



SERVICE PARTS LIST

BULLETIN NO.
54-40-6050

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

LEFT BLADE 7-1/4" CIRCLE SAW with TILT-LOK® HANDLE

CATALOG NO. 6391-21

**SERIAL
NUMBER**

189A

REVISED BULLETIN

DATE
Nov. 2008

WIRING INSTRUCTION
58-01-1330

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EXAMPLE:

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

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0847	Ball Bearing	(1)
2	02-04-1850	Ball Bearing	(1)
3	02-50-2423	Needle Bearing	(1)
4	05-78-0305	Switch Screw	(4)
5	45-22-0605	Lower Guard Sleeve	(1)
6	06-75-1010	Left Hand Blade Screw	(1)
7	06-75-5830	5/16 -18 Thread Bolt	(1)
8	06-75-2010	1/4-20 x 3/4" Left Hand Hex Hd. Screw	(1)
9	06-82-5314	10-24 x 1/2" Pan Hd. Taptite T-25	(14)
10	06-82-5358	12-24 x 3/4" Pan Hd. Taptite T-27	(3)
11	06-82-5474	10-24 x 1-3/4" Pan Hd. Taptite T-25	(1)
12	06-82-7270	8-16 x 5/8" Pan Hd. Sit. Plastite T-20	(10)
13	06-82-7395	8-16 x 1-3/4" Pan Hd. Plastite T-20	(2)
14	06-82-8875	5/8"-DG50 Thread Form Screw T-20	(3)
18	12-20-6391	Service Nameplate Kit	(1)
19	16-70-0075	Armature	(1)
20	18-70-1050	Field	(1)
21	22-18-0075	Brush Assembly	(2)
22	22-22-0030	Brush Tube Assembly	(2)
23	22-64-0100	Cord Assembly	(1)
24	23-66-2115	Switch	(1)
25	23-94-1180	Lead Assembly	(1)
26	23-94-1185	Lead Assembly	(1)
27	25-20-0140	Upper Guard Cover	(1)
28	14-67-0265	Bevel Bracket Assembly	(1)
29	28-14-0140	Gearcase	(1)
30	28-41-1045	Lower Guard	(1)
31	31-05-0045	Baffle	(1)
32	31-15-0500	Motor Cover	(1)
33	31-44-0151	Right Handle Half	(1)
34	31-44-0040	Front Handle	(1)
35	31-44-0161	Left Handle Half	(1)
36	31-44-2156	Handle Lever	(1)
37	31-50-0050	Motor Housing Assembly	(1)
38	31-52-0030	Depth Lever	(1)
39	31-52-0035	Guard Lever	(1)
40	32-75-3265	Gear	(1)
41	34-40-1375	O-Ring	(1)
42	34-40-1380	O-Ring	(1)
43	34-60-0320	External Retaining Ring	(1)
44	34-60-2330	Klip Ring	(1)
45	38-50-0070	Spindle	(1)
46	40-50-0045	Guard Spring	(1)
47	40-50-0055	Compression Spring	(1)
48	40-50-8040	Spring	(1)
49	42-16-0160	Handle Band	(1)
50	42-38-0222	Rubber Bumper	(1)
51	42-42-0225	Spindle Lock Button	(1)
52	43-34-0790	Inner Flange	(1)
53	43-34-0795	Outer Flange	(1)
54	43-78-0155	Hub (With Bearing)	(1)
55	44-10-0135	Bevel Adjustment Lever	(1)
56	44-20-0510	Spindle Lock Pin	(1)
57	44-40-0460	Adjustment Nut	(1)
58	44-52-0681	Grip	(1)
59	44-60-0075	Thru Pin	(1)
60	44-60-0085	Tapped Pin	(1)
61	44-60-1180	Pivot Pin	(1)
62	44-66-0125	Retaining Plate	(1)
64	44-66-0200	Lock Plate	(1)
65	44-72-0055	Pointer	(1)
66	45-04-0485	Bumper Screw	(1)
68	45-08-0420	Depth Shaft	(1)
69	45-16-0175	Shoe Assembly	(1)
70	45-88-0577	Wave Spring Washer	(2)
71	45-88-1545	Washer	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
72	45-88-8460	5/16" Washer	(1)
74	49-96-6205	Blade Wrench (Not Shown)	(1)
75	22-84-0085	Fan	(1)
	42-41-4115	7-1/4" Circle Saw Blade (Not Shown)	(1)
80	48-55-9166	Carrying Case	(1)

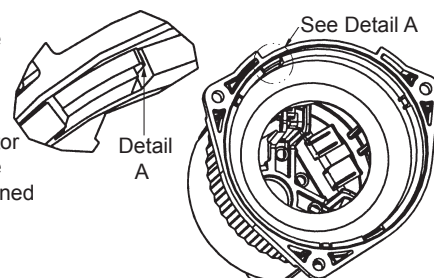
FIG. NOTE

- 1 Orient the ball bearing so that the seal faces the commutator.
- 3,29 Orient the needle bearing such that the text is facing the gear. Press the bearing .015" subflush to the gear cavity wall.
- 11 Tighten the handle lever screw such that it requires 3-7 lbs. force to close the handle lever to the locked position.
- 29 Apply .320 - .360 oz. "Y" Grease, No. 49-08-5270, to gear bore of upper guard gearcase. The grease should be directed toward the pinion end of the armature.

Note! Previous 63XX series Saws have used **TYPE "O"** (pink) or **TYPE "R"** (purple) **GREASE**. **TYPE "Y" GREASE** can be substituted for both TYPE "O" GREASE & TYPE "R" GREASE though, it requires complete removal of ALL TYPE "O" & TYPE "R" GREASE from the gearing and the gearcase.

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Orient the baffle with the crush ribs aligned with the screw holes in the motor housing and the locator tabs aligned and seated as shown.



- 30 Functionally check the lower guard with the saw set at full depth of cut and zero degree bevel. Place the saw upside down with the shoe horizontal. Retract the lower guard 100%. Release the lower guard lever. The guard should return in a brisk manner.
- 38 When tight, the depth adjustment lever should be parallel ($\pm 20^\circ$) with the shoe.
- 43 Orient the external retaining ring such that the beveled face is towards the guard.
- 55 When tight, the bevel adjustment lever should be bottomed out on the shoe. (Up to .100" off the shoe is acceptable).
- 28,65 Position the pointer such that the arrow indicates between the zero and one degree mark on the bevel plate scale. Loosen front handle screws to adjust pointer.
- 71 Orient the washer such that the rounded edge is towards the depth rail.
- 72 Orient the washer such that the rounded edge is towards the bevel plate.

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