



TO INFORM YOU

**PRODUCT
SUPPORT
BULLETIN # 504**

TO: AUTHORIZED *portable electric tool* SERVICE STATIONS
factory SERVICE CENTERS

DATE: April, 2010

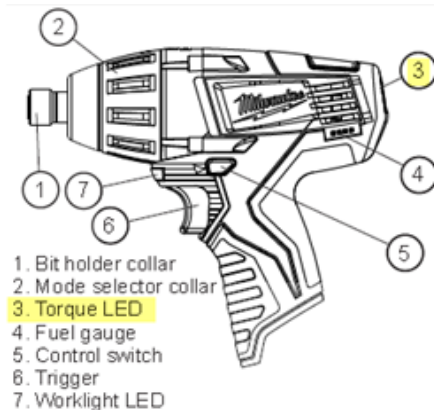
TOOL(S) \ PRODUCT(S) AFFECTED: 2455-20 M12™ No-Hub Coupling Drill / Driver

SUBJECT: re-Calibration

Milwaukee Electric Tool Corporation is pleased to introduce a 2455-20 M12™ No-Hub Coupling Drill/Driver intended for the professional **commercial plumbers**, providing heavy-duty reliability and innovation to help increase their productivity.



2455-20 M12™ No-Hub Coupling Drill / Driver has been developed offering either the preset 60 in-lbs or 80 in-lbs of torque required of No-Hub Couplings. To maintain the high-precision torque, the 2455-20 Driver will need to be recalibrated after 25,000 cycles – need verification that the tool is tightening to its 60/80 in-lbs torque specifications. To signify that the tool may be out of an acceptable tolerance torque range, the **Torque LED** of the driver will **'flash'** after the trigger is released – the driver should no longer be used for jobs requiring an accurate torque of the coupling bands.



What should I do when my M12™ No-Hub Coupling Driver needs CALIBRATION? Milwaukee offers a manufacturers calibration – the labor and performance tests necessary to calibrate the M12™ No-Hub Coupling Driver to our manufacturer's specification of 60/80 in-lbs, using test equipment traceable to the National Institute of Standards and Technology NIST Standards - product

will be returned with a standard manufacturers statement of calibration. There is an additional charge to obtain a separate NIST - National Institute of Standards and Technology Standards "Certificate of Calibration".

A 2455-20 M12™ No-Hub Coupling Driver needing repair/service of the torque mechanism - gearcase assembly or if the driver has reached its 25,000 cycles re-Calibration status **SHOULD NO LONGER BE USED** for jobs requiring the accurate 60/80 in-lbs torque of the coupling bands of No-Hub Couplings. Any required replacement of the **'torque' mechanism** spare parts - fig nos. 4 through 15 or replacement of gearcase assembly fig no. 70 requires a **re-calibration of the tool's torque mechanism to insure the 60/80 in-lbs torque output is being delivered by the** 2455-20 M12™ No-Hub Coupling Drill / Driver. Please send M12™ No-Hub Coupling Drill/Driver needing repair/service of the torque mechanism or if the driver has reached its 25,000 cycles to **Milwaukee Electric Tool Corporation - 13135 West Lisbon Road - Brookfield, Wisconsin 53005 - Attention: After-Sales Service.**

Calibration requires special tooling and equipment to calibrate the 2455-20 M12™ No-Hub Coupling Drill / Driver; to calibrate is regarded as the process of adjusting the output or indication on a special measurement instrument to agree with the value of the specified 60/80 in-lbs accuracy. Generally, for torque this requires capital equipment (*having an acquisition value of \$15,000 or more*) with ability to exacting tolerances, performed at a specific ambient temperature.

This bulletin is for informational purposes. PLEASE NOTE ON SERVICE PARTS LIST: 54- 06-2455