

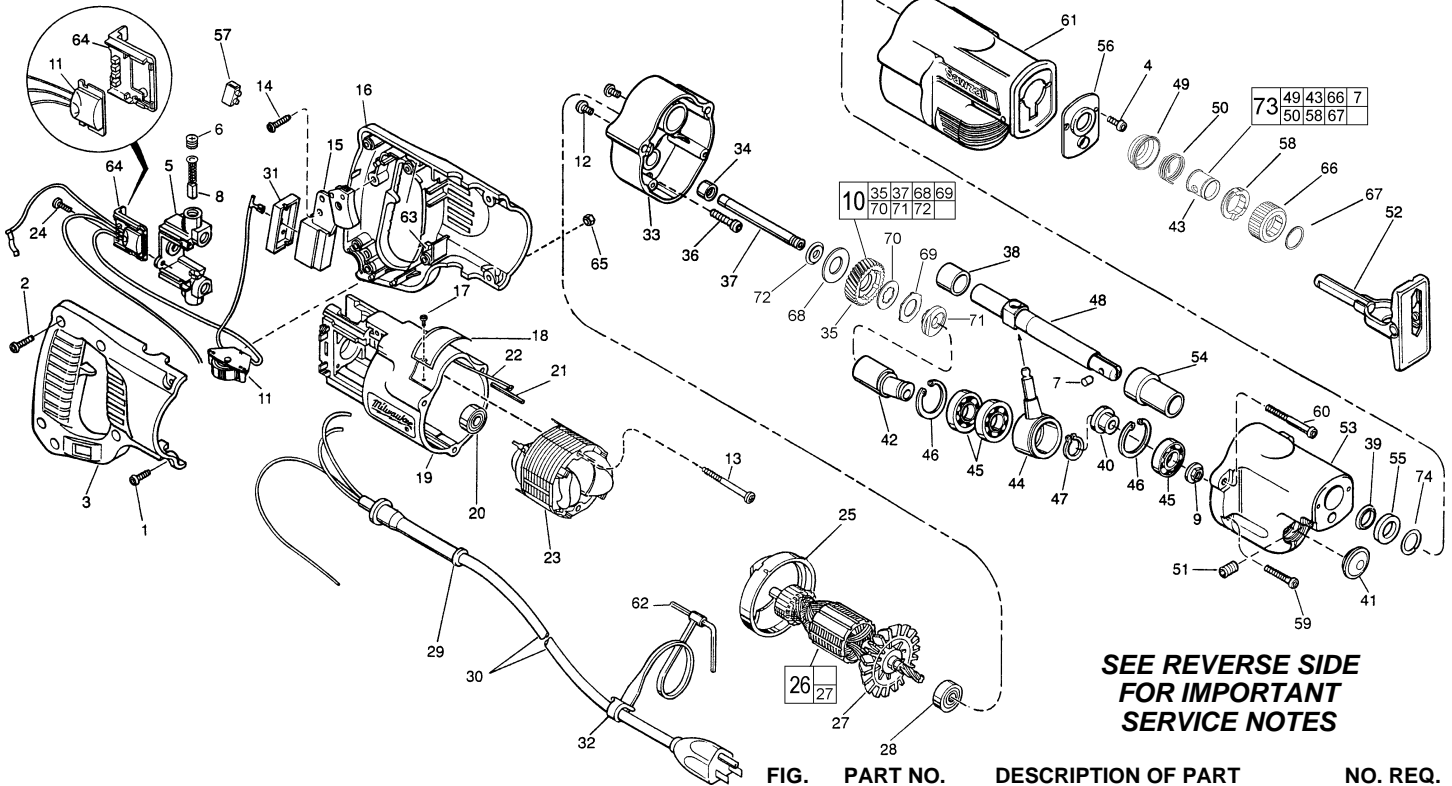


# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-40-0731**

<b>SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS</b>		REVISED BULLETIN 54-40-0730	DATE Feb.'99
<b>SAWZALL PLUS®</b>			
<b>CATALOG NO.</b>	<b>6518</b>	<b>STARTING SERIAL NO.</b>	<b>859G</b>
		WIRING INSTRUCTION <b>58-01-0781</b>	

**EXAMPLE:**  
00/0 Component Parts (Small #) Are Included  
When Ordering The Assembly (Large #).



**SEE REVERSE SIDE  
FOR IMPORTANT  
SERVICE NOTES**

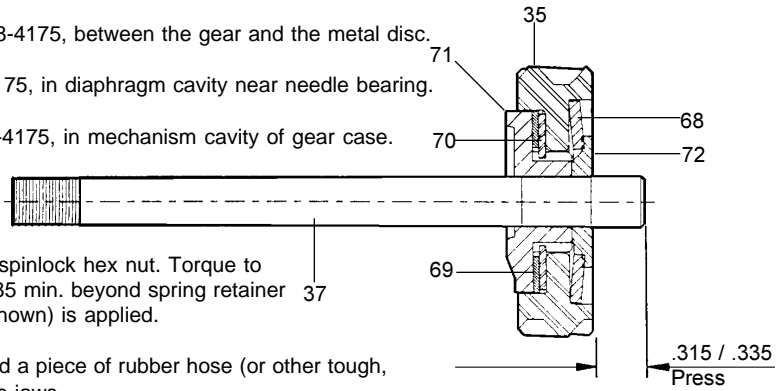
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-82-2390	8-32 x 1-1/4" Slotted Pan Hd. T-20	(2)
2	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(5)
3	31-44-1651	Right Handle Half	(1)
★4	06-95-0080	6-32 x 1/2" Truss Hd. Taptite T-10	(2)
5	22-22-1380	Brush Holder Assembly	(1)
6	23-44-0190	Brush Retaining Cap	(2)
★7	44-60-0626	Lock Pin	(1)
8	22-18-0910	Carbon Brush Assembly	(2)
9	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
10	32-40-2310	IPS Gear Assembly	(1)
11	14-20-3020	Dial Assembly	(1)
12	06-82-7252	8-32 x 3/8" Pan Hd. Taptite T-20	(2)
13	06-82-7410	8-16 x 1-7/8" Pan Hd. Slit. Plastite T-20	(2)
14	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(1)
15	23-66-1490	Switch	(1)
16	31-44-1656	Left Handle Half	(1)
17	06-72-1720	Nameplate Rivet	(2)
18	12-99-1735	Service Nameplate	(1)
19	31-50-0020	Motor Housing	(1)
20	02-04-0845	Ball Bearing	(1)
21	44-60-0530	Ground Pin	(1)
22	23-94-6100	Ground Wire Assembly	(1)
23	18-31-0600	120 V. Field	(1)
24	06-82-7240	6-19 x 1/2" Pan Hd. Slot. Plastite T-15	(2)
25	31-05-0055	Baffle	(1)
26	16-30-0560	120 V. Armature	(1)
27	22-84-0531	Fan Assembly	(1)
28	02-04-0911	Ball Bearing	(1)
29	44-76-0210	Cord Protector	(1)
30	22-64-3190	Cord Set	(1)
31	45-12-0470	Dust Shield	(1)
32	48-66-4080	Key Holder	(1)
33	28-28-2080	Diaphragm	(1)
34	02-50-2150	Needle Bearing	(1)
35	32-40-2095	Gear	(1)
36	05-88-8307	K50 x 22mm Pan Hd. PT T-20	(1)
37	42-12-0180	Axle-Wobble Shaft	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
38	42-24-0620	Rear Spindle Bearing	(1)
39	45-06-0475	Poly-Pak Seal	(1)
40	45-36-1450	Spacer	(1)
41	42-52-0380	Bearing Cap	(1)
42	36-92-0750	Wobble Shaft	(1)
★43	45-22-0081	Sleeve	(1)
44	30-72-0111	Wobble Plate	(1)
45	02-04-1510	Ball Bearing	(3)
46	34-80-2600	Internal Retaining Ring	(2)
47	34-60-1315	External Retaining Ring	(1)
48	38-50-6005	Reciprocating Spindle	(1)
★49	31-15-0511	Spring Cover	(1)
★50	40-50-0161	Torsion Spring	(1)
51	06-83-3150	5/16-18 x 1/2" Hex Socket Hd. Set Screw	(1)
52	45-16-0615	Pivot Shoe Assembly	(1)
53	28-14-2180	Gear Case	(1)
54	42-24-0615	Forward Spindle Bearing	(1)
55	45-06-0500	Felt Seal	(1)
56	44-86-0615	Seal Retainer	(1)
57	22-56-0456	Terminal Block	(1)
★58	42-50-0077	Rear Cam	(1)
59	06-82-5346	8-32 x 3/4" Pan Hd. Taptite T-20	(2)
60	05-88-8301	K50 x 60mm Pan Hd. PT T-20	(2)
61	45-12-0510	Gear Case Insulator	(1)
62	49-96-0070	5/32" Hex Key	(1)
63	14-46-1001	Foam Slug Kit (10 Slugs)	(2)
64	43-72-0176	Heat Sink Holder	(1)
65	06-55-0835	8-32 Hex Nut	(2)
★66	42-50-0076	Front Cam	(1)
★67	34-60-3680	External Retaining Ring	(1)
68	40-50-8850	Disc Spring	(1)
69	43-06-0675	Bronze Disc	(1)
70	43-06-0685	Metal Disc	(1)
71	43-78-0525	Drive Hub	(1)
72	43-78-0530	Spring Retainer	(1)
★73	14-46-1011	Steel Quik-Lok Blade Clamp Kit	(1)
★74	45-88-8577	Washer	(1)

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

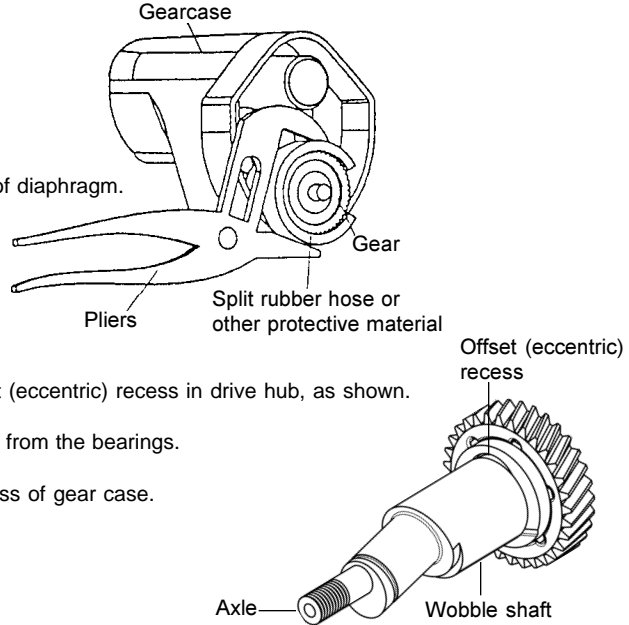
**FIG. LUBRICATION**

- 35,70 Apply a thin coat of type "L" grease, No. 49-08-4175, between the gear and the metal disc.
- 33 Place 3/4 oz. of type "L" grease, No. 49-08-4175, in diaphragm cavity near needle bearing.
- 53 Place 2-3/4 oz. of type "L" grease, No. 49-08-4175, in mechanism cavity of gear case.
- 55 Saturate with lightweight oil before assembly.



**FIG. NOTES**

- 9,37,72 Apply thread locking compound to threads of spinlock hex nut. Torque to 145in./lbs.-185 in./lbs. Axle Should extend .285 min. beyond spring retainer after seating torque to spinlock hex nut (not shown) is applied.
- 9,35 Hold the 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.
- 20 Seal side faces commutator.
- 20,28,45 Press bearings to shaft shoulders.
- 33,38 Press rear spindle bearing flush to .030 below bearing boss of diaphragm.
- 34 Press bearing flush ( $\pm .005$ ) to diaphragm surface.
- 35,37 See sketch for press specifications.
- 39 O-ring of seal towards rear of tool.
- 42,71 Make sure that the end of the wobble shaft fits into the offset (eccentric) recess in drive hub, as shown.
- 45,46 Retaining rings are to be installed with the beveled side away from the bearings.
- 53,54 Press forward spindle bearing flush to .030 below bearing boss of gear case.
- 68 Concave towards gear.
- 69 Tabs engage gear.
- 70 Tabs engage drive hub.



**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

- Remove external retaining ring (67) and pull front cam (66) off.
- Pull lock pin (7) 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 (49) onto spindle.
- Slide torsion spring (50) onto spindle with spring leg on hole side of spindle.
- Slide sleeve (43) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (58) over sleeve until it bottoms on sleeve shoulder, ensure spring leg inserts into hole in rear cam.
- Rotate rear cam in the direction of the arrows located on spring cover until there is clearance for lock pin (7) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (66) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring (67) 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.

