



SERVICE PARTS LIST

PAGE 1 OF 6

BASE ASSEMBLY

BULLETIN NO.
54-40-6901

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

12" DUAL BEVEL COMPOUND MITER SAW

REVISED BULLETIN
54-40-6900

DATE
Sept. 2011

CATALOG NO.

6950-20

**SERIAL
NUMBER**

B27B

WIRING INSTRUCTION

58-01-6901

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EXAMPLE:

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

★ = Part number change from
previous service parts list.

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	02-80-0050	Thrust Bearing	(1)
2	05-80-0510	M5 x 12mm Flat Head T-20 Screw	(5)
3	05-81-0135	M5 x 13mm Pan Head T-25 Screw	(9)
4	05-81-0150	M8 x 25mm Pan Head T-45 Screw	(4)
★ 5	22-90-0260	Grommet	(1)
6	05-86-0640	M5 x 18mm Hex Socket Set Screw	(1)
7	05-86-0660	M12 x 1 x 18mm T-25 Socket Set Screw	(2)
8	05-89-0530	M5 x 13mm Pan Hd T-25 Shoulder Scr	(5)
9	10-20-9115	Fence Label	(2)
10	22-38-0175	Cable Clamp	(1)
11	23-45-0015	Potentiometer (Incl. Hex Nut & Star Washer)	(1)
12	28-06-1265	12" Compound Miter Base	(1)
13	28-35-0100	Fixed Fence	(1)
14	28-35-0110	Left Fence	(1)
15	28-35-0115	Right Fence	(1)
16	32-48-0121	Rack	(1)
17	40-50-8620	Belleville Spring	(4)
19	42-92-1130	Potentiometer Cover	(1)
20	43-82-0170	Miter Scale	(1)
21	43-98-0275	Lock Knob Bolt	(2)
22	44-34-0025	Miter Base Foot	(4)
23	44-52-0950	Handle Grip	(2)
24	44-66-0970	Potentiometer Plate	(1)
★ 25	49-96-0180	1/4" Hex / T-25 Blade Wrench	(1)
58	42-90-0130	Tolerance Ring	(1)
74	45-08-0455	Table Bolt	(1)

SERVICE NOTES:

Orient Thrust Bearing #1 with printed ID stripe up, facing away from Base #12.

When assembling the Fixed Fence #13 to the Base #12, secure the left most Screw #4 as illustrated, followed by the other three screws.

Moving Fence Adjustment: (Left Fence)

- Turn Set Screw #7 (located on left side of Fixed Fence #13) clockwise until Set Screw touches Moving Fence #14, then back off 1/8 to 1/4 turn.
- The Moving Fence #14 must be able to be rotated and slide past the Set Screw #6.
- Set Screw #6 must protrude past machined surface of Fixed Fence #13.

Removable Fence Adjustment: (Right Fence)

- Turn Set Screw #7 (located on right side of Fixed Fence #13) clockwise until Set Screw touches Removable Fence #15, then back off 1/8 to 1/4 turn.

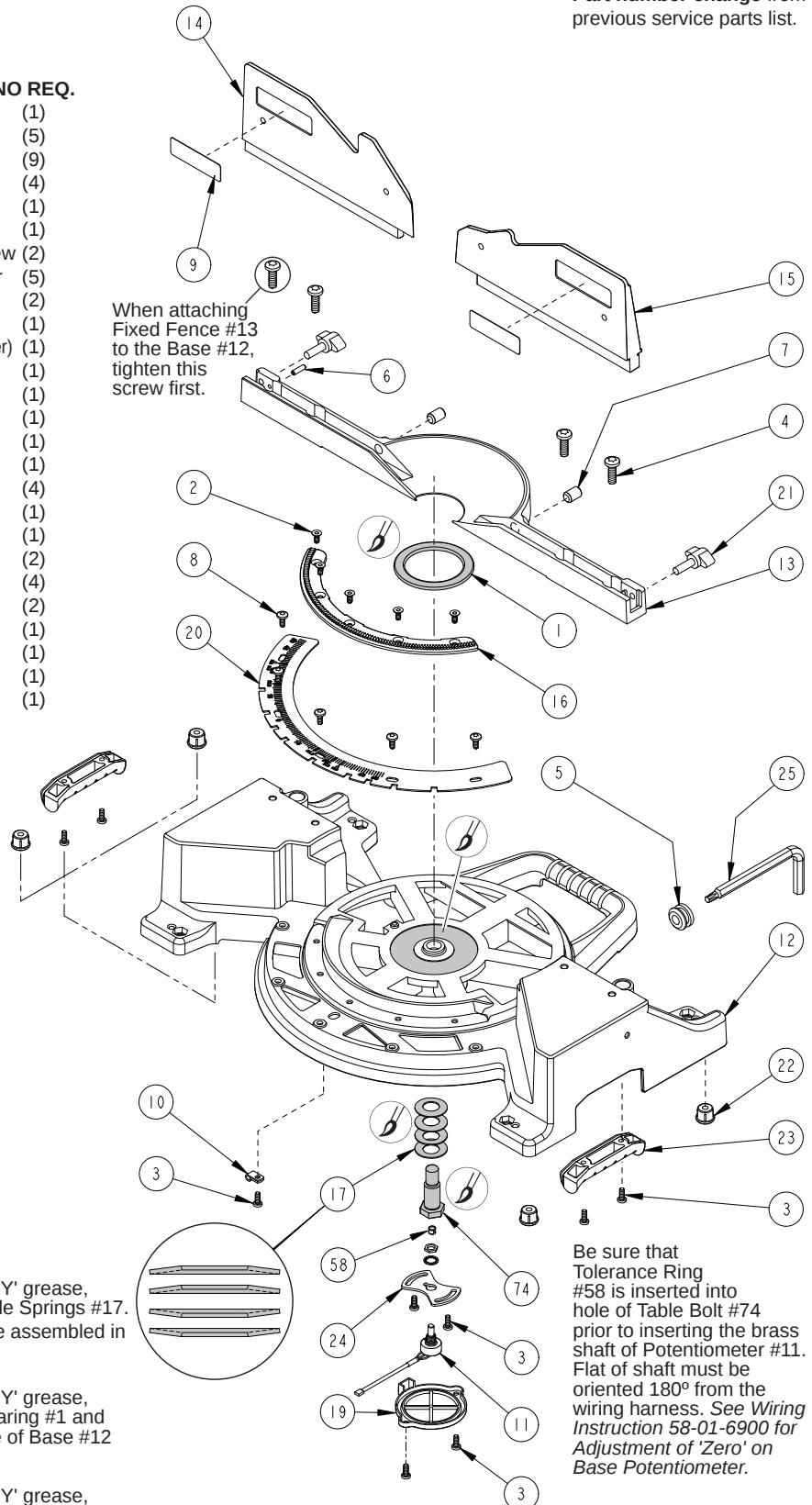


LUBRICATION NOTE

Place a light coat of Type 'Y' grease, No. 49-08-5270 to Belleville Springs #17. Belleville Springs are to be assembled in the order shown.

Place a light coat of Type 'Y' grease, to both sides of Thrust Bearing #1 and corresponding center bore of Base #12 as shown.

Place a light coat of Type 'Y' grease, on the shaft of Table Bolt #74 prior to inserting through hole in Base #12 and threading into hole on the bottom of Table #41 (shown on next page).



Be sure that Tolerance Ring #58 is inserted into hole of Table Bolt #74 prior to inserting the brass shaft of Potentiometer #11. Flat of shaft must be oriented 180° from the wiring harness. See Wiring Instruction 58-01-6900 for Adjustment of 'Zero' on Base Potentiometer.

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. LISBON RD., BROOKFIELD, WI 53005

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CATALOG NO.	6950-20	SERIAL NUMBER	B27B
		WIRING INSTRUCTION 58-01-6901	

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EXAMPLE:

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

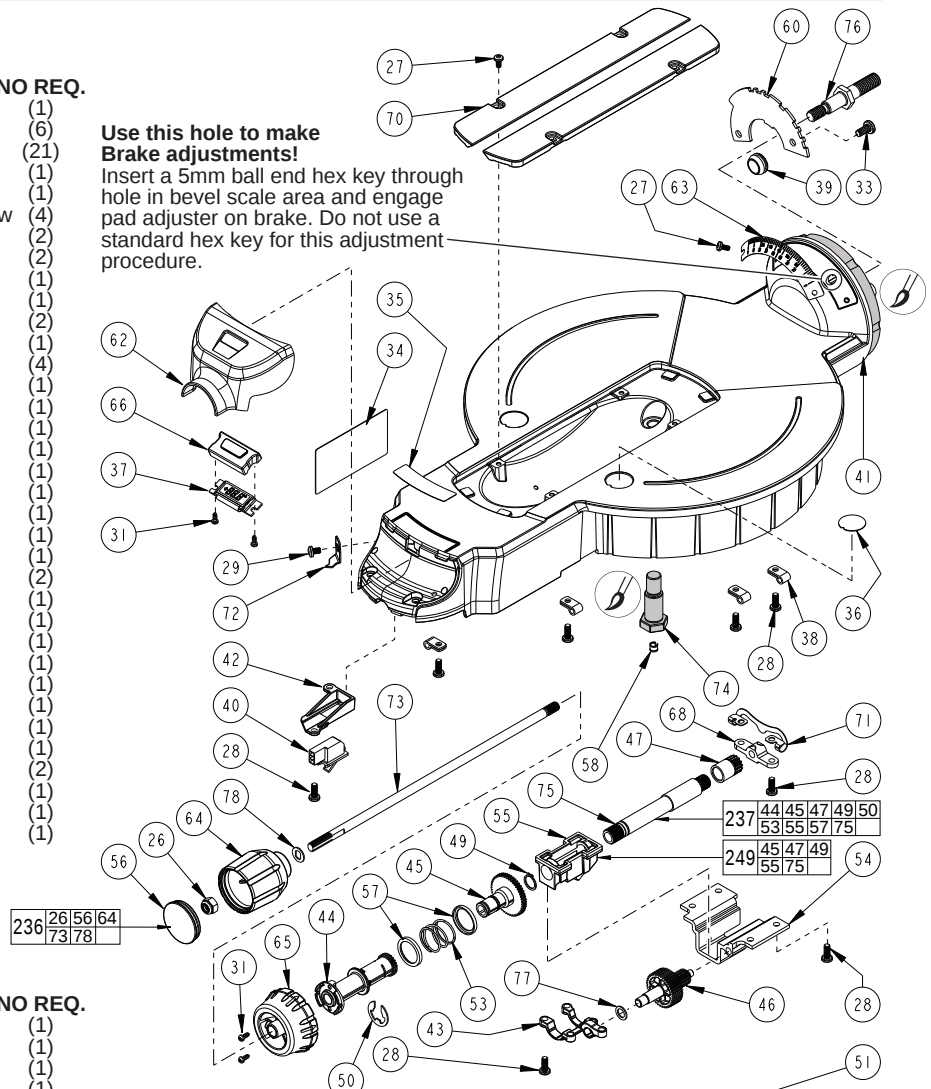
FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
26	05-55-0915	M8 Prevailing Torque Nut	(1)
27	05-81-0130	M4 x 8mm Pan Head T-20 Screw	(6)
28	05-81-0135	M5 x 13mm Pan Head T-25 Screw	(21)
29	05-81-0235	M5 x 7mm Pan Head T-25 Screw	(1)
30	06-86-0640	M5 x 18mm Set Screw	(1)
31	05-88-5910	M3.5 x 8mm Pan Hd Slit T-10 PT Screw	(4)
32	05-88-5988	K50 x 35mm Slit Pan Hd T-20 Screw	(2)
33	05-89-0535	K6 X 13mm Pan Head T-25 Screw	(2)
34	10-20-7900	Fine Adjustment Label	(1)
35	10-20-9125	Fine Adjustment Warning Label	(1)
36	10-20-9135	Round Label	(2)
37	22-09-1580	LCD Assembly	(1)
38	22-38-0175	Cable Clamp	(4)
39	22-90-0250	Grommet	(1)
40	23-66-0705	Calibration Switch	(1)
41	28-06-1240	Compound Miter Table	(1)
42	31-01-1580	Switch Mount (Miter)	(1)
43	31-12-0030	Bearing Cap	(1)
44	32-48-0115	Fine Adjustment Tube Gear	(1)
45	-----	Fine Adjustment Gear	(1)
46	32-48-0130	Reduction Gear	(1)
47	-----	Pinion Gear	(1)
48	34-60-0020	External Retaining Ring	(2)
49	-----	External Retaining Ring	(1)
50	34-60-1450	E-Ring	(1)
51	40-50-0390	Spring	(1)
52	40-50-0455	Miter Detent Spring	(1)
53	40-50-0460	Fine Adjustment Return Spring	(1)
54	-----	Fine Adjustment Chassis	(1)
55	-----	Slide Block	(1)
56	-----	Lock Handle Cap	(1)
57	42-52-1040	Spring Cap	(2)
58	42-90-0130	Tolerance Ring	(1)
59	42-92-1140	Cover (Detent Mech.)	(1)
60	43-06-0035	Brake Disk	(1)



LUBRICATION NOTES

Place a light coat of Type 'Y' grease, No. 49-08-5270 to Table Bolt #74.

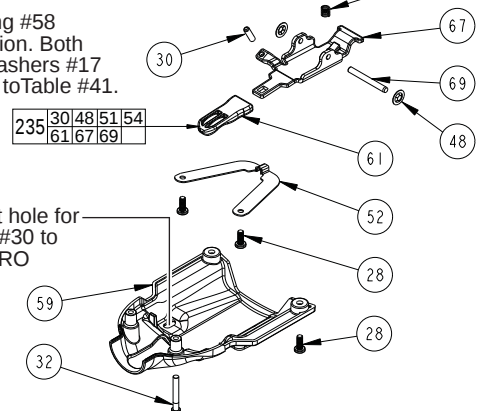
FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
61	43-62-1340	Detent Lever Handle	(1)
62	43-76-0740	LCD Cover	(1)
63	43-82-0160	Bevel Scale	(1)
64	-----	Table Lock Knob	(1)
65	43-98-0250	Fine Adjustment Knob	(1)
66	44-06-0030	LCD Lens Cover	(1)
67	44-10-0145	Detent Lever	(1)
68	44-40-0105	Lock Block	(1)
69	44-60-0495	Hinge Pin	(1)
70	14-46-1270	Service Kerf Plates (Set of 2)	(1)
71	44-66-1125	Miter Lock Plate	(1)
72	44-72-0061	Miter Pointer	(1)
73	-----	Handle Lock Rod	(1)
74	45-08-0455	Table Bolt	(1)
75	-----	Compound Pinion Tube	(1)
76	45-58-0125	Stud	(1)
78	45-88-3045	Washer	(1)
79	-----	Special Washer	(1)
235	14-48-0100	Chassis Assembly	(1)
236	14-48-0080	Table Lock Rod Assembly	(1)
237	14-48-0090	Fine Adjustment Assembly	(1)
238	28-06-1140	Table Assembly	(1)
249	14-48-0091	Slide Block Assembly	(1)



Use this hole to make Brake adjustments!
Insert a 5mm ball end hex key through hole in bevel scale area and engage pad adjuster on brake. Do not use a standard hex key for this adjustment — procedure.

Table Bolt #74 and Tolerance Ring #58 are shown for reference/orientation. Both parts must be routed through Washers #17 and Base #12 prior to assembly to Table #41.

Adjustment hole for
Set Screw #30 to
calibrate DRO
Switch #40



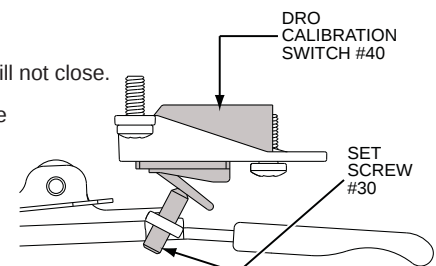
ADJUSTMENT OF Digital Readout (DRO) CALIBRATION SWITCH:

A. Turn the Calibration Set Screw #30 in (toward Switch #40) enough that the calibration switch contacts will not close.

B. With the Miter Detent Spring #52 out of the detent notch in the Miter Detent Scale #20, but resting on the Miter Scale, move the Table #41 about 1.5° to either side of the “0” position and return to the “0” notch.

C. Insert a 2.5mm hex key into Set Screw #30 and adjust by turning the screw out (clockwise when viewed from the operators position) until the digital read out changes from the set angle to "0". Turn Set Screw #30 an extra 1/4-1/2 turn out.

D. Remove 2.5mm adjustment hex key from Set Screw #30. See *Wiring Instruction* for more detail.





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PAGE 3 OF 6 BEVEL ARM ASSY.

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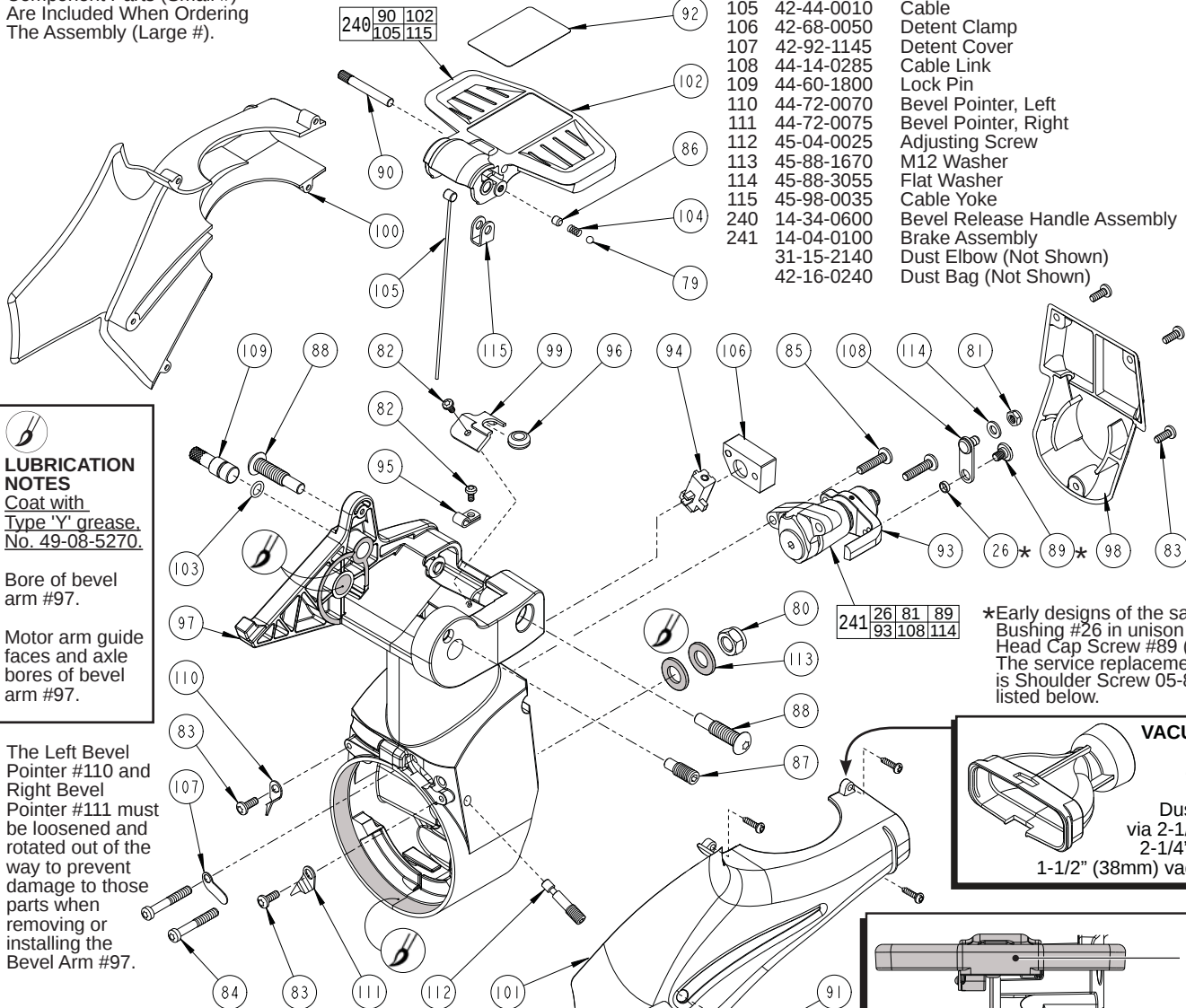
58-01-6901

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EXAMPLE:

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

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
105	42-44-0010	Cable	(1)
106	42-68-0050	Detent Clamp	(1)
107	42-92-1145	Detent Cover	(1)
108	44-14-0285	Cable Link	(1)
109	44-60-1800	Lock Pin	(1)
110	44-72-0070	Bevel Pointer, Left	(1)
111	44-72-0075	Bevel Pointer, Right	(1)
112	45-04-0025	Adjusting Screw	(1)
113	45-88-1670	M12 Washer	(2)
114	45-88-3055	Flat Washer	(1)
115	45-98-0035	Cable Yoke	(1)
240	14-34-0600	Bevel Release Handle Assembly	(1)
241	14-04-0100	Brake Assembly	(1)
	31-15-2140	Dust Elbow (Not Shown)	(1)
	42-16-0240	Dust Bag (Not Shown)	(1)



**LUBRICATION
NOTES**
Coat with
Type 'Y' grease.
No. 49-08-5270.

Bore of bevel
arm #97.

Motor arm guide
faces and axle
bores of bevel
arm #97.

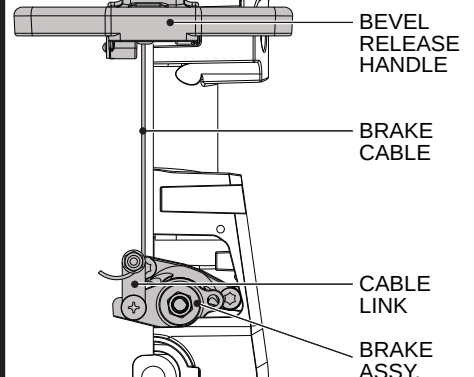
The Left Bevel
Pointer #110 and
Right Bevel
Pointer #111 must
be loosened and
rotated out of the
way to prevent
damage to those
parts when
removing or
installing the
Bevel Arm #97.

*Early designs of the saw utilized a
Bushings #26 in unison with a Button
Head Cap Screw #89 (05-73-0155).
The service replacement for either is
Shoulder Screw 05-89-0540,
listed below.

VACUUM HOSE ADAPTER 48-03-0200

Dust collection
via 2-1/2" (64mm),
2-1/4" (58mm) or
1-1/2" (38mm) vacuum hose.

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
26	42-40-0945	Bushing	(1)
79	02-02-1300	5mm Ball	(1)
80	05-55-0970	M12 Prevailing Torque Nut	(1)
81	05-55-0965	M6 Prevailing Torque Nut	(1)
82	05-81-0130	M4 x 8mm Pan Head T-20 Screw	(2)
83	05-81-0135	M5 x 13mm Pan Head T-25 Screw	(5)
84	05-81-0140	M6 x 40mm Pan Head T-25 Screw	(2)
85	05-81-0145	M6 x 25mm Pan Head T-30 Screw	(2)
86	05-86-0655	M6 x 1 x 6mm Hex Socket Set Screw	(1)
87	05-89-0520	M10 x 1.5mm Hex Socket Stop Screw	(1)
88	05-89-0525	M10 x 1.5 x 44mm T-45 Pivot Screw	(2)
89	05-89-0540	8 x 2.5mm Phillips Pan Hd Shoulder Scr	(1)
90	06-65-0530	Dowel Pin	(1)
91	06-82-9220	K40 x 5/8" Pan Hd Slotted T-20 Screw	(8)
92	10-20-9100	Bevel Lock Label	(1)
93	-----	Caliper	(1)
94	14-48-0075	Detent Assembly	(1)
95	22-38-0175	Cable Clamp	(1)
96	22-90-0245	Grommet	(1)
97	28-04-0400	Bevel Arm	(1)
98	31-15-1510	Back Cover	(1)
99	31-15-1520	Bevel Top Cover	(1)
100	31-15-2145	Dust Chute, Left	(1)
101	31-15-2150	Dust Chute, Right	(1)
102	31-44-2320	Bevel Release Handle	(1)
103	34-40-0250	O-Ring	(1)
104	40-50-3940	Spring	(1)



This view is shown
for reference purpose only.
DO NOT attempt to disassemble
Bevel Arm #97.

SEE NEXT PAGE FOR SPECIAL
INSTRUCTIONS FOR THE ADJUSTMENT
OF THE BRAKE CABLE AND THE
STATIONARY BRAKE PAD

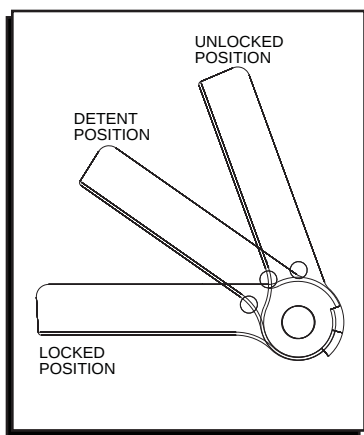


SERVICE PARTS LIST

4 OF 6 BEVEL ARM ASSY. CONT.

BULLETIN NO.
54-40-6901

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS			REVISED BULLETIN	DATE
12" DUAL BEVEL COMPOUND MITER SAW			54-40-6900	Sept. 2011
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		B27B		



Brake Release Handle #102

Brake Cable #105

5mm Ball #79

Spring #104

Set Screw #86

Cable Link #108

NOTE: Exercise caution when relieving pressure on the Brake Release Handle. 5mm Ball is under spring pressure.

This view is shown for reference purpose only. DO NOT attempt to disassemble Bevel Arm #97. See next page for exploded view illustration of components in the Bevel Arm Assembly.

Brake Lever

Brake Assembly #241

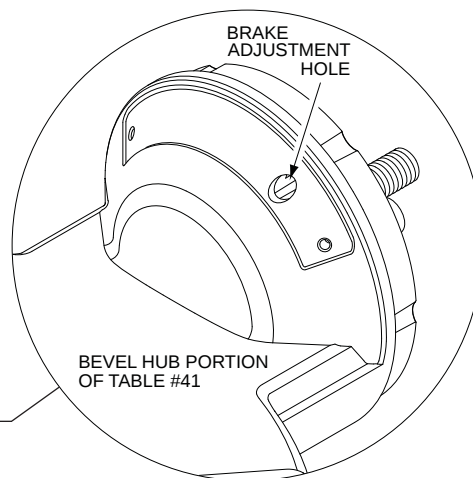
1. ADJUSTMENT OF BRAKE CABLE:

(Reference last page for Bevel Arm Assembly)

- Start with Bevel Release Handle #102, Brake Cable #105, Bevel Brake #241 and Cable Link #108 assembled in Bevel Arm #97. Cable inserted into Cable Link but not tightened.
- Move Bevel Release Handle to detent position.
- Move and hold brake release lever in position by use of a gage block.
 - For Compound model 6950-20 use special service fixture No. 61-10-0090.
- Pull Cable taught using needle nose pliers.
- Tighten Cable Locking Nut #81 to 45-50 in./lb.
- Lift Bevel Release Handle to release support of brake lever.
- Move Bevel Release Handle to locked position.

2. ADJUSTMENT OF STATIONARY BRAKE PAD IN BEVEL ARM:

- Remove Dust Chutes #100 and #101. Release Bevel Brake.
- Move Bevel Arm #97 to right side hard stop.
- Block Bevel Release Handle to hold Brake in the released position.
 - For Compound model 6950-20 use special service fixture No. 61-10-0280.
- Remove Bevel Scale Mounting Screw #27 on right side of Bevel Scale #63, loosen Scale Mounting Screw on left side of Scale and remove Bevel Scale.
- Insert a 5mm ball end hex key through right hole in bevel scale area at the rear of the Table (see illustration) and engage pad adjuster on Brake. Do not use a standard hex key for this adjustment procedure.
- Turn pad adjuster to the right until it stops against the Disk #60.
- Turn pad adjuster to the left 1/8 turn.
- Remove hex key from brake adjuster.
- Reassemble Bevel Scale and Dust Chutes to saw.





SERVICE PARTS LIST

PAGE 5 OF 6 MOTOR ASSEMBLY

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58-01-6901

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EXAMPLE:

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

★ = Part number change from
previous service parts list.

SERVICE NOTES:

Replacement of LED PCBA #172
must be done by removing Lens #218.

SERVICE NOTE:

O-Rings #197 fit in
recesses of Motor Housing
Halves #186 and #187.

Coat inside
#208 with
Type 'U' Grease,
No. 49-08-0150

LUBRICATION NOTES

Complete lubrication of the Gearcase #177 can be achieved by removing black Plug #189 from the front of the Motor Arm Assembly #242 and inserting the tip of a large syringe firmly into the plug opening and injecting 1-1/8 oz. Type 'Z' Grease, No. 49-08-7655 into Gearcase. See the next page for Motor Arm Assembly components.

Use Special Service Tool
No. 61-10-0105 to reset
DRO Board #164. Insert pin into small square hole located in Motor
Case Cover #188. See Wiring Instruction for more detail.

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
137	02-04-0100	Ball Bearing	(1)
138	02-04-0852	Ball Bearing	(1)
139	02-04-1212	Ball Bearing	(1)
141	02-08-0510	Ball Bearing	(2)
★142	02-50-2155	Needle Bearing	(1)
145	05-73-0155	M6 x 13 Pan Head T-27 Screw	(4)
149	05-81-0130	M4 x 8 Pan Head T-20 Screw	(6)
150	05-81-0135	M5 x 13 Pan Head T-25 Screw	(8)
152	05-81-0155	M5 x 16 Pan Head T-25 Screw	(4)
★154	05-88-5910	M3.5 x 1.57 x 8mm Pan Hd T-10 Screw	(2)
157	06-82-9220	K40 x 5/8" Slotted T-20 PT Screw	(2)
158	06-95-6290	M5 x 2.24 x 18 Slotted T-20 PT Screw	(9)
162	16-70-5010	Service Armature Assembly	(1)
163	18-70-5000	Service Field	(1)
164	22-09-1060	DRO Board	(1)
165	22-09-1590	120V Motor Control	(1)
166	14-46-1260	Brush Set (Set of 2)	(1)
167	-----	Brush Holder	(2)
168	-----	Brush Tube	(2)
170	22-56-0470	Terminal Block	(1)
171	22-64-6495	120V Cord Set	(1)
★172	14-20-6955	LED PCBA	(1)
175	23-80-0020	Speed Control Sensor	(1)
177	-----	Gear Case	(1)
183	31-17-0155	Cord Clamp	(1)
186	-----	Motor Housing - Left	(1)
187	-----	Motor Housing - Right	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
188	31-50-2210	Motor Case Cover	(1)
190	31-55-0035	Lower Tray	(1)
191	31-55-0040	Upper Tray	(1)
194	-----	Bevel Gear	(1)
195	32-60-0081	Bevel Pinion Shaft	(1)
197	34-40-0260	O-Ring	(4)
199	-----	Pinion Gear	(1)
201	40-50-0390	Spring	(1)
207	42-76-0540	Speed Control Collar	(1)
208	42-90-0095	Coupling	(1)
209	42-96-0080	Bearing Cup	(1)
212	43-44-0055	Gasket	(1)
218	44-06-0115	Lens	(1)
221	44-60-0705	Spindle Lock Pin	(1)
223	44-66-0950	Bearing Plate	(1)
224	44-66-0955	Bearing Plate	(1)
225	44-76-0210	Cord Protector	(1)
★226	44-79-0041	LED Light Reflector	(1)
230	45-36-2010	Spacer	(1)
243	14-29-0240	Bevel Pinion Shaft Assembly	(1)
244	14-29-0250	Gear Service Assembly	(1)
246	22-20-0980	Brush Holder Assembly	(2)
247	14-30-0910	Gear Case Service Assembly	(1)
248	31-50-2206	Motor Housing Assembly	(1)
★250	45-88-3065	Washer	(2)



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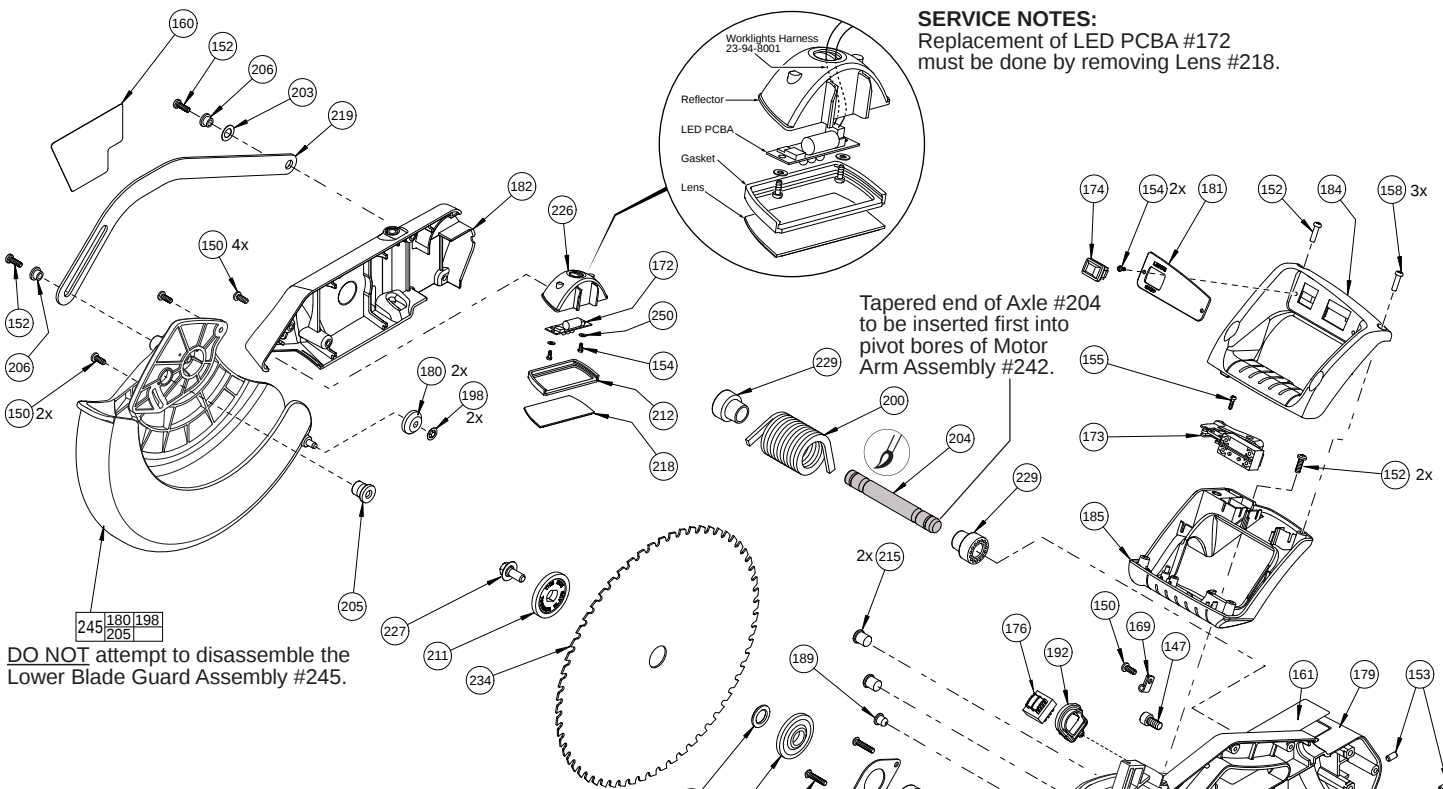
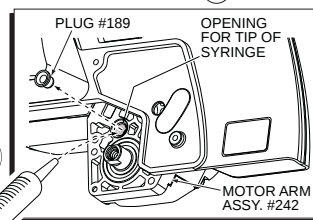


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
140	02-04-1700	Ball Bearing	(1)
143	-----	Needle Bearing	(1)
146	05-73-0160	M5 x 25 Button Head T-25 Screw	(2)
147	05-74-0050	M8 x 16 Socket Head Cap Screw	(1)
★148	05-80-0500	K40 x 12mm Flat Head T-20 PT Screw	(1)
150	05-81-0135	M5 x 13 Pan Head T-25 Screw	(7)
152	05-81-0155	M5 x 16 Pan Head T-25 Screw	(5)
153	05-86-0645	M6 Set Screw	(2)
★154	05-88-5910	M3.5 x 1.57 x 8mm Pan Hd T-10 Screw	(4)
155	05-88-5915	M3.5 x 1.57 x 12mm Pan Hd T-10 Screw	(1)
158	06-95-6290	M5 x 2.24 x 18 Slotted T-20 PT Screw	(3)
159	10-20-9105	Guard Plate Label	(1)
160	10-20-9110	Arm Warning Label	(1)
161	12-20-0095	Service Nameplate	(1)
169	22-38-0175	Cable Clamp	(1)
★172	14-20-6955	LED PCBA	(1)
173	23-66-3035	Switch	(1)
174	23-66-3040	Rocker Switch	(1)
★176	23-81-0585	LED Lighting Transformer	(1)
178	-----	Upper Guard	(1)
179	-----	Motor Arm	(1)
180	31-01-2500	Lower Guard Wheel	(2)
181	31-15-2120	Handle Cover	(1)
182	31-15-2160	Transformer Cover	(1)
184	31-44-2325	Top Handle	(1)
185	31-44-2330	Bottom Handle	(1)
189	31-53-0235	Plug	(1)
★192	31-55-0401	Transformer Shield	(1)
196	32-75-0080	Spindle Gear	(1)
198	34-60-0020	External Retaining Ring	(2)
200	40-50-0385	Torsion Spring	(1)
203	40-50-3945	Spring washer	(1)
204	42-12-0045	Axle	(1)
205	42-38-0390	Bumper	(1)
206	42-40-0935	Bushing	(2)
210	43-34-0865	Inner Blade Flange	(1)
211	43-34-0870	Outer Blade Flange	(1)
212	43-44-0055	Gasket	(1)
215	43-56-0825	Blade Deflector	(2)
216	43-56-0830	Chip Deflector	(1)
218	44-06-0115	Lens	(1)



LUBRICATION NOTES

Complete lubrication of Gearcase #177 (see previous page) can be achieved by removing black Plug #189 from the front of the Motor Arm Assembly #242 and inserting the tip of a large syringe firmly into the plug opening and injecting 1-1/8 oz. Type 'Z' Grease, No. 49-08-7655 into Gearcase.

LUBRICATION NOTES

Fill outer grooves and coat surface of Axle #204 with Type 'Y' Grease, No. 49-08-5270.

Coat pivot bores of Motor Arm Assembly #242 with Type 'Y' Grease.

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
219	44-14-0280	Guard Link	(1)
222	44-66-0945	Bearing Plate	(1)
★226	44-79-0041	LED Light Reflector	(1)
227	45-04-0925	Blade Screw	(1)
229	45-36-1640	Spring Support Bushing	(2)
233	45-36-2025	Blade Spacer	(1)
234	42-41-4550	12" Miter Saw Blade	(1)
242	14-38-0690	Motor Arm Assembly	(1)
245	14-32-0205	Lower Blade Guard Assembly	(1)
★250	45-88-3065	Washer	(2)