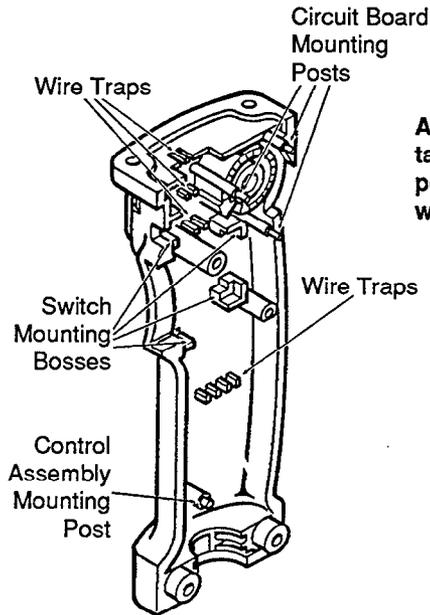


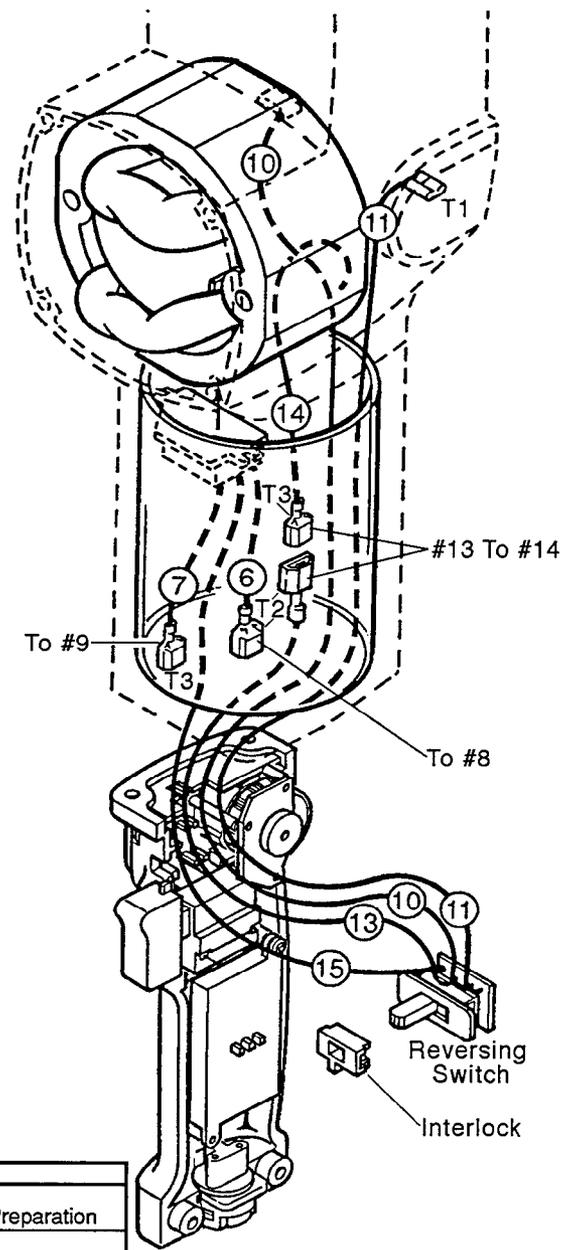
WIRING INSTRUCTIONS

TITLE VARIABLE SPEED HOLE-HAWG®	MILWAUKEE ELECTRIC TOOL CORP. 13135 WEST LISBON RD. BROOKFIELD, WIS.	DATE Aug. '97	BULLETIN 58-01-0665
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As an aid in reassembly, take note of wire routing and position in wire guides and traps while dismantling tools.

SEE REVERSE SIDE FOR ADDITIONAL WIRING INFORMATION



Run wires #10 and #11 under the flanges, then through the slots in the coil shield. Route red wire #10 to the right hand side of the tool and terminate to the right hand brush tube. Route white wire #11 to the left hand brush tube. Make sure to trap wires #10 and #11 behind pegs in coil shield.

Install the coil shield, field insulator and the field into the motor housing while feeding the triac/reversing switch assembly through handle hole in motor housing. Connect yellow field wire #14 to yellow wire #13 from the reversing switch. Attach triac portion of assembly to the motor housing with two screws No. 06-82-5266. Connect triac blue/black wire #6 to blue/black control assembly wire #8. Connect white/blue #7 triac wire to the white/blue #9 wire from the control assembly.

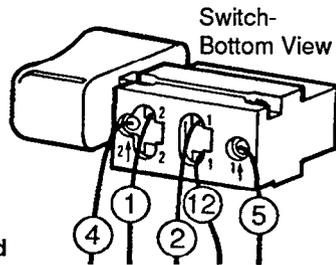
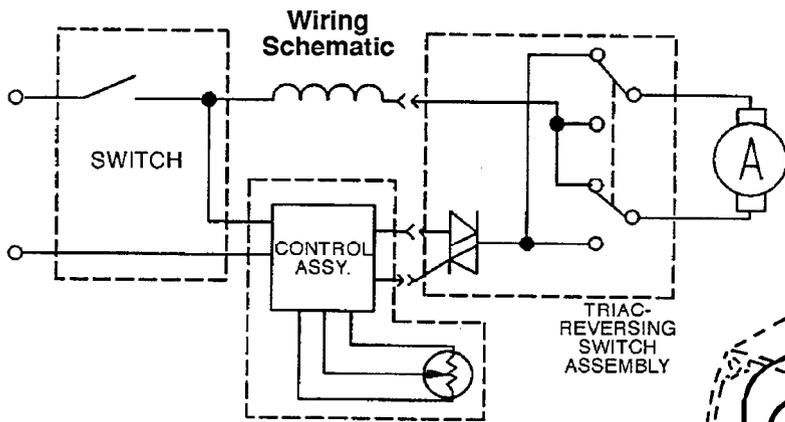
WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Part No.	Gauge	Length	Terminals, Connectors and End Wire Preparation
1	White	Control Assy.	18	2-1/4"	Component of control assembly
2	Black	Control Assy.	18	2-1/4"	Component of control assembly
3	Green	Pin Hsg. Assy.	18	14"	Component of pin housing assembly / Strip 3/16" for T4
4	White	Pin Hsg. Assy.	18	5"	Component of pin housing assembly
5	Black	Pin Hsg. Assy.	18	5"	Component of pin housing assembly
6	Blue/Black	Triac	18	4"	Component of triac assembly / Strip 3/16" for T2
7	White/Blue	Triac	18	4"	Component of triac assembly / Strip 3/16" for T3
8	Blue/Black	Control Assy.	18	9-1/2"	Component of control assembly / Strip 3/16" for T3
9	White/Blue	Control Assy.	18	9-1/2"	Component of control assembly / Strip 3/16" for T2
10	Red	Rev. Switch	18	10-5/8"	Component of reversing switch / Strip 1/8" for T1
11	White	Rev. Switch	18	10-5/8"	Component of reversing switch / Strip 1/8" for T1
12	Black	Field	18	11"	Component of field
13	Yellow	Rev. Switch	18	2"	Component of reversing switch / Strip 3/16" for T2
14	Yellow	Field	18	6"	Component of field / Strip 3/16" for T3
15	Black	Triac/Rev. Switch	18	6-13/16"	Component of triac/reversing switch assembly

NOTE:
 All leads must be held to ± 1/8".
 All lead lengths are before stripping.

TERMINAL DESCRIPTION		
Code	Part No.	Qty.
T1	23-74-0755	2
T2	23-74-0440	3
T3	23-74-0430	3
T4	23-74-0851	1

CONNECTOR DESCRIPTION		



As an aid in reassembly, take note of wire routing and position in wire guides and traps while dismantling tools.

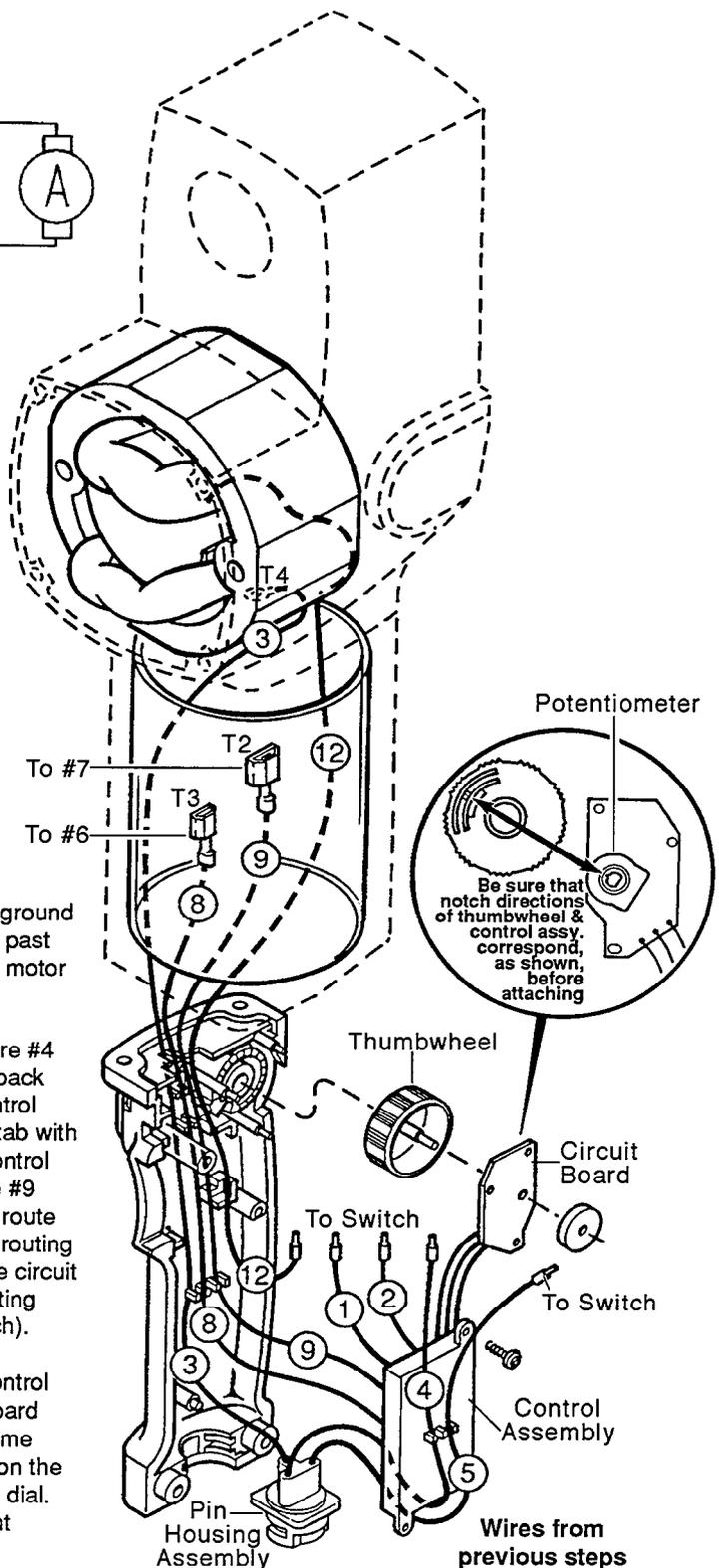
Slide insulator and spacer over all assembled components and wires coming off of the motor housing.

Place pin housing assembly into right handle half. Position green ground wire #3 to the back. Route green wire #3 in handle wire traps, out past the top of the handle. Fasten ground terminal to the bottom of the motor housing with ground screw No. 06-95-5150.

Position control assembly between the green wire #3 and white wire #4 and black wire #5 of the pin housing assembly (Green wire in the back and white and black wires in the front). Mount lower left tab of control assembly to post on the right handle half and secure the top right tab with screw No. 06-82-7240. Route all the wires from the back of the control assembly upward. Position blue/black wire #8 and white/blue wire #9 from the control assembly in wire traps of handle in any order and route out past the top of the handle. (Note: Care should be taken when routing wires #8 and #9, along with the three thin black wires that go to the circuit board, to make sure wires are placed in-between the switch mounting bosses so that they will not interfere with the mounting of the switch).

Properly position thumbwheel on the circuit board portion of the control assembly with a foam washer on the opposite side of the circuit board from the thumbwheel. Align the notch of the thumbwheel in the same direction as the notch on the speed control wheel (potentiometer) on the circuit board for the correct orientation and full range on the speed dial. Mount the circuit board on the 3 posts located at the top of the right handle half.

Insert the reversing switch, with the interlock attached, into slotted area in the right handle half with wires facing upward. Place white wire #4 and black wire #5 from the pin housing assembly in the wire traps on the front face of the control assembly. Connect wire #4 to the bottom front of the switch and wire #5 to the bottom back of the switch and fasten with switch screws. Connect white wire #1 and black wire #2 from the control assembly to the switch. Route black field wire #12 down through the insulation sleeve. Place wire #12 into wire traps of the handle half taking care to route the wire under the switch before connecting. Once wires #1, #2, #4, #5 and #12 are properly connected, position switch into place being sure that the switch is seated correctly and not pinching wires in the back.



Wires from previous steps not shown to aid in clarity of wire routing