

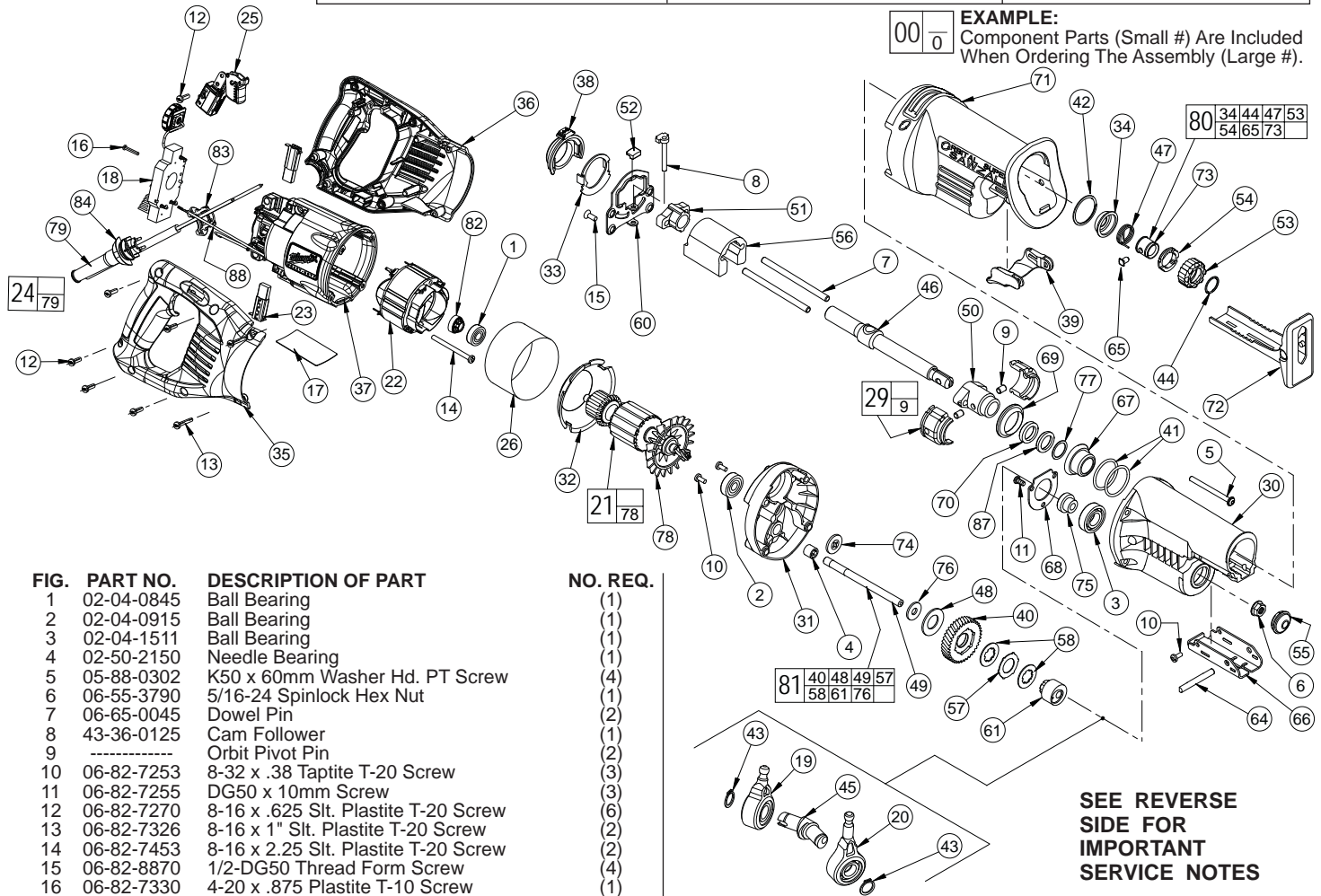


SERVICE PARTS LIST

BULLETIN NO.
54-40-7571

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
1-1/4" STROKE SAWZALL®		54-40-7570	Oct. 2013
CATALOG NO.	6538-21	WIRING INSTRUCTION See Page 3	
STARTING SERIAL NO.	B36A		

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



**SEE REVERSE
SIDE FOR
IMPORTANT
SERVICE NOTES**

FIG.	PART NO.	DESCRIPTION OF PART
1	02-04-0845	Ball Bearing
2	02-04-0915	Ball Bearing
3	02-04-1511	Ball Bearing
4	02-50-2150	Needle Bearing
5	05-88-0302	K50 x 60mm Washer Hd. PT Screw
6	06-55-3790	5/16-24 Spinlock Hex Nut
7	06-65-0045	Dowel Pin
8	43-36-0125	Cam Follower
9	-----	Orbit Pivot Pin
10	06-82-7253	8-32 x .38 Taptite T-20 Screw
11	06-82-7255	DG50 x 10mm Screw
12	06-82-7270	8-16 x .625 Slit. Plastite T-20 Screw
13	06-82-7326	8-16 x 1" Slit. Plastite T-20 Screw
14	06-82-7453	8-16 x 2.25 Slit. Plastite T-20 Screw
15	06-82-8870	1/2-DG50 Thread Form Screw
16	06-82-7330	4-20 x .875 Plastite T-10 Screw
17	12-99-2576	Service Nameplate
★18	14-20-1115	Remote Electronics Assembly
19	14-67-0126	Secondary Wobble Plate Assembly
20	14-67-0136	Primary Wobble Plate Assembly
21	16-30-0705	Service Armature
22	18-31-0220	Service Field
23	22-20-0535	Carbon Brush Assembly
24	22-64-0595	Cord Assembly
25	23-66-2490	Switch
26	23-16-0045	Cardboard Tube
29	14-30-0080	Orbit Pocket Assembly
30	28-14-2600	Gearcase
31	28-28-2600	Diaphragm
32	31-05-0155	Baffle
33	31-11-0130	Orbital Cam Plate
34	31-15-0170	Spring Cover
35	31-44-2090	Handle Half - Right
36	31-44-2095	Handle Half - Left
37	31-50-1990	Motor Housing
38	31-52-0045	Orbit Shift Lever
39	31-52-0090	Shoe Release Lever
40	32-40-2050	Intermediate Gear
41	34-40-0040	O-Ring
42	34-60-0125	Retaining Ring
43	34-60-1315	External Retaining Ring
44	34-60-3700	Retaining Ring
45	36-92-0701	Wobble Shaft
46	38-50-6400	Reciprocating Spindle
47	40-50-0162	Torsion Spring
48	40-50-8850	Disc Spring
49	42-12-0190	Wobble Shaft Axle
50	42-24-0066	Front Spindle Bushing
51	42-24-0525	Rear Spindle Bushing
52	42-38-0055	Orbit Bumper
53	42-50-0355	Front Cam
54	42-50-0360	Rear Cam
55	42-52-0380	Bearing Cap

NO. REQ.	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
(1)		1	Ball Bearing	(1)
(1)		2	Ball Bearing	(1)
(1)		3	Ball Bearing	(1)
(1)		4	Needle Bearing	(1)
(1)		5	K50 x 60mm Washer Hd. PT Screw	(1)
(1)		6	5/16-24 Spinlock Hex Nut	(1)
(2)		7	Dowel Pin	(2)
(1)		8	Cam Follower	(1)
(1)		9	Orbit Pivot Pin	(1)
(2)		10	8-32 x .38 Taptite T-20 Screw	(2)
(3)		11	DG50 x 10mm Screw	(3)
(6)		12	8-16 x .625 Slit. Plastite T-20 Screw	(6)
(2)		13	8-16 x 1" Slit. Plastite T-20 Screw	(2)
(2)		14	8-16 x 2.25 Slit. Plastite T-20 Screw	(2)
(4)		15	1/2-DG50 Thread Form Screw	(4)
(1)		16	4-20 x .875 Plastite T-10 Screw	(1)
(1)		17	Service Nameplate	(1)
(1)		★18	Remote Electronics Assembly	(1)
(1)		19	Secondary Wobble Plate Assembly	(1)
(1)		20	Primary Wobble Plate Assembly	(1)
(1)		21	Service Armature	(1)
(1)		22	Service Field	(1)
(1)		23	Carbon Brush Assembly	(1)
(1)		24	Cord Assembly	(1)
(1)		25	Switch	(1)
(1)		26	Cardboard Tube	(1)
(2)		29	Orbit Pocket Assembly	(2)
(1)		30	Gearcase	(1)
(1)		31	Diaphragm	(1)
(1)		32	Baffle	(1)
(1)		33	Orbital Cam Plate	(1)
(1)		34	Spring Cover	(1)
(1)		35	Handle Half - Right	(1)
(1)		36	Handle Half - Left	(1)
(1)		37	Motor Housing	(1)
(1)		38	Orbit Shift Lever	(1)
(1)		39	Shoe Release Lever	(1)
(1)		40	Intermediate Gear	(1)
(2)		41	O-Ring	(2)
(1)		42	Retaining Ring	(1)
(2)		43	External Retaining Ring	(2)
(1)		44	Retaining Ring	(1)
(1)		45	Wobble Shaft	(1)
(1)		46	Reciprocating Spindle	(1)
(1)		47	Torsion Spring	(1)
(1)		48	Disc Spring	(1)
(1)		49	Wobble Shaft Axle	(1)
(1)		50	Front Spindle Bushing	(1)
(1)		51	Rear Spindle Bushing	(1)
(1)		52	Orbit Bumper	(1)
(1)		53	Front Cam	(1)
(1)		54	Rear Cam	(1)
(1)		55	Bearing Cap	(1)
(1)		56	Counter Weight	(1)
(1)		57	Bronze Plate	(1)
(2)		58	Metal Plate	(2)
(1)		60	Orbit Plate	(1)
(1)		61	Orbit Drive Hub	(1)
(1)		64	Shoe Pin	(1)
(1)		65	Lock Pin	(1)
(1)		66	Shoe Retainer	(1)
(1)		67	Front Orbit Cap	(1)
(1)		68	Bearing Retainer	(1)
(1)		69	Orbit Seal	(1)
(1)		70	Polypak Seal	(1)
(1)		71	Gearcase Insulator	(1)
(1)		72	Shoe Assembly	(1)
(1)		73	Sleeve	(1)
(1)		74	Slinger	(1)
(1)		75	Spacer	(1)
(1)		76	Washer	(1)
(1)		77	Washer	(1)
(1)		78	Fan	(1)
(1)		79	Cord Protector	(1)
(1)		80	Large Quik-Lok Blade Clamp	(1)
(1)		81	Gear Protecting Clutch Assembly	(1)
(1)		82	Magnet	(1)
(1)		83	Cord Clamp	(1)
(1)		84	Cord Clamp	(1)
(1)		87	Felt Seal	(1)
(1)		88	Leadwire Assembly	(1)
(2)		★89	Fiberglass Sleeve	(2)
(1)		42-55-2051	Carrying Case (Not Shown)	(1)

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

Drwg. 2

FIG. 1

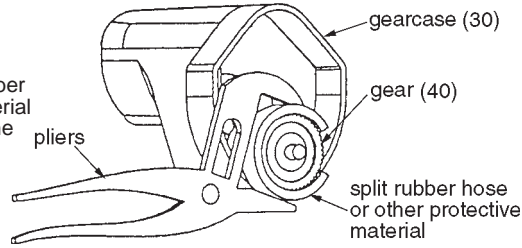
NOTES:

Bearing to be installed with seal towards commutator.

4,31 Press needle bearing flush $\pm .005$ with inner surface of diaphragm.

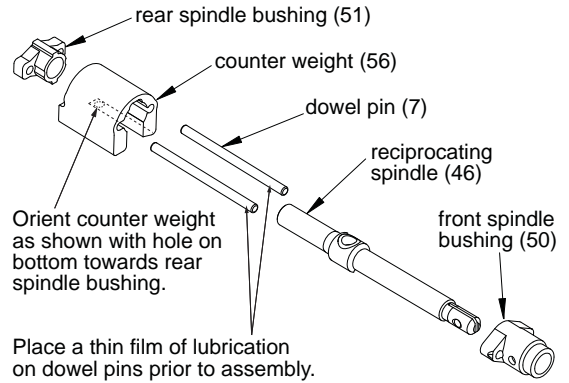
6,49 Apply Blue Loctite® 242 to treads of wobble shaft axle prior to installing spinlock hex nut. Torque spinlock hex nut to 160-190 in. lbs.

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.



Service Fixture 61-10-0270 (Pressing Pin Tool)

7,46,50,51,56 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) and counter weight (56) must be installed inside assembly (7,50) and (7,51) prior to pressing last spindle bushing into place. Be sure to orientate the counter weight with the hole on bottom towards rear spindle bushing, as shown.



17,37 Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing.

29,42 **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29).

40,57 Tabs of bronze plate engage intermediate gear.

40,48 Concave side of disc spring towards intermediate gear.

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.

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.

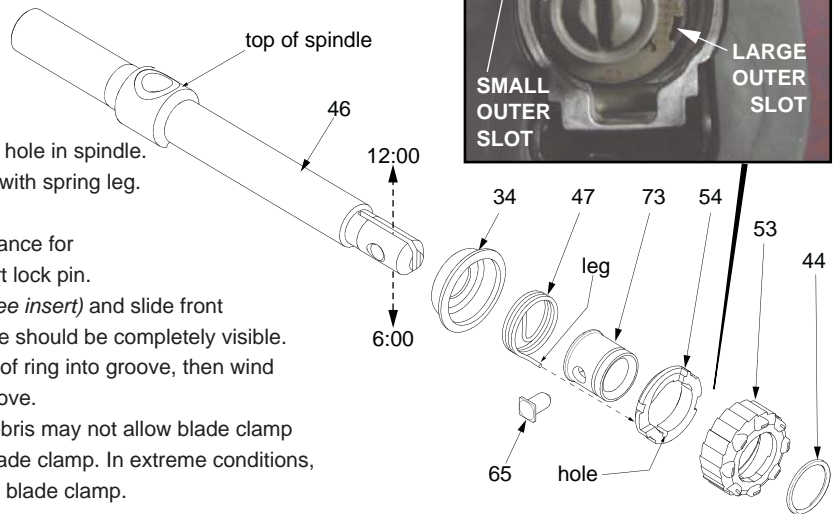


FIG. LUBRICATION:

29,41 Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets.

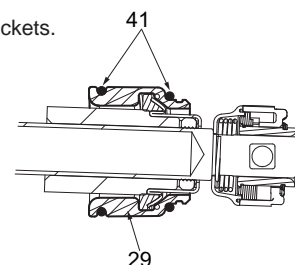
30 Place 3.2 oz. (80 grams \pm 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case.

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.



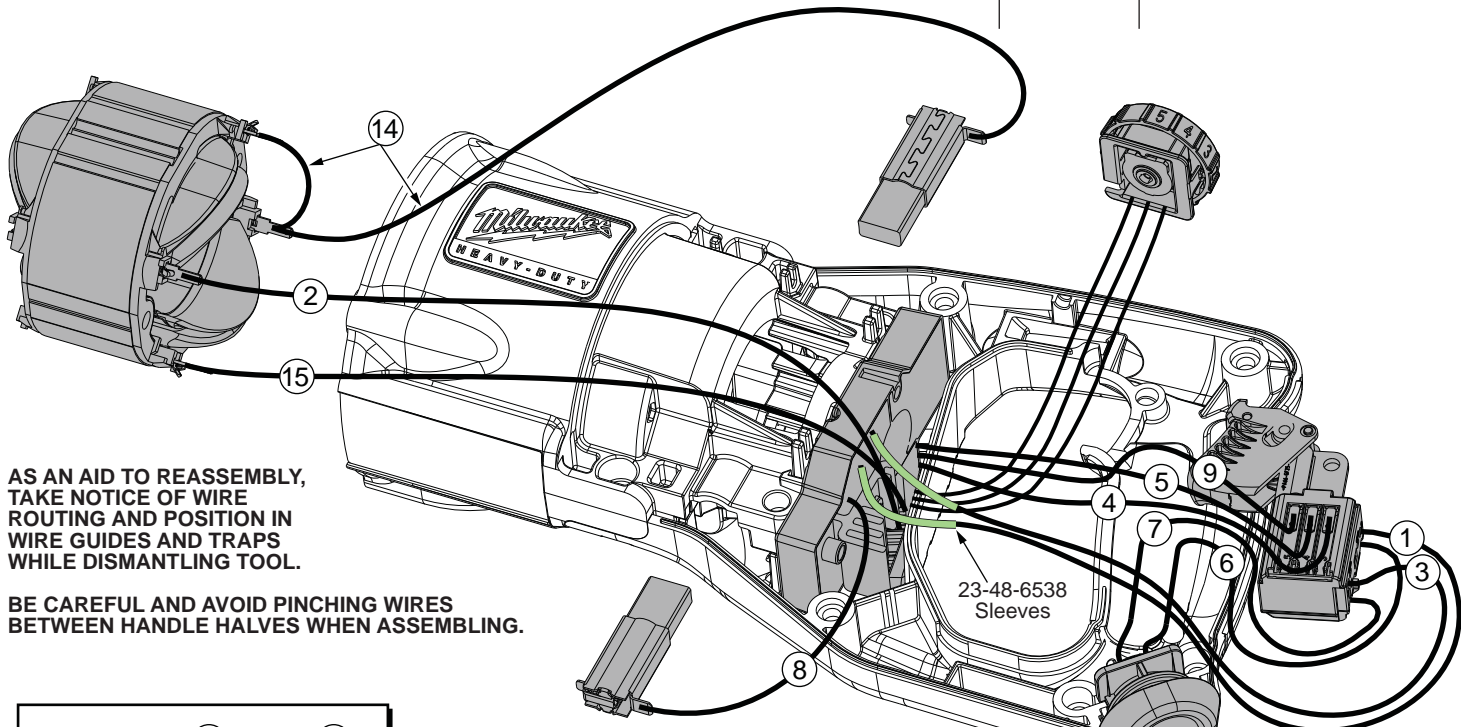
WIRING INSTRUCTIONS

TITLE **6538-21 SAWZALL® with 14-20-1115 Remote Electronics Assembly**

BULLETIN

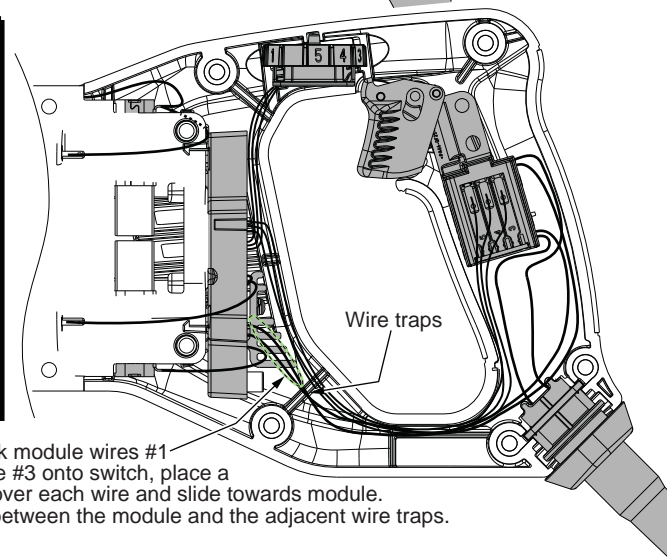
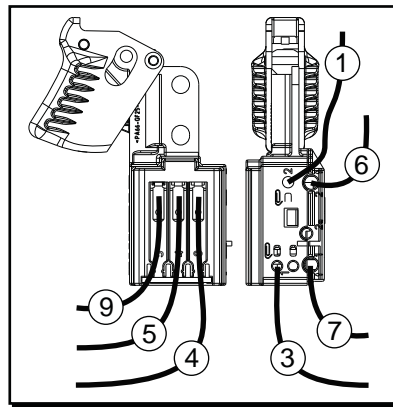
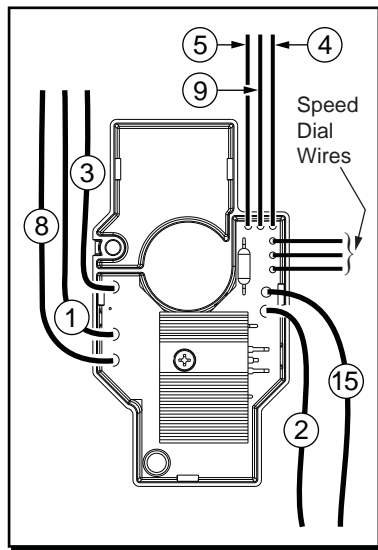
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DATE



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.



Prior to installing black module wires #1 and white module wire #3 onto switch, place a sleeve (23-48-6538) over each wire and slide towards module. Locate both sleeves between the module and the adjacent wire traps.

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	14-20-1105	----	Component of the speed control module. Connect to position '2' on the back of the on-off switch.
2	Yellow	14-20-1105	----	Component of the speed control module. Connect to the bottom left field terminal.
3	White	14-20-1105	----	Component of the speed control module. Connect to position '1' on the back of the on-off switch.
4	Black	14-20-1105	----	Component of the speed control module. Connect to position '3' on the left side of the on-off switch.
5	White	14-20-1105	----	Component of the speed control module. Connect to position '4' on the left side of the on-off switch.
6	Black	22-64-4522	----	Component of the power cord set. Connect the other end to position '2↑' on switch.
7	White	22-64-4522	----	Component of the power cord set. Connect the other end to position '1↑' on switch.
8	Black	14-20-1105	----	Component of the speed control module. Connect to the bottom brush tube terminal.
9	Blue	14-20-1105	----	Component of the speed control module. Connect to position '5' on the left side of the on-off switch.
14	White	23-94-7425	----	Leadwire assembly. Connect to the top right and left field terminals. Connect to top brush tube terminal.
15	Yellow	14-20-1105	----	Component of the speed control module. Connect to the bottom right field terminal.