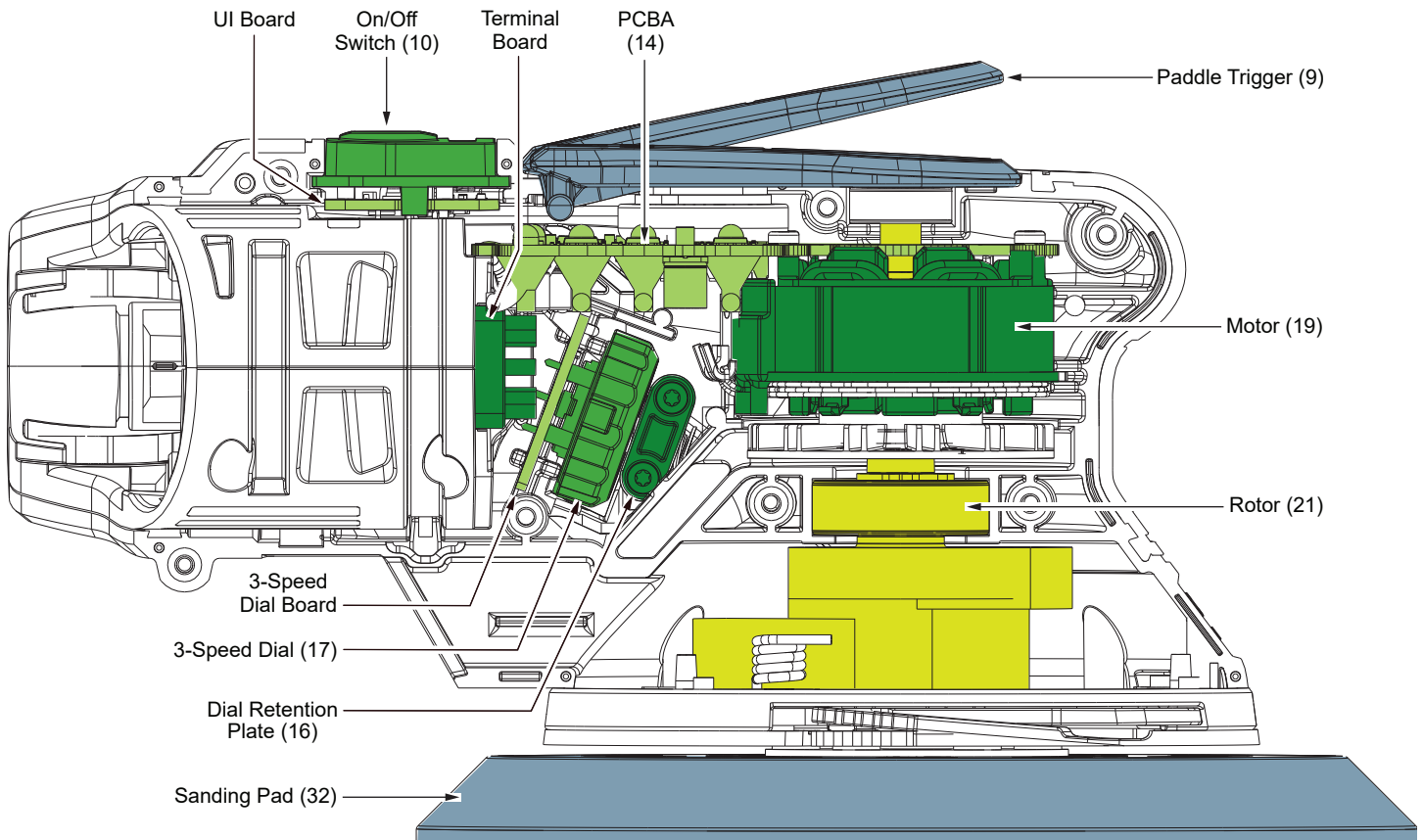
EXAMPLE:
Component Parts (Small #)
Are Included When Ordering
The Assembly (Large #).

FIG. 50 NOTES
A clean, dry surface is essential for proper performance for any adhesive system. The area intended for application of any adhesive label or nameplate must be prepared by cleaning with isopropyl alcohol. The solvent is to be applied with a clean, lint free applicator and the surface allowed to dry before applying the label or name plate.

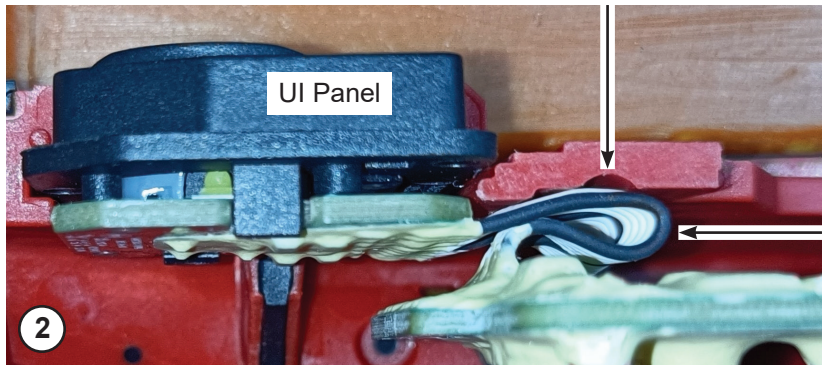
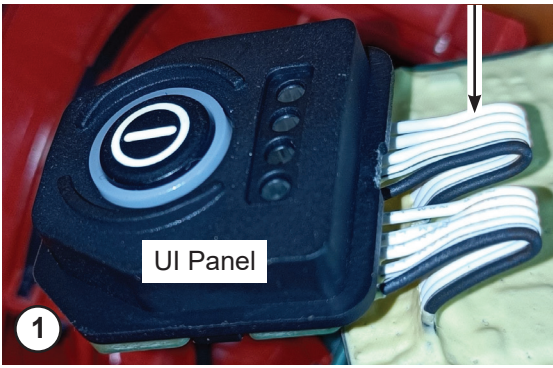
SCREW TORQUE SPECIFICATIONS			
FIG.	PART NO.	WHERE USED	SEAT TORQUE (kgf-cm) (lb-in)
6	-----	Hall Sensor Holder	2.7±.5 2.3±0.4
8	05-88-0106	Hall Board	2.7±.5 2.3±0.4
15	-----	Speed Dial Cap to Housing	5±1 4.3±0.8
33	-----	Wrench Ring to Housing	8±1 7±0.8
34	-----	Wrench Frame to Ring	8±2 7±1.7
37	05-78-0044	Housing Support to Cover	8±1 7±0.8
37	05-78-0044	Battery Cage	8±1 7±0.8
43	-----	Vacuum Tube to Housing	6±1 5±0.8

SERVICE BILL OF MATERIAL (BOM) LISTING

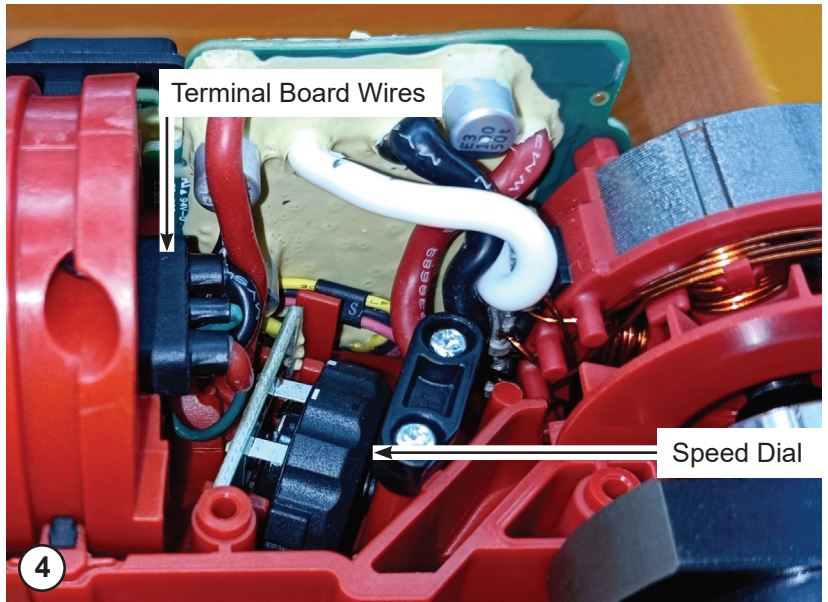
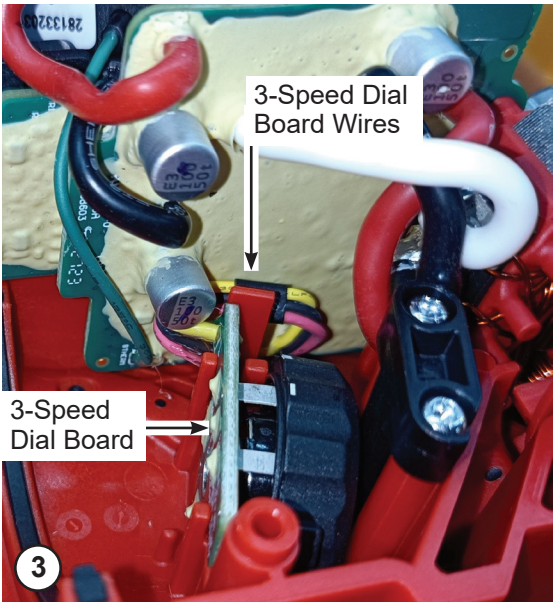
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	-----	Support Half of Spring	(1)	33	-----	M3 x Flat Head Torx T-10 Taptite Screw	(4)
2	-----	Hall Sensor Spring	(1)	34	-----	M3 x 10mm Flat Hd. Torx T-10 B Screw	(4)
3	-----	Hall Sensor Holder	(1)	35	-----	Handle Support	(1)
4	-----	Hall Sensor Magnet	(1)	36	-----	Handle Cover	(1)
5	-----	Cover Half of Spring Retention	(1)	37	05-78-0044	M3 x 12mm Pan Hd. Torx Taptite Screw	(9)
6	-----	M2 x 7.8mm ST Screw	(3)	38	-----	Battery Support	(1)
7	-----	Sealing Foam	(1)	39	42-70-0480	Spring Clip	(1)
8	05-88-0106	M2 x 5.5mm Pan Head Torx T-8 Screw	(4)	40	-----	Battery Cover	(1)
9	31-92-0043	Paddle Trigger for 3/16" Paddle	(1)	41	-----	Left Hand Vacuum Port	(1)
10	-----	UI Bezel	(1)	42	-----	Right Hand Vacuum Port	(1)
11	-----	Light Pipe	(1)	43	-----	M3 x 12mm Cap Hd. Hexagon M Screw	(2)
12	-----	Power Mode Lense	(1)	44	43-76-0059	Vacuum Adaptor	(1)
13	-----	UI Power Bottom	(1)	46	-----	Wire Clip	(1)
14	-----	PCBA for the 3/16" version	(1)	47	-----	Rubber Slug	(2)
15	-----	M2.6 x 10mm Torx T-8 Taptite Screw	(2)	50	12-20-0644	Service Nameplate	(1)
16	-----	Dial Retention Plate	(1)	60	14-46-0133	Handles Kit	(1)
17	-----	3-Speed Dial	(1)	61	14-46-0184	Battery Support Kit	(1)
18	-----	7 x 11mm Spring	(1)	62	14-46-0187	Sensor Trigger Kit	(1)
19	-----	Motor Field, 12V-DC BL45	(1)	63	14-46-0319	Quick Change Mech Kit	(1)
20	02-04-0071	Deep Groove Ball Bearing	(1)	64	14-46-0261	UI Bottom Kit	(1)
21	-----	Rotor	(1)	65	14-46-0299	Retention Kit	(1)
22	-----	Double Row Ball Bearing	(1)	66	14-46-0269	Speed Dial Kit	(1)
23	-----	Rubber Gasket	(1)	67	14-46-0323	Right Hand Vacuum Port Kit	(1)
24	-----	BP Attachment Nut	(1)	68	14-46-0324	Left Hand Vacuum Port Kit	(1)
25	-----	Internal Inverted Retaining Ring	(1)	69	14-46-0199	PCBA / Motor Kit for 3/16"	(1)
26	-----	Quick Change Hinge	(1)	71	14-46-0293	Rotor Kit for 3/16"	(1)
27	-----	Torsion Spring	(1)	80	49-36-2584	6" Hook & Loop Backing Pad - Firm	(1)
28	-----	Quick Change Mechanism Ring	(1)			- Accessory (Not Shown)	
30	-----	Quick Change Wrench	(1)	81	49-36-2586	6" PSA Pressure & Sensitive Adhesive	(1)
31	-----	Quick Change Frame Ring	(1)			- Firm - Accessory (Not Shown)	
32	-----	6" Pad for 3/16" Orbit Sander	(1)				



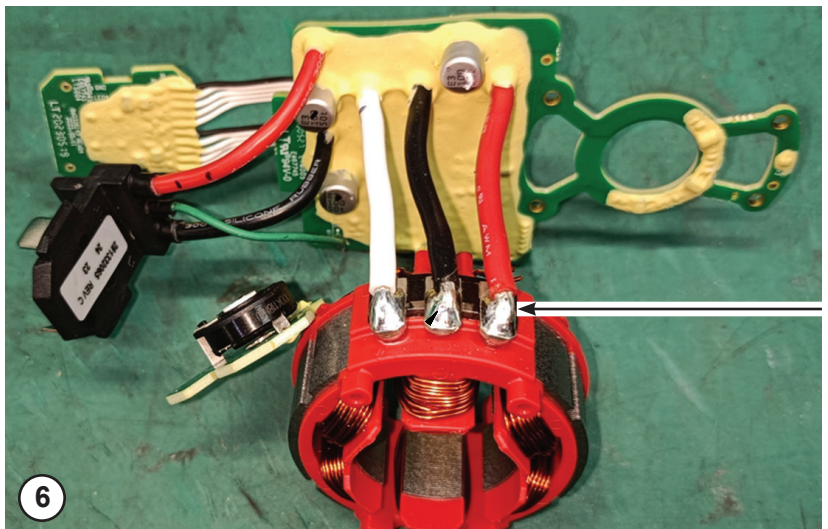
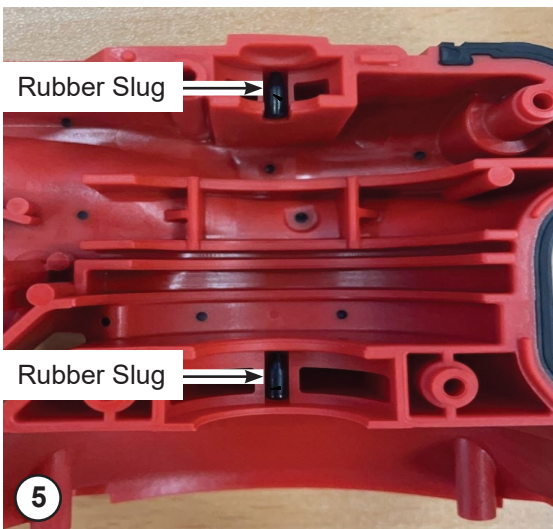
WIRING



- The UI Wires should be folded (Fig. 1) first and then routed inside the Housing (Fig. 2)



- The 3-Speed Dial Board Wires **should be routed behind the rib** (Fig. 3)
- The 3 Terminal Board Wires should be routed to **avoid them being above the Speed Dial**. (Fig. 4)
There should be no wires above the Speed Dial.



- The Rubber Slugs (47) **should be assembled in the SAME direction**. (Fig. 5)
- The Welding Temperature 420° ~ 450°C (Fig. 6)