



SERVICE PARTS LIST

BULLETIN NO.
55-40-5103

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
SAWZALL PLUS®		55-40-5102	Sept. '98
CATALOG NO.	6518-51	WIRING INSTRUCTION	
STARTING SERIAL NO.	859D	58-03-1701	

EXAMPLE:
00 0 Component Parts (Small #)
Are Included When Ordering
The Assembly (Large #).

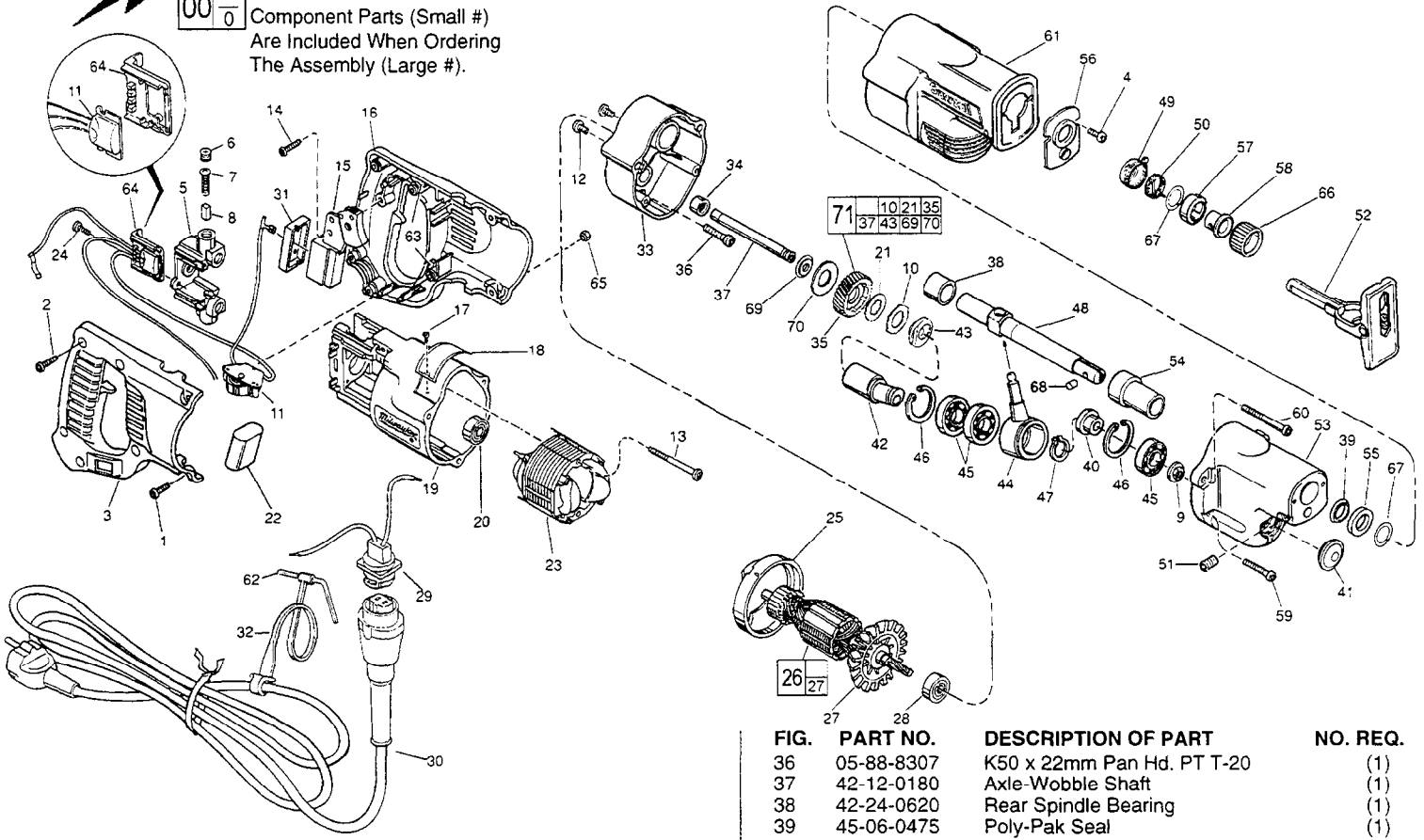


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-82-2390	8-32 x 1-1/4" Slot Pan Hd. T-20	(2)
2	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(5)
3	31-44-1661	Right Handle Half	(1)
4	06-95-0075	6-32 x 3/8" Truss Hd. Taptite T-10 Screw	(2)
5	22-22-1380	Brush Holder Assembly	(1)
6	23-44-0190	Brush Retaining Cap	(2)
7	23-52-0160	Brush Spring	(2)
8	22-16-0375	Carbon Brush	(2)
9	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
★ 10	43-06-0675	Bronze Disc	(1)
11	14-20-3030	Dial Assembly	(1)
12	06-82-7252	8-32 x 3/8" Pan Hd. Taptite T-20	(2)
13	06-82-7410	8-16 x 1-7/8" Pan Hd. Slit. Plastite T-20	(2)
14	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(1)
15	23-66-1975	Switch	(1)
16	31-44-1666	Left Handle Half	(1)
17	06-72-1720	Nameplate Rivet	(2)
18	12-99-0942	Nameplate Blank	(1)
19	31-50-0020	Motor Housing	(1)
20	02-04-0845	Ball Bearing	(1)
★ 21	43-06-0685	Metal Disc	(1)
22	14-20-0580	Suppressor Assembly	(1)
23	18-32-0235	230 V. Field	(1)
24	06-82-7240	6-19 x 1/2" Pan Hd. Slit. Plastite T-15	(2)
25	31-05-0055	Baffle	(1)
26	16-34-0440	230 V. Armature	(1)
27	22-84-0531	Fan Assembly	(1)
28	02-04-0911	Ball Bearing	(1)
29	22-56-0692	Blade Housing Assembly	(1)
30	48-76-5012	Quik-Lok Cord Set	(1)
31	45-12-0470	Dust Shield	(1)
32	48-66-4080	Key Holder	(1)
33	28-28-2080	Diaphragm	(1)
34	02-50-2150	Needle Bearing	(1)
★ 35	32-40-2095	Gear	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
36	05-88-8307	K50 x 22mm Pan Hd. PT T-20	(1)
37	42-12-0180	Axle-Wobble Shaft	(1)
38	42-24-0620	Rear Spindle Bearing	(1)
39	45-06-0475	Poly-Pak Seal	(1)
40	45-36-1450	Spacer	(1)
41	42-52-0380	Bearing Cap	(1)
★ 42	36-92-0750	Wobble Shaft	(1)
★ 43	43-78-0525	Drive Hub	(1)
44	30-72-0111	Wobble Plate	(1)
45	02-04-1510	Ball Bearing	(3)
46	34-80-2600	Internal Retaining Ring	(2)
47	34-60-1315	External Retaining Ring	(1)
48	38-50-6005	Reciprocating Spindle	(1)
49	31-15-0510	Spring Cover	(1)
50	40-50-0160	Torsion Spring	(1)
51	06-83-3150	5/16-18 x 1/2" Hex Socket Hd. Set Screw	(1)
52	45-16-0615	Pivot Shoe Assembly	(1)
53	28-14-2180	Gear Case	(1)
54	42-24-0615	Forward Spindle Bearing	(1)
55	45-06-0500	Felt Seal	(1)
56	44-86-0615	Seal Retainer	(1)
57	42-50-0075	Cam Collar	(1)
58	45-22-0080	Sleeve	(1)
59	06-82-5346	8-32 x 3/4" Pan Hd. Taptite T-20	(2)
60	05-88-8301	K50 x 60mm Pan Hd. PT T-20	(2)
61	45-12-0510	Gear Case Insulator	(1)
62	49-96-0070	5/32" Socket Wrench	(1)
63	14-46-1001	Foam Slug Kit (10 Slugs)	(2)
64	43-72-0176	Heat Sink Holder	(1)
65	06-55-0835	8-32 Hex Nut	(2)
66	31-15-0075	Plastic Collar	(1)
67	45-88-8576	Washer	(2)
68	44-60-0625	Pin	(1)
★ 69	43-78-0530	Spring Retainer	(1)
★ 70	40-50-8850	Disc Spring	(1)
★ 71	32-40-2310	IPS Gear Assembly	(1)

**SEE REVERSE SIDE FOR
IMPORTANT SERVICE NOTES**

MILWAUKEE ELECTRIC TOOL CORPORATION
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FIG. 21,35 **LUBRICATION**
Apply a thin coat of type "L" grease, No. 49-08-4175, between the gear and the metal disc.

33 Place 3/4 oz. of type "L" grease, No. 49-08-4175, in diaphragm cavity near needle bearing.

53 Place 2-3/4 oz. of type "L" grease, No. 49-08-4175, in mechanism cavity of gear case.

55 Saturate with lightweight oil before assembly.

FIG. 9,37,69 **NOTES**
Apply thread locking compound to threads of spinlock hex nut. Torque to 145in./lbs.-185 in./lbs. Axle Should extend .285 min. beyond spring retainer after seating torque to spinlock hex nut (not shown) is applied.

9,35 Hold the gear still with a large pair of pliers and a piece of rubber hose (or other tough, but pliable material to protect the gear from the jaws of the pliers) and remove the 5/16" spinlock hex nut with a wrench, as shown.

10 Tabs engage gear.

21 Tabs engage drive hub.

35,37 See sketch for press specifications.

20 Seal side faces commutator.

20,28,45 Press bearings to shaft shoulders.

33,38 Press rear spindle bearing flush to .030 below bearing boss of diaphragm.

34 Press bearing flush ($\pm .005$) to diaphragm surface.

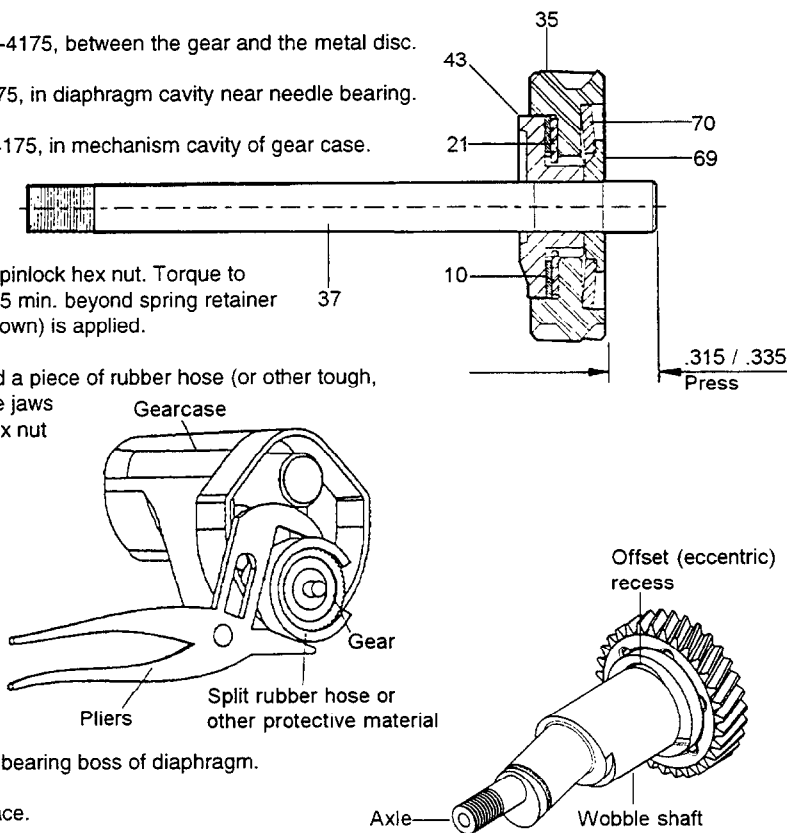
39 O-ring of seal towards rear of tool.

42,43 Make sure that the end of the wobble shaft fits into the offset (eccentric) recess in drive hub, as shown.

45,46 Retaining rings are to be installed with the beveled side away from the bearings.

53,54 Press forward spindle bearing flush to .030 below bearing boss of gear case.

70 Concave towards gear.



REMOVING THE KEYLESS QUIK-LOK BLADE CLAMP

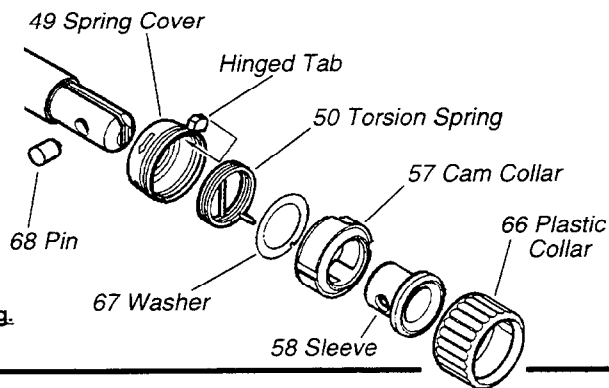
48,49,50,57, 58,66,67,68 To remove keyless blade clamp, cut, pry or press off plastic collar. Pop up the hinged tab on spring cover. Rotate cam collar until it stops fully open. While holding cam collar, insert Sawzall blade to push pin partially out. Insert a rigid wire-like instrument, like a paper clip with a slight bend on the end. Locate the pin area on inside slot and twist the paper clip to remove the pin from spindle. (Use of a strong magnet may also remove the pin from spindle.)



Clean all parts before reassembly.

57,68 If cam collar or pin is replaced, coat pin with powdered graphite.

49,66 **Always replace plastic collar and spring cover when servicing.**



REASSEMBLY OF THE KEYLESS QUIK-LOK BLADE CLAMP

48,49,50,57, 58,66,67,68 To reassemble keyless blade clamp, place sleeve (58) in cam collar (57) then place washer (67) on sleeve (58). Insert spring leg of torsion spring (50) into hole on cam collar (57) and slot in washer (67). Cover up with spring cover (49).

Facing the front end of the tool, position reciprocating spindle with the pin hole facing up. Slide keyless blade clamp assembly onto the spindle with slot in cam collar (57) toward the left. Rotate the assembly in the direction of the arrows, approximately 205°. A ground pin may be used to keep the slot and sleeve hole in alignment until hole in spindle is reached. Use a pliers to hold assembly and remove ground pin. Pin (68) can now be inserted into clamp. Snap clamp to assure proper functioning before adding plastic collar (66). Fold hinged tab on spring cover (49) into slot on cam collar (57) as shown. Tab **must be present** to assure proper function. Slide plastic collar (66) onto assembly. Rotate plastic collar (66) until keyways line up and slide plastic collar (66) over snap in spring cover (49).