Milwaukee	8	SERVICE	PARTS LIS	т		LETIN NO. - 40-7594
110000	SPECIFY CATALOG		AL NO. WHEN ORDE		REVISED BULLETIN 54-40-7593	Feb. 2017
	CATALOG NO.	6520-21	STARTING SERIAL NO.	B02E	WIRING INSTI	
24,79 79 12 13 62 16 12 13 15 13 35 23 13 35 23 10 EXAMPLE: Component Parts (Small When Ordering The Asset	25 ₁₈ 25 ₁₀ 25 ₁₀	36 38 33 5 21 78		7 46 50	71 42 34 47 9 69 69 65 65 67 67 44 0000 60 60 60 60 60 60 60 60 60 60 60 6	73 54 53 70 72
1 02-04-0845 Ball Bearing 2 02-04-0915 Ball Bearing 3 02-04-1511 Ball Bearing 4 02-50-2150 Needle Bear 5 05-88-0302 K50 x 60mm 6 06-55-3790 5/16-24 Spin 7 06-65-0045 Dowel Pin 8 43-36-0125 Cam Followe 9	Washer Hd. PT Screw lock Hex Nut er in aptite T-20 Screw m Screw Slt. Plastite T-20 Screw Plastite T-20 Screw Slt. Plastite T-20 Screw uread Form Screw	NO. REQ. (1) (1) (1) (1) (1) (2) (1) (2) (3) (3) (3) (6) (2) (2) (4)	81 40 4	74 67 76 48 4 60 849157 49 176 49 67 67		
20 14-67-0136 16-30-0700 Primary Wob 21 16-30-0700 Service Arma 22 18-30-1700 Service Field 23 22-20-0590 Carbon Brus 24 22-64-1622 Cord Asseml ★ 25 23-66-4245 Switch Asser 29 14-30-0080 Orbit Pocket 30 28-14-2600 Gearcase 31 28-28-2600 Diaphragm 32 31-05-0155 Baffle 33 31-11-0130 Orbital Cam 34	tronics Assembly bble Plate Assembly ature h Assembly bly mbly Assembly Plate - Right - Left ng ever Gear ng aining Ring ng t g Spindle ng t Axle e Bushing		FIG. PART NO. 58 43.06-0685 60 43.56-0620 61 43.78-0577 62 44-52-0105 64 44-60-1635 65	Orbit Plate Orbit Drive Hub Cushion Grip Shoe Pin Lock Pin Shoe Retainer Front Orbit Cap Bearing Retainer Orbit Seal Polypak Seal Gearcase Insula Shoe Assembly Sleeve Slinger Spacer Washer Fan Cord Protector Large Quik-Lok Gear Protecting Felt Seal Leadwire Assen	er ator Blade Clamp Clutch Assembly ably (Not Shown) ably (Not Shown)	NO. REQ. (2) (1) (1) (1) (1) (1) (1) (1) (1) (1) (1
51 42-24-0525 Rear Spindle 52 42-38-0055 Orbit Bumpe 53 Front Cam 54 Rear Cam	r	(1) (1) (1) (1)			IPORTANT SER	
55 42-52-0380 Bearing Cap 57 43-06-0676 Bronze Plate		(1) (1)		WILWAUKEE EL 13135 W. LISBO	ECTRIC TOOL CON RD., BROOKFIE	DRPORATION ELD, WI 53005 Drwg. 3

 FIG.
 NOTES: Bearing to be installed with seal towards commutator.

 4,31
 Press needle bearing flush ±.005 with inner surface of diaphragm.

 6,49
 Apply Blue Loctite® 242 to treads of wobble shaft axle prior to installing spinlock hex nut. Torque spinlock hex nut to 160-190 in. lbs.

- 6,40 Hold the intermediate 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.
- gearcase (30) gear (40)

 \cap

split rubber hose or other protective material

Place a thin film of lubrication on dowel pins prior to assembly.

rear spindle bushing (51)

SMAL

INNER

RIB

dowel pin (7)

reciprocating spindle (46)

front spindle bushing (50)

LARGE

INNER

RIB

- 7,46,50,51 Press dowel pins flush to front side of front spindle bushing. Press dowel pins flush to back side of rear spindle bushing. **NOTE:** Reciprocating spindle (46) must be installed inside assembly (7,50) and (7,51) prior to pressing last spindle bushing into place.
- 17,37 Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing.
- 29,42 Service fixture #61-10-0205 must be used when installing retaining ring (42) onto orbit pocket assembly (29).
- 40,57 Tabs of bronze plate engage intermediate gear.
- 40,48 Concave side of disc spring towards intermediate gear.
- 58,61 Tabs of metal plates engage orbit drive hub.
- 70 O-ring of polypak seal faces mechanism toward rear of tool.
- 74 Shoulder extension of grease slinger should face bearing.

REMOVING THE STEEL QUIK-LOK® BLADE CLAMP

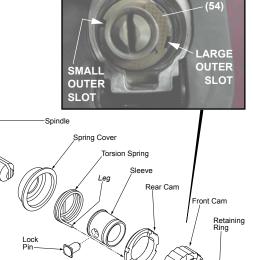
- Remove external retaining ring (44) and pull front cam (53) off.
- Pull lock pin (65) out and remove remainder of parts and discard.

REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP

- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.
- Place spring cover (34) onto spindle.
- Slide torsion spring (47) onto spindle shaft with leg positioned at the 6:00 position.
- Slide sleeve (73) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (54) over sleeve, aligning hole in rear cam with spring leg. Ensure spring leg inserts into hole in rear cam.
- Rotate rear cam (54) counter clockwise until there is clearance for lock pin (65) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (53) inner ribs with rear cam outer slots (see insert) and slide front cam onto sleeve until it bottoms. Retaining ring (44) 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.

FIG. LUBRICATION: -

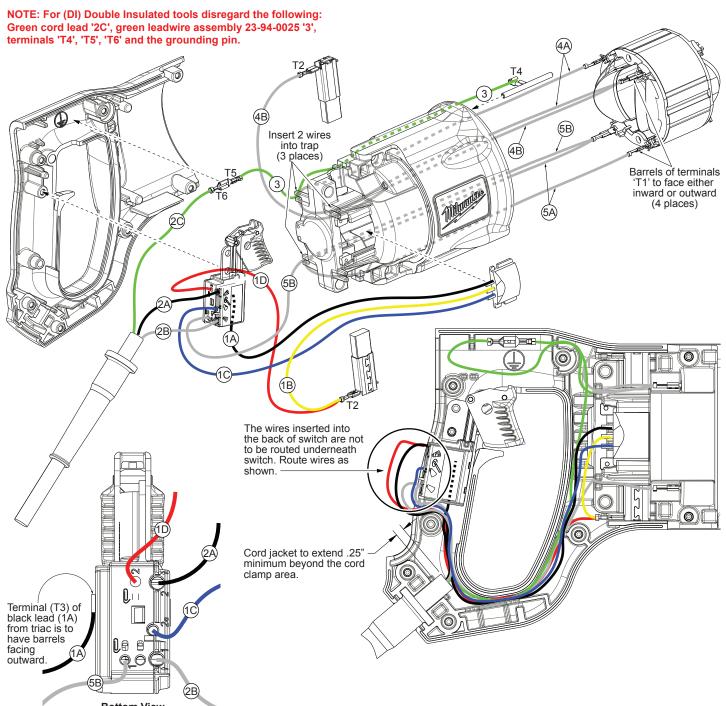
29,41	Lightly coat o-rings with lubrication for ease of installation onto assembled orbit poc	kets.
30	Place 3.2 oz. (80 grams \pm 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case.	[
31	Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm.	
40,58	Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate.	
65	Pin to be coated with graphite prior to assembly.	
87	Soak in lightweight bushing oil prior to assembly.	



Hole/Groc

41

29



Bottom View of Switch

	WIRING SPECIFICATIONS						
Wire No.	Wire Color	Origin or Part No.	Ga.	Length	Terminals, Connectors and End Wire Preparation		
1A	Black	TRIAC			Component of Switch Ass	sembly 23-66-4245.	
1B	Yellow	TRIAC			Component of Switch Assembly 23-66-4245.		
1C	Blue	TRIAC			Component of Switch Assembly 23-66-4245.		
1D	Red	TRIAC			Component of Switch Assembly 23-66-4245.		
2A	Black	Cord Assembly	16	4.00	Strip .340 and tin.		
2B	White	Cord Assembly	16	3.25	Strip .340 and tin.		
2C	Green	Cord Assembly	16	11.25	Strip .19 for T6.		
3	Green	23-94-0025	18	7.00	Strip each end .190 for T4 and T5.		
4A	White	23-94-6750	18	2.90	Strip one end .19 for T2.	Strip both .15 and join for T1.	
4B	White	23-94-6750	18	5.00	Strip one end .15 for T1.	Suppour . IS and join for T	
5A	White	23-94-6755	18	9.25	Strip one .320 and tin.	Strip both .15 and join for T1.	
5B	White	23-94-6755	18	5.00	Strip one end .15 for T1.		
	BULK LEAD WIRE - BULLETIN 58-01-0003						

NOTE:

All leads must be held to \pm 1/8". All lead lengths are before stripping.

TERMINAL DESCRIPTION			
Code	Part No.	Qnty.	
T1	23-74-1060	4	
T2	23-74-0017	2	
T3	23-74-0010	1	
T4	23-74-0605	1	
T5	23-74-0105	1	
T6	23-74-1095	1	