SERVICE PARTS LIST

Milwankee

42-24-0525

42-38-0055

42-50-0355

52

Rear Spindle Bushing

Orbit Bumper

Front Cam

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

1-1/4" STROKE SAWZALL®

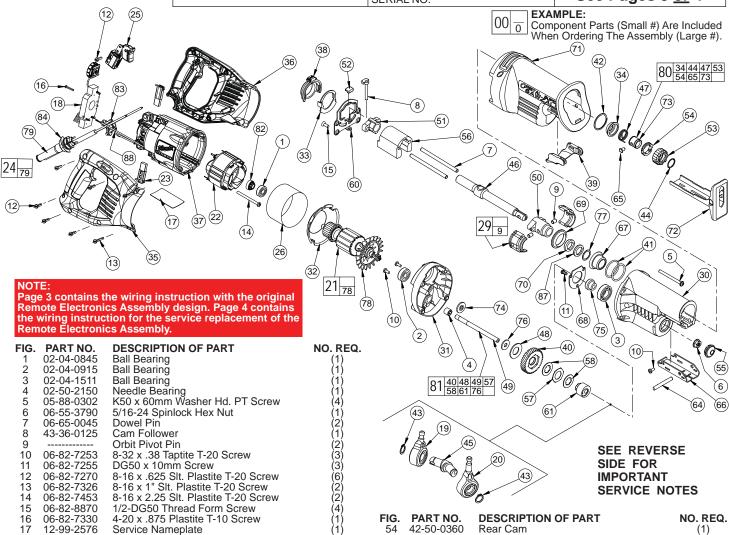
CATALOG NO. 6538-21 STARTING SERIAL NO. B36A

STARTING SERIAL NO. B36A

REVISED BULLETIN DATE Jan. 2013

WIRING INSTRUCTION

See Pages 3 or 4



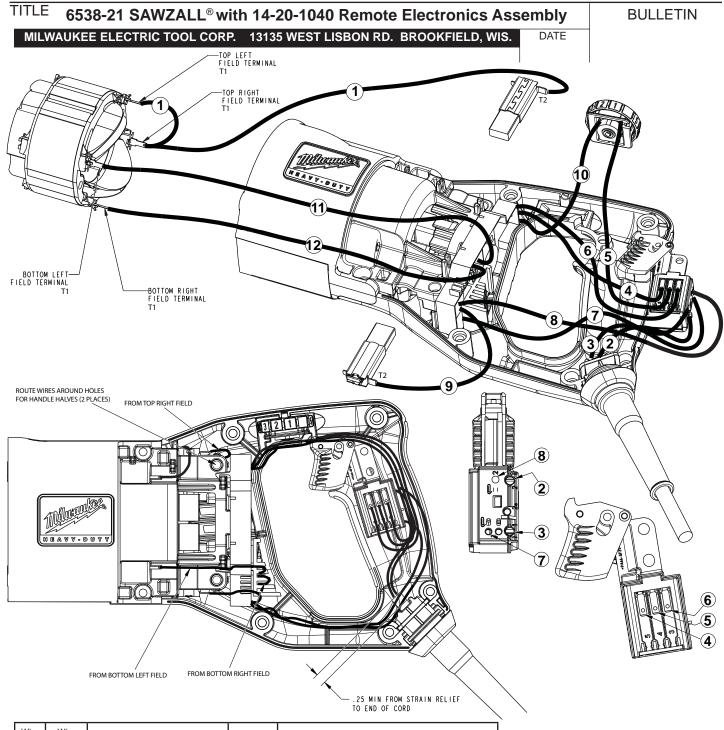
13	06-82-7326	8-16 x 1" Slt. Plastite T-20 Screw	(2) (2)	SERVICE NOTES			
14	06-82-7453	8-16 x 2.25 Slt. Plastite T-20 Screw				0	
15	06-82-8870	1/2-DG50 Thread Form Screw	(4)	FIC	DARTNO	DESCRIPTION OF PART	NO DEO
16	06-82-7330	4-20 x .875 Plastite T-10 Screw	(1)	FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
17	12-99-2576	Service Nameplate	(1)	54	42-50-0360	Rear Cam	(1)
18	14-20-1115	Remote Electronics Assembly	(1)	55	42-52-0380	Bearing Cap	(1)
19	14-67-0126	Secondary Wobble Plate Assembly	(1)	56	42-87-0180	Counter Weight	(1)
20	14-67-0136	Primary Wobble Plate Assembly	(1)	57	43-06-0676	Bronze Plate	(1)
21	16-30-0705	Service Armature	(1)	58	43-06-0685	Metal Plate	(2)
22	18-31-0220	Service Field	(1)	60	43-56-0620	Orbit Plate	(1)
23	22-20-0535	Carbon Brush Assembly	(2)	61	43-78-0575	Orbit Drive Hub	(1)
24	22-64-0595	Cord Assembly	(1)	64	44-60-1635	Shoe Pin	(1)
25	23-66-2490	Switch	(1)	65	44-60-1750	Lock Pin	(1)
26	23-16-0045	Cardboard Tube	(1)	66	44-66-0880	Shoe Retainer	(1)
29	14-30-0080	Orbit Pocket Assembly	(2)	67	44-86-0035	Front Orbit Cap	(1)
30	28-14-2600	Gearcase	(1)	68	44-86-0655	Bearing Retainer	(1)
31	28-28-2600	Diaphragm	(1)	69	45-06-0110	Orbit Seal	(1)
32	31-05-0155	Baffle	(1)	70	45-06-0475	Polypak Seal	(1)
33	31-11-0130	Orbital Cam Plate	(1)	71	45-12-0700	Gearcase Insulator	(1)
34	31-15-0170	Spring Cover	(1)	72	45-16-0645	Shoe Assembly	(1)
35	31-44-2090	Handle Half - Right	(1)	73	45-22-0175	Sleeve	(1)
36	31-44-2095	Handle Half - Left	(1)	74	45-28-0555	Slinger	(1)
37	31-50-1990	Motor Housing	(1)	75	45-36-1445	Spacer	(1)
38	31-52-0045	Orbit Shift Lever	(1)	76	45-88-1555	Washer	(1)
39	31-52-0090	Shoe Release Lever	(1)	77	45-88-8577	Washer	(1)
40	32-40-2050	Intermediate Gear	(1)	78	22-84-0531	Fan	(1)
41	34-40-0040	O-Ring	(2)	79	44-76-0210	Cord Protector	(1)
42	34-60-0125	Retaining Ring	(1)	80	14-46-1060	Large Quik-Lok Blade Clamp	(1)
43	34-60-1315	External Retaining Ring	(2)	81	14-08-0075	Gear Protecting Clutch Assembly	(1)
44	34-60-3700	Retaining Ring	(1)	82	23-38-0200	Magnet	(1)
45	36-92-0701	Wobble Shaft	(1)	83	31-17-0260	Cord Clamp	(1)
46	38-50-6400	Reciprocating Spindle	(1)	84	31-17-0265	Cord Clamp	(1)
47	40-50-0162	Torsion Spring	(1)	87	45-06-0501	Felt Seal	(1)
48	40-50-8850	Disc Spring	(1)	88	23-94-7425	Leadwire Assembly	(1)
49	42-12-0190	Wobble Shaft Axle	(1)	89	23-48-6538	Fiberglass Sleeve	(2)
50	42-24-0066	Front Spindle Bushing	(1)			-	` '
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(1) (1) (1)

FIG.	NOTES:						
1 1	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 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 G1-10-0270					
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.	rear spindle bushing (51) counter weight (56) dowel pin (7) reciprocating					
17,37	Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing.	spindle (46)					
29,42	Service fixture #61-10-0205 must be used when installing retaining ring (42) onto orbit pocket assembly (29).	Orient counter weight as shown with hole on bottom towards rear spindle bushing.					
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.	Place a thin film of lubrication 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.	SMALL LARGE INNER INNER					
74	Shoulder extension of grease slinger should face bearing.	RIB					
Remove e Pull lock p REASSEMBLY Coat new Hold tool ii Place sprii Slide torsic with leg po Slide sleev Slide rear Ensure sp Rotate real lock pin (6 Align front cam onto s Attach retaremainder Blade clant to rotate fr	Atternal retaining ring (44) and pull front cam (53) off. in (65) out and remove remainder of parts and discard. OF THE STEEL QUIK-LOK® BLADE CLAMP lock pin with powdered graphite. In a vertical position. Ing cover (34) onto spindle. In spring (47) onto spindle shaft positioned at the 6:00 position. In ge (73) onto spindle aligning hole on sleeve with hole in spindle. In a cam (54) over sleeve, aligning hole in rear cam with spring leg. In ring leg inserts into hole in rear cam. In cam (54) counter clockwise until there is clearance for (55) to be inserted into sleeve/spindle holes. Insert lock pin. In cam (53) inner ribs with rear cam outer slots (see insert) and slide front sleeve until it bottoms. Retaining ring (44) groove should be completely visible aining ring by separating coils and inserting end of ring into groove, then wind of ring into groove. Ensure ring is seated in groove. In should rotate freely. During normal usage, debris may not allow blade clarely. The use of spray lubricant can help free blade clamp. In extreme conditions in the structions to remove, clean and reassemble blade clamp.	d mp					

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

WIRING INSTRUCTIONS



Wire No.	Wire Color	Origin or Part No.	Length	Terminals, Connectors and End Wire Preparation
1	White	23-94-7425		
2	Black	Cord Assembly	3.5	Strip .35 and tin.
3	White	Cord Assembly	3.0	Strip .35 and tin.
4	Red	Remote Electronics Assembly		
5	Black	Remote Electronics Assembly		
6	White	Remote Electronics Assembly		
7	White	Remote Electronics Assembly		
8	Black	Remote Electronics Assembly		
9	Black	Remote Electronics Assembly		
10	Black	Remote Electronics Assembly		
11	Yellow	Remote Electronics Assembly		
12	Yellow	Remote Electronics Assembly		

NOTES:

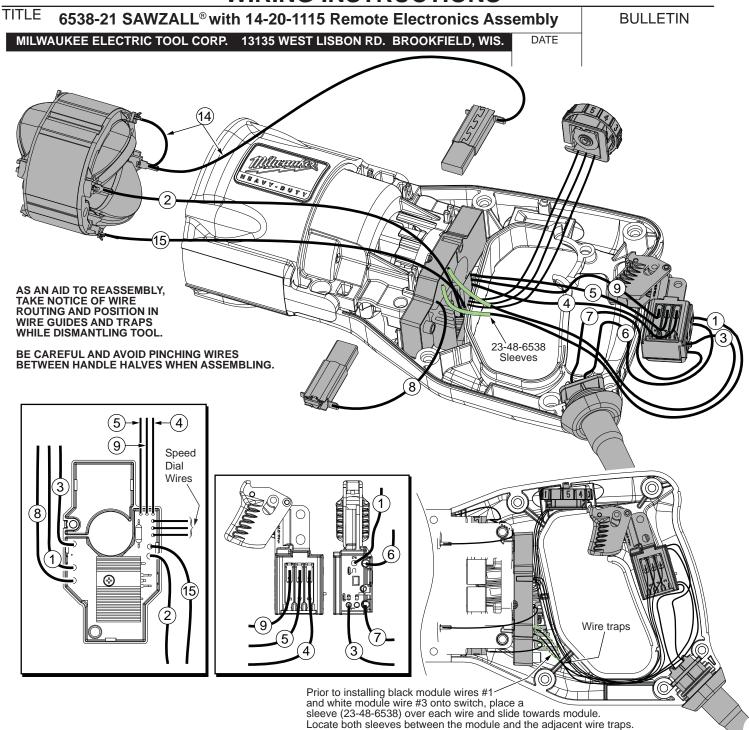
TERMINALS MAY BE SECURED WITH BARRELS FACING IN OR OUT. (4 PLACES).

NOTE:

All leads must be held to \pm 1/8". All lead lengths are before stripping.

TERMINAL DESCRIPTION						
Code	Part No.	Qnty.				
T1	23-74-1060	4				
T2	23-74-0605	2				

WIRING INSTRUCTIONS



	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.			