



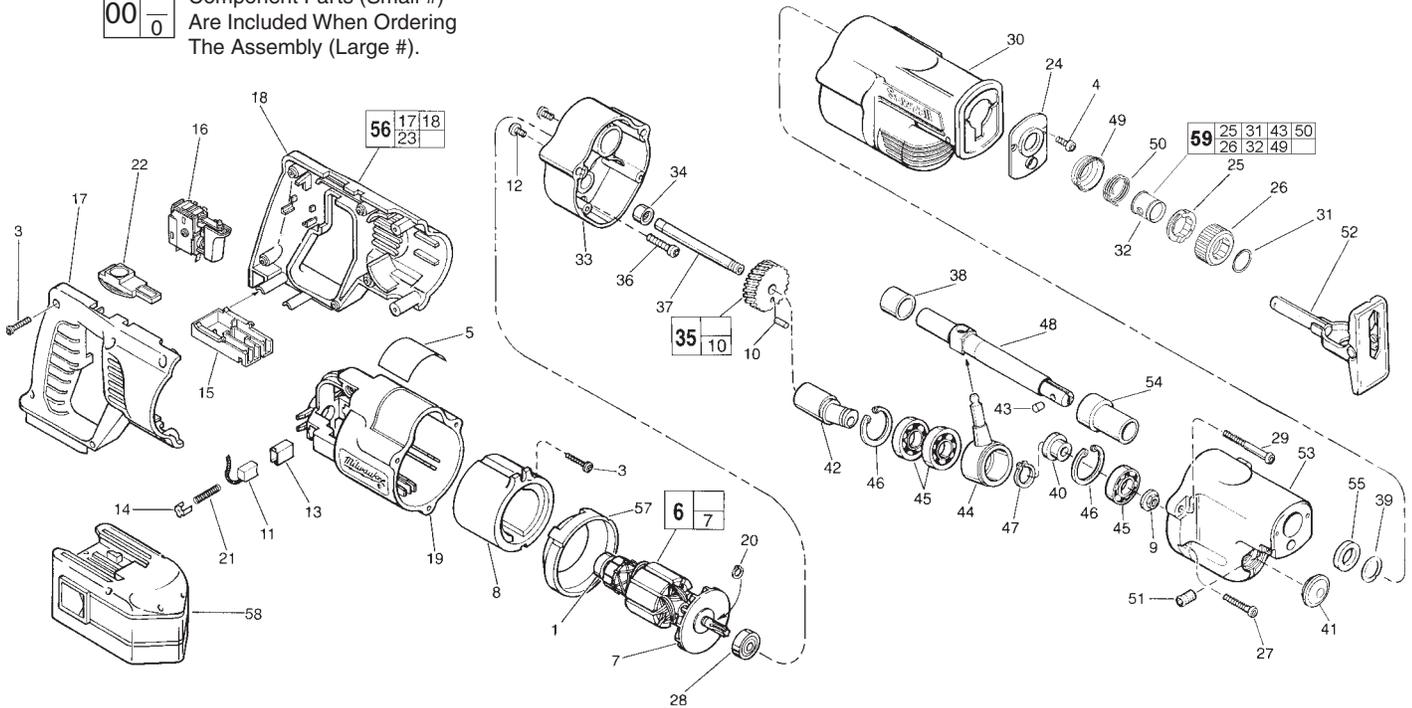
SERVICE PARTS LIST

BULLETIN NO.
54-40-1602

| | | | |
|--|----------------|--|-------------------|
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | REVISED BULLETIN 54-40-1601 | DATE Jan. 2007 |
| CORDLESS SAWZALL® | | | |
| CATALOG NO. | 6515-20 | STARTING SERIAL NO. | 971C |
| | | WIRING INSTRUCTION 58-01-0790 | |

EXAMPLE:

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



| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|--|----------|
| 1 | 02-04-5130 | Ball Bearing | (1) |
| 3 | 06-82-7261 | 6-19 x 11/16" Pan Hd. St. Plastite T-15 | (8) |
| 4 | 06-95-0080 | 6-32 x 1/2" Truss Hd. Taptite T-10 Screw | (2) |
| 5 | 12-20-1425 | Service Nameplate Kit | (1) |
| ★ 6 | 16-01-1140 | Armature | (1) |
| ★ 7 | 22-84-0950 | Fan Assembly | (1) |
| ★ 8 | 18-01-0070 | Field | (1) |
| 9 | 06-55-3790 | 5/16-24 Spinlock Hex Nut | (1) |
| 10 | 06-65-0606 | 3/16" x 1/2" Drivelok Pin | (1) |
| 11 | 22-18-0975 | Carbon Brush Assy.-Right | (1) |
| 11A | 22-18-0970 | Carbon Brush Assy.-Left (Not Shown) | (1) |
| 12 | 06-82-7252 | 8-32 x 3/8" Pan Hd. Taptite T-20 | (2) |
| 13 | 22-20-0860 | Brush Tube | (2) |
| 14 | 22-32-0400 | Brush Spring Clip | (2) |
| 15 | 22-56-0230 | Connector Block | (1) |
| 16 | 23-66-2351 | Switch Assembly | (1) |
| 17 | 31-44-0750 | Handle Half-Right | (1) |
| 18 | 31-44-0755 | Handle Half-Left | (1) |
| 19 | 31-50-0961 | Motor Housing | (1) |
| ★ 20 | 34-60-0810 | External Retaining Ring | (1) |
| 21 | 40-50-8840 | Brush Spring | (2) |
| 22 | 45-24-0201 | Lock Off Slide | (1) |
| 24 | 44-86-0615 | Seal Retainer | (1) |
| 25 | 42-50-0077 | Cam Collar | (1) |
| 26 | 42-50-0076 | Front Cam | (1) |
| 27 | 06-82-5346 | 8-32 x 3/4" Pan Hd. Taptite T-20 | (2) |
| ★ 28 | 02-04-1017 | Ball Bearing | (1) |
| 29 | 05-88-8301 | K50 x 60mm Pan Hd. PT T-20 | (2) |
| 30 | 45-12-0510 | Gear Case Insulator | (1) |
| 31 | 34-60-3680 | External Retaining Ring | (1) |
| 32 | 45-22-0081 | Sleeve | (2) |
| 33 | 28-28-2080 | Diaphragm | (1) |
| 34 | 02-50-2150 | Needle Bearing | (1) |
| ★ 35 | 32-40-2365 | Intermediate Gear Assembly | (1) |
| 36 | 05-88-8307 | K50 x 22mm Pan Hd. PT T-20 | (1) |
| 37 | 42-12-0180 | Axle-Wobble Shaft | (1) |
| 38 | 42-24-0620 | Rear Spindle Bearing | (1) |
| 39 | 45-88-8577 | Washer | (1) |
| 40 | 45-36-1450 | Spacer | (1) |
| 41 | 42-52-0380 | Bearing Cap | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|---|----------|
| 42 | 36-92-0740 | Wobble Shaft | (1) |
| 43 | 44-60-0626 | Pin | (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 | 06-83-3151 | 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 | 31-44-0775 | Handle Kit | (1) |
| 57 | 31-05-0080 | Baffle | (1) |
| 58 | ----- | Battery (Accessory) | (1) |
| 59 | 14-46-1011 | Steel Quik-Lok Blade Clamp Kit | (1) |
| | 49-96-0070 | 5/32" Hex Key | (1) |
| | 23-94-5890 | Leadwire Assy.-Black (See 58-01-0790) | (1) |
| | 23-94-5895 | Leadwire Assy.-White (See 58-01-0790) | (1) |

FIG. 11,11A,13 NOTES:
Remove Brushes And Brush Tubes To Prevent Damage
When Installing Or Removing Armature From Motor Hsg.

**SEE REVERSE SIDE FOR
IMPORTANT SERVICE NOTES**

MILWAUKEE ELECTRIC TOOL CORPORATION
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Drwg. 2

FIG. LUBRICATION

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.

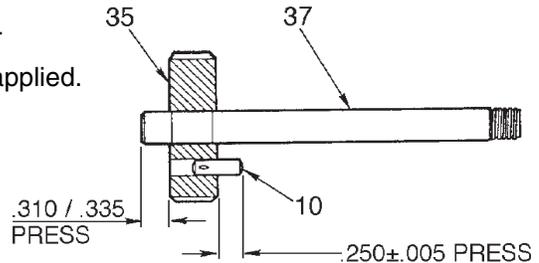
FIG. NOTES

9 Apply thread locking compound to threads of spinlock hex nut. Torque to 145in./lbs.-185 in./lbs.

9,10,35,37 Axle should extend .285 min. beyond intermediate gear after seating torque to spinlock hex nut (not shown) is applied.

Pin is to be pressed into gear 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 (±.005) to diaphragm surface.

39 O-ring of seal towards rear of tool.

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.

REMOVING THE STEEL QUIK-LOK® BLADE CLAMP

- Remove external retaining ring (31) and pull front cam (26) off.
- Pull lock pin (43) 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 (32) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear cam (25) 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 (43) to be inserted into sleeve/spindle holes. Insert lock pin.
- Align front cam (26) inner ribs with rear cam outer slots and slide front cam onto sleeve until it bottoms. Retaining ring (31) 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.

