SERVICE PARTS LIST

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

REVISED BULLETIN 54-40-7592

DATE Feb. 2017

WIRING INSTRUCTION 58-01-0056

CATALOG NO.

6520-21

STARTING SERIAL NO.

B02D

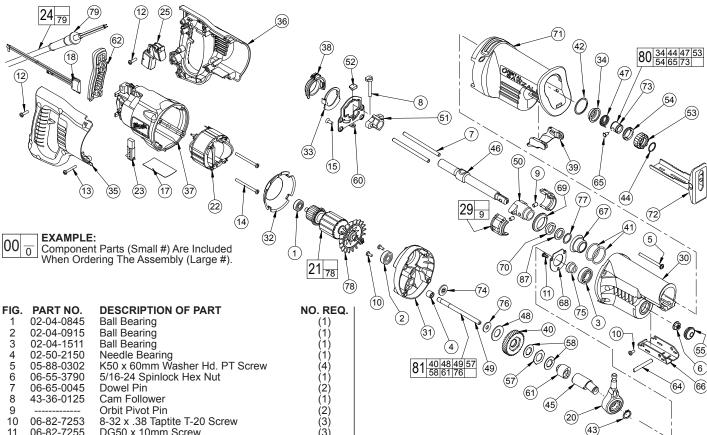


FIG.	PART NO.	DESCRIPTION OF PART	NO. REC
1	02-04-0845	Ball Bearing	(1)
2	02-04-0915	Ball Bearing	(1)
3	02-04-1511	Ball Bearing	(1)
4	02-50-2150	Needle Bearing	(1)
5	05-88-0302	K50 x 60mm Washer Hd. PT Screw	(4)
6	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
7	06-65-0045	Dowel Pin	(2)
8	43-36-0125	Cam Follower	$(\overline{1})$
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	14-20-3151	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	23-66-0205	Switch	(1)
29	14-30-0080	Orbit Pocket Assembly	(2)
30	28-14-2600	Gearcase	$(\overline{1})$
31	28-28-2600	Diaphragm	(1)
32	31-05-0155	Baffle	(1)
33	31-11-0130	Orbital Cam Plate	(1)
34			
± 35	21 44 2505	Spring Cover	(1)
	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	42-30-0055	Front Cam	(1)
53 54		Rear Cam	
			(1)
55 57	42-52-0380		(1)
57	43-06-0676	Bronze Plate	(1)

60 * 61 62 64 65 66 67 68 69 70 71 72 73 74 75 76 77 78 80	43-06-0685 43-56-0620 43-78-0577 44-52-0105 44-60-1635 	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 Felt Seal	NO. REQ. (2) (1) (1) (1) (1) (1) (1) (1) (1) (1) (1

SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES

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

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 s	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) 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.	rear spindle bushing (51) dowel pin (7) reciprocating
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).	bushing (50)
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 LARGE

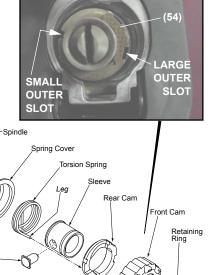
REMOVING THE STEEL QUIK-LOK® BLADE CLAMP -

- Remove external retaining ring (44) and pull front cam (53) off.
- Pull lock pin (65) out and remove remainder of parts and discard.

REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP

- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.

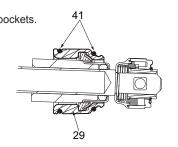
- Place spring cover (34) onto spindle.
- Slide torsion spring (47) onto spindle shaft with leg positioned at the 6:00 position.
- Slide sleeve (73) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (54) over sleeve, aligning hole in rear cam with spring leg. Ensure spring leg inserts into hole in rear cam.
- Rotate rear cam (54) counter clockwise until there is clearance for lock pin (65) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (53) inner ribs with rear cam outer slots (see insert) and slide front 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 remainder of ring into groove. Ensure ring is seated in groove.
- 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, follow these instructions to remove, clean and reassemble blade clamp.



INNER

(53)

FIG.	LUBRICATION:
110.	ESSIGNATION.
29,41	Lightly coat o-rings with lubrication for ease of installation onto assembled orbit po
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.
87	Soak in lightweight bushing oil prior to assembly.



Lock Pin-

INNER

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