



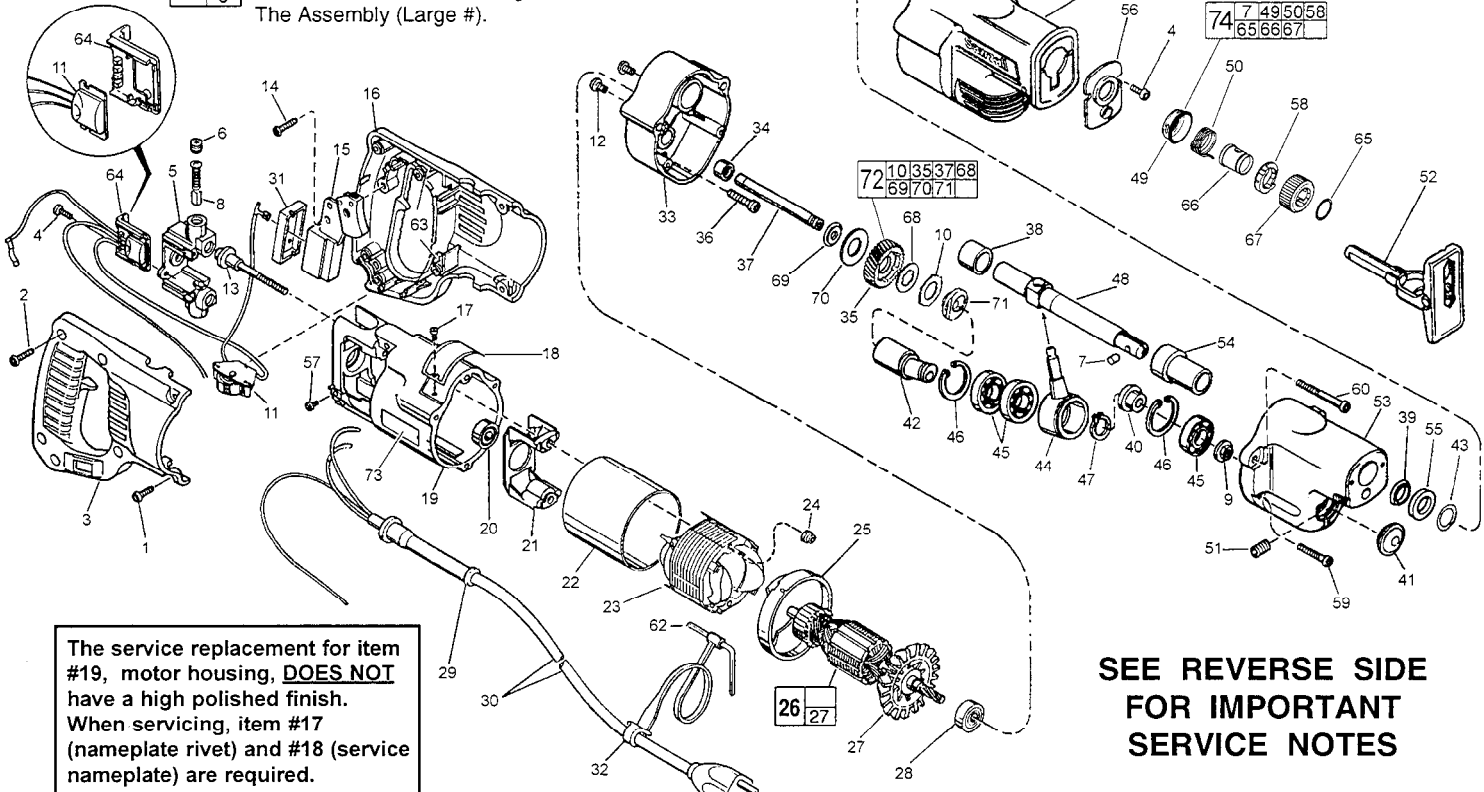
SERVICE PARTS LIST

BULLETIN NO.
54-40-7500

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
75th ANNIVERSARY SAWZALL PLUS®			Jan. '99
CATALOG NO.	6518-75	STARTING SERIAL NO.	985A
		WIRING INSTRUCTION 58-01-0780	

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

00 0



The service replacement for item #19, motor housing, **DOES NOT** have a high polished finish. When servicing, item #17 (nameplate rivet) and #18 (service nameplate) are required.

SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-82-5316	8-32 x 1/2" Slot Pan Hd. T-20	(4)	40	45-36-1450	Spacer	(1)
2	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(5)	41	42-52-0380	Bearing Cap	(1)
3	31-44-1651	Right Handle Half	(1)	42	36-92-0750	Wobble Shaft	(1)
4	06-95-0075	6-32 x 3/8" Truss Hd. Taptite Screw	(4)	43	45-88-8577	Washer	(1)
5	22-22-1380	Brush Holder Assembly	(1)	44	30-72-0111	Wobble Plate	(1)
6	23-44-0190	Brush Retaining Cap	(2)	45	02-04-1510	Ball Bearing	(3)
7	44-60-0626	Lock Pin	(1)	46	34-80-2600	Internal Retaining Ring	(2)
8	22-18-0910	Carbon Brush Assembly	(2)	47	34-60-1315	External Retaining Ring	(1)
9	06-55-3790	5/16-24 Spinlock Hex Nut	(1)	48	38-50-6005	Reciprocating Spindle	(1)
10	43-06-0675	Bronze Disc	(1)	49	31-15-0511	Spring Cover	(1)
11	14-20-3020	Dial Assembly	(1)	50	40-50-0161	Torsion Spring	(1)
12	06-82-7252	8-32 x 3/8" Pan Hd. Taptite T-20	(2)	51	06-83-3151	Set Screw	(1)
13	06-81-1060	8-32 x 2-1/4 Field Bolt	(2)	52	45-16-0615	Pivot Shoe Assembly	(1)
14	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(1)	53	28-14-2180	Gear Case	(1)
15	23-66-1490	Switch	(1)	54	42-24-0615	Forward Spindle Bearing	(1)
16	31-44-1656	Left Handle Half	(1)	55	45-06-0500	Felt Seal	(1)
17	06-72-1720	Nameplate Rivet	(2)	56	44-86-0615	Seal Retainer	(1)
18	12-99-1735	Service Nameplate	(1)	57	06-95-5150	6-32 x 1/4" Hex Hd. Taptite Sems	(1)
19	28-50-6220	Motor Housing	(1)	58	42-50-0077	Rear Cam	(1)
20	02-04-0845	Ball Bearing	(1)	59	06-82-5346	8-32 x 3/4" Pan Hd. Taptite T-20	(2)
21	31-55-0190	Coil Shield	(1)	60	06-82-5516	8-32 x 2-3/8" Pan Hd. Sit. Taptite T-20	(2)
22	23-16-0456	Field Insulator	(1)	61	45-12-0510	Gear Case Insulator	(1)
23	18-31-0500	120 V. Field	(1)	62	49-96-0070	5/32" Hex Key	(1)
24	06-57-2975	8-32 Flexlock Hex Nut	(2)	63	14-46-1001	Foam Slug Kit (10 Slugs)	(1)
25	31-05-0055	Baffle	(1)	64	43-72-0176	Heat Sink Holder	(1)
26	16-30-0565	120 V. Armature	(1)	65	34-60-3680	External Retaining Ring	(1)
27	22-84-0531	Fan Assembly	(1)	66	45-22-0081	Sleeve	(1)
28	02-04-0911	Ball Bearing	(1)	67	42-50-0076	Front Cam	(1)
29	44-76-0210	Cord Protector	(1)	68	43-06-0685	Metal Disc	(1)
30	22-64-3190	Cord Set	(1)	69	43-78-0530	Spring Retainer	(1)
31	45-12-0470	Dust Shield	(1)	70	40-50-8850	Disc Spring	(1)
32	48-66-4080	Key Holder	(1)	71	43-78-0525	Drive Hub	(1)
33	28-28-2080	Diaphragm	(1)	72	32-40-2310	IPS Gear Assembly (Plus)	(1)
34	02-50-2150	Needle Bearing	(1)	73	12-20-6519	Service Nameplate Kit	(1)
35	32-40-2095	Gear	(1)	74	14-46-1011	Quik-Lok Clamp Kit	(1)
36	06-82-5320	8-32 x 5/8" Pan Hd. Sit. Taptite 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)				

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FIG. 35,68 LUBRICATION
Apply a thin coat of type "N" grease, No. 49-08-4240, between the gear and the metal disc.

33 Place 3/4 oz. of type "N" grease, No. 49-08-4240, 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.

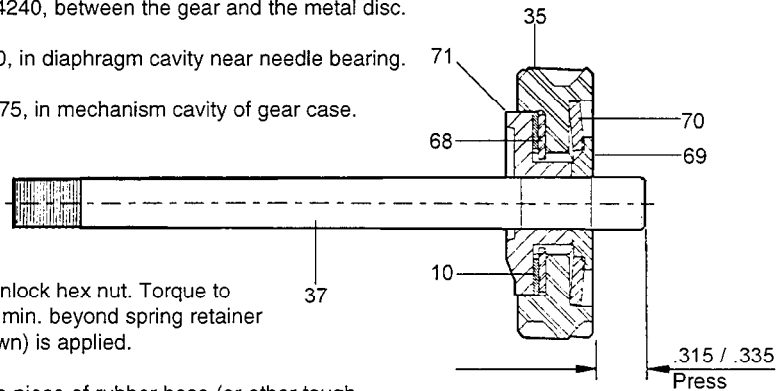
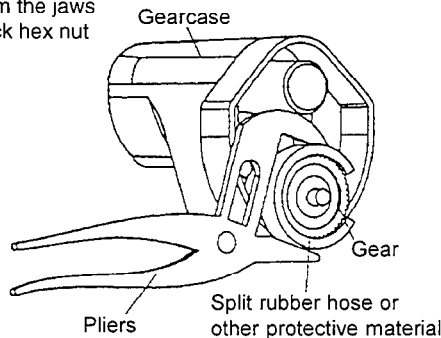


FIG. 70
Concave towards gear.

9,37,69 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.

68 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.

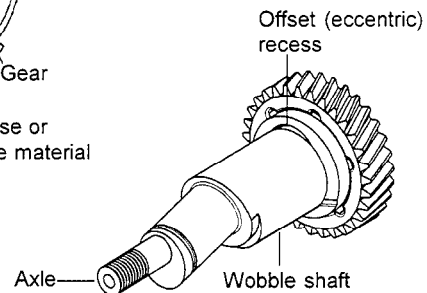
34 Press bearing flush ($\pm .005$) to diaphragm surface.

39 O-ring of seal towards rear of tool.

42,71 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.

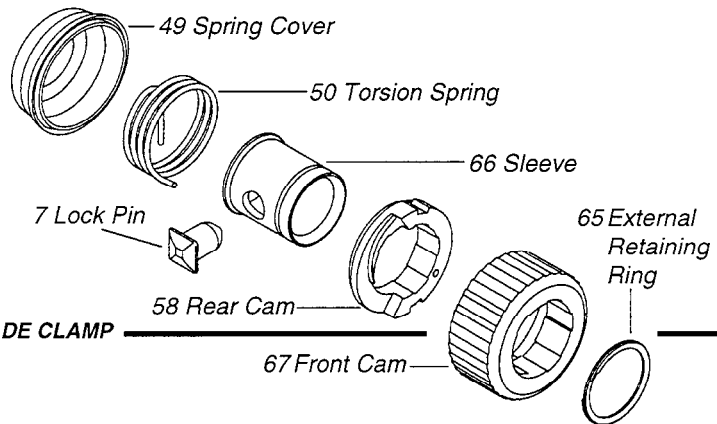
53,54 Press forward spindle bearing flush to .030 below bearing boss of gear case.



REMOVING THE KEYLESS QUIK-LOK® BLADE CLAMP

7,48,49,50, 58,65,66,67 To remove keyless blade clamp:

- Remove external retaining ring (65).
- Pull the front cam (67) off.
- Pull the lock pin (7) out.
- **Clean all parts before reassembly.**
- Coat lock pin (7) with powdered graphite.



REASSEMBLY OF THE KEYLESS QUIK-LOK® BLADE CLAMP

7,48,49,50, 58,65,66,67 To reassemble keyless blade clamp:

- Place spring cover (49) onto spindle (48).
- Place sleeve (66) into rear cam (58), positioning hole in sleeve with start of cam profile.
- Hold spindle with lock pin hole facing up and slide torsion spring (50) onto spindle with torsion leg positioned on same side as lock pin hole.
- Slide sleeve / rear cam onto spindle, inserting torsion leg of torsion spring into hole on rear cam.
- Rotate sleeve assembly in the direction of the arrows (located on spring cover) until hole in sleeve aligns with hole in spindle.
- Rotate rear cam until there is clearance for lock pin (7) to insert into sleeve / spindle holes. Insert lock pin.
- Align front cam (67) inner ribs with rear cam outer slots and slide front cam onto sleeve.
- Snap clamp to assure proper functioning before adding external retaining ring (65) to groove in sleeve.