



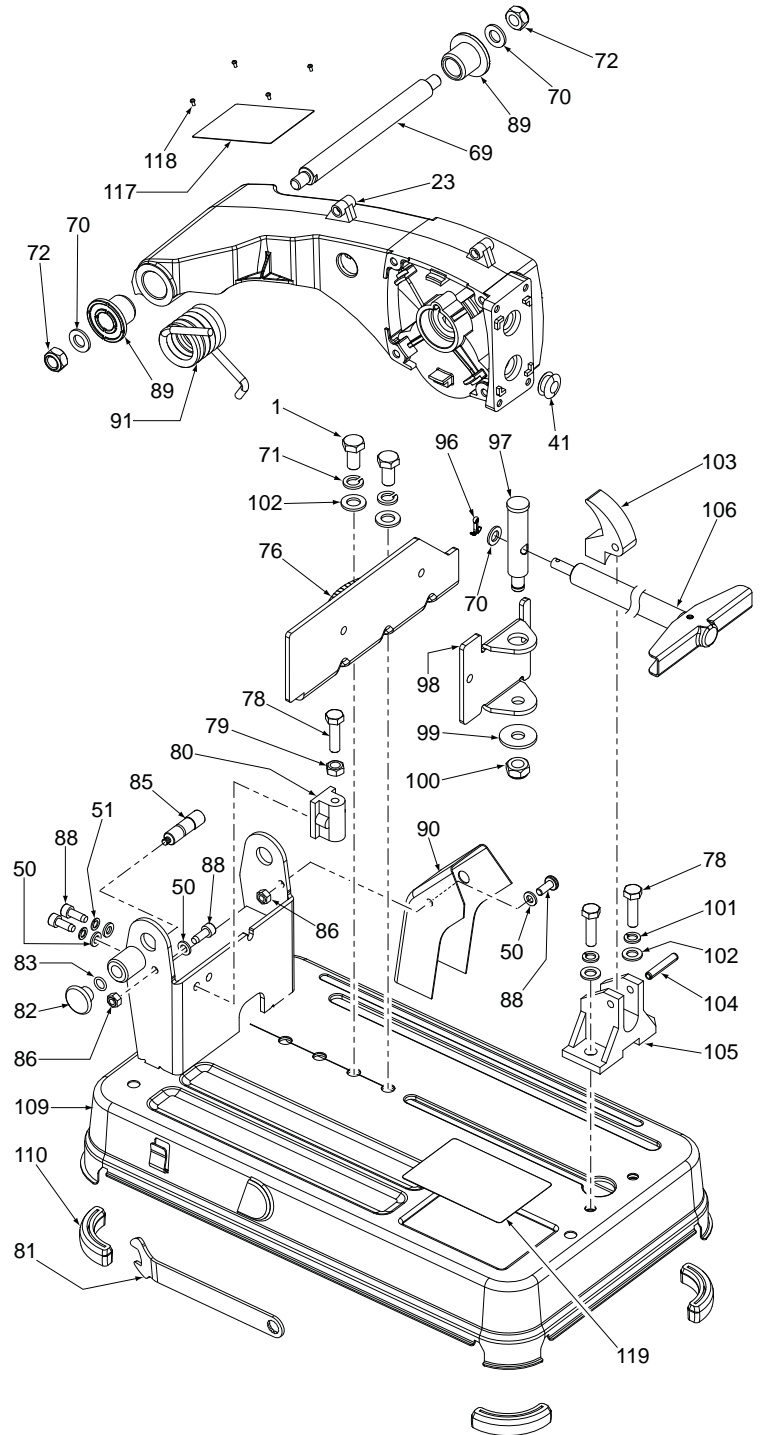
# SERVICE PARTS LIST

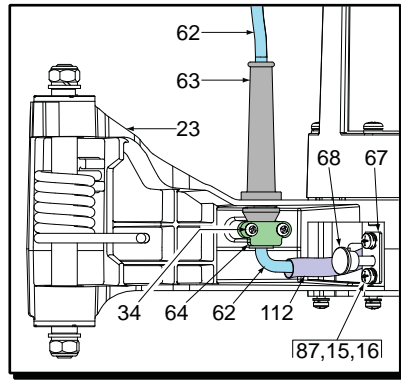
**BULLETIN NO.**  
**54-40-0675**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>14" ABRASIVE CUT-OFF MACHINE</b>			Feb. 2013
CATALOG NO. <b>6177-20</b>	STARTING SERIAL NO. <b>C77A</b>	WIRING INSTRUCTION <b>58-01-0552</b>	

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

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	05-75-0065	M10 x 17 Hex Bolt	(2)
23	28-50-0020	Upper Arm	(1)
41	44-76-0104	Grommet	(1)
50	45-88-8495	6mm Flat Washer	(4)
51	05-90-0185	6mm Spring Washer	(2)
69	42-12-0425	Shaft	(1)
70	45-88-8905	10mm Flat Washer	(3)
71	05-90-0205	10mm Spring Washer	(2)
72	05-55-0135	M10 Nut	(2)
76	45-84-0130	Rear Vise	(1)
78	05-86-0800	M8 x 13 Bolt	(3)
79	05-55-0140	M8 Hex Nut	(1)
80	42-30-0415	Stopper Body	(1)
81	45-96-0100	Wrench	(1)
82	42-42-0465	Lock Button	(1)
83	34-40-0091	O-Ring	(1)
85	44-50-0175	Lock Down Pin	(1)
86	05-55-0125	M6 Nut	(2)
88	05-74-0745	M6 x 16 Bolt	(4)
89	45-22-0690	Sleeve	(2)
90	43-54-0910	Spark Guard	(1)
91	40-50-1295	Torsion Spring	(1)
96	06-65-0017	Cotter Pin	(1)
97	44-64-0020	Vise Shaft	(1)
98	45-84-0135	Clamp Fence	(1)
99	45-88-8421	10mm Flat Washer	(1)
100	05-55-0145	M8 Nylon Hex Nut	(1)
101	05-90-0210	8mm Spring Washer	(2)
102	45-88-8915	8mm Flat Washer	(2)
103	44-40-0016	Release Nut	(1)
104	06-65-0019	Roll Pin	(1)
105	45-07-0010	Seat	(1)
106	45-84-0140	Screw Bar Assembly	(1)
109	31-06-0016	Base	(1)
110	44-34-0018	Rubber Foot	(3)
117	12-20-6177	Service Nameplate	(1)
118	06-72-1720	Nameplate Rivet	(4)
119	10-20-7300	Warning Label	(1)





**BOTTOM VIEW OF ARM (23)**

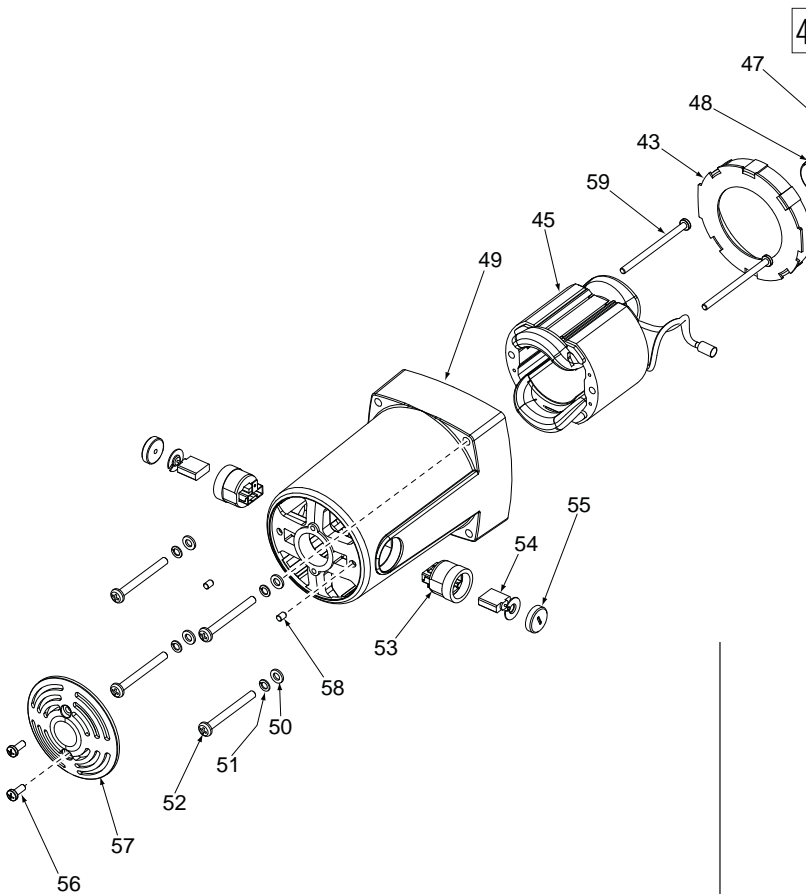


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
15	05-90-0190	5mm Spring Washer	(6)
16	45-88-8485	5mm Flat Washer	(6)
23	28-50-0020	Upper Arm	(1)
24	05-81-0811	M5 x 13 Pan Hd. Plast. Screw	(2)
25	05-81-0776	M4 x 16 Pan Hd. Plast. ST Screw	(2)
26	31-44-3220	Carrying Handle - Right	(1)
27	31-44-3225	Carrying Handle - Left	(1)
28	05-55-0030	M5 Hex Nut	(2)
30	31-44-3230	Handle - Right	(1)
31	05-81-0522	M5 x 20 Pan Hd. Screw	(4)
32	-----	Retaining Ring	(1)
34	05-81-0432	M4 x 13 Pan Hd. Screw	(2)
35	05-78-0428	M4 x 16 Pan Hd. Plast. ST Screw	(3)
36	31-44-3235	Handle - Left	(1)
38	05-78-0427	M4 x 10 Pan Hd. Plast. ST Screw	(1)
39	23-66-1425	Switch	(1)

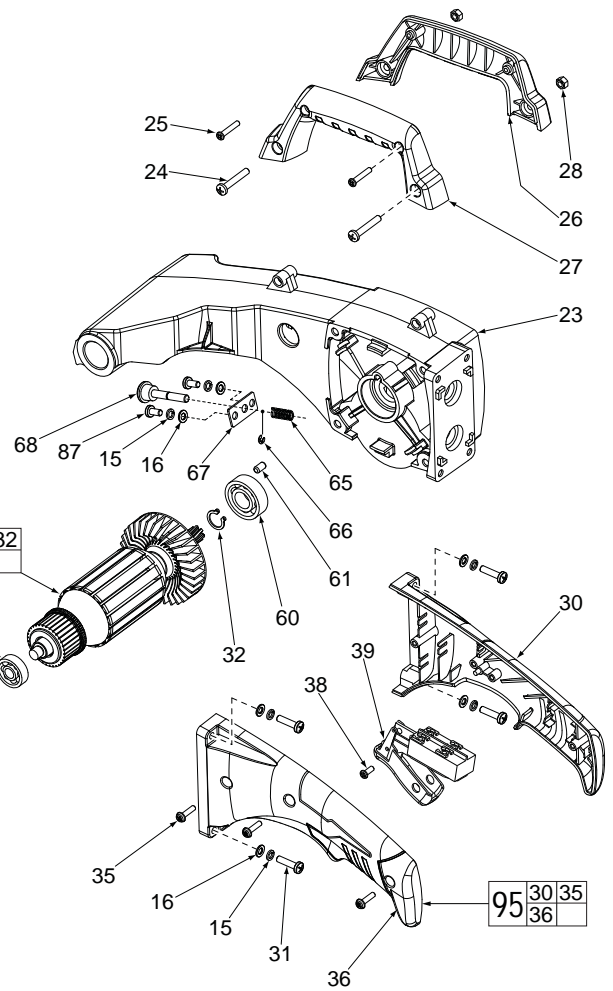


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
43	31-05-0016	Baffle	(1)
45	18-82-0100	120 V Field	(1)
46	16-82-0200	120 V Armature	(1)
47	02-04-0016	Ball Bearing	(1)
48	45-22-0725	Bearing Sleeve	(1)
49	31-50-0025	Motor Housing	(1)
50	45-89-8495	6mm Flat Washer	(4)
51	05-90-0185	6mm Spring Washer	(4)
52	05-81-0521	M6 x 60 Pan Hd. Screw	(4)
53	22-20-0017	Brush Holder	(2)
54	22-16-0036	120 V Brush	(2)
55	22-24-0027	Brush Cap	(2)
56	05-81-0476	M5 x 13 ST Screw	(2)
57	31-15-0515	End Cap	(1)
58	05-81-0495	M5 x 8 Set Screw	(2)
59	05-81-0681	M5 x 80 ST Screw	(2)
60	02-04-0026	Ball Bearing	(1)
61	44-60-1900	Rubber Pin	(1)
62	22-64-1422	120V Power Cord	(1)
63	44-76-0061	Cord Protector	(1)
64	42-68-0910	Cord Clamp	(1)
65	40-50-0136	Lock Pin Spring	(1)
66	34-60-0015	Retaining Ring	(1)
67	42-36-0056	Plate	(1)
68	44-60-0061	Lock Pin Assembly	(1)
87	05-81-0431	M5 x 10 Screw	(2)
95	14-46-3200	Operating Handle Kit	(1)
112	23-48-0105	Insulation Sleeve	(1)

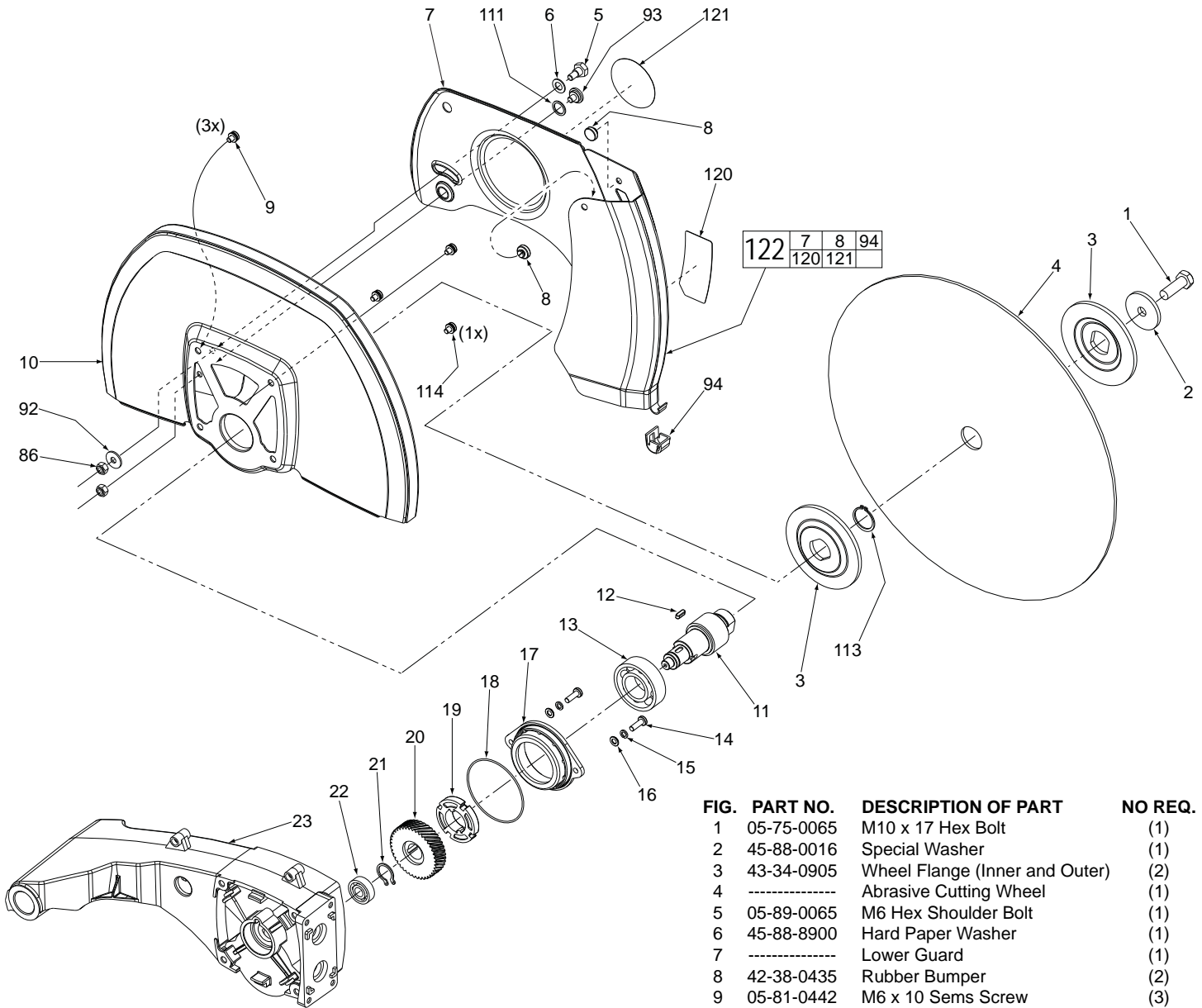


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	05-75-0065	M10 x 17 Hex Bolt	(1)
2	45-88-0016	Special Washer	(1)
3	43-34-0905	Wheel Flange (Inner and Outer)	(2)
4	-----	Abrasive Cutting Wheel	(1)
5	05-89-0065	M6 Hex Shoulder Bolt	(1)
6	45-88-8900	Hard Paper Washer	(1)
7	-----	Lower Guard	(1)
8	42-38-0435	Rubber Bumper	(2)
9	05-81-0442	M6 x 10 Sems Screw	(3)
10	43-54-0905	Upper Guard	(1)
11	38-50-0056	Spindle	(1)
12	05-42-0016	4 x 4 x 12 Key	(1)
13	02-04-0046	Ball Bearing	(1)
14	05-81-0120	M5 x 20 Pan Hd. Screw	(2)
15	05-90-0190	5mm Spring Washer	(2)
16	45-88-8485	5mm Flat Washer	(2)
17	43-34-0900	Bearing Flange	(1)
18	34-40-0090	O-Ring	(1)
19	42-74-0063	Wheel Lock	(1)
20	32-75-0016	Gear	(1)
21	05-92-0056	Retaining Ring	(1)
22	02-04-0036	Ball Bearing	(1)
23	28-50-0020	Upper Arm	(1)
86	05-55-0125	M6 Nut	(2)
92	45-88-8910	M6 Special Washer (Flat)	(1)
93	05-89-0080	M6 Shoulder Screw	(1)
94	42-52-0040	Lower Guard Cap	(1)
111	45-88-8925	Washer	(1)
113	34-60-0018	Retaining Ring	(1)
114	05-81-0441	M6 x 18 Sems Screw	(1)
120	10-20-7301	Lower Guard Label	(1)
121	10-15-6176	Round Lower Guard Label	(1)
122	43-54-0901	Lower Guard Assembly	(1)
	49-08-5270	Type 'Y' Grease (6 oz. Tube)	(1)
		(23-27 grams, approx. 7/8 oz. needed)	



# SERVICE PARTS LIST

BULLETIN NO.

54-40-0900

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>14" PREMIUM CUT-OFF MACHINE</b>			May 2011
CATALOG NO. <b>6180-20</b>	STARTING SERIAL NO. <b>896A</b>	WIRING INSTRUCTION <b>58-01-0575</b>	

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**EXAMPLE:**

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

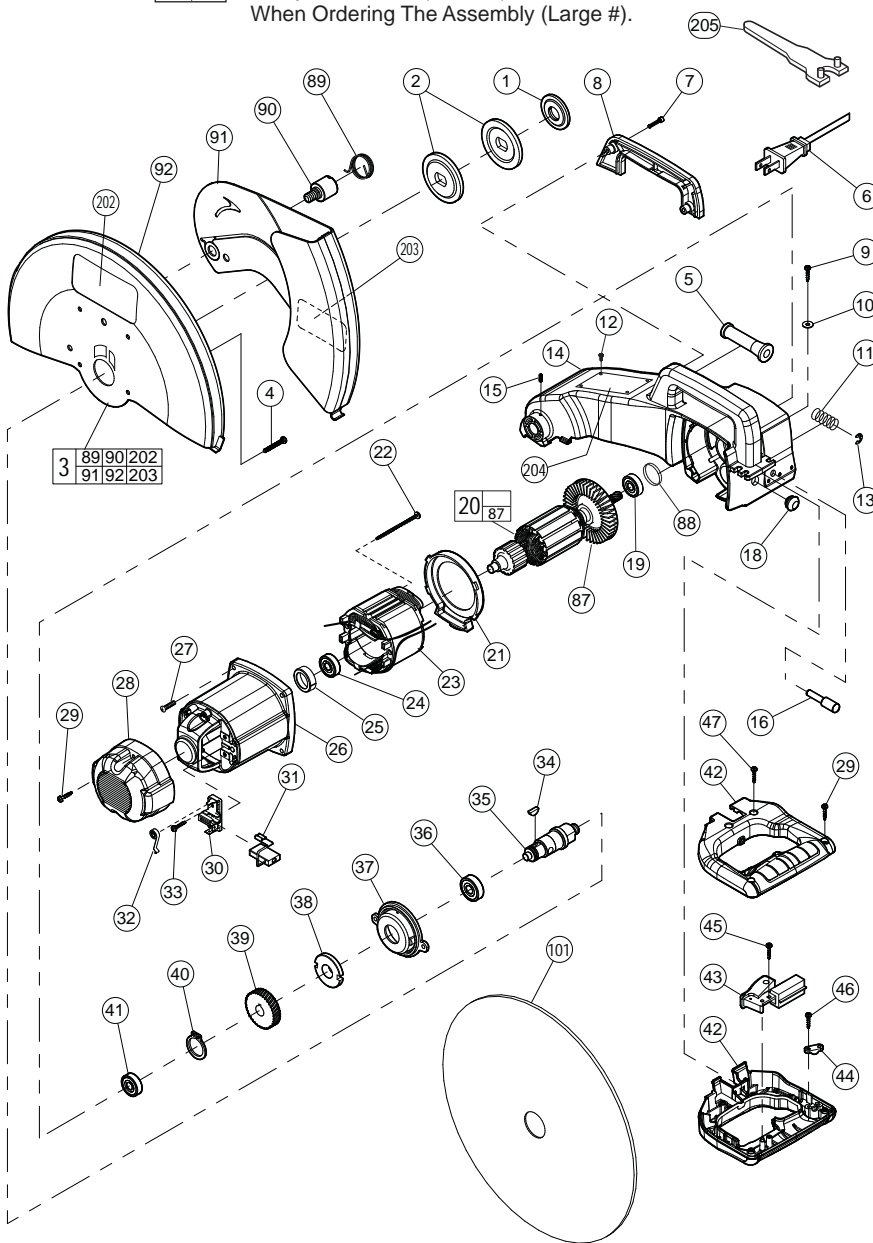


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	05-59-0120	M14 Fixtec Nut	(1)
1a	49-05-0130	Flange Nut	(1)
2	43-34-0420	Flange	(2)
3	43-54-1030	Safety Cover Assembly	(1)
4	05-81-0735	M5 x 20 Pan Hd. Screw	(4)
5	44-76-0040	Cord Protector	(1)
6	22-64-0800	Cord	(1)
7	05-74-0030	M4 x 16 Socket Hd. Hex Screw	(2)
8	31-44-0170	Handle Cover	(1)
9	05-78-0030	TS5 x 20 Tapping Screw	(2)
10	45-88-1025	Flat Washer	(2)
11	40-50-0275	Spindle Lock Spring	(1)
12	06-72-1720	Service Rivet	(4)
13	05-92-0065	Retaining Ring	(1)
14	31-40-0085	Gear Housing	(1)
15	05-86-0100	M4 x 10 Hex Socket Set Screw	(1)
16	44-60-0995	Spindle Lock Pin	(1)
18	22-90-0010	Rubber Grommet	(1)
19	02-04-0060	Ball Bearing	(1)
20	16-70-0540	Armature	(1)
21	42-14-0420	Fan Guide	(1)
22	05-78-0035	TS5 x 75 Tapping Screw	(2)
23	18-70-0540	Field	(1)
24	02-04-0065	Ball Bearing	(1)
25	42-96-0020	Rubber Cup	(1)
26	28-50-0040	Motor Housing	(1)
27	05-81-0775	M5 x 30 Pan Hd. Screw	(4)
28	42-92-0090	Motor Cover	(1)
29	05-78-0040	TS4 x 18 Tapping Screw	(4)
30	22-20-0025	Carbon Brush Holder	(2)
31	22-16-0045	Carbon Brush	(2)
32	40-50-0280	Brush Spring	(2)
33	05-78-0045	TS4 x 12 Tapping Screw	(4)
34	05-42-0020	Woodruff Key	(1)
35	38-50-0090	Spindle Shaft	(1)
36	02-04-0070	Ball Bearing	(1)
37	42-92-0095	Front Brg. Cover (Incl. Rubber Retainer)	(1)
38	42-76-0705	Spindle Stop Collar	(1)
39	32-75-0025	Gear	(1)
40	05-92-0075	Retaining Ring	(1)
41	02-04-1090	Ball Bearing	(1)
42	31-44-0175	D-Handle Halves	(1)
43	23-66-1035	Switch (Incl. 4 Screws & Star Washers)	(1)
44	44-76-0045	Strain Relief	(1)
45	05-78-0050	TS4 x 10 Tapping Screw	(1)
46	05-78-0020	TS4 x 14 Tapping Screw	(2)
47	05-78-0055	TS4 x 28 Tapping Screw	(2)
87	22-84-0090	Fan with Bushing	(1)
88	34-40-6180	O-Ring	(1)
89	-----	Safety Cover Spring	(1)
90	-----	Spring Retainer Pivot Bolt	(1)
91	-----	Outer Safety Cover	(1)
92	-----	Safety Cover	(1)
101	-----	14" Abrasive Wheel	(1)
202	10-15-2560	Logo Label	(2)
203	10-20-3055	'No Toothed Blade' Label	(1)
204	12-99-6180	Service Nameplate	(1)
205	49-96-0390	Spanner Wrench	(1)

**FIG. LUBRICATION:**

14 Place 1 to 1.25 ounces (28 - 35 grams) of Type 'Y' Grease, No. 49-08-5270, in the gear cavity of the gear housing.

**FIG. NOTES:**

1, 1a, Fixtec nut (05-59-0120) has a built in hinged lever for hand tightening or removal.

Flange nut (49-05-0130) must be tightened or removed with spanner wrench (49-96-0390).

19 Seal to face spindle gear.

24 Seal to face armature.

25 Place in motor housing prior to inserting armature.

**SERVICE TOOLS:**

61-10-1025	3/8" Slide Hammer Attachment	(1)
61-10-1050	1/2" Slide Hammer Attachment	(1)
61-10-1075	1/4" Slide Hammer Attachment	(1)

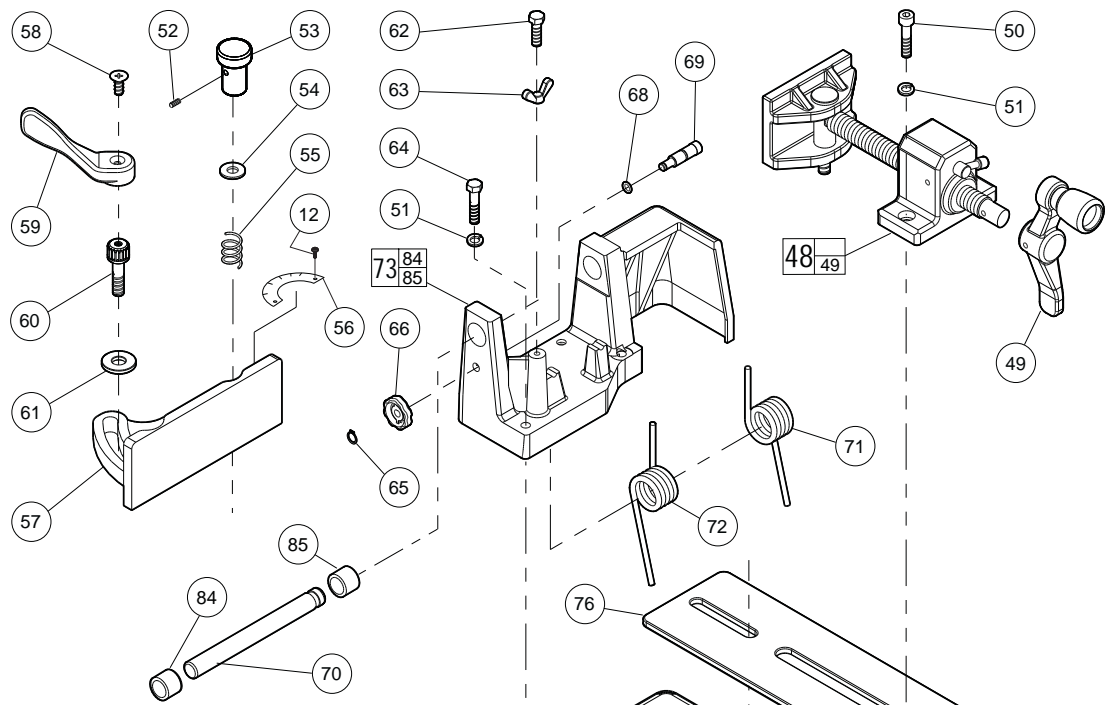
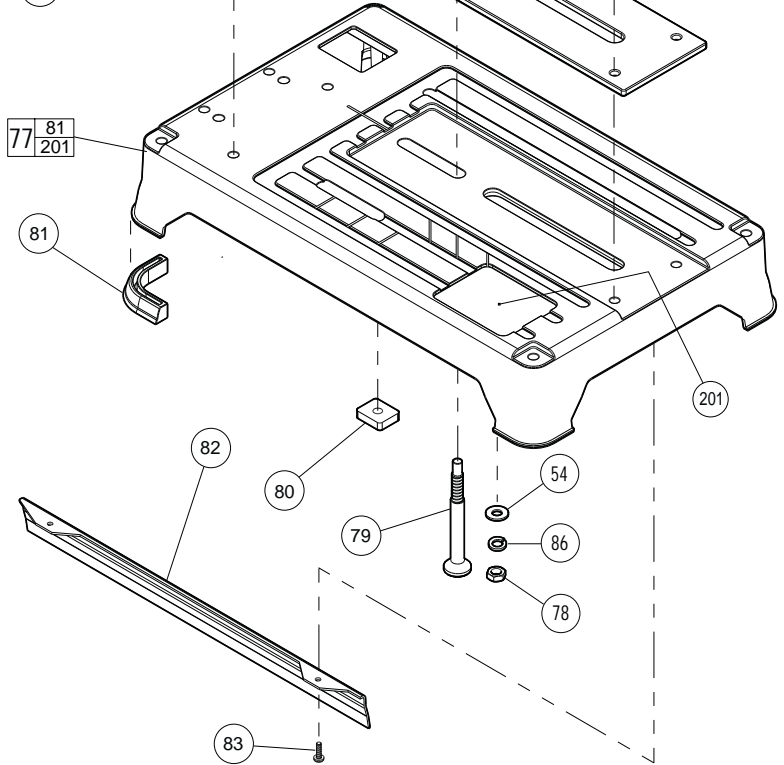


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
	12	06-72-1720 Service Rivet	(2)
	48	45-84-0120 Service Vise Assembly	(1)
	49	45-84-0125 Vise Handle Set	(1)
		(Includes two 1/4-20 Cup Point Set Screws, No. 06-83-6035, threaded into handle collar)	
	50	05-74-0035 M8 x 35 Socket Hd. Hex Screw	(2)
	51	05-90-0030 Split Washer	(6)
	52	05-86-0105 M5 x 6 Hex Socket Set Screw	(1)
	53	43-98-0020 Fence Guide Knob	(1)
	54	45-88-1355 Flat Washer	(2)
	55	40-50-0285 Spring	(1)
	56	43-82-0140 Scale Indicator	(1)
	57	42-68-0715 Fence Guide	(1)
	58	05-80-0440 M6 x 12 Counter Sunk Hd. Screw	(1)
	59	44-10-0325 Fence Guide Lever	(1)
	60	42-32-0310 Fence Bolt	(1)
	61	45-88-1360 Flat Washer	(1)
	62	05-75-0010 M8 x 45 Hex Hd. Screw	(1)
	63	06-59-0110 M8 Thumb Screw	(1)
	64	05-75-0020 M8 x 50 Hex Hd. Screw	(4)
	65	05-92-0080 Retaining Ring	(1)
	66	31-01-0055 Transportation Lock Handle	(1)
	68	34-40-0030 O-Ring	(1)
	69	44-50-0100 Transportation Lock Pin	(1)
	70	06-65-3745 Pivot Shaft	(1)
	71	40-50-0320 Torsion Spring (Right)	(1)
	72	40-50-0325 Torsion Spring (Left)	(1)
	73	42-36-1745 Pivot Block with Bushings	(1)
	74	42-92-0135 Cover Plate	(1)
	76	44-66-0210 Vise Guide Plate	(1)
	77	28-06-1120 Base	(1)
	78	05-55-0120 M10 Hex Nut	(1)
	79	42-32-0315 Fence Guide Bolt	(1)
	80	05-59-0110 Fence Guide Nut	(1)
	81	44-34-0210 Rubber Foot	(4)
	82	43-54-0350 Base Side Shield	(1)
	83	05-81-0745 M4 x 10 Pan Hd. Screw	(4)
	84	----- Bushing (20mm) Incl. with Pivot Block	(1)
	85	----- Bushing (22mm) Incl. with Pivot Block	(1)
	86	45-88-1370 Split Washer	(1)
	93	42-92-0135 Cover Plate	(1)
	94	05-78-0410 M4 x 12 Pan Hd. Screw	(2)
	201	10-15-0425 Warning Label	(1)



**NOTE:**  
 #93 Cover Plate (42-92-0135) and #94 Screws (05-78-0410) were utilized on early version Base Assemblies to close off an opening in the back of the Base. This is on tools with serial number breaks 896A and 896B.  
 Later versions of that Base Assembly have that opening closed off in the casting.

**FIG. NOTES:**  
 48,49 Vise handle set includes two (2) 1/4-20 cup point set screws threaded into handle collar.  
 77,81 If replacing the rubber feet, 3M Scotch-Grip® Rubber Cement, No. 44-22-0060, must be used to hold onto the base.





# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-40-0901**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN 54-40-0900	DATE May 2011
<b>14" PREMIUM CUT-OFF MACHINE</b>			
CATALOG NO. <b>6180-20</b>	STARTING SERIAL NO. <b>896B, 896C</b>	WIRING INSTRUCTION <b>58-01-0575</b>	

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

★ = Part number change from  
previous service parts list.

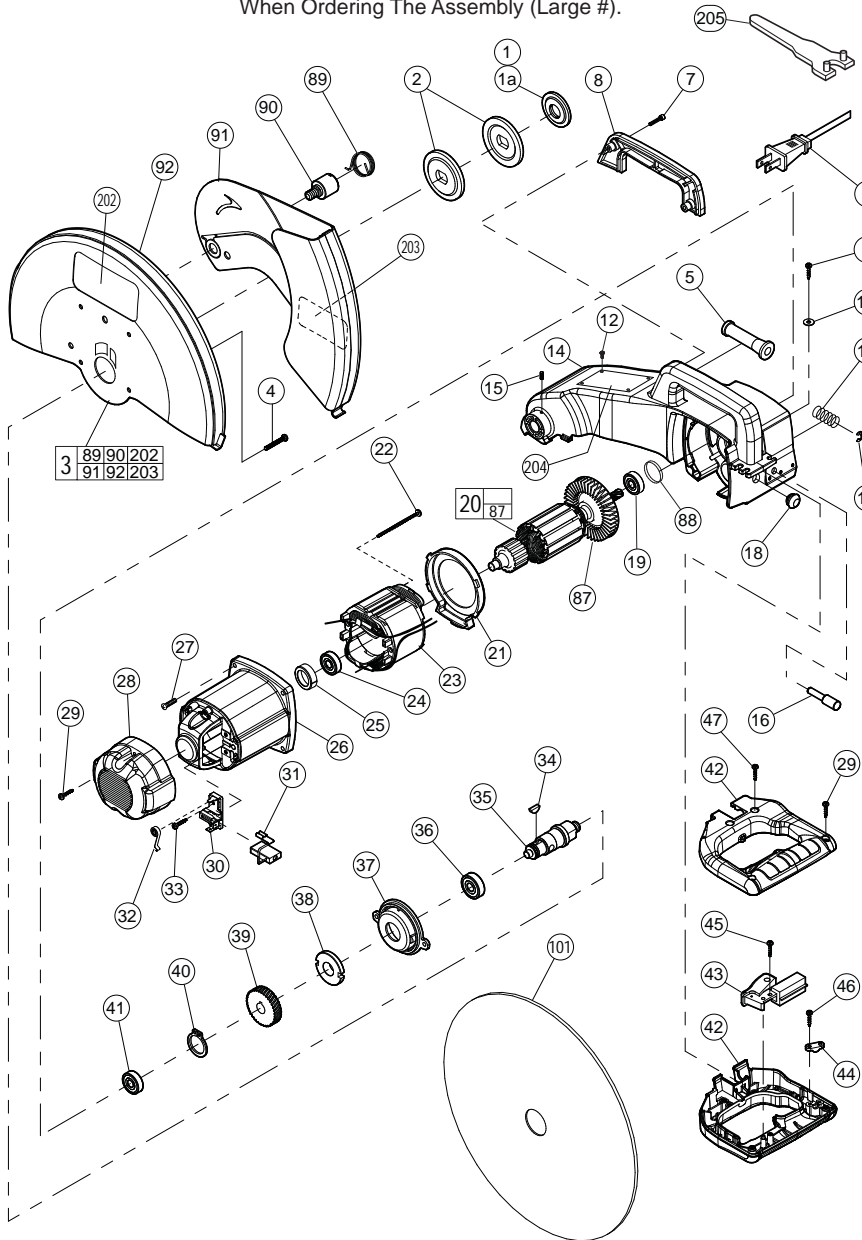


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	05-59-0120	M14 Fixtec Nut	(1)
1a	49-05-0130	Flange Nut	(1)
2	43-34-0420	Flange	(2)
3	43-54-1030	Safety Cover Assembly	(1)
4	05-81-0735	M5 x 20 Pan Hd. Screw	(4)
5	44-76-0040	Cord Protector	(1)
6	22-64-0800	Cord	(1)
7	05-74-0030	M4 x 16 Socket Hd. Hex Screw	(2)
8	31-44-0170	Handle Cover	(1)
9	05-78-0030	TS5 x 20 Tapping Screw	(2)
10	45-88-1025	Flat Washer	(2)
11	40-50-0275	Spindle Lock Spring	(1)
12	06-72-1720	Service Rivet	(4)
13	05-92-0065	Retaining Ring	(1)
14	31-40-0085	Gear Housing	(1)
15	05-86-0100	M4 x 10 Hex Socket Set Screw	(1)
16	44-60-0995	Spindle Lock Pin	(1)
18	22-90-0010	Rubber Grommet	(1)
19	02-04-0060	Ball Bearing	(1)
20	16-70-0540	Armature	(1)
21	42-14-0420	Fan Guide	(1)
22	05-78-0035	TS5 x 75 Tapping Screw	(2)
23	18-70-0540	Field	(1)
24	02-04-0065	Ball Bearing	(1)
25	42-96-0020	Rubber Cup	(1)
26	28-50-0040	Motor Housing	(1)
27	05-81-0775	M5 x 30 Pan Hd. Screw	(4)
28	42-92-0090	Motor Cover	(1)
29	05-78-0040	TS4 x 18 Tapping Screw	(4)
30	22-20-0025	Carbon Brush Holder	(2)
31	22-16-0045	Carbon Brush	(2)
32	40-50-0280	Brush Spring	(2)
33	05-78-0045	TS4 x 12 Tapping Screw	(4)
34	05-42-0020	Woodruff Key	(1)
35	38-50-0090	Spindle Shaft	(1)
36	02-04-0070	Ball Bearing	(1)
37	42-92-0095	Front Brg. Cover (Incl. Rubber Retainer)	(1)
38	42-76-0705	Spindle Stop Collar	(1)
39	32-75-0025	Gear	(1)
40	05-92-0075	Retaining Ring	(1)
41	02-04-1090	Ball Bearing	(1)
42	31-44-0175	D-Handle Halves	(1)
43	23-66-1035	Switch (Incl. 4 Screws & Star Washers)	(1)
44	44-76-0045	Strain Relief	(1)
45	05-78-0050	TS4 x 10 Tapping Screw	(1)
46	05-78-0020	TS4 x 14 Tapping Screw	(2)
47	05-78-0055	TS4 x 28 Tapping Screw	(2)
87	22-84-0090	Fan with Bushing	(1)
88	34-40-6180	O-Ring	(1)
89	-----	Safety Cover Spring	(1)
90	-----	Spring Retainer Pivot Bolt	(1)
91	-----	Outer Safety Cover	(1)
92	-----	Safety Cover	(1)
101	-----	14" Abrasive Wheel	(1)
202	10-15-2560	Logo Label	(2)
203	10-20-3055	'No Toothed Blade' Label	(1)
204	12-99-6180	Service Nameplate	(1)
205	49-96-0390	Spanner Wrench	(1)

**FIG. LUBRICATION:**

14 Place 1 to 1.25 ounces (28 - 35 grams) of Type 'Y' Grease, No. 49-08-5270, in the gear cavity of the gear housing.

**FIG. NOTES:**

1, 1a, Fixtec nut (05-59-0120) has a built in hinged lever for hand tightening or removal.

Flange nut (49-05-0130) must be tightened or removed with spanner wrench (49-96-0390).

19 Seal to face spindle gear.

24 Seal to face armature.

25 Place in motor housing prior to inserting armature.

**SERVICE TOOLS:**

61-10-1025	3/8" Slide Hammer Attachment	(1)
61-10-1050	1/2" Slide Hammer Attachment	(1)
61-10-1075	1/4" Slide Hammer Attachment	(1)

★ = Part number change from previous service parts list.

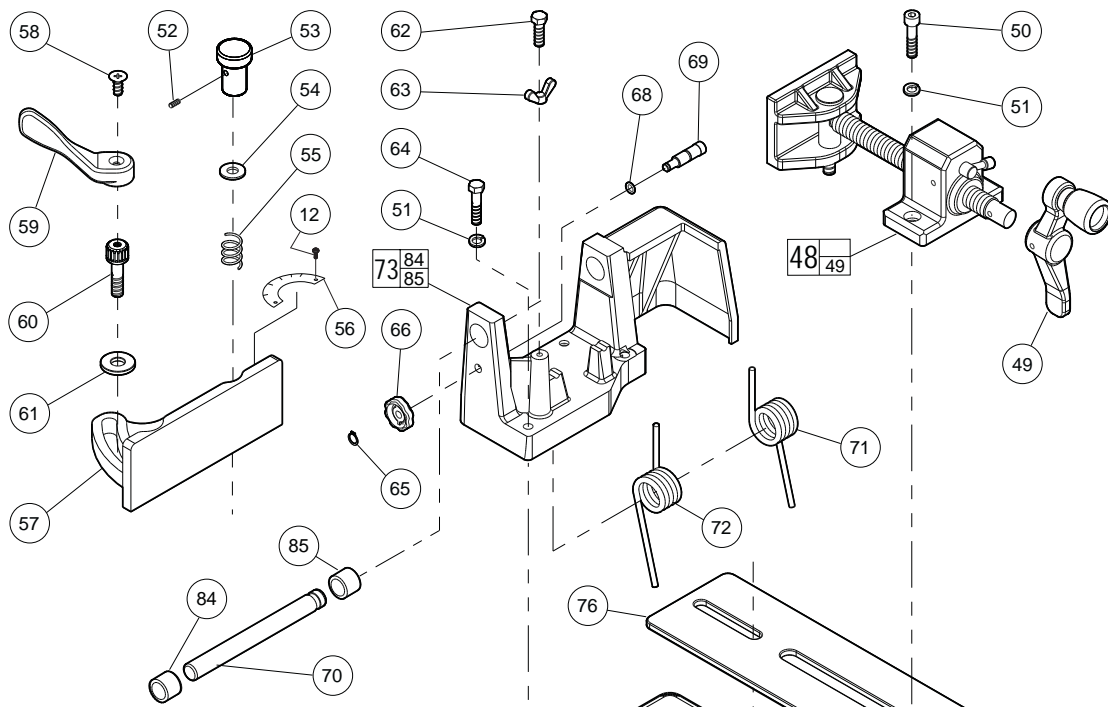
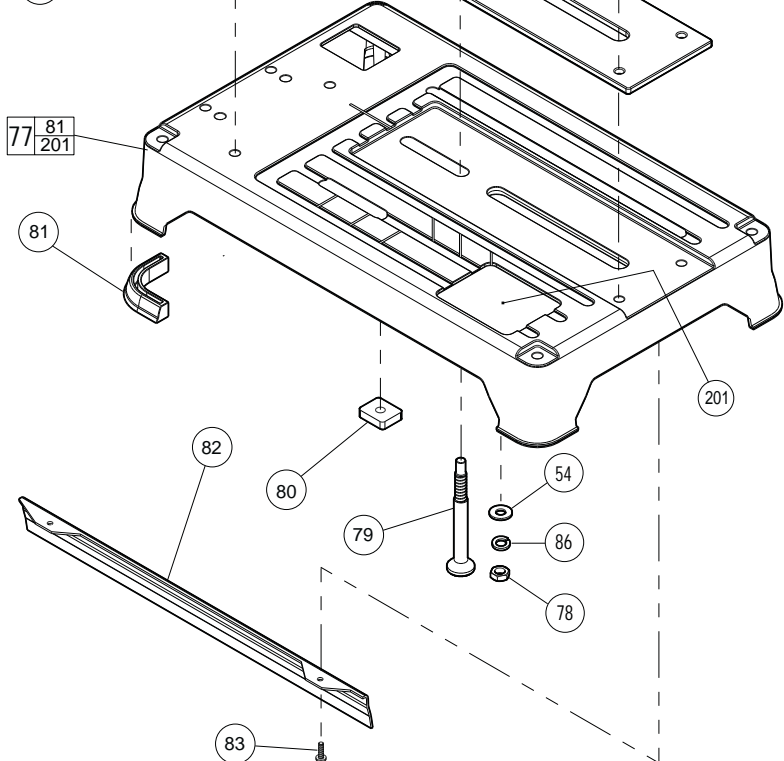


FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
	12	06-72-1720 Service Rivet	(2)
	48	45-84-0120 Service Vise Assembly	(1)
	49	45-84-0125 Vise Handle Set (Includes two 1/4-20 Cup Point Set Screws, No. 06-83-6035, threaded into handle collar)	(1)
	50	05-74-0035 M8 x 35 Socket Hd. Hex Screw	(2)
	51	05-90-0030 Split Washer	(6)
	52	05-86-0105 M5 x 6 Hex Socket Set Screw	(1)
	53	43-98-0020 Fence Guide Knob	(1)
	54	45-88-1355 Flat Washer	(2)
	55	40-50-0285 Spring	(1)
	56	43-82-0140 Scale Indicator	(1)
	57	42-68-0715 Fence Guide	(1)
	58	05-80-0440 M6 x 12 Counter Sunk Hd. Screw	(1)
	59	44-10-0325 Fence Guide Lever	(1)
	60	42-32-0310 Fence Bolt	(1)
	61	45-88-1360 Flat Washer	(1)
	62	05-75-0010 M8 x 45 Hex Hd. Screw	(1)
	63	06-59-0110 M8 Thumb Screw	(1)
	64	05-75-0020 M8 x 50 Hex Hd. Screw	(4)
	65	05-92-0080 Retaining Ring	(1)
	66	31-01-0055 Transportation Lock Handle	(1)
	68	34-40-0030 O-Ring	(1)
	69	44-50-0100 Transportation Lock Pin	(1)
	70	06-65-3745 Pivot Shaft	(1)
	71	40-50-0320 Torsion Spring (Right)	(1)
	72	40-50-0325 Torsion Spring (Left)	(1)
	73	42-36-1745 Pivot Block with Bushings	(1)
	76	44-66-0210 Vise Guide Plate	(1)
★	77	28-06-1125 Base	(1)
	78	05-55-0120 M10 Hex Nut	(1)
	79	42-32-0315 Fence Guide Bolt	(1)
	80	05-59-0110 Fence Guide Nut	(1)
	81	44-34-0210 Rubber Foot	(4)
	82	43-54-0350 Base Side Shield	(1)
★	83	05-78-0410 M4 x 12 Pan Hd. Screw	(2)
	84	----- Bushing (20mm) Incl. with Pivot Block	(1)
	85	----- Bushing (22mm) Incl. with Pivot Block	(1)
	86	45-88-1370 Split Washer	(1)
	93	42-92-0135 Cover Plate	(1)
	94	05-78-0410 M4 x 12 Pan Hd. Screw	(2)
	201	10-15-0425 Warning Label	(1)



**NOTE:**  
 #93 Cover Plate (42-92-0135) and #94 Screws (05-78-0410) were utilized on early version Base Assemblies to close off an opening in the back of the Base. This is on tools with serial number breaks 896A and 896B.  
 Later versions of that Base Assembly have that opening closed off in the casting.

**FIG. NOTES:**  
 48,49 Vise handle set includes two (2) 1/4-20 cup point set screws threaded into handle collar.

77,81 If replacing the rubber feet, 3M Scotch-Grip® Rubber Cement, No. 44-22-0060, must be used to hold onto the base.