



# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-40-0728**

<b>SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS</b>		<b>REVISED BULLETIN</b>	<b>DATE</b>
<b>TSC SAWZALL with QUIK-LOK BLADE CLAMP</b>		54-40-0727	Mar. '97
<b>CATALOG NO.</b>	<b>6518</b>	<b>WIRING INSTRUCTION</b>	
<b>STARTING SERIAL NO.</b>	<b>859D</b>	<b>58-01-0781</b>	

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

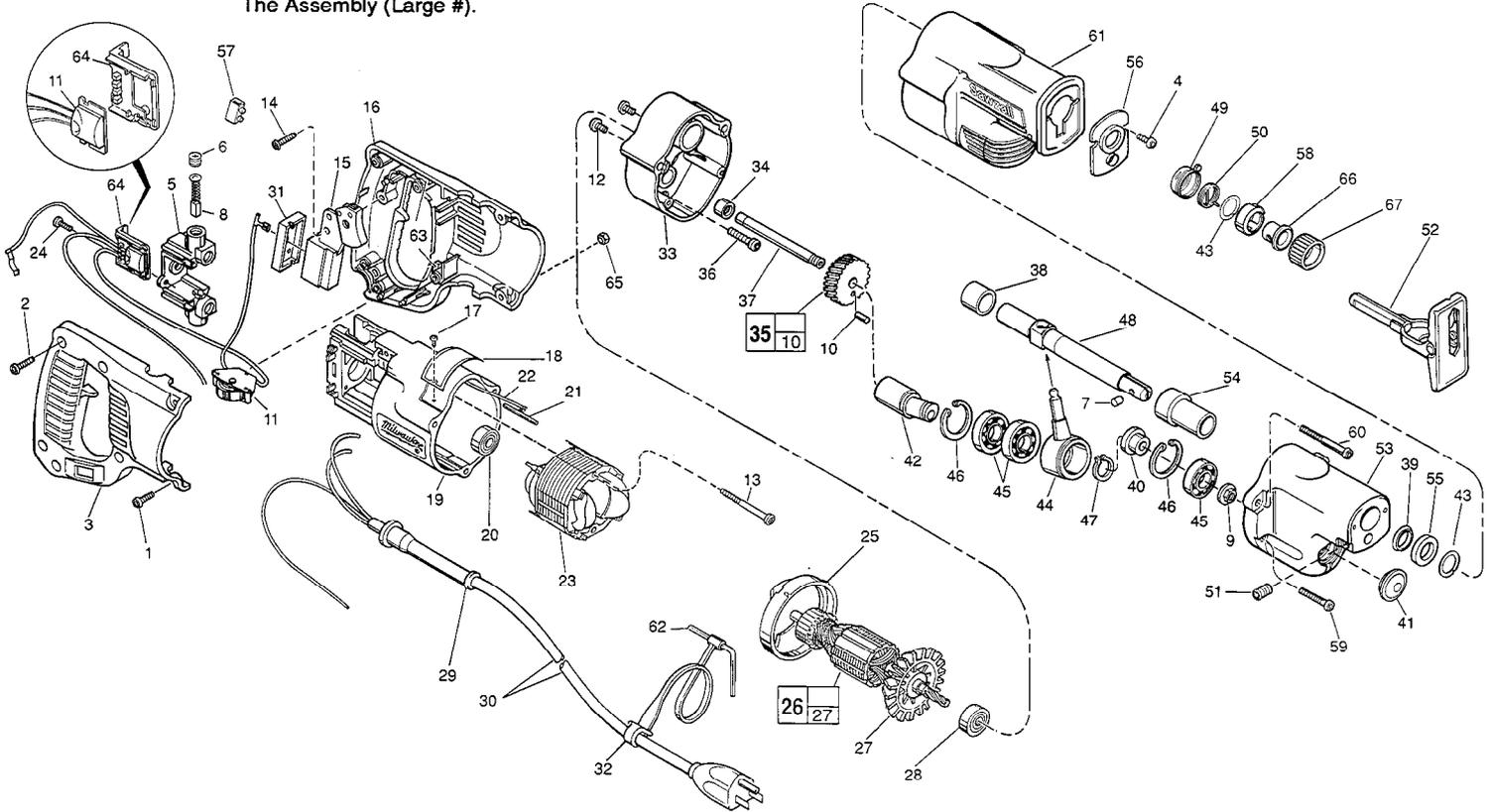


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	06-82-2390	8-32 x 1-1/4" Slotted Pan Hd. T-20	(2)
2	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(5)
3	31-44-1651	Right Handle Half	(1)
4	06-95-0075	6-32 x 3/8" Truss Hd. Taptite T-10 Screw	(2)
5	22-22-1380	Brush Holder Assembly	(1)
6	23-44-0190	Brush Retaining Cap	(2)
★ 7	44-60-0625	Pin	(1)
★ 8	22-18-0910	Carbon Brush Assembly	(2)
9	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
10	06-65-0606	3/16" x 1/2" Drivelok Pin	(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	12-99-1730	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	16-30-0535	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	32-40-2218	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)

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	36-92-0740	Wobble Shaft	(1)
★ 43	45-88-8576	Washer	(2)
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	31-15-0510	Spring Cover	(1)
★ 50	40-50-0160	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	42-50-0075	Cam Collar	(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" Socket Wrench	(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	45-22-0080	Sleeve	(1)
★ 67	31-15-0075	Plastic Collar	(1)

**SEE REVERSE SIDE FOR  
IMPORTANT SERVICE NOTES**

**MILWAUKEE ELECTRIC TOOL CORPORATION**  
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**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.

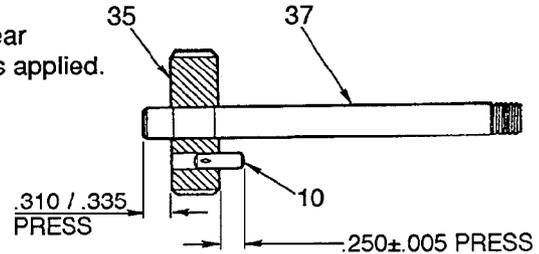
55 Saturate with lightweight oil before assembly.

**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.

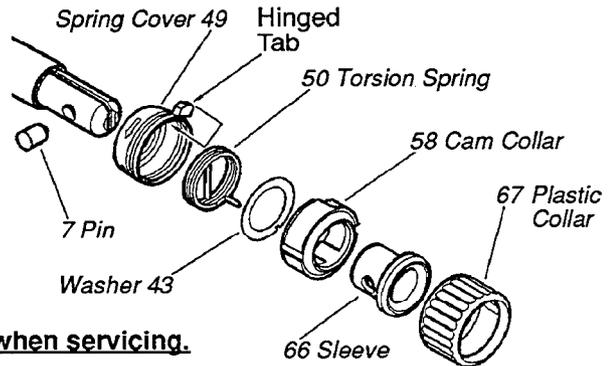
45,46 Retaining rings are to be installed with the beveled side away from the bearings.

53,54 Press forward spindle bearing flush to .030 below bearing boss of gear case.

**REMOVING THE KEYLESS QUIK-LOK BLADE CLAMP**

7,43,48,49, 50,58,66,67

To remove keyless blade clamp, cut, pry or press off plastic collar. Pop up the hinged tab on spring cover. Rotate cam collar until it stops fully open. While holding cam collar, insert Sawzall blade to push pin partially out. Insert a rigid wire-like instrument, like a paper clip with a slight bend on the end. Locate the pin area on inside slot and twist the paper clip to remove the pin from spindle.



**Clean all parts before reassembly.**

7,58 If cam collar or pin is replaced, coat pin with powdered graphite.

49,67 **Always replace plastic collar and spring cover when servicing.**

**REASSEMBLY OF THE KEYLESS QUIK-LOK BLADE CLAMP**

7,43,48,49, 50,58,66,67

To reassemble keyless blade clamp, place sleeve (66) in cam collar (58) then place washer (43) on sleeve (66). Insert spring leg of torsion spring (50) into hole on cam collar (58) and slot in washer (43). Cover up with spring cover (49).

Facing the front end of the tool, position reciprocating spindle with the pin hole facing up. Slide keyless blade clamp assembly onto the spindle with slot in cam collar (58) toward the left. Rotate the assembly in the direction of the arrows, approximately 205°. A dowel pin may be used to keep the slot and sleeve hole in alignment until hole in spindle is reached. Use a pliers to hold assembly and remove dowel pin. Pin (7) can now be inserted into clamp. Snap clamp to assure proper functioning before adding plastic collar (67). Fold hinged tab on spring cover (49) into slot on cam collar (58) as shown. Tab must be present to assure proper function. Slide plastic collar (67) onto assembly. Rotate plastic collar (67) until keyways line up and slide plastic collar (67) over snap in spring cover (49).