



# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-40-5181**

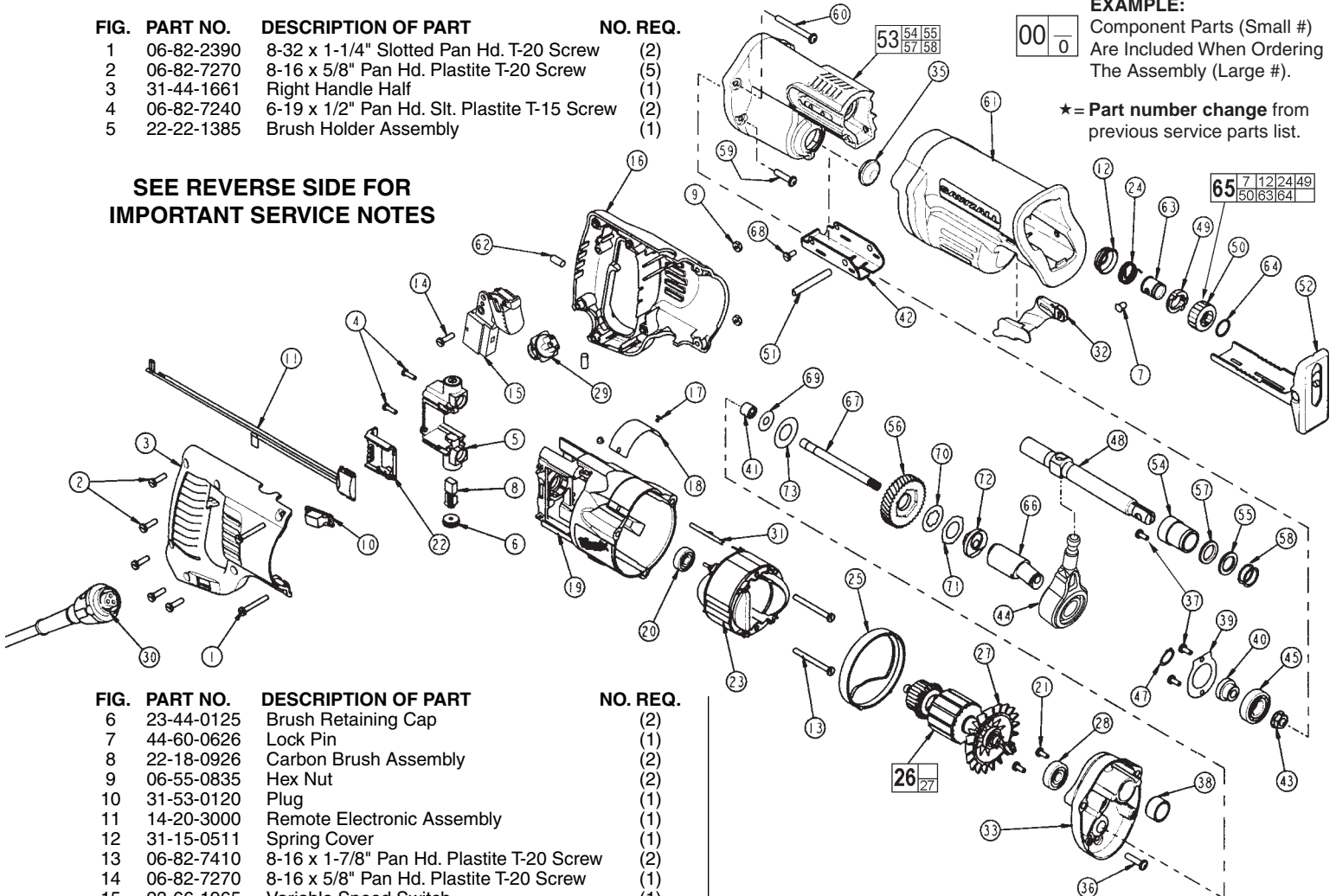
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS |                | REVISED BULLETIN                               | DATE      |
|--|----------------|--|-----------|
| <b>SAWZALL®</b>  |                | 54-40-5180                                     | Aug. 2006 |
| <b>CATALOG NO.</b>                                     | <b>6519-22</b> | <b>WIRING INSTRUCTION</b><br><b>58-01-0277</b> |           |
| <b>STARTING SERIAL NO.</b>                             | <b>A18B</b>    |  |           |

| FIG. | PART NO.   | DESCRIPTION OF PART                           | NO. REQ. |
|------|------------|---|----------|
| 1    | 06-82-2390 | 8-32 x 1-1/4" Slotted Pan Hd. T-20 Screw      | (2)      |
| 2    | 06-82-7270 | 8-16 x 5/8" Pan Hd. Plastite T-20 Screw       | (5)      |
| 3    | 31-44-1661 | Right Handle Half                             | (1)      |
| 4    | 06-82-7240 | 6-19 x 1/2" Pan Hd. Slit. Plastite T-15 Screw | (2)      |
| 5    | 22-22-1385 | Brush Holder Assembly                         | (1)      |

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

★ = Part number change from  
previous service parts list.

**SEE REVERSE SIDE FOR  
IMPORTANT SERVICE NOTES**



| FIG. | PART NO.   | DESCRIPTION OF PART                       | NO. REQ. |
|------|------------|---|----------|
| 6    | 23-44-0125 | Brush Retaining Cap                       | (2)      |
| 7    | 44-60-0626 | Lock Pin                                  | (1)      |
| 8    | 22-18-0926 | Carbon Brush Assembly                     | (2)      |
| 9    | 06-55-0835 | Hex Nut                                   | (2)      |
| 10   | 31-53-0120 | Plug                                      | (1)      |
| 11   | 14-20-3000 | Remote Electronic Assembly                | (1)      |
| 12   | 31-15-0511 | Spring Cover                              | (1)      |
| 13   | 06-82-7410 | 8-16 x 1-7/8" Pan Hd. Plastite T-20 Screw | (2)      |
| 14   | 06-82-7270 | 8-16 x 5/8" Pan Hd. Plastite T-20 Screw   | (1)      |
| 15   | 23-66-1965 | Variable Speed Switch                     | (1)      |
| 16   | 31-44-1666 | Left Handle Half                          | (1)      |
| ★ 17 | 06-72-1720 | Nameplate Rivet                           | (2)      |
| 18   | 12-99-1765 | Service Nameplate                         | (1)      |
| 19   | 31-50-0020 | Motor Housing                             | (1)      |
| 20   | 02-04-0845 | Ball Bearing                              | (1)      |
| 21   | 06-82-7253 | 8-32 x 3/8" Pan Hd. Slit. Taptite T-20    | (2)      |
| 22   | 43-72-0176 | Heat Sink Holder                          | (1)      |
| 23   | 18-31-0515 | 120 V. Field                              | (1)      |
| 24   | 40-50-0161 | Torsion Spring                            | (1)      |
| 25   | 31-05-0055 | Baffle                                    | (1)      |
| 26   | 16-30-0570 | 120 V. Armature                           | (1)      |
| 27   | 22-84-0531 | Fan Assembly                              | (1)      |
| 28   | 02-04-0915 | Ball Bearing                              | (1)      |
| 29   | 22-56-0840 | Pin Housing Assembly                      | (1)      |
| 30   | 48-76-4008 | Quik-Lok Cord Set                         | (1)      |
| 31   | 44-60-0530 | Ground Pin                                | (1)      |
| 32   | 31-52-0090 | Shoe Release Lever                        | (1)      |
| 33   | 28-28-1000 | Diaphragm                                 | (1)      |
| 35   | 42-52-0380 | Bearing Cap                               | (1)      |
| 36   | 05-88-8309 | K50 x 35mm Round Washer Hd. PT T-20       | (1)      |
| ★ 37 | 06-82-7253 | 8-32 x 3/8" Pan Hd. Slit. Taptite T-20    | (3)      |
| 38   | 42-24-0620 | Rear Spindle Bearing                      | (1)      |
| 39   | 44-86-0055 | Bearing Retainer                          | (1)      |
| 40   | 45-36-1445 | Spacer                                    | (1)      |
| 41   | 02-50-2150 | Needle Bearing                            | (1)      |
| 42   | 44-66-0880 | Shoe Retainer                             | (1)      |
| 43   | 06-55-3790 | 5/16-24 Spinlok Hex Nut                   | (1)      |
| ★ 44 | 14-67-0135 | Wobble Plate Assembly                     | (1)      |
| ★ 45 | 02-04-1510 | Ball Bearing                              | (1)      |
| 47   | 34-60-1315 | Retaining Ring                            | (1)      |
| ★ 48 | 38-50-0680 | Reciprocating Spindle                     | (1)      |

| FIG. | PART NO.   | DESCRIPTION OF PART                    | NO. REQ. |
|------|------------|--|----------|
| 49   | 42-50-0077 | Rear Cam                               | (1)      |
| 50   | 42-50-0076 | Front Cam                              | (1)      |
| 51   | 44-60-1635 | Shoe Pin                               | (1)      |
| 52   | 45-16-0645 | Shoe Assembly                          | (1)      |
| ★ 53 | 28-14-0996 | Gear Case                              | (1)      |
| ★ 54 | -----      | Front Spindle Bearing                  | (1)      |
| ★ 55 | -----      | Felt Seal                              | (1)      |
| 56   | 32-40-2050 | Intermediate Gear                      | (1)      |
| ★ 57 | -----      | Seal                                   | (1)      |
| ★ 58 | -----      | Washer                                 | (2)      |
| 59   | 06-82-5363 | 8-32 x 1" Washer Hd. Taptite T-20      | (2)      |
| 60   | 05-88-0302 | K50 x 60mm Round Washer Hd. PT T-20    | (2)      |
| 61   | 45-12-0999 | Gear Case Insulator                    | (1)      |
| 62   | 14-46-1001 | Foam Slug Kit - 10 Slugs               | (2)      |
| 63   | 45-22-0081 | Sleeve                                 | (1)      |
| 64   | 34-60-3680 | External Retaining Ring                | (1)      |
| 65   | 14-46-1011 | Steel Quik-Lok Blade Clamp Kit         | (1)      |
| ★ 66 | 36-92-0501 | Wobble Shaft                           | (1)      |
| 67   | 42-12-0155 | Wobble Shaft Axel                      | (1)      |
| 68   | 06-82-7253 | 8-32 x 3/8" Pan Hd. Slit. Taptite T-20 | (1)      |
| 69   | 45-88-1555 | Washer                                 | (1)      |
| 70   | 43-06-0685 | Metal Plate                            | (1)      |
| ★ 71 | 43-06-0676 | Bronze Disc                            | (1)      |
| 72   | 43-78-0525 | Drive Hub                              | (1)      |
| 73   | 40-50-8850 | Disc Spring                            | (1)      |

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13135 W. LISBON RD., BROOKFIELD, WI 53005  
Drwg. 3

**FIG. LUBRICATION**

- 53 Place 1/2 oz. of type "Y" grease, No. 49-08-5270, in gearing cavity near diaphragm.
- 53 Place 2-1/2 oz. of type "L" grease, No. 49-08-4175, in cavity in front of bearing plate.

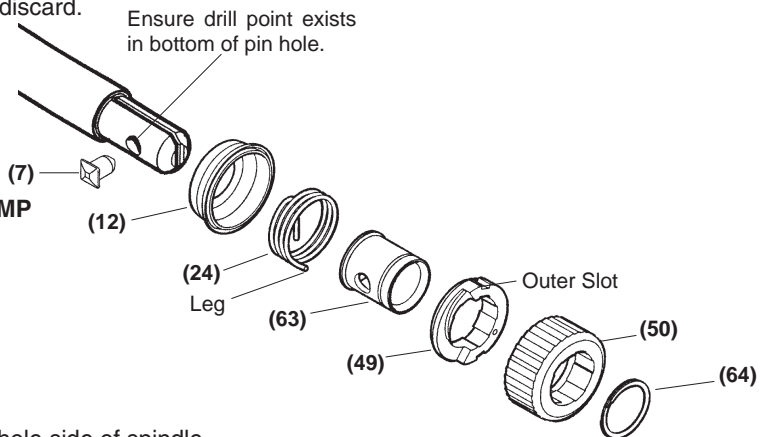
**FIG. NOTES**

- 20 Seal side faces commutator.
- 20,28,41,45 Press bearings to shaft shoulders.
- 33,38 Press rear spindle bearing flush to -.030 from front exterior face in diaphragm boss.
- 43 Torque to 180 in./lbs. to 210 in./ lbs.
- 33,41 Needle bearing is to be pressed from the open end flush to -.015 to face of bearing boss of diaphragm.
- 62 After routing wires, place one foam slug in each location shown on the front page. Center slugs on screw bosses and push down until flush with top of handle half.

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**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

- Remove external retaining ring (64) and pull front cam (50) off.
- Pull lock pin (7) out and remove remainder of parts and discard.



**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.
- Place spring cover (12) onto spindle.
- Slide torsion spring (24) onto spindle with spring leg on hole side of spindle.
- Slide sleeve (63) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (49) over sleeve until it bottoms on sleeve shoulder, ensure spring leg inserts into hole in rear cam.
- Rotate rear cam in the direction of the arrows located on spring cover until there is clearance for lock pin (7) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (50) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring (64) groove should be completely visible.
- Attach retaining ring by separating coils and inserting end of ring into groove, then wind remainder of ring into groove. Ensure ring is seated in groove.
- Blade clamp should rotate freely. During normal usage, debris may not allow blade clamp to rotate freely. The use of spray lubricant can help free blade clamp. In extreme conditions, follow these instructions to remove, clean and reassemble blade clamp.