



# SERVICE PARTS LIST

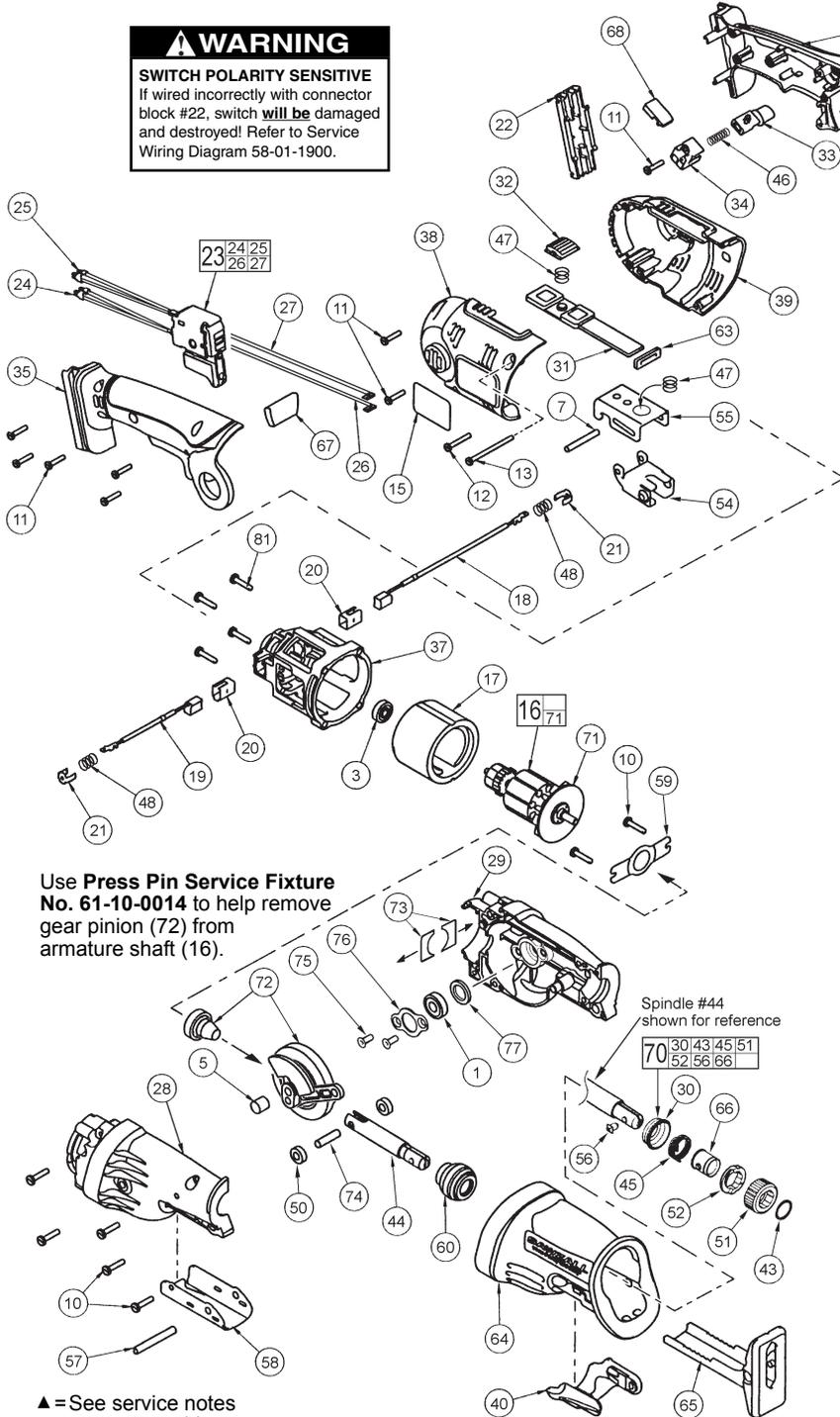
**BULLETIN NO.**  
**55-40-6500**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>CORDLESS 18 VOLT HATCHET SAWZALL®</b>			Dec. 2005
CATALOG NO.	<b>6514-50</b>	STARTING SERIAL NO.	<b>372A</b>
		WIRING INSTRUCTION <b>58-01-1900</b>	

**WARNING**  
**SWITCH POLARITY SENSITIVE**  
If wired incorrectly with connector block #22, switch **will be** damaged and destroyed! Refer to Service Wiring Diagram 58-01-1900.

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

**SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES**



Use Press Pin Service Fixture No. 61-10-0014 to help remove gear pinion (72) from armature shaft (16).

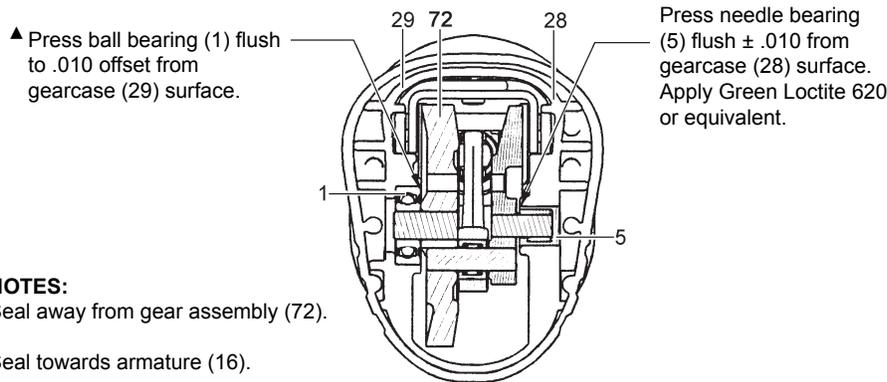
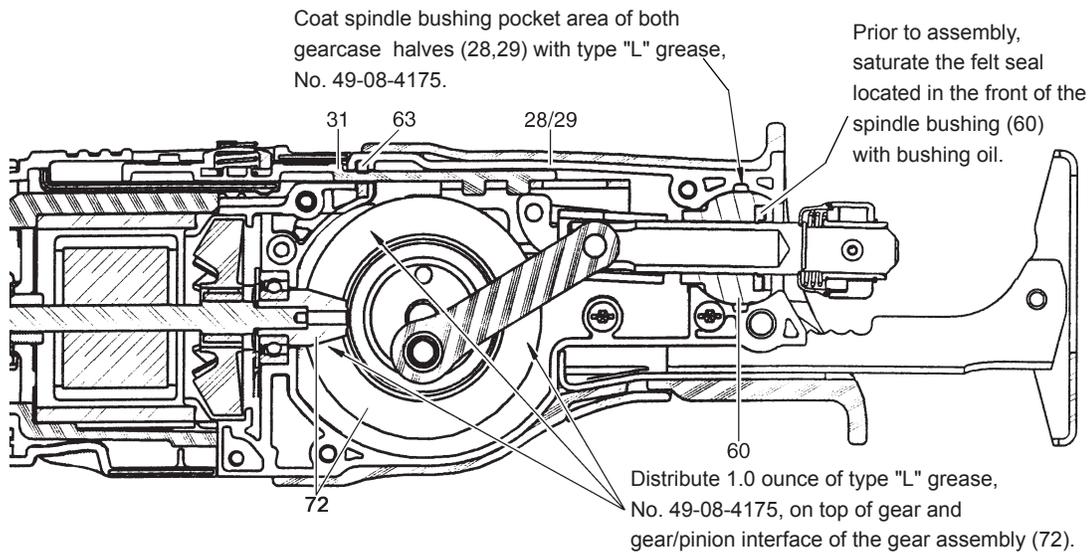
Spindle #44 shown for reference  
70 30 43 45 51 52 56 66

▲ = See service notes on reverse side.

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
18	22-18-0995	Carbon Brush Assembly - Black	(1)
19	22-18-0997	Carbon Brush Assembly - Red	(1)
20	22-20-0860	Brush Tube	(2)
21	22-32-0400	Brush Spring Clip	(2)
22	22-56-0200	Connector Block	(1)
23	23-66-2349	Switch Assembly	(1)
24	23-94-3010	Leadwire Assembly - Red	(1)
25	23-94-3020	Leadwire Assembly - Black	(1)
26	23-94-3030	Leadwire Assembly - Red	(1)
27	23-94-3040	Leadwire Assembly - Black	(1)
28	28-14-2901	Gearcase Assembly - Right	(1)
29	28-14-2906	Gearcase Assembly - Left	(1)
30	31-15-0511	Spring Cover	(1)
31	31-15-0625	Lock Slide Cover	(1)
32	31-15-0626	Lock Slide Button	(1)
33	31-15-1500	Button	(1)
34	31-15-1505	Box Bottom	(1)
35	31-44-2400	Handle Halve - Right	(1)
36	31-44-2405	Handle Halve - Left	(1)
37	31-50-0051	Motor Cage	(1)
38	31-50-0625	Motor Housing - Right	(1)
39	31-50-0626	Motor Housing - Left	(1)
40	31-52-0095	Shoe Release Lever	(1)
43	34-60-3680	Retaining Ring	(1)
44	38-50-6105▲	Spindle	(1)
45	40-50-0161	Torsion Spring	(1)
46	40-50-0760	Compression Spring	(1)
47	40-50-0766	Compression Spring	(2)
48	40-50-8840	Brush Spring	(2)
50	42-40-1011	Spindle Pin Bushing	(2)
51	42-50-0076	Front Cam	(1)
52	42-50-0077	Rear Cam	(1)
54	43-56-0628	Orbit Slot	(1)
55	43-56-0685	Orbit Control Link	(1)
56	44-60-0626	Lock Pin	(1)
57	44-60-1635	Shoe Pin	(1)
58	44-66-0891	Shoe Retainer	(1)
59	44-66-5335	Bearing Retaining Plate	(1)
60	44-86-0130	Spindle Bushing Assembly	(1)
63	45-06-0375	Felt Seal	(1)
64	45-12-0900	Gearcase Insulator	(1)
65	45-16-0646	Shoe Assembly	(1)
66	45-22-0081	Sleeve	(1)
67	45-24-0203	Lock Off Slide	(1)
68	45-24-0750	Slide Lock	(1)
70	14-46-1011	Steel Quik-Lok Blade Clamp Kit	(1)
71	22-84-0830	Fan	(1)
72	32-05-3340	Gear Assembly	(1)
73	45-06-0301	Bearing Seal	(2)
74	06-65-2995	Pin	(1)
75	06-82-8870	1/2 DG50 Thread Form Screw	(2)
76	44-66-5500	Bearing Retaining Plate	(1)
77	45-88-8585	Washer	(1)
81	06-82-5362	8-32 x 1" Pan Hd. Slit. Tapt. T-20	(4)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0845▲	Ball Bearing	(1)
3	02-04-5130▲	Ball Bearing	(1)
5	02-50-1640	Needle Bearing	(1)
7	06-65-3005	Orbit Control Pin	(1)
10	06-82-5346	Slotted Taptite Torx Screw T-20	(7)
11	06-82-7261	Slotted Plastite Torx Screw T-15	(8)
12	06-82-7276	Slotted Plastite Torx Screw T-20	(1)
13	06-82-7300	Slotted Plastite Torx Screw T-20	(1)
15	12-20-3390	Service Nameplate Kit	(1)
16	16-01-1095	Armature	(1)
17	18-01-0070	Field	(1)

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



TORQUE SPECIFICATIONS		
Fig. No.	Max. Seating Torque	Min. Seating Torque
10	35 in.-lbs.	25 in.-lbs.
11	20 in.-lbs.	15 in.-lbs.
12	20 in.-lbs.	15 in.-lbs.
13	20 in.-lbs.	15 in.-lbs.
75	40 in.-lbs.	30 in.-lbs.
81	35 in.-lbs.	25 in.-lbs.

- FIG. NOTES:**
- ▲ 1 Seal away from gear assembly (72).
  - ▲ 3 Seal towards armature (16).
  - 10,28 Tighten screws located at "1" and "2", marked on right gearcase (28), prior to tightening the remaining screws.

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

- Remove external retaining ring (43) and pull front cam (51) off.
- Pull lock pin (56) 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 (30) onto spindle.
- Slide torsion spring (45) onto spindle with spring leg on hole side of spindle.
- Slide sleeve (66) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (52) 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 (56) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (51) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring (43) 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.

