



## SERVICE PARTS LIST

**BULLETIN NO.****54-40-6241****SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS****REVISED BULLETIN**

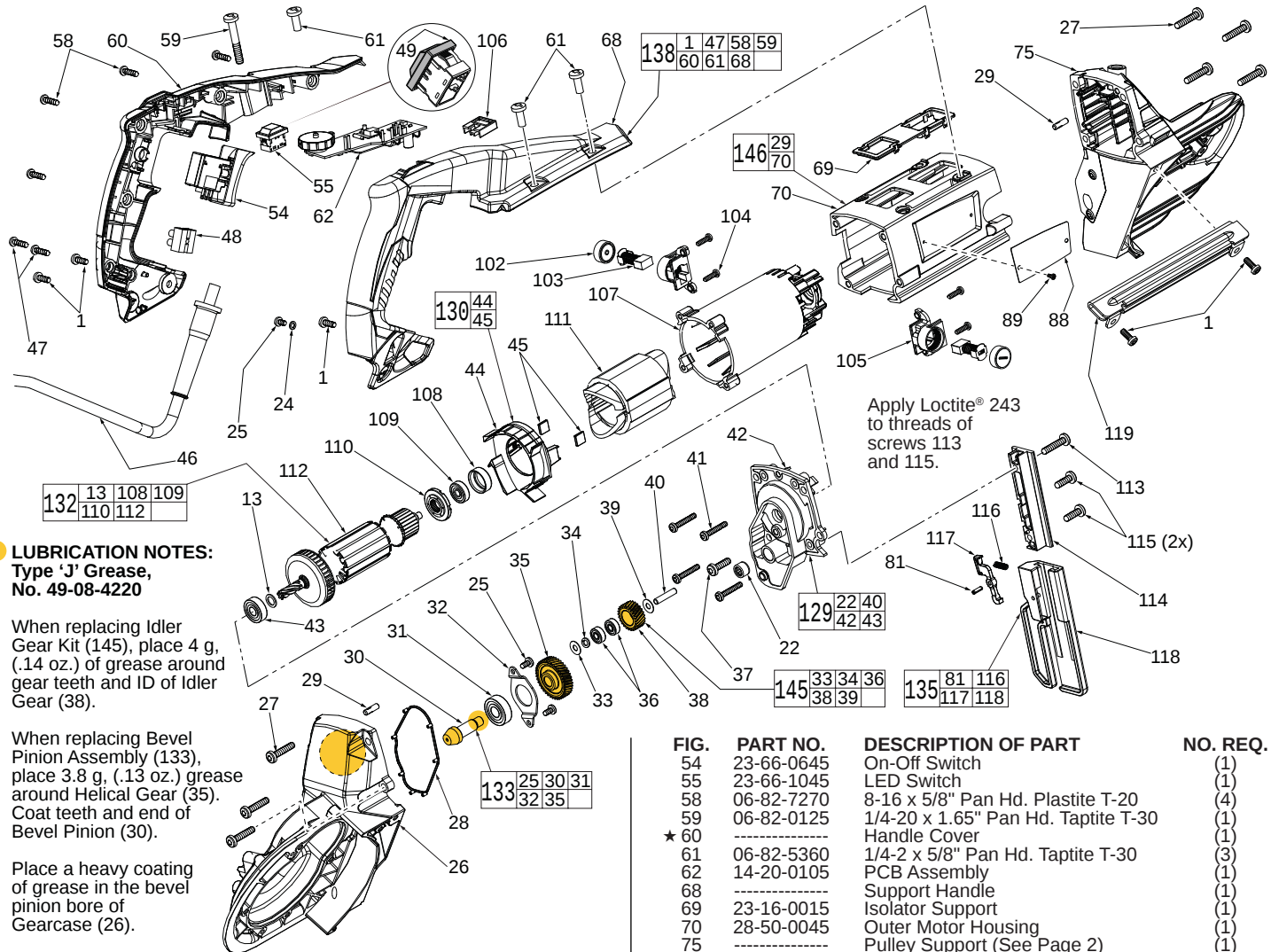
54-40-6240

**DATE**

Apr. 2015

**DEEP CUT BANDSAW****CATALOG NO. 6232-20****STARTING  
SERIAL NO.****D51B****WIRING INSTRUCTION****See Page 4 thru 7**

★ = Part number change from previous service parts list.

**LUBRICATION NOTES:**  
**Type 'J' Grease,**  
**No. 49-08-4220**

When replacing Idler Gear Kit (145), place 4 g. (.14 oz.) of grease around gear teeth and ID of Idler Gear (38).

When replacing Bevel Pinion Assembly (133), place 3.8 g. (.13 oz.) grease around Helical Gear (35). Coat teeth and end of Bevel Pinion (30).

Place a heavy coating of grease in the bevel pinion bore of Gearcase (26).

| FIG. | PART NO.   | DESCRIPTION OF PART                       | NO. REQ. |
|------|------------|-------------------------------------------|----------|
| 1    | 06-82-5314 | 10-24 x 1/2" Pan Hd. Tapt. T-25 (5 of 23) | (23)     |
| 13   | 45-88-0406 | Washer (1 of 2)                           | (2)      |
| 22   | -----      | Needle Bearing (1 of 3)                   | (3)      |
| 24   | 05-90-0225 | Washer                                    | (1)      |
| 25   | 06-82-8828 | 8-32 x .313" Pan Hd. Taptite T-20         | (3)      |
| ★ 26 | -----      | Gearcase (See Page 3)                     | (1)      |
| 27   | 06-82-5376 | 12-24 x 1" Pan Hd. Taptite T-27           | (7)      |
| 28   | 34-40-0185 | Seal Gasket                               | (1)      |
| 29   | -----      | Pin                                       | (2)      |
| 30   | -----      | Bevel Pinion                              | (1)      |
| 31   | -----      | Ball Bearing                              | (1)      |
| 32   | -----      | Bearing Plate                             | (1)      |
| 33   | 45-88-0895 | Washer                                    | (1)      |
| 34   | 45-88-6230 | Spring Washer                             | (1)      |
| 35   | -----      | Helical Gear                              | (1)      |
| 36   | -----      | Ball Bearing                              | (2)      |
| 37   | 06-82-5358 | 12-24 x 3/4" Pan Hd. Taptite T-27         | (1)      |
| 38   | -----      | Idler Gear                                | (1)      |
| 39   | 45-88-6232 | Washer                                    | (1)      |
| 40   | -----      | Pin                                       | (1)      |
| 41   | 06-82-7326 | 8-16 x 1" Pan Hd. Plastite T-20           | (4)      |
| 42   | -----      | Diaphragm                                 | (1)      |
| 43   | 02-04-0175 | Ball Bearing (1 of 2)                     | (2)      |
| 44   | -----      | Baffle                                    | (1)      |
| 45   | 42-28-0085 | Rubber Block                              | (2)      |
| 46   | 22-64-0440 | Power Cord                                | (1)      |
| 47   | 06-82-7409 | 8-16 x 1/2" Pan Hd. Plastite T-20         | (2)      |
| 48   | 22-56-0470 | Terminal Block                            | (1)      |
| 49   | 42-38-0085 | Rubber Switch Cover                       | (1)      |
| 50   | 23-94-0405 | Leadwire Assembly-Black (Not Shown)       | (1)      |
| 51   | 23-94-0435 | Leadwire Assembly-White (Not Shown)       | (1)      |
| 52   | 23-94-0440 | Leadwire Assembly-Red (Not Shown)         | (1)      |

| FIG.  | PART NO.   | DESCRIPTION OF PART                 | NO. REQ. |
|-------|------------|-------------------------------------|----------|
| 54    | 23-66-0645 | On-Off Switch                       | (1)      |
| 55    | 23-66-1045 | LED Switch                          | (1)      |
| 58    | 06-82-7270 | 8-16 x 5/8" Pan Hd. Plastite T-20   | (4)      |
| 59    | 06-82-0125 | 1/4-20 x 1.65" Pan Hd. Taptite T-30 | (1)      |
| ★ 60  | -----      | Handle Cover                        | (1)      |
| 61    | 06-82-5360 | 1/4-2 x 5/8" Pan Hd. Taptite T-30   | (3)      |
| 62    | 14-20-0105 | PCB Assembly                        | (1)      |
| 68    | -----      | Support Handle                      | (1)      |
| 69    | 23-16-0015 | Isolator Support                    | (1)      |
| 70    | 28-50-0045 | Outer Motor Housing                 | (1)      |
| 75    | -----      | Pulley Support (See Page 2)         | (1)      |
| 81    | 06-65-0115 | Coiled Pin (1 of 3)                 | (3)      |
| 88    | 12-20-6232 | Service Nameplate                   | (1)      |
| 89    | -----      | Nameplate Screw                     | (2)      |
| 102   | 23-44-0220 | Brush Cap                           | (2)      |
| 103   | 22-18-0025 | Carbon Brush                        | (2)      |
| 104   | 05-88-1360 | M4 x 13.5mm ST Screw                | (4)      |
| 105   | 22-20-0080 | Brush Holder Assembly               | (2)      |
| 106   | 14-20-0195 | Sensor Assembly                     | (1)      |
| 107   | 31-50-0305 | Inner Motor Housing                 | (1)      |
| 108   | 42-96-0016 | Bearing Cap                         | (1)      |
| 109   | 02-04-0645 | Ball Bearing                        | (1)      |
| 110   | 23-38-0030 | Magnetic Ring                       | (1)      |
| 111   | 18-07-0025 | Service Field Kit                   | (1)      |
| 112   | -----      | Armature                            | (1)      |
| 113   | 06-82-0065 | 10-32 x 1" Pan Hd. Taptite T-25     | (1)      |
| ★ 114 | 30-13-0015 | T-Block                             | (1)      |
| 115   | 06-82-5330 | 10-32 x 5/8" Pan Hd. Taptite T-25   | (2)      |
| 116   | 40-50-0845 | Lever Release Spring                | (1)      |
| 117   | 42-42-0060 | Release Button                      | (1)      |
| 118   | -----      | Shoe Bumper                         | (1)      |
| 119   | 43-54-0085 | Blade Guard                         | (1)      |
| 129   | 14-13-0010 | Diaphragm Kit                       | (1)      |
| 130   | 42-14-0015 | Fan Baffle Kit                      | (1)      |
| 132   | 16-10-0025 | Service Armature Kit                | (1)      |
| 133   | 32-60-0095 | Bevel Pinion Assembly               | (1)      |
| 135   | 42-18-0035 | Shoe Bumper Kit                     | (1)      |
| 138   | 31-44-0745 | Handle Assembly Kit                 | (1)      |
| 145   | 32-60-6230 | Idler Gear Kit                      | (1)      |
| 146   | 14-30-6230 | Outer Motor Housing Kit             | (1)      |

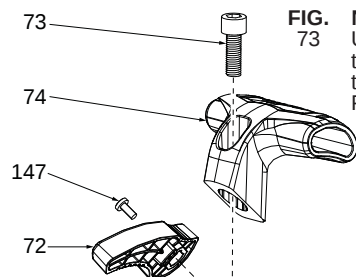
**SEE PAGE 3 FOR FASTENER TORQUE CHART****MILWAUKEE ELECTRIC TOOL CORPORATION**

13135 W. Lisbon Road, Brookfield, WI 53005

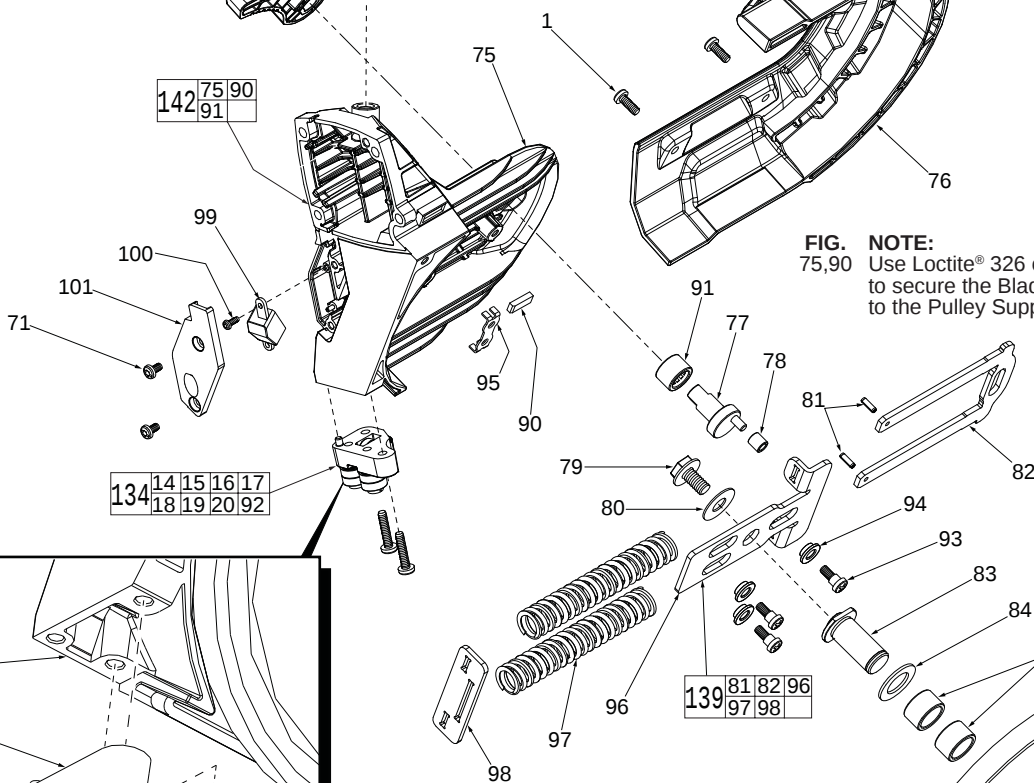
Drwg. 4

**EXAMPLE:**

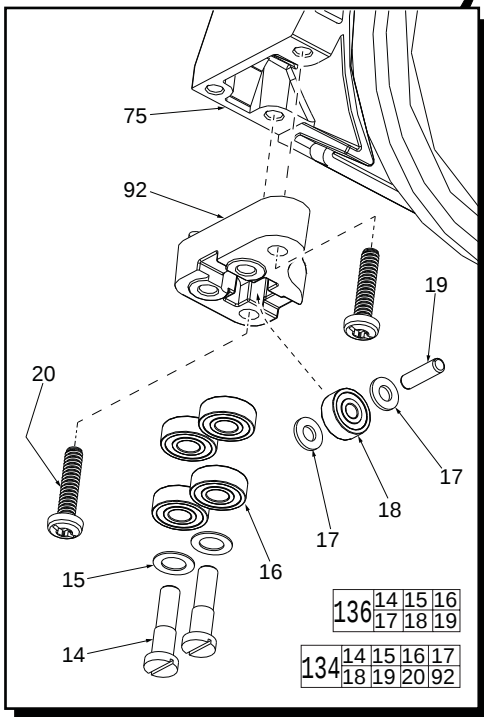
Component Parts  
(Small #) Are Included  
When Ordering The  
Assembly (Large #).



**FIG. 73 NOTE:**  
Use Loctite® 243 or the equivalent  
to the threads of Screw (73) prior  
to installing T-Handle (74) onto  
Pulley Support (75).



**FIG. 75,90 NOTE:**  
Use Loctite® 326 or the equivalent  
to secure the Blade Backing Pad (90)  
to the Pulley Support (75).



| FIG. | PART NO.   | DESCRIPTION OF PART                            | NO. REQ. |
|------|------------|------------------------------------------------|----------|
| 1    | 06-82-5314 | 10-24 x 1/2" Pan Hd. Tapt. T-25 (7 of 23) (23) | (23)     |
| 2    | 31-15-0325 | Pulley Cover (1 of 2)                          | (2)      |
| 8    | 45-69-0010 | Pulley Tire (1 of 2)                           | (2)      |
| 14   | -----      | 12-24 UNC x .96" Slotted (2 of 4)              | (4)      |
| 15   | -----      | Washer (2 of 4)                                | (4)      |
| 16   | -----      | Ball Bearing (4 of 8)                          | (8)      |
| 17   | -----      | Washer (2 of 4)                                | (4)      |
| 18   | -----      | Ball Bearing (1 of 2)                          | (2)      |
| 19   | -----      | Pin (1 of 2)                                   | (2)      |
| 20   | 06-82-5574 | 10-24 x 7/8" Pan Hd. Tapt. T-25 (2 of 4)       | (4)      |
| 71   | 06-82-7252 | 8-32 x .38" Pan Hd. Taptite T-20               | (2)      |
| 72   | 31-52-0066 | Tension Release Lever                          | (1)      |
| 73   | 06-75-4675 | 3/8"-16 UNC x 1" Socket Hd. Cap Screw          | (1)      |
| 74   | 31-44-0740 | Front T-Handle                                 | (1)      |
| 75   | -----      | Pulley Support                                 | (1)      |
| 76   | 31-15-0335 | Front Pulley Shroud                            | (1)      |
| 77   | 45-08-0070 | Cam Shaft                                      | (1)      |
| 78   | 42-40-0105 | Cam Bushing                                    | (1)      |
| 79   | 06-75-0035 | 5/16-18 x 9/16" Screw                          | (1)      |
| 80   | 45-88-0395 | Washer                                         | (1)      |

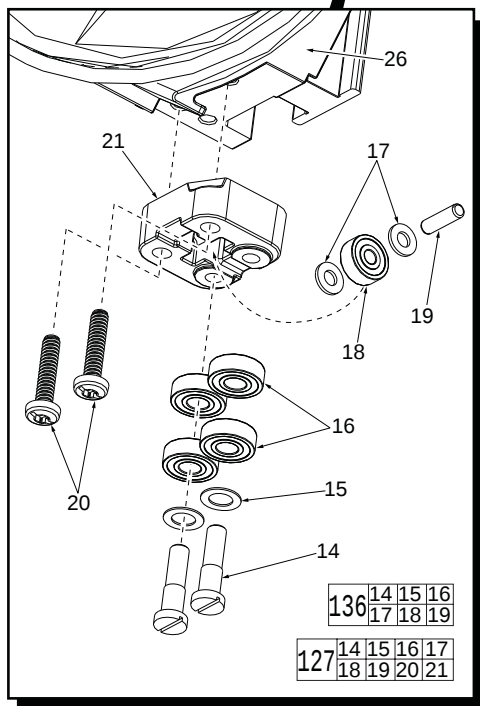
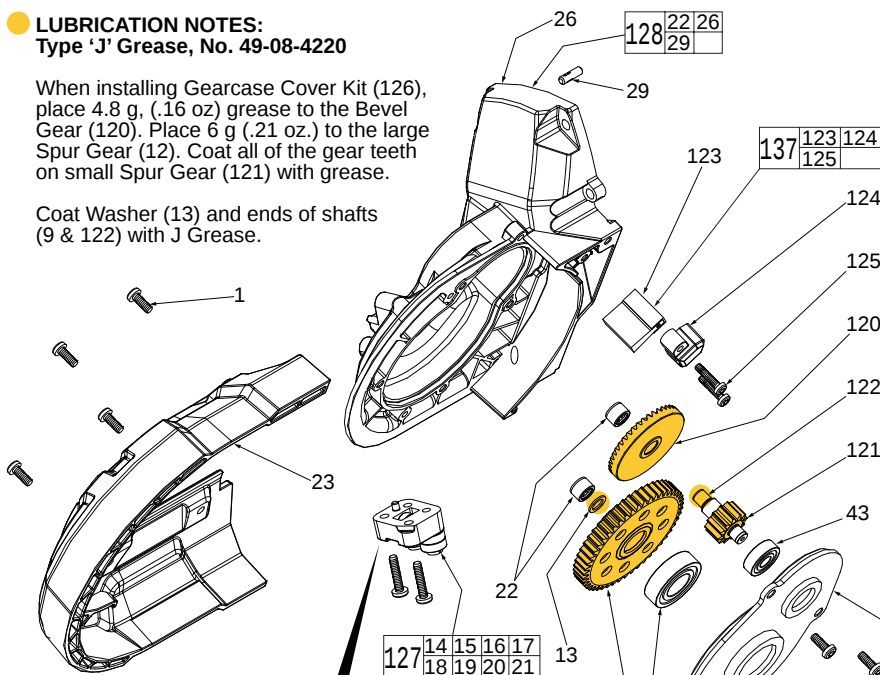
| FIG. | PART NO.   | DESCRIPTION OF PART              | NO. REQ. |
|------|------------|----------------------------------|----------|
| 81   | 06-65-0115 | Coil Pin (2 of 3)                | (3)      |
| 82   | -----      | Driver Plate                     | (1)      |
| 83   | 42-12-0010 | Front Pulley Shaft               | (1)      |
| 84   | 45-88-7165 | Washer                           | (2)      |
| 85   | 42-40-0580 | Sleeve Bearing                   | (2)      |
| 86   | 28-95-0050 | Front Pulley                     | (1)      |
| 87   | 34-60-1400 | Snap Ring                        | (1)      |
| 90   | 44-52-0120 | Blade Backing Pad                | (1)      |
| 91   | 02-50-0035 | Needle Bearing                   | (1)      |
| 92   | -----      | Front Roller Block               | (1)      |
| 93   | 06-81-0075 | Shoulder Screw                   | (3)      |
| 94   | 42-40-0115 | Tension Bushing                  | (3)      |
| 95   | 44-66-6232 | Wear Plate                       | (1)      |
| 96   | -----      | Support Plate                    | (1)      |
| 97   | -----      | Blade Tension Spring             | (2)      |
| 98   | -----      | Contact Plate                    | (1)      |
| 99   | 14-20-0115 | LED Assembly                     | (1)      |
| 100  | 05-81-0010 | M3 x 8mm Screw                   | (1)      |
| 101  | 31-15-0345 | LED Cover                        | (1)      |
| 134  | 42-24-0015 | Front Guide Roller Kit           | (1)      |
| 136  | 14-46-0465 | Guide Roller Kit                 | (1)      |
| 139  | 42-18-0015 | Tensioning Mechanism Assembly    | (1)      |
| 142  | 14-30-0060 | Pulley Support Kit               | (1)      |
| 147  | 06-82-0145 | 8-32 x .48" Pan Hd. M Screw T-20 | (1)      |

SEE PAGE 3 FOR FASTENER TORQUE CHART

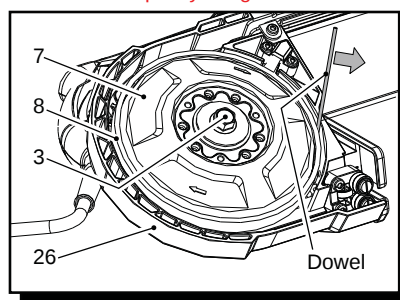
**LUBRICATION NOTES:**  
Type 'J' Grease, No. 49-08-4220

When installing Gearcase Cover Kit (126), place 4.8 g (.16 oz) grease to the Bevel Gear (120). Place 6 g (.21 oz.) to the large Spur Gear (12). Coat all of the gear teeth on small Spur Gear (121) with grease.

Coat Washer (13) and ends of shafts (9 & 122) with J Grease.



To properly tighten hex head screw (3), use a wooden dowel or a nylon rod in the opening between the rear pulley (7) and gearcase (26). Be careful not to damage pulley tire (8). Apply enough pressure to prevent rear pulley from turning. Torque hex head screw (3) to 312 in/lbs. **Service Tool 61-30-6232 can be ordered to secure rear pulley to tighten hex hd. screw.**



| SCREW TORQUE CHART |            |                           |                  |
|--------------------|------------|---------------------------|------------------|
| Fig.               | Part No.   | Location                  | Torque (In/Lbs.) |
| 3                  | 06-75-0010 | Rear Pulley               | 312              |
| 20                 | 06-82-5574 | Front Roller Block        |                  |
|                    |            | Rear Roller Block         | 39               |
| 25                 | 06-82-8828 | Bearing Plate             |                  |
|                    |            | Ground Terminal           | 17               |
| 27                 | 06-82-5376 | Gearcase                  |                  |
|                    |            | Pulley Support            | 38               |
| 37                 | 06-82-5358 | Diaphragm                 | 38               |
| 41                 | 06-82-7326 | Diaphragm                 | 16               |
| 47                 | 06-82-7409 | Handle Cover              | 17               |
| 58                 | 06-82-7270 | Handle Cover              | 17               |
| 59                 | 06-82-0125 | Handle Cover              | 39               |
| 61                 | 06-82-5360 | Handle Cover              |                  |
|                    |            | Support Handle            | 39               |
| 71                 | 06-82-7252 | LED Cover                 | 22               |
| 73                 | 06-75-4675 | Front T-Handle            | 83               |
| 79                 | 06-75-0035 | Support Plate             | 104              |
| 93                 | 06-81-0075 | Support Plate             | 36               |
| 100                | 05-81-0010 | LED Assembly              | 6                |
| 104                | 05-88-1360 | Brush Holder Assembly     | 5                |
| 113                | 06-82-0065 | T-Block                   | 19               |
| 115                | 06-82-5330 | T-Block                   | 19               |
| 125                | 06-82-5346 | Tire Cleaning Brush Cover | 22               |
| 147                | 06-82-0145 | Tension Release Lever     | 22               |

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

Lightly coat both sides of Washers (5) and Clutch Plates (6) with J Grease.

**NOTE:**  
312 in/lbs.  
or 26 ft/lbs.

Use screws (1) to temporarily attach service tool to rear pulley. Hold tool and tightened hex head screw (3) to 312 in/lbs.

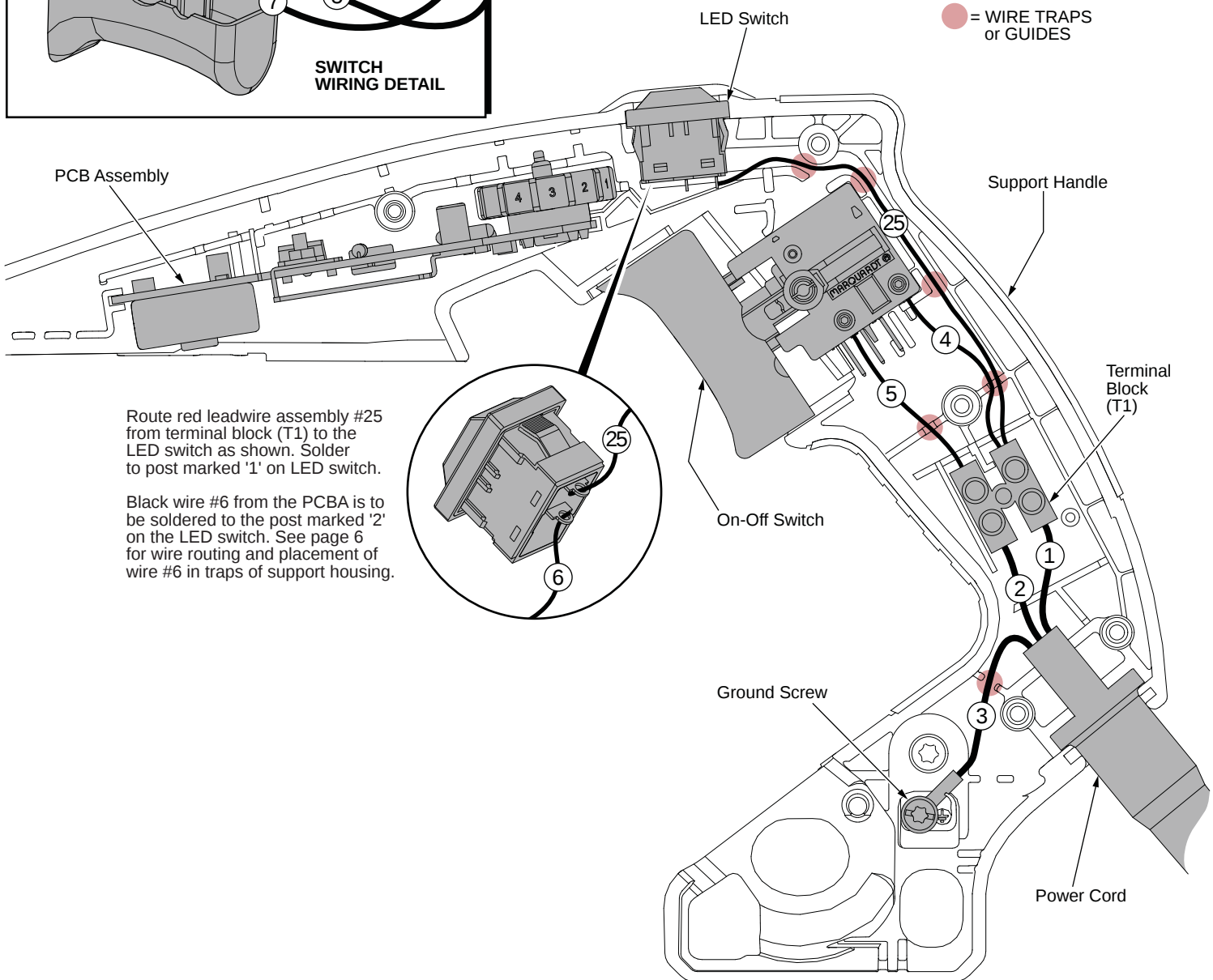
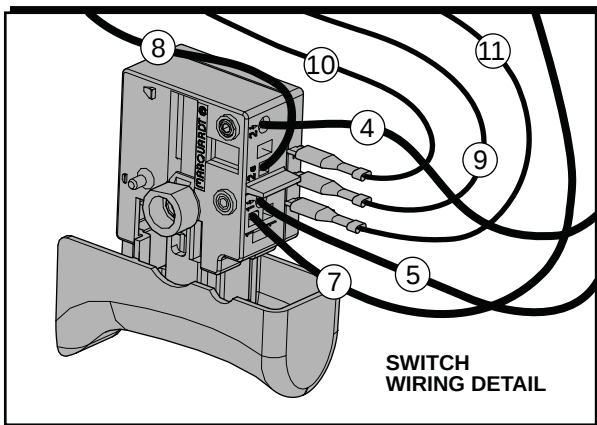


| FIG. | PART NO.   | DESCRIPTION OF PART                            | NO. REQ. |
|------|------------|------------------------------------------------|----------|
| 1    | 06-82-5314 | 10-24 x 1/2" Pan Hd. Tapt. T25 (11 of 23) (23) | (2)      |
| 2    | 31-15-0325 | Pulley Cover (1 of 2)                          | (2)      |
| 3    | 06-75-0010 | M Screw, 3/8"-16 UNC 5/8" Hex Hd.              | (1)      |
| 4    | 40-50-0805 | Disc Spring                                    | (1)      |
| 5    | 43-06-0010 | Clutch Washer                                  | (2)      |
| 6    | 43-06-0015 | Clutch Plate                                   | (2)      |
| 7    | 28-95-0040 | Rear Pulley                                    | (1)      |
| 8    | 45-69-0010 | Pulley Tire (1 of 2)                           | (2)      |
| 9    | -----      | Spindle                                        | (1)      |
| 10   | -----      | Gearcase Cover                                 | (1)      |
| 11   | -----      | Ball Bearing                                   | (1)      |
| 12   | -----      | Spur Gear                                      | (1)      |
| 13   | 45-88-0406 | Washer (1 of 2)                                | (2)      |
| 14   | -----      | 12-24 UNC x .96" Slotted (2 of 4)              | (4)      |
| 15   | -----      | Washer (2 of 4)                                | (4)      |
| 16   | -----      | Ball Bearing (4 of 8)                          | (8)      |
| 17   | -----      | Washer (2 of 4)                                | (4)      |
| 18   | -----      | Ball Bearing (1 of 2)                          | (2)      |
| 19   | -----      | Pin (1 of 2)                                   | (2)      |
| 20   | 06-82-5574 | 10-24 x 7/8" Pan Hd. Tapt. T-25 (2 of 4)       | (4)      |

| FIG. | PART NO.   | DESCRIPTION OF PART                   | NO. REQ. |
|------|------------|---------------------------------------|----------|
| 21   | -----      | Rear Roller Block                     | (1)      |
| 22   | -----      | Needle Bearing (2 of 3)               | (3)      |
| 23   | 31-15-0330 | Rear Pulley Shroud                    | (1)      |
| ★ 26 | -----      | Gearcase                              | (1)      |
| 29   | -----      | Pin (1 of 2)                          | (2)      |
| 43   | 02-04-0175 | Ball Bearing (1 of 2)                 | (2)      |
| 120  | -----      | Bevel Gear                            | (1)      |
| 121  | -----      | Spur Gear                             | (1)      |
| 122  | -----      | Shaft                                 | (1)      |
| 123  | -----      | Tire Cleaning Brush                   | (1)      |
| 124  | -----      | Tire Cleaning Brush Cover             | (1)      |
| 125  | 06-82-5346 | 8-32 x 3/4" Pan Hd. Taptite T-20      | (2)      |
| 126  | 14-30-0010 | Gearcase Cover Kit                    | (1)      |
| 127  | 42-28-0025 | Rear Guide Roller Kit                 | (1)      |
| 128  | 14-30-0015 | Gearcase Top Assembly                 | (1)      |
| 136  | 14-46-0465 | Guide Roller Kit                      | (1)      |
| 137  | 44-60-0295 | Tire Cleaning Brush Kit               | (1)      |
|      | 42-55-6232 | Blow Molded Carrying Case (Not Shown) | (1)      |

AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.



### WIRING SPECIFICATIONS

| Wire No. | Wire Color | Origin or Gauge | Length | Terminals, Connectors and 1 or 2 End Wire Preparation                                                                                                                                     |
|----------|------------|-----------------|--------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 1        | Black      | Cord            | -----  | Component of the cord set. Connect to lower right of terminal block (T1).                                                                                                                 |
| 2        | White      | Cord            | -----  | Component of the cord set. Connect to lower left of terminal block (T1).                                                                                                                  |
| 3        | Green      | Cord            | -----  | Component of the cord set. Connect to grounding area on surface of gearcase.                                                                                                              |
| 4        | Black      | 23-94-0405      | -----  | Leadwire assembly. On one end twist strands together with red wire #25 and connect with the upper right of terminal block (T1). Connect the other end to the '2↓' position of the switch. |
| 5        | White      | 23-94-0435      | -----  | Leadwire assembly. Connect one end to the upper left of terminal block (T1). Connect the other end to the '1↓' position of the switch.                                                    |
| 25       | Red        | 23-94-0440      | -----  | Leadwire assembly. On one end twist strands together with black wire #4 and connect with the upper right of terminal block (T1). Solder other end to position '1' on LED switch.          |

**SWITCH WIRING DETAIL**

PCB Assembly

LED Switch

On-Off Switch

Support Handle

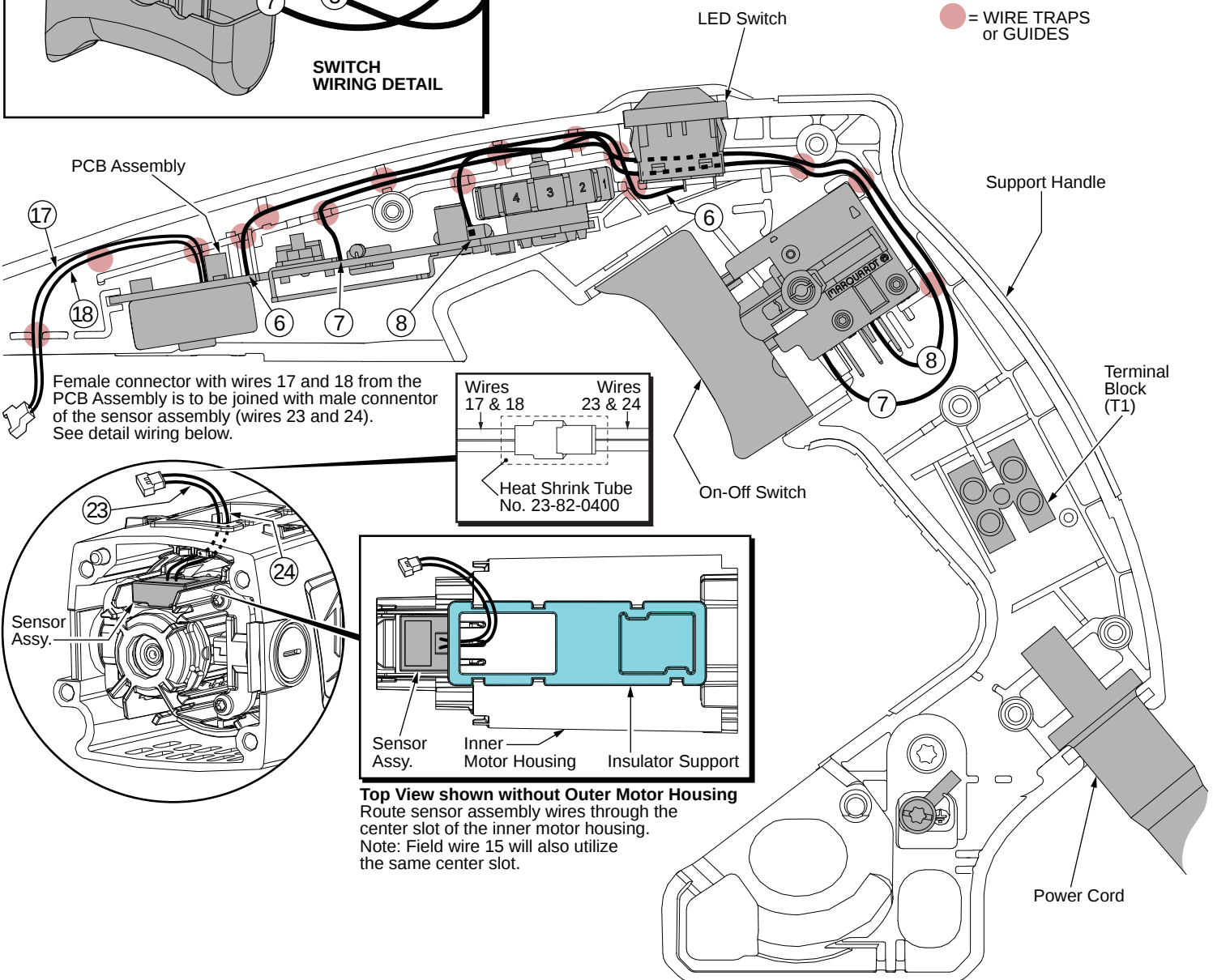
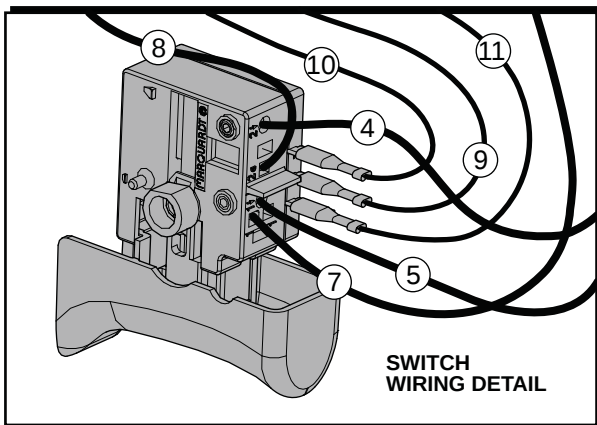
Terminal Block (T1)

Power Cord

Heat Shrink Tube  
No. 23-82-0400 (2 places)  
Place over connected wires 17 and 18 from PCB Assembly and wires 23 and 24 of Sensor Assembly. Heat over the joined connectors. (See page 6).  
Place over connected wires 19 and 20 from PCB Assembly and wires 21 and 22 of LED Assembly. Heat over the joined connectors. (See page 7).

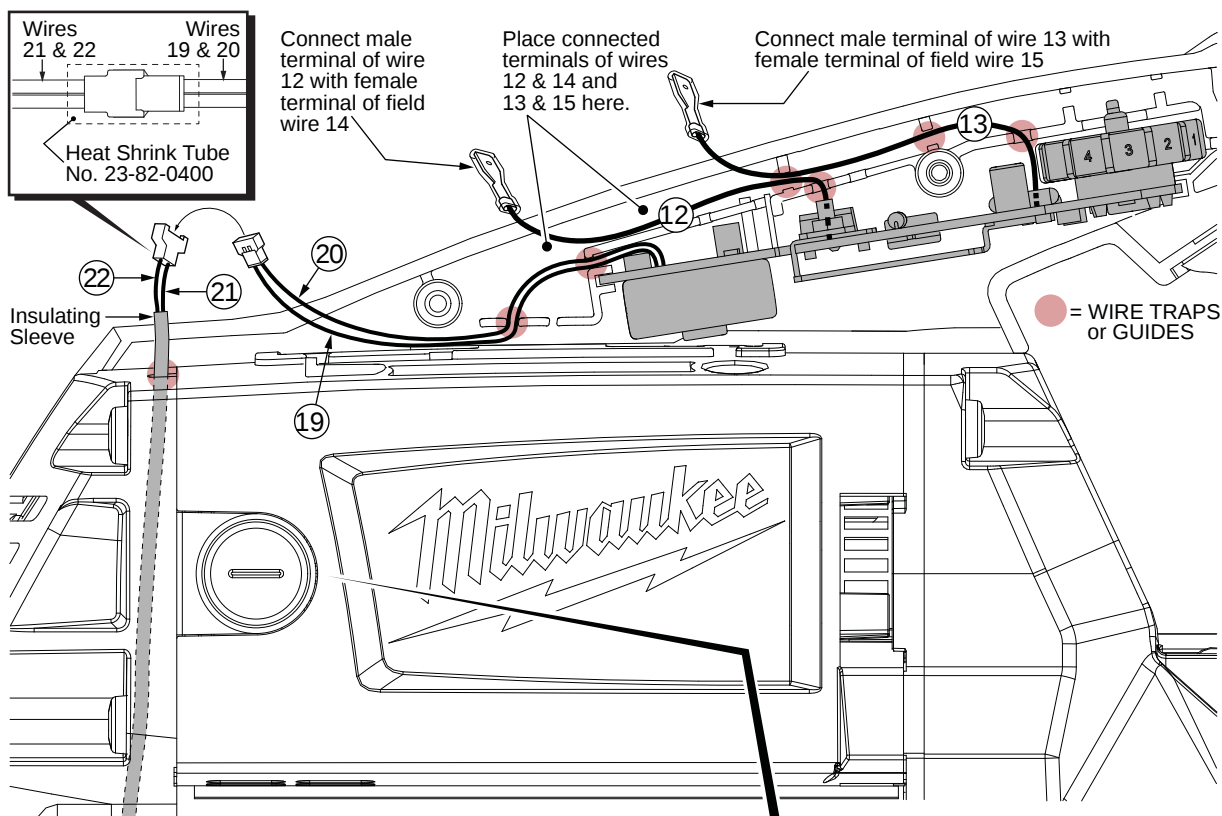
AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.



### WIRING SPECIFICATIONS

| Wire No. | Wire Color | Origin or Gauge | Length | Terminals, Connectors and 1 or 2 End Wire Preparation                                     |
|----------|------------|-----------------|--------|-------------------------------------------------------------------------------------------|
| 6        | Black      | 14-20-0105      | -----  | Component of the PCB Assembly. Solder to position '2' on LED switch.                      |
| 7        | White      | 14-20-0105      | -----  | Component of the PCB Assembly. Connect to position '1' at the on-off switch.              |
| 8        | Black      | 14-20-0105      | -----  | Component of the PCB Assembly. Connect to position '1' at the on-off switch.              |
| 17       | Black      | 14-20-0105      | -----  | Components of the PCB Assy. Wires 17 and 18 are joined together with a female connector.  |
| 18       | White      | 14-20-0105      | -----  | The female connector is to connect with the male terminal of sensor assembly 14-20-0195.  |
| 23       | Red        | 14-20-0195      | -----  | Components of the Sensor Assy. Wires 23 and 24 are joined together with a male connector. |
| 24       | White      | 14-20-0195      | -----  | The male connector is to connect with female terminal of wires 17 and 18.                 |
|          |            |                 |        |                                                                                           |
|          |            |                 |        |                                                                                           |
|          |            |                 |        |                                                                                           |



BACK VIEW (INSIDE) OF PULLEY SUPPORT

FRONT VIEW (BRUSH END) OF OUTSIDE MOTOR HOUSING

### WIRING SPECIFICATIONS

| Wire No. | Wire Color | Origin or Gauge | Length | Terminals, Connectors and 1 or 2 End Wire Preparation                                    |
|----------|------------|-----------------|--------|------------------------------------------------------------------------------------------|
| 12       | Blue       | 14-20-0105      | -----  | Component of PCB Assembly. Connect male terminal with female terminal of wire 14.        |
| 13       | Red        | 14-20-0105      | -----  | Component of PCB Assembly. Connect male terminal with female terminal of wire 15.        |
| 14       | Black      | 18-07-0025      | -----  | Component of the field. Connect female terminal to the male terminal of blue wire #12.   |
| 15       | Black      | 18-07-0025      | -----  | Component of the field. Connect female terminal to the male terminal of red wire #13.    |
| 19       | Black      | 14-20-0105      | -----  | Components of PCB Assembly. Wires 19 and 20 are joined together with a male terminal.    |
| 20       | White      | 14-20-0105      | -----  | Connect the male terminal to the female terminal of wires 21 and 22 of the LED assembly. |
| 21       | Black      | 14-20-0115      | -----  | Components of the LED assy. Wires 21 and 22 are joined together with a female terminal.  |
| 22       | White      | 14-20-0115      | -----  | Connect the female terminal to the male terminal of wires 19 and 20 of the PCB Assembly. |
| 26       | White      | 18-07-0025      | -----  | Component of the field. From top of field, connect to the right brush holder tab.        |
| 27       | White      | 18-07-0025      | -----  | Component of the field. From bottom of field, connect to the left brush holder tab.      |