## SERVICE PARTS LIST

Milwaukee

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14-67-0126

14-67-0136

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18-31-0221

22-20-0535

22-64-0595

23-66-2490

23-16-0046

14-30-0080

28-14-2600

28-28-2600

31-05-0155

31-11-0130

31-44-2090

31-44-2095

31-50-1990

31-52-0045

31-52-0090

32-40-2050

34-40-0040

34-60-0125

34-60-1315

34-60-3700

36-92-0701

38-50-6400

40-50-8850

42-12-0190

42-24-0066

42-24-0525

42-38-0055

42-52-0380

Secondary Wobble Plate Assembly

Primary Wobble Plate Assembly

Servicé Armature

Carbon Brush Assembly

**Orbit Pocket Assembly** 

Service Field

Switch

Baffle

O-Ring Retaining Ring

Gearcase

Diaphragm

Cord Assembly

Cardboard Tube

Orbital Cam Plate

Spring Cover Handle Half - Right Handle Half - Left

Shoe Release Lever

External Retaining Ring

Reciprocating Spindle

Front Spindle Bushing

Rear Spindle Bushing

Intermediate Gear

Motor Housing

Retaining Ring Wobble Shaft

Torsion Spring

Wobble Shaft Axle

Disc Spring

Orbit Bumper

Front Cam

Rear Cam

Bearing Cap

Orbit Shift Lever

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS 1-1/4" STROKE SAWZALL®

REVISED BULLETIN 54-40-7571

DATE Aug. 2019

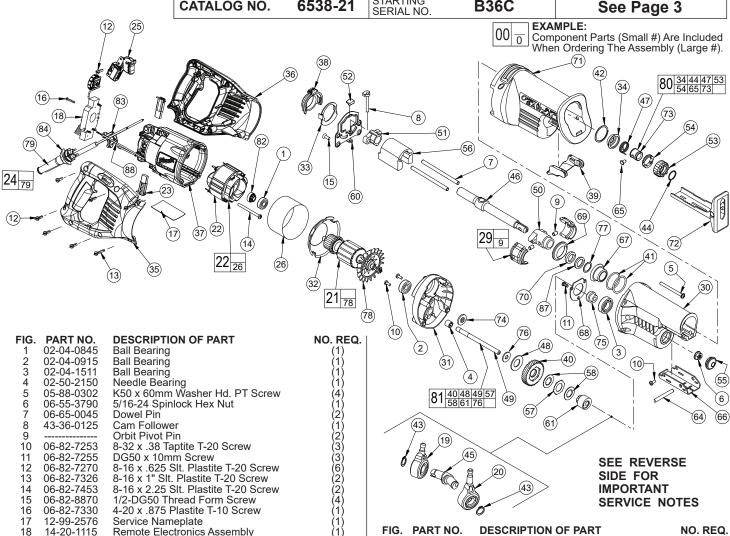
WIRING INSTRUCTION

CATALOG NO.

6538-21

STARTING SERIAL NO

**B36C** 



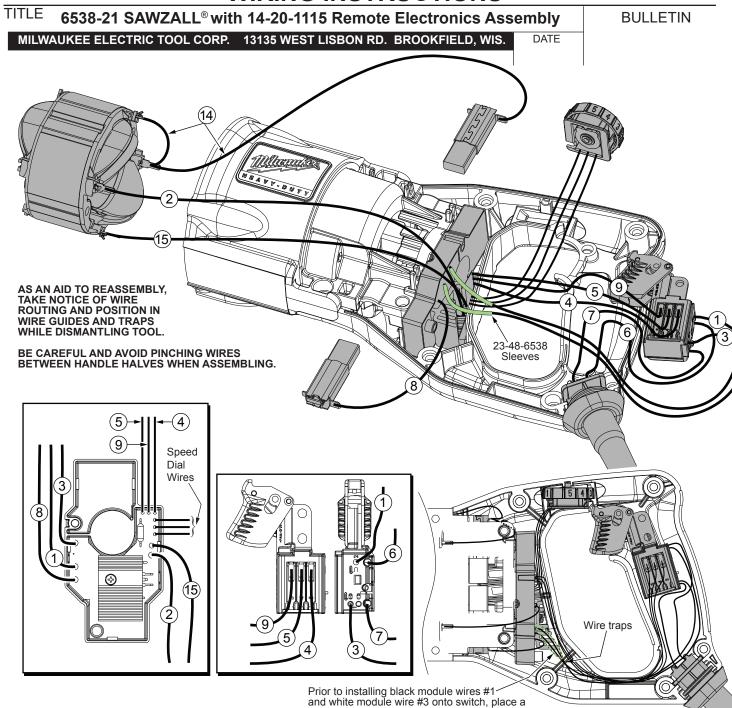
58 60 61 64 65 66 67 68 69 71 72 73 74 75 76 77 78 80 **80 **80 **80 **80 **80 **80	PART NO. 42-87-0180 43-06-0676 43-06-0685 43-56-0620 43-78-0575 44-60-1635	Counter Weight Bronze Plate Metal Plate Orbit Plate Orbit Plate Orbit Plate Orbit Drive Hub Shoe Pin Lock Pin Shoe Retainer Front Orbit Cap Bearing Retainer Orbit Seal Polypak Seal Gearcase Insulator Shoe Assembly Sleeve Slinger Spacer Washer Washer Washer Fan Cord Protector Large Quik-Lok Blade Clamp Gear Protecting Clutch Assembly Magnet Cord Clamp Cord Clamp Felt Seal Leadwire Assembly Fiberglass Sleeve	NO. REQ. (1) (1) (2) (1) (1) (1) (1) (1) (1) (1) (1) (1) (1
		Leadwire Assembly Fiberglass Sleeve Carrying Case (Not Shown)	(1) (2) (1)

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<b>FIG.</b> 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.	gearcase (30)				
		split rubber hose Service Fixture or other protective 61-10-0270 material (Pressing Pin Tool	)			
7,46,50,51,56	Press dowel pins flush to front side of front spindle bushing. Press dowel pins flush to back side of rear spindle bushing. <b>NOTE:</b> Reciprocating spindle (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) prior to pressing last spindle bushing into place. Be sure to orientate the counter weight with the hole on bottom towards rear spindle bushing, as shown.	rear spindle bushing (51)  counter weight (56)  dowel pin (7)	,			
17,37	Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing.	reciprocating spindle (46)				
29,42	Service fixture #61-10-0205 must be used when installing retaining ring (42) onto orbit pocket assembly (29).	Orient counter weight as shown with hole on bottom towards rear spindle bushing.				
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.	Place a thin film of lubrication 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.	SMALL LARGE INNER				
74	Shoulder extension of grease slinger should face bearing.	RIB INNER RIB				
REMOVING TH	E STEEL QUIK-LOK® BLADE CLAMP ————————————————————————————————————					
	xternal retaining ring (44) and pull front cam (53) off.	(53)				
•	in (65) out and remove remainder of parts and discard.  OF THE STEEL QUIK-LOK® BLADE CLAMP	(54)				
	ock pin with powdered graphite.					
<ul> <li>Hold tool in</li> </ul>	n a vertical position.	op of spindle				
	ng cover (34) onto spindle.	LARGE				
	on spring (47) onto spindle shaft sitioned at the 6:00 position.	46 SMALL OUTER SLOT				
	ve (73) onto spindle aligning hole on sleeve with hole in spindle.	12:00 SLOT				
	cam (54) over sleeve, aligning hole in rear cam with spring leg.	34 47 73 54				
Rotate rea	ring leg inserts into hole in rear cam. r cam (54) counter clockwise until there is clearance for 5) to be inserted into sleeve/spindle holes. Insert lock pin.	leg   53   44				
Align front	cam (53) inner ribs with rear cam outer slots (see insert) and slide front sleeve until it bottoms. Retaining ring (44) groove should be completely visib	ole. 6:00				
<ul> <li>Attach reta</li> </ul>						
	np should rotate freely. During normal usage, debris may not allow blade cla					
	eely. The use of spray lubricant can help free blade clamp. In extreme condi te instructions to remove, clean and reassemble blade clamp.	itions, 65 hole	)			

FIG.	LUBRICATION:	
29,41	Lightly coat o-rings with lubrication for ease of installation onto assembled orbit p	oockets. 41
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 $\pm$ 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.	29
87	Soak in lightweight bushing oil prior to assembly	

## WIRING INSTRUCTIONS



	WIRING SPECIFICATIONS							
Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation				
Black	14-20-	1105	Compo	nent of the speed control module. Connect to position '2' on the back of the on-off switch.				
Yellow	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom left field terminal.				
White	14-20-	1105	Compo	nent of the speed control module. Connect to position '1' on the back of the on-off switch.				
Black	14-20-	1105	Compo	nent of the speed control module. Connect to position '3' on the left side of the on-off switch.				
White	14-20-	1105	Compo	nent of the speed control module. Connect to position '4' on the left side of the on-off switch.				
Black	22-64-4	1522	Compo	nent of the power cord set. Connect the other end to position '2↑' on switch.				
White	22-64-4	1522	Compo	nent of the power cord set. Connect the other end to position '1↑' on switch.				
Black	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom brush tube terminal.				
Blue	14-20-	1105	Compo	nent of the speed control module. Connect to position '5' on the left side of the on-off switch.				
White	23-94-7	7425	Leadw	re assembly. Connect to the top right and left field terminals. Connect to top brush tube terminal.				
Yellow	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom right field terminal.				

sleeve (23-48-6538) over each wire and slide towards module. Locate both sleeves between the module and the adjacent wire traps.