



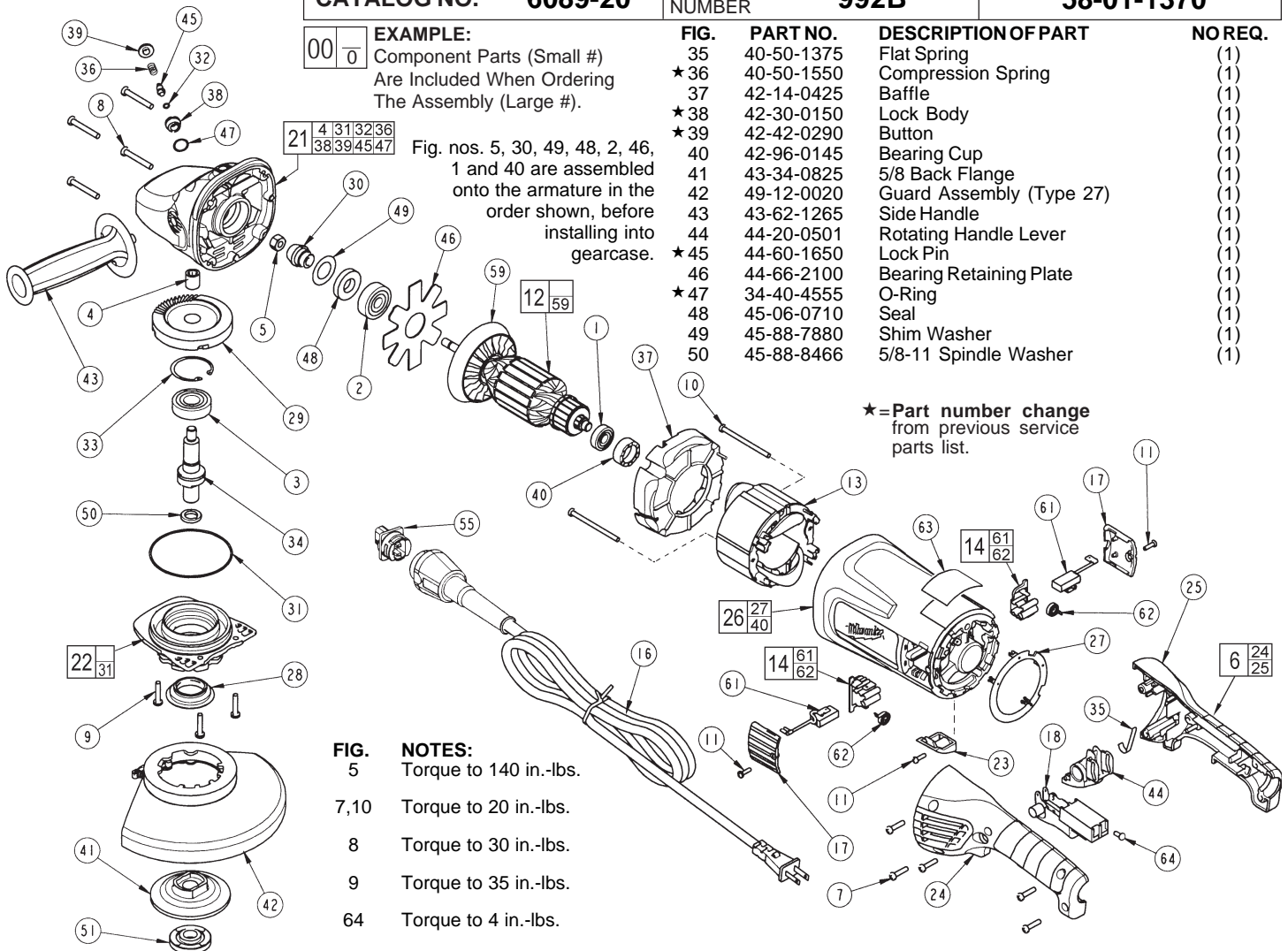
# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-38-1626**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS |                |                      | REVISED BULLETIN                               | DATE      |
|--|----------------|----------------------|--|-----------|
| <b>9" GRINDER</b>                                      |                |                      | 54-38-1625                                     | Aug. 2007 |
| <b>CATALOG NO.</b>                                     | <b>6089-20</b> | <b>SERIAL NUMBER</b> | <b>WIRING INSTRUCTION</b><br><b>58-01-1370</b> |           |
|  |                |                      |  |           |

| FIG. | PART NO.               | DESCRIPTION OF PART   | NO REQ. |
|------|------------------------|---|---------|
| 00   | 0                      | <b>EXAMPLE:</b><br>Component Parts (Small #)<br>Are Included When Ordering<br>The Assembly (Large #).                         |         |
| 21   | 4 31 32 36 38 39 45 47 | Fig. nos. 5, 30, 49, 48, 2, 46, 1 and 40 are assembled onto the armature in the order shown, before installing into gearcase. |         |
| 35   | 40-50-1375             | Flat Spring   | (1)     |
| ★36  | 40-50-1550             | Compression Spring  | (1)     |
| 37   | 42-14-0425             | Baffle  | (1)     |
| ★38  | 42-30-0150             | Lock Body   | (1)     |
| ★39  | 42-42-0290             | Button  | (1)     |
| 40   | 42-96-0145             | Bearing Cup   | (1)     |
| 41   | 43-34-0825             | 5/8 Back Flange   | (1)     |
| 42   | 49-12-0020             | Guard Assembly (Type 27)  | (1)     |
| 43   | 43-62-1265             | Side Handle   | (1)     |
| 44   | 44-20-0501             | Rotating Handle Lever   | (1)     |
| ★45  | 44-60-1650             | Lock Pin  | (1)     |
| 46   | 44-66-2100             | Bearing Retaining Plate   | (1)     |
| ★47  | 34-40-4555             | O-Ring  | (1)     |
| 48   | 45-06-0710             | Seal  | (1)     |
| 49   | 45-88-7880             | Shim Washer   | (1)     |
| 50   | 45-88-8466             | 5/8-11 Spindle Washer   | (1)     |

★=Part number change from previous service parts list.



- FIG. 5** Torque to 140 in.-lbs.  
**7,10** Torque to 20 in.-lbs.  
**8** Torque to 30 in.-lbs.  
**9** Torque to 35 in.-lbs.  
**64** Torque to 4 in.-lbs.

| FIG. | PART NO.   | DESCRIPTION OF PART                  | NO REQ. |
|------|------------|--------------------------------------|---------|
| 1    | 02-04-1675 | Ball Bearing                         | (1)     |
| 2    | 02-04-1680 | Ball Bearing                         | (1)     |
| 3    | 02-04-1745 | Ball Bearing                         | (1)     |
| 4    | 02-50-2429 | Needle Bearing                       | (1)     |
| 5    | 06-55-2455 | Hex Nut                              | (1)     |
| 6    | 14-34-0575 | Handle Kit                           | (1)     |
| 7    | 06-82-0055 | 8-16 Torx Plastite Screw T-20        | (5)     |
| 8    | 06-82-0060 | 10-14 Torx Plastite Screw T-25       | (4)     |
| 9    | 06-82-0065 | 10-32 x 1 Pan Hd. Taptite T-25 Screw | (3)     |
| 10   | 06-82-0070 | 8-16 Torx Plastite Screw T-15        | (2)     |
| 11   | 06-82-7240 | 6-19 x 1/2 Slit. Pan Hd. Plast. T-15 | (3)     |
| 12   | 16-70-0132 | Armature Assembly                    | (1)     |
| 13   | 18-70-1130 | Field                                | (1)     |
| 14   | 22-20-0120 | Brush Holder Assembly                | (2)     |
| 16   | 48-76-5110 | Quik-Lok Cord Set                    | (1)     |
| 17   | 23-44-0255 | Brush Cover                          | (2)     |
| ★18  | 23-66-2720 | Switch                               | (1)     |
| 21   | 28-14-1131 | Gearcase Assembly                    | (1)     |
| 22   | 28-53-0151 | Spindle Hub Assembly                 | (1)     |
| 23   | 31-15-0166 | Cover                                | (1)     |
| 24   | -----      | Left Hand Handle Halve               | (1)     |
| 25   | -----      | Right Hand Handle Halve              | (1)     |
| 26   | 31-50-1751 | Motor Housing Assembly               | (1)     |
| 27   | 31-53-0160 | Plug                                 | (1)     |
| 28   | 31-55-0150 | Bearing Shield                       | (1)     |
| 29   | 32-05-1505 | Gear                                 | (1)     |
| 30   | 32-60-1505 | Pinion Gear                          | (1)     |
| 31   | 34-40-0505 | O-Ring                               | (1)     |
| ★32  | 34-40-4300 | O-Ring                               | (1)     |
| 33   | 34-80-2960 | Retaining Ring                       | (1)     |
| 34   | 38-50-2500 | Spindle Shaft                        | (1)     |

| FIG. | PART NO.   | DESCRIPTION OF PART    | NO REQ. |
|------|------------|------------------------|---------|
| 51   | 49-05-0051 | Flange Nut             | (1)     |
| 55   | 22-56-0900 | Blade Housing Assembly | (1)     |
| 59   | 22-84-0540 | Fan Assembly           | (1)     |
| 61   | 22-18-0126 | Carbon Brush Assembly  | (2)     |
| 62   | -----      | Brush Spring           | (2)     |
| 63   | 12-99-5006 | Nameplate Blank        | (1)     |
| 64   | 05-78-0305 | Switch Screw           | (4)     |
|      | 23-94-2650 | Leadwire Assembly      | (1)     |
|      | 23-94-2655 | Leadwire Assembly      | (1)     |
|      | 49-96-7205 | Spanner Wrench         | (1)     |

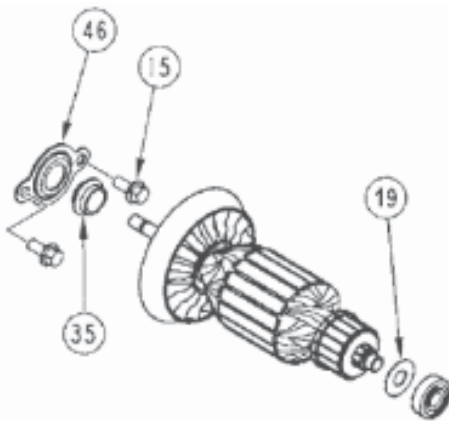
**FIG. LUBRICATION:**  
**21** 1.25 oz. (35 grams) of Type "Y" grease, No. 49-08-5270 in main gear cavity of gearcase.

**29,30** "Y" grease must be applied to all gear teeth.  
**31,32** Lightly coat o-rings with "Y" grease prior to installation.

- FIG. NOTES:**  
**4,21** Press needle bearing flush ±.02 to gearcase boss face.  
**33** Bevel side of retaining ring away from bearing face.  
**1,40** Seat bearing cup completely onto ball bearing.

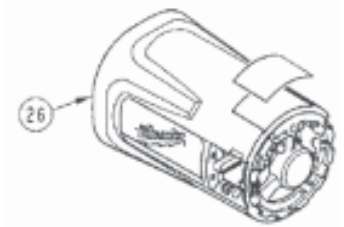
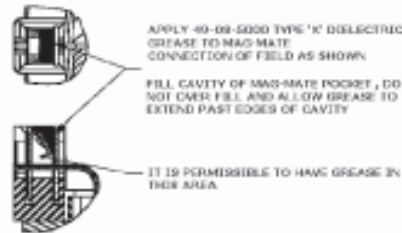
**SEE BACK PAGE FOR IMPORTANT SERVICE NOTES**

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
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**31-50-1752 Motor Housing Kit** incorporates changes to the shielding of the armature pinion and commutator ball bearings along with the retaining of the pinion ball bearing into the gearcase assembly of 7"/ 9" 15Amp Sander / Grinders – 6080-20, 6081-20, 6082-20, 6086-20, 6088-20 and 6089-20.

Additionally, a change has been made to the motor housing and wiring of the tool. The ATF field coil is now 'hard-wired' with four [4] new leadwire assemblies, see **Wiring Instruction 58-01-1371**. Add 'X' Grease, 49-08-5000 to mag-mate field terminals as need.



Caution! Do Not overfill the cavity, excess grease can cause a build up of dust / dirt and result in a possible 'shorting-out' or burning at the connection.

| Motor Housing Kit consist of:                               | Discarded Parts:             | Model Affected |
|---|------------------------------|----------------|
| 2ea <b>06-75-0510</b> ¼-20 Hex Screw* item 15               |                              | All            |
| 1ea <b>45-06-0830</b> Bearing Seal item 19                  |                              | All            |
| 1ea <b>31-50-1785</b> Motor Housing item 26                 | 31-50-1751 Motor Housing     | All            |
| 1ea <b>31-53-0160</b> Plug**                                | 31-53-0160 Plug*             | All            |
| 1ea <b>31-55-0290</b> Dust Shield item 35                   |                              | All            |
| 1ea <b>44-86-0040</b> Bearing Retainer <sup>A</sup> item 46 | 44-66-2100 Bearing Ret Plate | All            |
| 1ea <b>23-94-9300</b> LeadWire Assembly                     | 23-94-2650 LeadWire Assy     | All            |
| 1ea <b>23-94-9305</b> LeadWire Assembly                     | 23-94-2655 LeadWire Assy     | All            |
| 1ea <b>23-94-9310</b> LeadWire Assembly                     |                              | All            |
| 1ea <b>23-94-9315</b> LeadWire Assembly                     |                              | All            |
|   | 42-96-0145 Bearing Cup       | All            |

<sup>A</sup> Service Note - 'check for slip fit' - mounting of 02-04-1680 Ball Bearing to the armature shaft may require removal of a 0.0001" - 0.0002" from the O.D. of the armature pinion end ball bearing journal - It is recommended to use emery cloth and armature lathe to lightly sand, for a few seconds, removing the material necessary for the pinion shaft to be a 'slip fit through the pinion ball bearing' as it is being held in place in the GearCase by the 44-86-0040 Bearing Retainer.

\* Torque 06-75-0510 to 65-75 in-lbs.

\*\* running change, part modified without part number change - two wire traps added - part must have a total of 4 wire traps

**ITEMS NOT INCLUDED IN KIT: MUST BE ORDERED AS NEEDED**

|   |                           |                  |
|---|---------------------------|------------------|
| 1ea <b>22-56-1050</b> Blade Hsg Assembly*** | 22-56-0900 Blade Hsg Assy | 6086-20, 6089-20 |
|---|---------------------------|------------------|

\*\*\* 6086-20 & 6089-20 will also require changing out of the Quik-Lok™ Cord Blade Housing Assembly.

|   |                          |                    |
|---|--------------------------|--------------------|
| 1ea <b>28-14-1131</b> GearCase Assembly**** | 28-14-1131 GearCase Assy | All, prior to 2003 |
|---|--------------------------|--------------------|

\*\*\*\* required for early version Gear Case Assembly, manufactured prior to 2003, without screw bosses to accept the 06-75-0510 ¼-20 Hex Head Screws

Stamp or etch an 'R' in the tool's nameplate next to the catalog number after installation of the 'current production' service replacement parts listed above.

