



SERVICE PARTS LIST

BULLETIN NO.
55-40-7540

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
1-1/4" STROKE SAWZALL®			Sept. 2012
CAT. NO. 6537-55 (SSPE 1300 SX)	STARTING SERIAL NO.	WIRING INSTRUCTION See Page 3	
PRODUCT NUMBER 4000 4291 06			

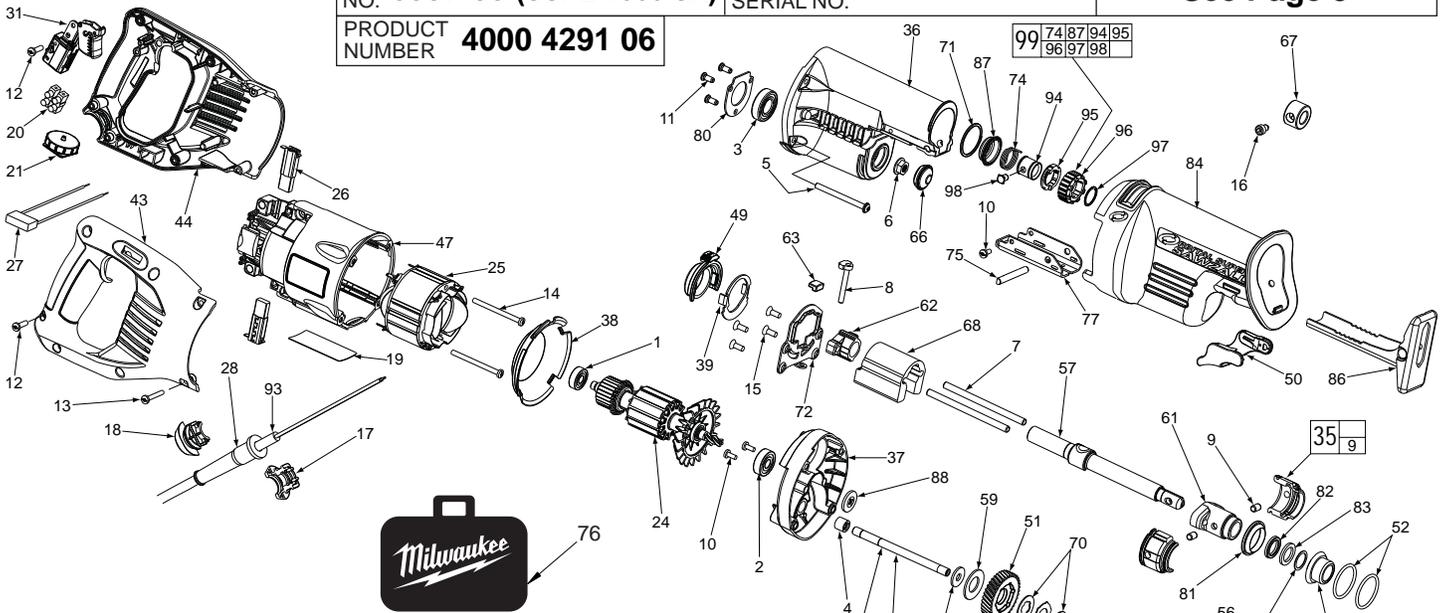


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	02-04-0845	Ball Bearing	(1)
2	02-04-0915	Ball Bearing	(1)
3	02-04-1511	Ball Bearing	(1)
4	02-50-2150	Needle Bearing	(1)
5	05-88-0302	K50 x 60mm Washer Hd. PT Screw	(4)
6	06-55-3790	5/16-24 Spinlock Hex Nut	(1)
7	06-65-0045	Dowel Pin	(2)
8	43-36-0125	Cam Follower	(1)
9	06-65-0505	Orbit Pivot Pin	(2)
10	06-82-7253	8-32 x .38 Taptite T-20 Screw	(3)
11	06-82-7255	DG50 x 10mm Screw	(3)
12	06-82-7270	8-16 x .625 Slit. Plastite T-20 Screw	(6)
13	06-82-7326	8-16 x 1 Slit. Plastite T-20 Screw	(2)
14	06-82-7453	8-16 x 2.25 Slit. Plastite T-20 Screw	(2)
15	06-82-8870	1/2-DG50 Thread Form Screw	(4)
16	06-83-0115	Blade Clamp Screw	(1)
17	31-17-0260	Cord Clamp - Left	(1)
18	31-17-0265	Cord Clamp - Right	(1)
19	12-99-6537	Service Nameplate	(1)
20	22-56-0625	Terminal Block	(1)
21	14-20-6537	Remote Dial Assembly	(1)
22	14-67-0126	Secondary Wobble Plate Assembly	(1)
23	14-67-0136	Primary Wobble Plate Assembly	(1)
24	16-30-0700	Service Armature	(1)
25	18-30-1700	Service Field	(1)
26	22-20-0590	Carbon Brush Assembly	(2)
27	22-33-0035	Suppressor	(1)
28	44-76-0210	Strain Relief	(1)
31	23-66-0205	Switch	(1)
35	14-30-0080	Orbit Pocket Assembly	(2)
36	28-14-2600	Gearcase	(1)
37	28-28-2600	Diaphragm	(1)
38	31-05-0155	Baffle	(1)
39	31-11-0130	Orbital Cam Plate	(1)
43	31-44-2090	Handle Half - Right	(1)
44	31-44-2095	Handle Half - Left	(1)
47	31-50-0085	Motor Housing	(1)
49	31-52-0045	Orbit Shift Lever	(1)
50	31-52-0090	Shoe Release Lever	(1)
51	32-40-2050	Intermediate Gear	(1)
52	34-40-0040	O-Ring	(2)
54	34-60-1315	External Retaining Ring	(2)
56	36-92-0701	Wobble Shaft	(1)
57	38-50-6400	Reciprocating Spindle	(1)
59	40-50-8850	Disc Spring	(1)
60	42-12-0190	Wobble Shaft Axle	(1)
61	42-24-0066	Front Spindle Bushing	(1)
62	42-24-0525	Rear Spindle Bushing	(1)
63	42-38-0055	Orbit Bumper	(1)
66	42-52-0380	Bearing Cap	(1)
67	42-68-0110	Keyp Blade Clamp	(1)

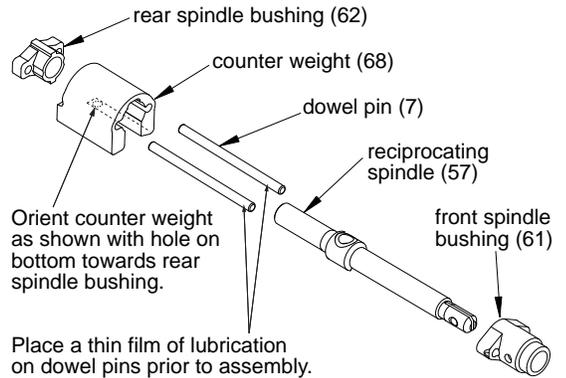
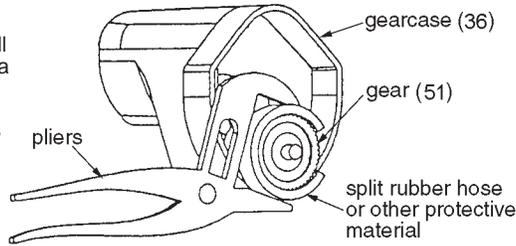
EXAMPLE:
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
68	42-87-0180	Counter Weight	(1)
69	43-06-0676	Bronze Plate	(1)
70	43-06-0685	Metal Plate	(2)
71	34-60-0125	Retaining Ring	(1)
72	43-56-0620	Orbit Plate	(1)
73	43-78-0577	Orbit Drive Hub	(1)
74	40-50-0162	Torsion Spring	(1)
75	44-60-1635	Shoe Pin	(1)
76	42-55-2056	Carrying Case	(1)
77	44-66-0880	Shoe Retainer	(1)
79	44-86-0035	Front Orbit Cap	(1)
80	44-86-0655	Bearing Retainer	(1)
81	45-06-0110	Orbit Seal	(1)
82	45-06-0475	Seal	(1)
83	45-06-0501	Felt Seal	(1)
84	45-12-0700	Gearcase Insulator	(1)
86	45-16-0645	Shoe Assembly	(1)
87	31-15-0170	Spring Cover	(1)
88	45-28-0555	Slinger	(1)
89	45-36-1445	Spacer	(1)
90	45-88-1555	Washer	(1)
91	45-88-8577	Washer	(1)
92	14-08-0075	Gear Protection Clutch Assembly	(1)
93	22-64-4522	110V Power Cord	(1)
94	45-22-0175	Sleeve	(1)
95	42-50-0360	Rear Cam	(1)
96	42-50-0355	Front Cam	(1)
97	34-60-3700	Retaining Ring	(1)
98	44-60-1750	Lock Pin	(1)
99	14-46-1060	Large Quik-Lok Blade Clamp Kit	(1)
	23-94-0100	Leadwire Assembly (Not Shown)	(2)
	23-94-6750	Leadwire Assembly (Not Shown)	(2)
	23-94-6755	Leadwire Assembly (Not Shown)	(1)
	49-08-4290	Type "T" Grease	(1)

SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES

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

- FIG. 1**
- NOTES:**
 Bearing to be installed with seal towards commutator.
- 4,37 Press needle bearing flush ± 0.005 with inner surface of diaphragm.
- 6,60 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.
- 36,51 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.
- 7,57,61,62,68 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 (57) and counter weight (68) must be installed inside assembly (7,61) and (7,62) 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.
- 19,47 Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing.
- 51,69 Tabs of bronze plate engage intermediate gear.
- 51,59 Concave side of disc spring towards intermediate gear.
- 70,73 Tabs of metal plates engage orbit drive hub.
- 82 O-ring of polypak seal faces mechanism - toward rear of tool.
- 88 Shoulder extension of grease slinger should face bearing.

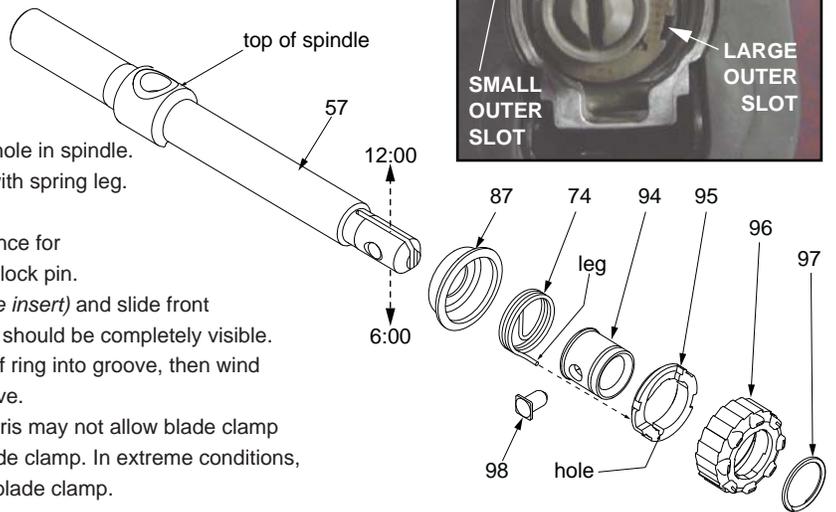


REMOVING THE STEEL QUIK-LOK® BLADE CLAMP

- Remove external retaining ring (44) and pull front cam (53) off.
- Pull lock pin (65) out and remove remainder of parts and discard.

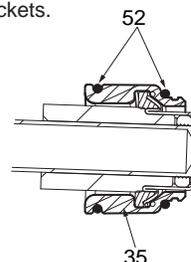
REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP

- 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.

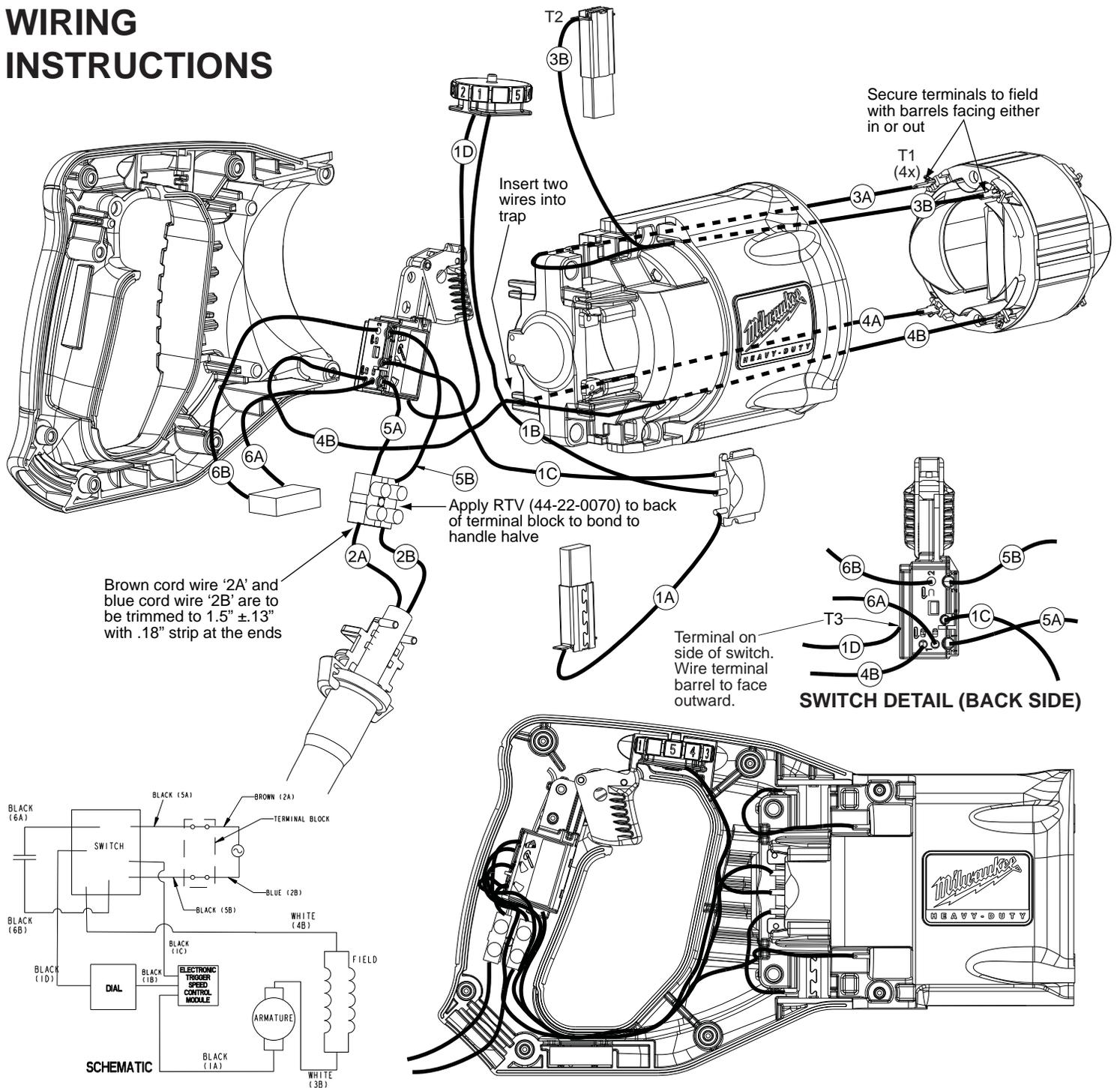


- FIG. 35,52**
- LUBRICATION:**
 Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets.

- 36 Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case.
- 37 Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm.
- 51,70 Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate.
- 67 Pin to be coated with graphite prior to assembly.
- 83 Soak in lightweight bushing oil prior to assembly.



WIRING INSTRUCTIONS



WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Part No.	Length	Terminals, Connectors and End Wire Preparation
1A	Black	14-20-6537	--	Component of the Remote Dial Assembly
1B	Black	14-20-6537	--	Component of the Remote Dial Assembly
1C	Black	14-20-6537	--	Component of the Remote Dial Assembly
1D	Black	14-20-6537	--	Component of the Remote Dial Assembly
2A	Brown	22-64-4522	1.5"	Component of the 110V Power Cord. Strip end to .18".
2B	Blue	22-64-4522	1.5"	Component of the 110V Power Cord. Strip end to .18".
3A	White	23-94-6750	--	Leadwire Assembly
3B				
4A	White	23-94-6755	--	Leadwire Assembly
4B				
5A	Black	23-94-0100	--	Leadwire Assembly
5B	Black	23-94-0100	--	Leadwire Assembly
6A	Black	22-33-0035	--	Component of the Suppressor Assembly
6B	Black	22-33-0035	--	Component of the Suppressor Assembly

NOTE:
All leads must be held to ± .125".
All lead lengths are before stripping.

TERMINAL DESCRIPTION		
Code	Part No.	Qty.
T1	23-74-1060	4
T2	23-74-0017	2
T3	23-74-0010	1

CONNECTOR DESCRIPTION		