

SERVICE PARTS LIST

BULLETIN NO.
54-40-5204

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN 54-40-5203	DATE Mar. 2000
SAWZALL®			
CATALOG NO. 6509-21	STARTING SERIAL NO. 962E	WIRING INSTRUCTION 58-01-0276	

EXAMPLE:

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

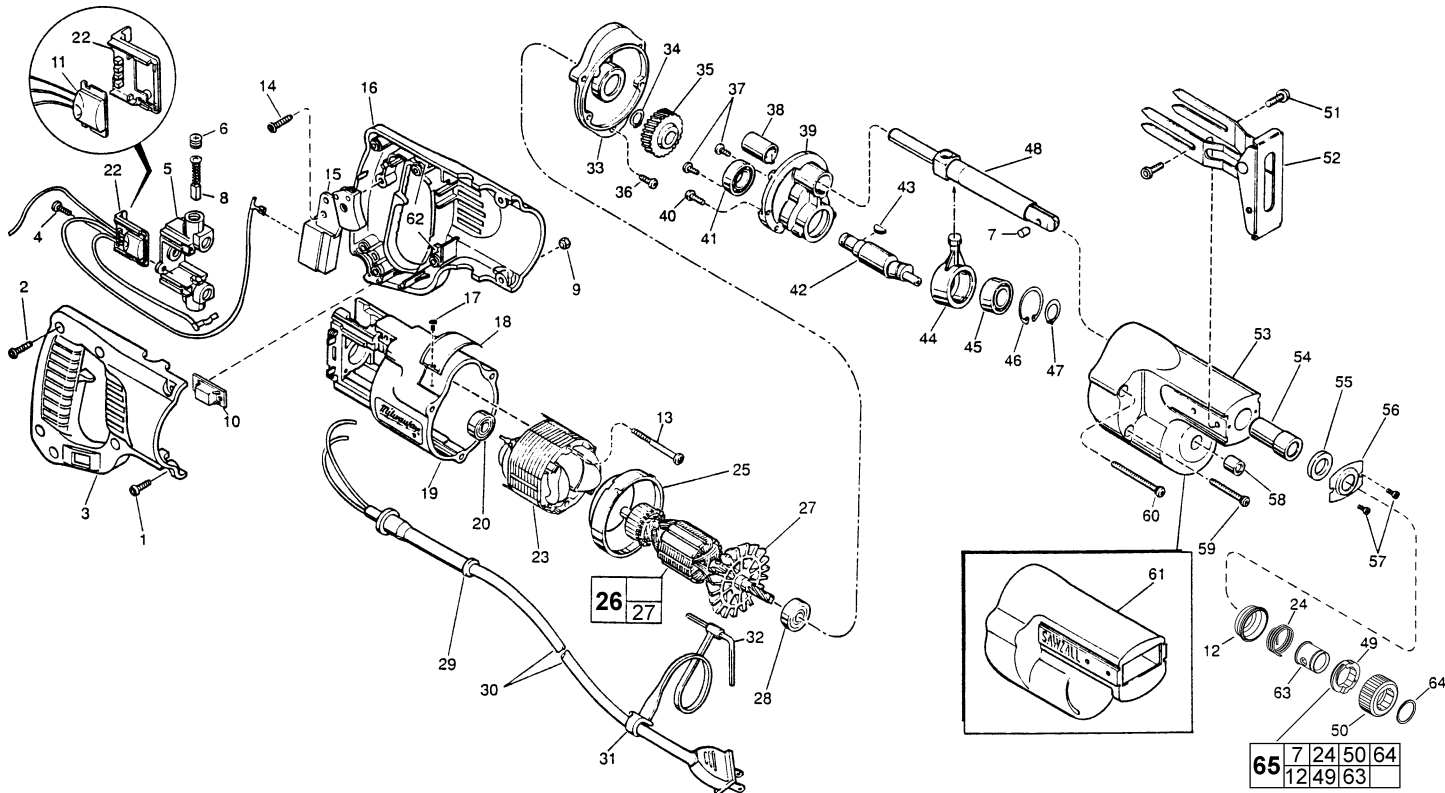


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-82-2390	8-32 x 1-1/4" Slotted Pan Hd. T-20 Screw	(2)
2	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20 Screw	(5)
3	31-44-1651	Right Handle Half	(1)
4	06-82-7240	6-19 x 1/2" Pan Hd. Slit. Plastite T-15 Screw	(2)
5	22-22-1380	Brush Holder Assembly	(1)
6	23-44-0190	Brush Retaining Cap	(2)
7	44-60-0626	Lock Pin	(1)
8	22-18-0910	Carbon Brush Assembly	(2)
9	06-55-0835	Hex Nut	(2)
10	31-53-0120	Plug	(1)
11	14-20-3015	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	23-66-1970	Variable Speed Switch	(1)
16	31-44-1656	Left Handle Half	(1)
17	06-72-1720	Nameplate Rivet	(2)
18	12-99-1745	Service Nameplate	(1)
19	31-50-0020	Motor Housing	(1)
20	02-04-0845	Ball Bearing	(1)
22	43-72-0176	Heat Sink Holder	(1)
★23	18-31-0215	120 V. Field	(1)
24	40-50-0161	Torsion Spring	(1)
25	31-05-0055	Baffle	(1)
★26	16-30-0550	120 V. Armature	(1)
27	22-84-0531	Fan Assembly	(1)
28	02-04-0911	Ball Bearing	(1)
29	44-76-0210	Cord Protector	(1)
30	22-64-0408	Cord Set	(1)
31	48-66-4080	Key Holder	(1)
32	49-96-0070	5/32" Hex Key	(1)
33	28-28-0350	Diaphragm	(1)
34	34-60-0920	External Retaining Ring	(1)
★35	32-40-1925	Intermediate Gear	(1)
36	05-88-8306	K50 x 22mm Fil. Hd. PT T-20 Screw	(1)
37	06-95-0075	6-32 x 3/8" Truss Hd. Taptite Screw	(2)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
38	42-24-0250	Rear Spindle Bearing	(1)
39	28-72-1002	Bearing Plate	(1)
40	06-82-3056	8-32 x 1/2" Fil. Hd. Taptite T-20 Screw	(2)
41	02-04-1510	Ball Bearing	(1)
42	36-92-0720	Wobble Shaft	(1)
43	06-42-1200	Woodruff Key	(1)
44	30-72-0060	Wobble Plate	(1)
45	02-04-1510	Ball Bearing	(1)
46	34-80-2355	Internal Retaining Ring	(1)
47	34-60-1200	Retaining Ring	(1)
48	38-50-5405	Reciprocating Spindle	(1)
49	42-50-0077	Rear Cam	(1)
50	42-50-0076	Front Cam	(1)
51	06-95-6270	10-24 x 1/2" Pan Hd. Taptite Sems Screw	(4)
52	45-16-0485	Pivot Shoe Assembly	(1)
53	28-14-1780	Gear Case	(1)
54	42-24-0320	Spindle Bearing	(1)
55	45-06-0300	Felt Seal	(1)
56	44-86-0370	Seal Retainer	(1)
57	06-95-0050	4-40 x 3/16" Pan Hd. Taptite Screw	(2)
58	02-50-1640	Needle Bearing	(1)
59	06-82-3154	8-32 x 1-3/8" Fil. Hd. Taptite T-20 Screw	(2)
60	05-88-8305	K50 x 54mm Fil. Hd. PT T-20 Screw	(2)
61	45-12-0305	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)

**SEE REVERSE SIDE FOR
IMPORTANT SERVICE NOTES**

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005

FIG. LUBRICATION

53 Place 1/2 oz. of type "A" grease, No. 49-08-0800, in gearing cavity near diaphragm.

53 Place 2-1/2 oz. of type "B" grease, No. 49-08-0600, in cavity in front of bearing plate.

FIG. NOTES

20 Seal side faces commutator.

20,28,41,45 Press bearings to shaft shoulders.

38,39 Press rear spindle bearing flush to $\pm .030$ from back face in bearing plate.

45,46 Retaining ring is to be installed with the beveled side away from the bearing.

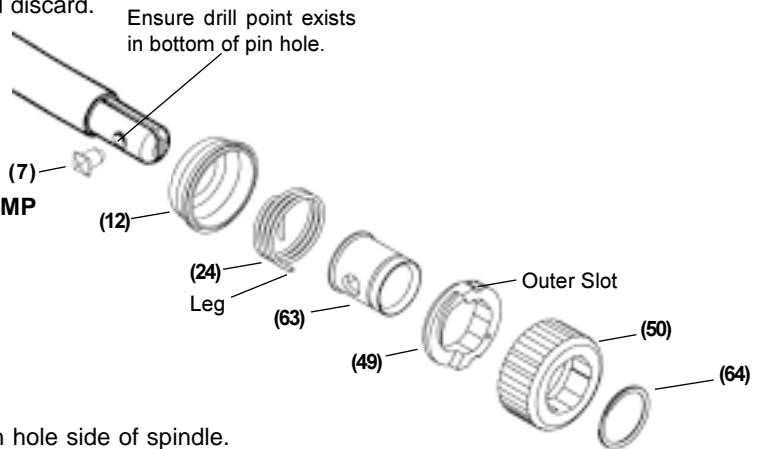
53,54 Press forward spindle bearing .020 to .030 below exterior surface of gear case.

58 Needle bearing is to be pressed from the open end flush to $\pm .030$ to back of bearing boss of gear case.

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.

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.