



SERVICE PARTS LIST

BULLETIN NO.
54-40-7550

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
CORDED HATCHET SAWZALL®			Mar. 2004
CATALOG NO. 6524-21	STARTING SERIAL NO. A44A	WIRING INSTRUCTION 58-01-0095	

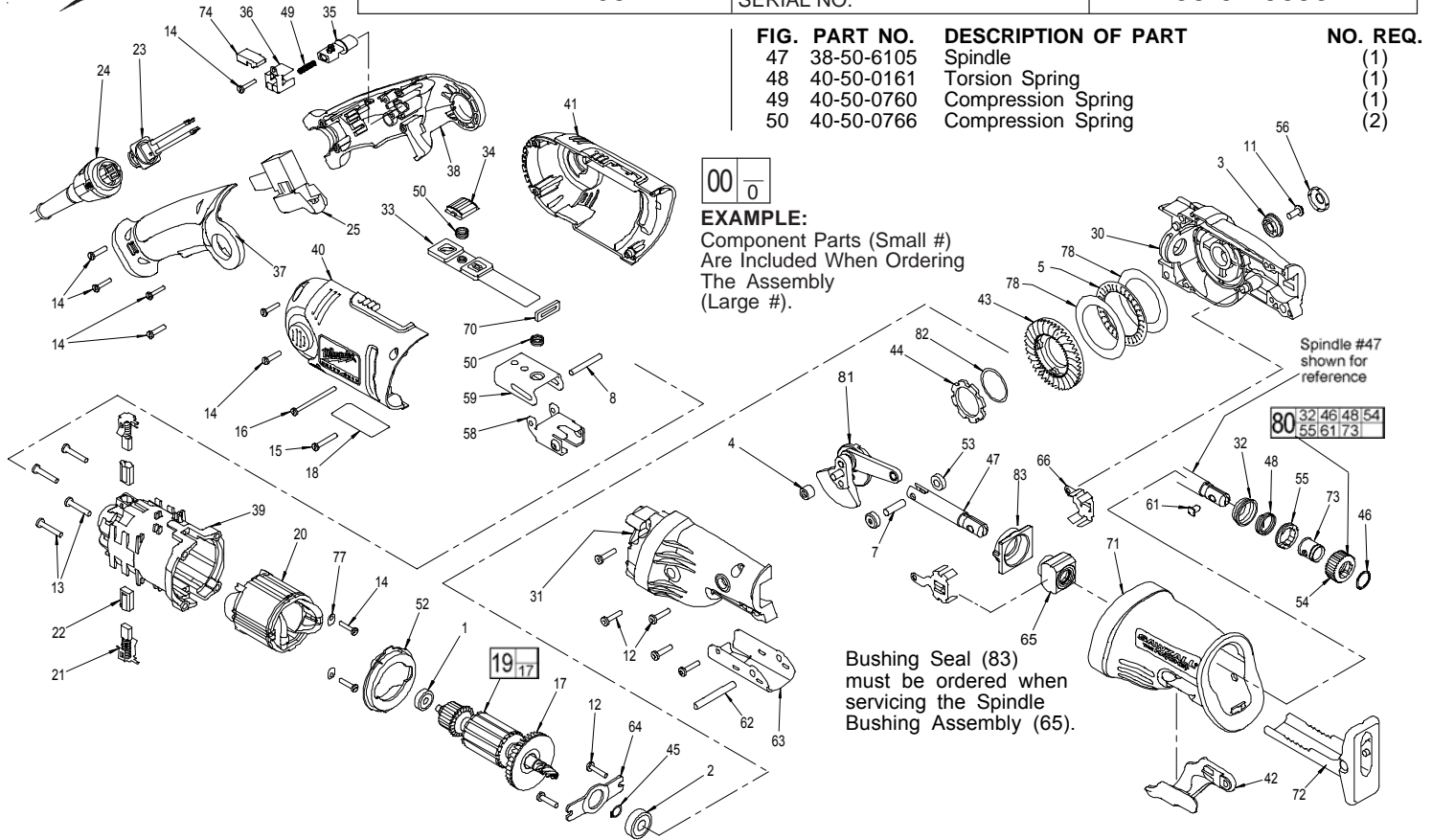


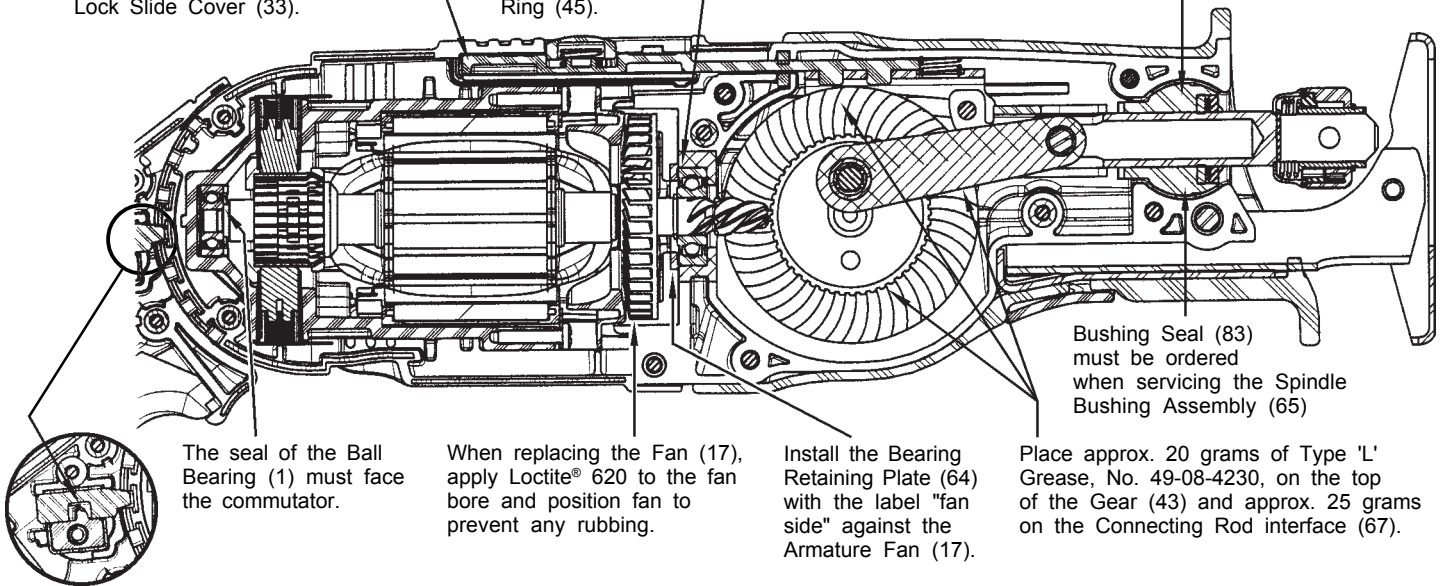
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0645	Ball Bearing	(1)	52	42-14-0455	Baffle	(1)
2	02-04-1020	Ball Bearing	(1)	53	42-40-1011	Spindle Pin Bushing	(2)
3	02-04-1900	Ball Bearing, Flanged	(1)	54	42-50-0076	Front Cam	(1)
4	02-50-1615	Needle Bearing	(1)	55	42-50-0077	Rear Cam	(1)
5	02-80-5000	Thrust Needle Bearing	(1)	56	42-52-0190	Bearing Cap	(1)
7	06-65-2995	Pin	(1)	58	43-56-0628	Orbit Slot	(1)
8	06-65-3005	Orbit Control Pin	(1)	59	43-56-0685	Orbit Control Link	(1)
11	06-82-2000	8-32 x .50 Rd. Wash. Hd. Tapt. T-20 w/ blue patch	(1)	61	44-60-0626	Lock Pin	(1)
12	06-82-5346	8-32 x .75 Pan Hd. Taptite T-20	(7)	62	44-60-1635	Shoe Pin	(1)
13	06-82-5362	8-32 x 1.00 Pan Hd. Taptite T-20	(4)	63	44-66-0891	Shoe Retainer	(1)
14	06-82-7261	6-19 x .687 Slotted Plastite T-15	(9)	64	44-66-5335	Bearing Retaining Plate	(1)
15	06-82-7276	6-19 x 1.00 Slotted Plastite T-15	(1)	65	44-86-0135	Spindle Bushing Assembly	(1)
16	06-82-7300	6-19 x 2.00 Slotted Plastite T-15	(1)	66	44-86-0115	Spindle Bushing Cage	(2)
17	22-84-0975	Fan	(1)	70	45-06-0375	Orbit Control Seal	(1)
18	12-20-6524	Service Nameplate Kit	(1)	71	45-12-0900	Gearcase Insulator	(1)
19	16-10-2220	Armature	(1)	72	45-16-0646	Shoe Assembly	(1)
20	18-07-2206	Field	(1)	73	45-22-0081	Sleeve	(1)
21	22-18-0040	Brush Assembly	(2)	74	45-24-0750	Slide Lock	(1)
22	22-20-0110	Brush Tube	(2)	77	45-88-0142	Motor Mount Washer	(2)
23	22-56-1100	Blade Housing Assembly	(1)	78	45-88-0530	Thrust Bearing Washer	(2)
24	48-76-5010	Quik-Lok Cord Set	(1)	80	14-46-1011	Steel Quik-Lok Blade Clamp Kit	(1)
25	23-66-2586	Switch	(1)	81	32-05-3335	Gear Linkage Assembly	(1)
30	28-14-2920	Left Gearcase Assembly	(1)	82	34-40-4565	O-Ring	(1)
31	28-14-2925	Right Gearcase Assembly	(1)	83	45-06-0196	Bushing Seal	(1)
32	31-15-0511	Spring Cover	(1)		23-94-3100	Leadwire Assembly	(1)
33	31-15-0625	Lock Slide Cover	(1)		23-94-3105	Leadwire Assembly	(1)
34	31-15-0626	Lock Slide Button	(1)		23-94-3110	Leadwire Assembly	(1)
35	31-15-1500	Button	(1)		23-94-3115	Leadwire Assembly - Black	(1)
36	31-15-1505	Box Button	(1)				
37	31-44-2401	Handle Half - Right	(1)				
38	31-44-2406	Handle Half - Left	(1)				
39	31-50-0052	Motor Cage	(1)				
40	31-50-0627	Motor Housing - Right	(1)				
41	31-50-0628	Motor Housing - Left	(1)				
42	31-52-0095	Shoe Release Lever	(1)				
43	32-05-3305	Gear	(1)				
44	32-10-4105	Steel Shim	(1)				
45	34-60-0810	External Retaining Ring	(1)				
46	34-60-3680	Retaining Ring	(1)				

**SEE REVERSE SIDE
FOR IMPORTANT
SERVICE NOTES**

Apply a thin coat of Type 'L' Grease, No. 49-08-4230, to the bottom of the Lock Slide Cover (33).

Press the Ball Bearing (2) to seat on the Retaining Ring (45).

Coat the pocket area of the Gearcase Halves (30, 31) with Type 'L' Grease, No. 49-08-4230.



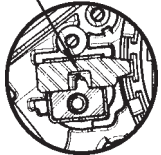
Bushing Seal (83) must be ordered when servicing the Spindle Bushing Assembly (65)

The seal of the Ball Bearing (1) must face the commutator.

When replacing the Fan (17), apply Loctite® 620 to the fan bore and position fan to prevent any rubbing.

Install the Bearing Retaining Plate (64) with the label "fan side" against the Armature Fan (17).

Place approx. 20 grams of Type 'L' Grease, No. 49-08-4230, on the top of the Gear (43) and approx. 25 grams on the Connecting Rod interface (67).



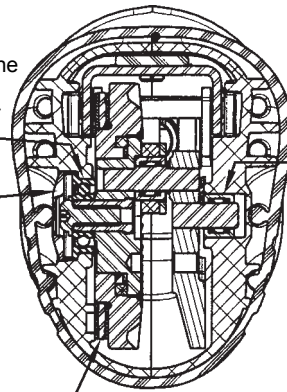
Coat the pocket of the Lock Slide (74) with Type 'L' Grease, No. 49-08-4230.

Press the Ball Bearing (3) to seat the flange portion against the Gearcase shoulder (30). Apply Loctite® 620 or equivalent to the bearing bore.

Press the Bearing Cap (56) to seat on the Bearing shoulder (3).

Press the Needle Bearing (4) flush ±.010 from the Gearcase (31). Apply Loctite® 620 or equivalent to the bearing bore.

The Thrust Bearing (5) is to be greased with 1-3 grams of Type 'L' Grease, No. 49-08-4230.



TORQUE SPECIFICATIONS		
Fig. No.	Max. Seating Torque	Min. Seating Torque
11	45 in.-lbs.	35 in.-lbs.
12	35 in.-lbs.	25 in.-lbs.
13	23 in.-lbs.	17 in.-lbs.
14	20 in.-lbs.	15 in.-lbs.
15	20 in.-lbs.	15 in.-lbs.
16	20 in.-lbs.	15 in.-lbs.
25	5.5 in.-lbs.	3.5 in.-lbs.

REMOVING THE STEEL QUIK-LOK® BLADE CLAMP

- Remove external retaining ring (46) and pull front cam (54) off.
- Pull lock pin (61) 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 (32) onto spindle.
- Slide torsion spring (48) onto spindle with spring leg on hole side of spindle.
- Slide sleeve (73) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (55) 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 (61) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (54) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring (46) 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.

