SERVICE PARTS LIST

Milwaukee SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS 1-1/8" STROKE DOUBLE INSULATED SAWZALL®

REVISED BULLETIN 54-40-7594

DATE Jan. 2017

WIRING INSTRUCTION See Page 3

CATALOG NO.

6520-21

STARTING SERIAL NO.

B02F

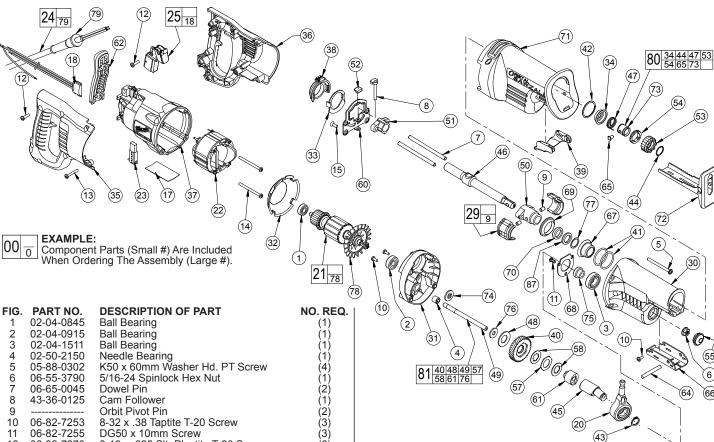


FIG.	PART NO.	DESCRIPTION OF PART	NO. RE
1	02-04-0845	Ball Bearing	(1)
2	02-04-0915	Ball Bearing	(1)
3	02-04-1511	Ball Bearing	(1)
4	02-50-2150	Needle Bearing	(1)
5	05-88-0302	K50 x 60mm Washer Hd. PT Screw	(4)
6	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
7	06-65-0045	Dowel Pin	(2)
8	43-36-0125	Cam Follower	(1)
9		Orbit Pivot Pin	(2)
10	06-82-7253	8-32 x .38 Taptite T-20 Screw	(3)
11	06-82-7255	DG50 x 10mm Screw	(3)
12	06-82-7270	8-16 x .625 Slt. Plastite T-20 Screw	(6)
13	06-82-7326	8-16 x 1" Slt. Plastite T-20 Screw	(2)
14	06-82-7453	8-16 x 2025 Slt. Plastite T-20 Screw	(2)
15	06-82-8870	1/2-DG50 Thread Form Screw	(4)
17	12-99-2576	Service Nameplate	(1)
18		Remote Electronics Assembly	(1)
20	14-67-0136	Primary Wobble Plate Assembly	(1)
21	16-30-0700	Service Armature	(1)
22	18-30-1700	Service Field	(1)
23	22-20-0590	Carbon Brush Assembly	(2)
24	22-64-1622	Cord Assembly	(1)
25	23-66-4245	Switch Assembly	(1)
29	14-30-0080	Orbit Pocket Assembly	(2)
30	28-14-2600	Gearcase	(1)
31	28-28-2600	Diaphragm	(1)
32	31-05-0155	Baffle	(1)
33	31-11-0130	Orbital Cam Plate	(1)
34		Spring Cover	(1)
35	31-44-2505	Handle Half - Right	(1)
36	31-44-2506	Handle Half - Left	(1)
37	31-50-0085	Motor Housing	(1)
38	31-52-0045	Orbit Shift Lever	(1)
39	31-52-0090	Shoe Release Lever	(1)
40	32-40-2050	Intermediate Gear	(1)
41	34-40-0040	O-Ring	(2)
42	34-60-0125	Retaining Ring	(1)
43	34-60-1315	External Retaining Ring	(1)
44	34-60-3700	Retaining Ring	(1)
45	36-92-0506	Wobble Shaft	(1)
46	38-50-6400	Reciprocating Spindle	(1)
47		Torsion Spring	(1)
48	40-50-8850	Disc Spring	(1)
49	42-12-0190	Wobble Shaft Axle	(1)
50	42-24-0066	Front Spindle Bushing	(1)
51	42-24-0525	Rear Spindle Bushing	(1)
52	42-38-0055	Orbit Bumper	(1)
53		Front Cam	(1)
54	40.50.000	Rear Cam	(1)
55	42-52-0380		(1)
57	43-06-0676	Bronze Plate	(1)

64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 80 81	43-06-0685 43-56-0620 43-78-0577 44-52-0105 44-60-1635 	Orbit Plate Orbit Drive Hub Cushion Grip Shoe Pin Lock Pin Shoe Retainer Front Orbit Cap Bearing Retainer Orbit Seal Polypak Seal Gearcase Insulator Shoe Assembly Sleeve Slinger Spacer Washer Washer Fan Cord Protector Large Quik-Lok Blade Clamp Gear Protecting Clutch Assembly	NO. REQ. (2) (1) (1) (1) (1) (1) (1) (1) (1) (1) (1

SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES

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FIG. 1	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. gear (40) split rubber hose or other protective material
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. spindle (46) front spindle
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. Place a thin film of lubrication
40,48	Concave side of disc spring towards intermediate gear. on dowel pins prior to assembly.
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. SMALL INNER RIB RIB
REMOVING TH	HE STEEL QUIK-LOK® BLADE CLAMP —————
	external retaining ring (44) and pull front cam (53) off.
	oin (65) out and remove remainder of parts and discard. OF THE STEEL QUIK-LOK® BLADE CLAMP
Coat new	lock pin with powdered graphite.
	n a vertical position. top of spindle
	ng cover (34) onto spindle.
	on spring (47) onto springle shart
	positioned at the 6:00 position. ve (73) onto spindle aligning hole on sleeve with hole in spindle.
	cam (54) over sleeve, aligning hole in rear cam with spring leg
Ensure sp	ring leg inserts into hole in rear cam.
	ar cam (54) counter clockwise until there is clearance for
	55) to be inserted into sleeve/spindle holes. Insert lock pin. cam (53) inner ribs with rear cam outer slots (see insert) and slide front
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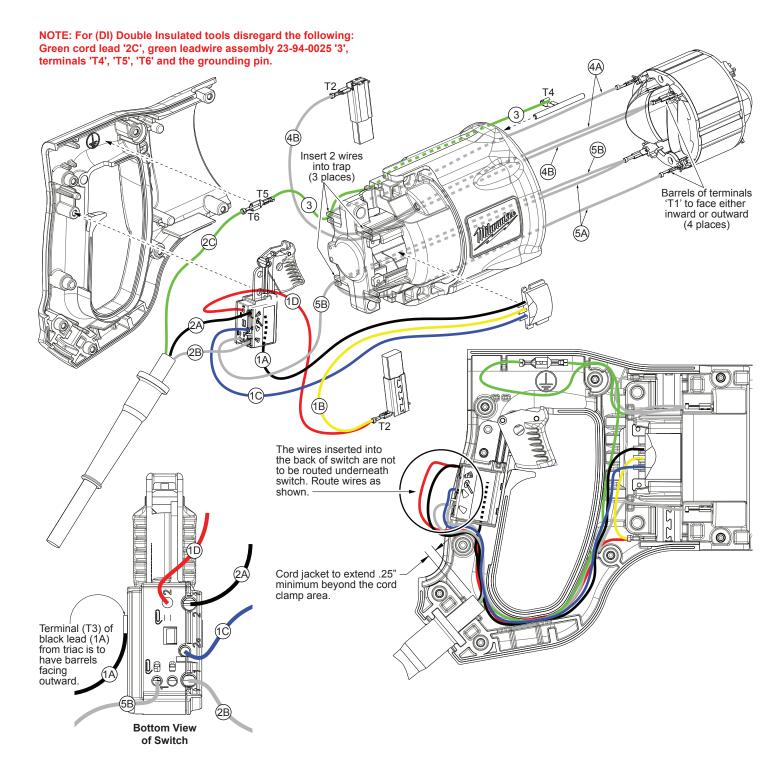
FIG.	LUBRICATION:
29,41	Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets.
30	Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case.
31	Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), 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.

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

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,

remainder of ring into groove. Ensure ring is seated in groove.

follow these instructions to remove, clean and reassemble blade clamp.



WIRING SPECIFICATIONS							
Wire No.	Wire Color	Origin or Part No.	Ga.	Length	Terminals, Connectors and End Wire Preparation		
1A	Black	TRIAC			Component of Switch Assembly 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 To	Γ4 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.	Suip bout .13 and Join for 11.	
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.	Strip both .15 and join for T1.	

BULK LEAD WIRE - BULLETIN 58-01-0003

NOTE: All leads must be held to ± 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	