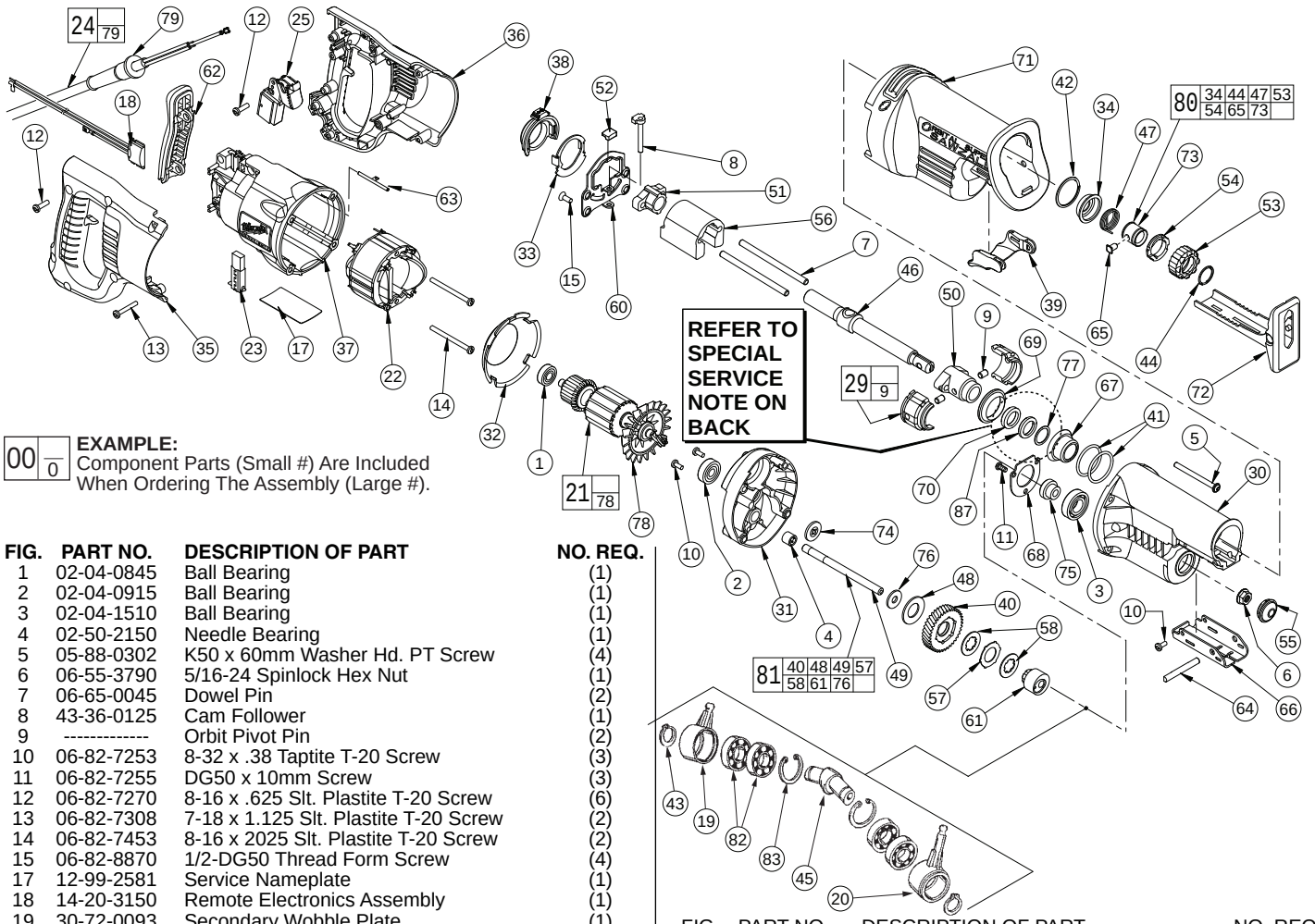
# SERVICE PARTS LIST

BULLETIN NO. 54-40-7580

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|
| 1-1/4" STROKE SAWZALL® | | | | Feb. 2017 |
| CATALOG NO. 6536-21 | STARTING SERIAL NO. A66A | | WIRING INSTRUCTION 58-01-0055 | |

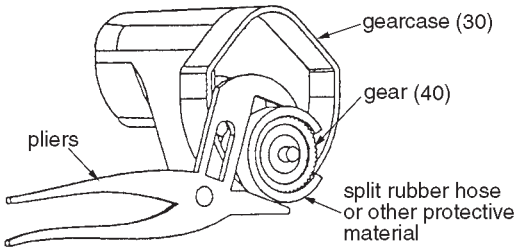



00/0 **EXAMPLE:** Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

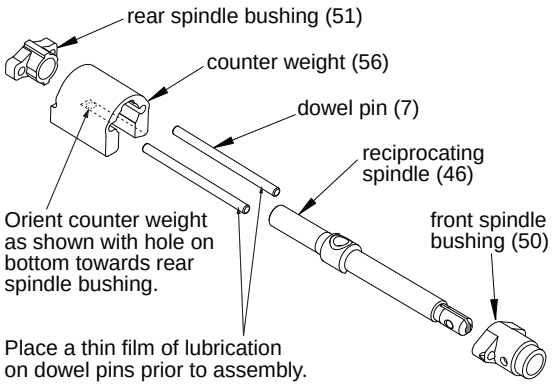
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 1 | 02-04-0845 | Ball Bearing | (1) |
| 2 | 02-04-0915 | Ball Bearing | (1) |
| 3 | 02-04-1510 | Ball Bearing | (1) |
| 4 | 02-50-2150 | Needle Bearing | (1) |
| 5 | 05-88-0302 | K50 x 60mm Washer Hd. PT Screw | (4) |
| 6 | 06-55-3790 | 5/16-24 Spinlock Hex Nut | (1) |
| 7 | 06-65-0045 | Dowel Pin | (2) |
| 8 | 43-36-0125 | Cam Follower | (1) |
| 9 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7308 | 7-18 x 1.125 Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| 18 | 14-20-3150 | Remote Electronics Assembly | (1) |
| 19 | 30-72-0093 | Secondary Wobble Plate | (1) |
| 20 | 30-72-0085 | Primary Wobble Plate | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| 24 | 22-64-1121 | Cord Assembly | (1) |
| 25 | 23-66-1965 | Switch | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2500 | Handle Half - Right | (1) |
| 36 | 31-44-2501 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0065 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0575 | Orbit Drive Hub | (1) |
| 62 | 44-52-1000 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 82 | 02-04-1510 | Ball Bearing | (4) |
| 83 | 34-80-2600 | Internal Retaining Ring | (2) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |
| 82,83 | Sharp side of retaining ring faces ball bearing. |




**SPECIAL SERVICE NOTE:**

Early production (Series 1) of Sawzall 6536-21 with serial break 'A' will have a 'Red' spindle seal (45-06-0115) and two steel washers (45-88-8577).

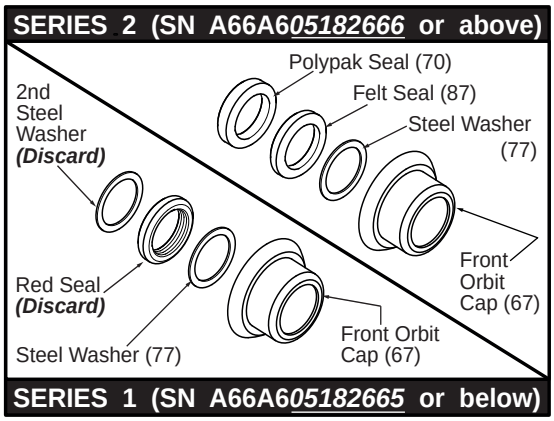
'Red' spindle seal No. 45-06-0115 is obsolete with no direct replacement.

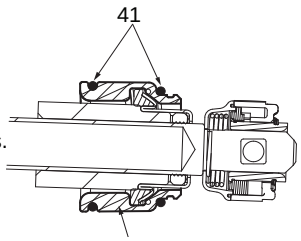
When servicing Series 1 (A) revision Sawzalls (SN A66A605182665 or less) with worn out / damaged 'Red' spindle seal, the following needs to be done:

- use the existing front orbit cap No. 44-86-0035.
- use one of the existing steel washers (discard the second washer).
- discard worn out / damaged 'Red' spindle seal.

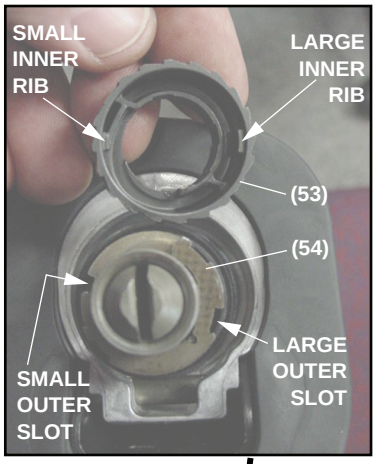
To Assemble

- place one steel washer (45-88-8577) inside front orbit cap.
- place felt seal (45-06-0501) inside front orbit cap. (Soak in lightweight bushing oil prior to assembly).
- place / press polypak seal (45-06-0475) inside front orbit cap. (O-ring of polypak seal must face mechanism - toward rear of tool).






| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | 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. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |

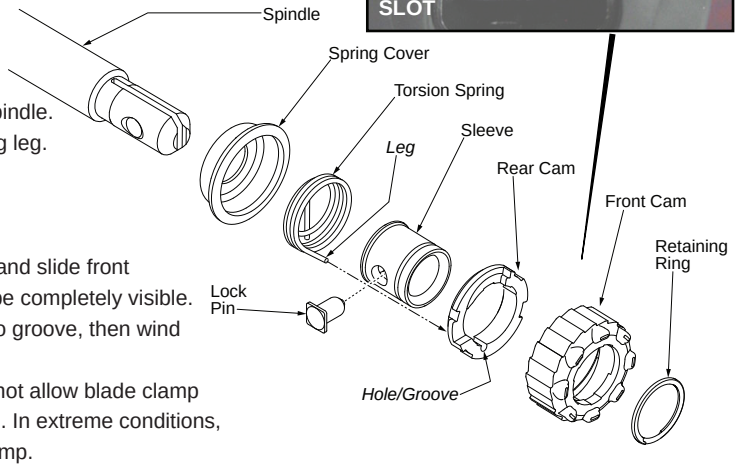



**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

- 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**

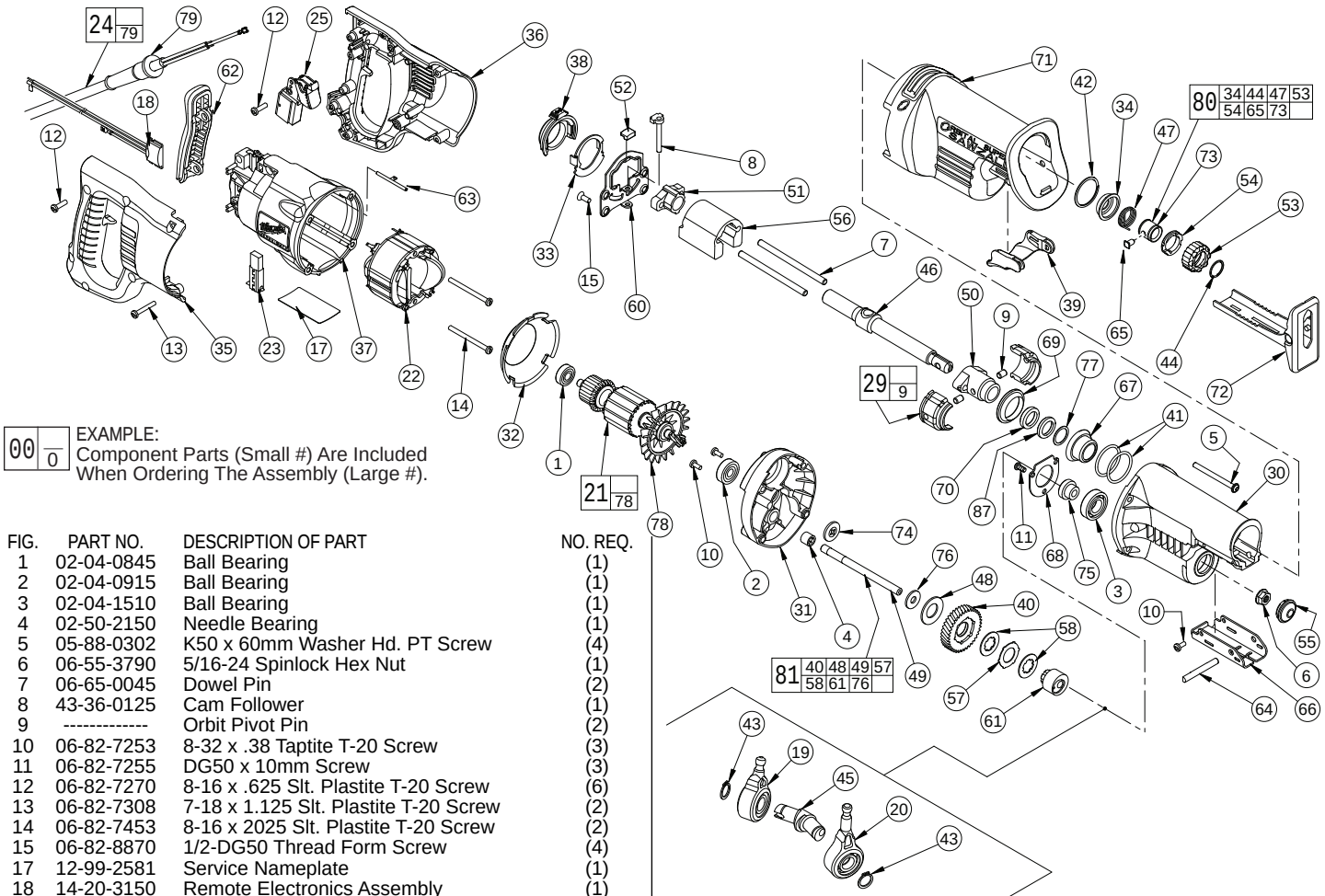
- Coat new lock pin with powdered graphite.
- Hold tool in a vertical position.
- Place spring cover (34) onto spindle.
- Slide torsion spring (47) onto spindle shaft with leg positioned at the 6:00 position.
- Slide sleeve (73) onto spindle aligning hole on sleeve with hole in spindle.
- Slide rear 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.



# SERVICE PARTS LIST

BULLETIN NO. 54-40-7581

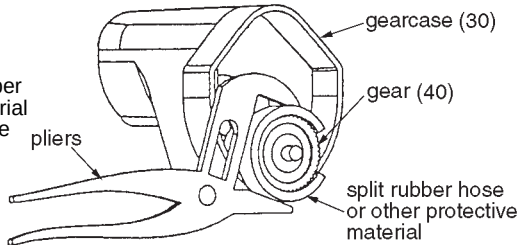
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|---|
| 1-1/4" STROKE SAWZALL® | | | | 54-40-7580 | Feb. 2017 |
| CATALOG NO. | 6536-21 | STARTING SERIAL NO. | A66B | WIRING INSTRUCTION | 58-01-0055 |



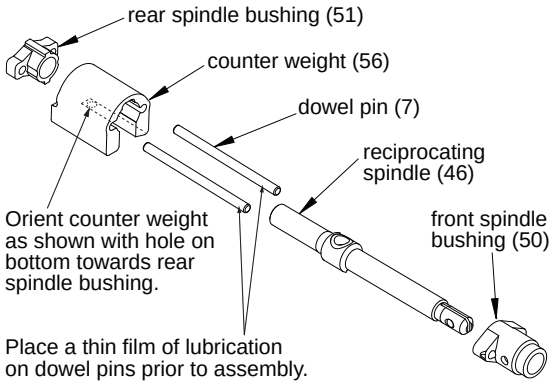

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 1 | 02-04-0845 | Ball Bearing | (1) |
| 2 | 02-04-0915 | Ball Bearing | (1) |
| 3 | 02-04-1510 | Ball Bearing | (1) |
| 4 | 02-50-2150 | Needle Bearing | (1) |
| 5 | 05-88-0302 | K50 x 60mm Washer Hd. PT Screw | (4) |
| 6 | 06-55-3790 | 5/16-24 Spinlock Hex Nut | (1) |
| 7 | 06-65-0045 | Dowel Pin | (2) |
| 8 | 43-36-0125 | Cam Follower | (1) |
| 9 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7308 | 7-18 x 1.125 Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| 18 | 14-20-3150 | Remote Electronics Assembly | (1) |
| ★ 19 | 14-67-0125 | Secondary Wobble Plate Assembly | (1) |
| ★ 20 | 14-67-0135 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| 24 | 22-64-1121 | Cord Assembly | (1) |
| 25 | 23-66-1965 | Switch | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2500 | Handle Half - Right | (1) |
| 36 | 31-44-2501 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0065 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0575 | Orbit Drive Hub | (1) |
| 62 | 44-52-1000 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

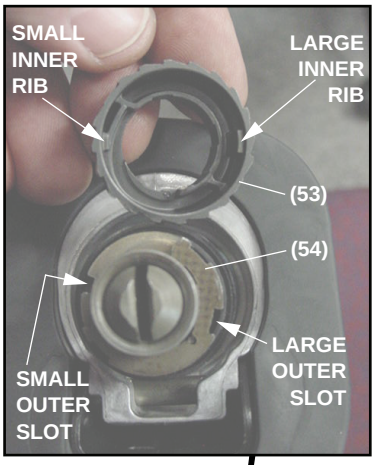


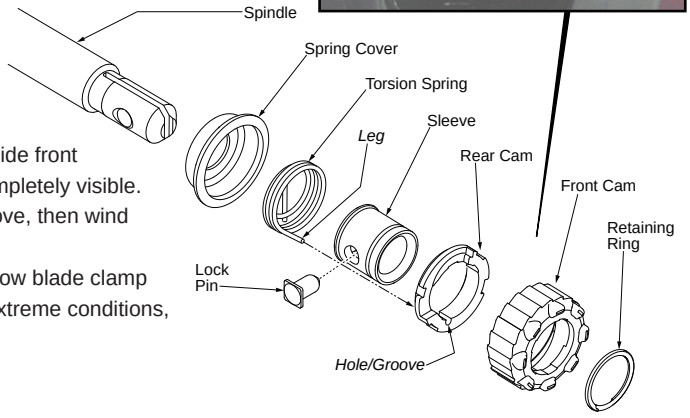

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

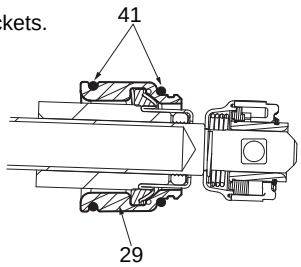
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.



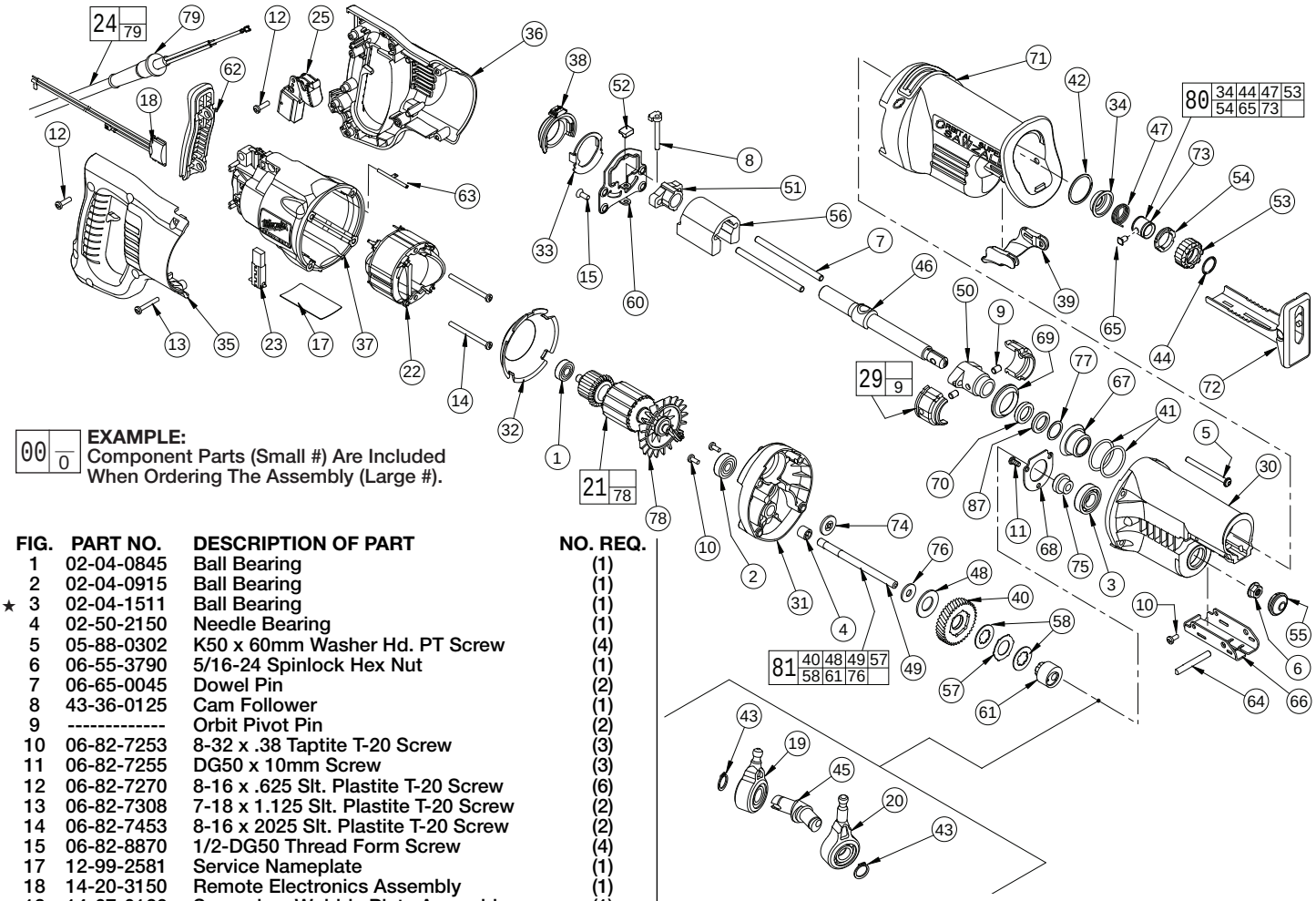

| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



# SERVICE PARTS LIST

BULLETIN NO. 54-40-7582

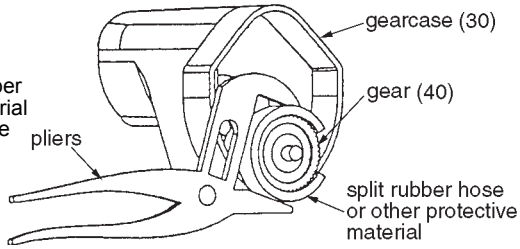
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|
| 1-1/4" STROKE SAWZALL® | | | 54-40-7581 | Feb. 2017 |
| CATALOG NO. | 6536-21 | STARTING SERIAL NO. | A66C | WIRING INSTRUCTION 58-01-0055 |



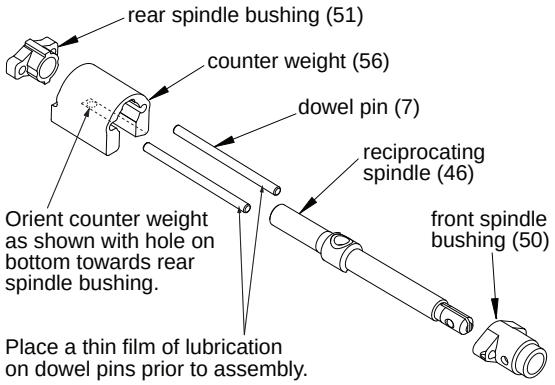

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 1 | 02-04-0845 | Ball Bearing | (1) |
| 2 | 02-04-0915 | Ball Bearing | (1) |
| ★ 3 | 02-04-1511 | Ball Bearing | (1) |
| 4 | 02-50-2150 | Needle Bearing | (1) |
| 5 | 05-88-0302 | K50 x 60mm Washer Hd. PT Screw | (4) |
| 6 | 06-55-3790 | 5/16-24 Spinlock Hex Nut | (1) |
| 7 | 06-65-0045 | Dowel Pin | (2) |
| 8 | 43-36-0125 | Cam Follower | (1) |
| 9 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7308 | 7-18 x 1.125 Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| 18 | 14-20-3150 | Remote Electronics Assembly | (1) |
| ★ 19 | 14-67-0126 | Secondary Wobble Plate Assembly | (1) |
| ★ 20 | 14-67-0136 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| 24 | 22-64-1121 | Cord Assembly | (1) |
| 25 | 23-66-1965 | Switch | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2500 | Handle Half - Right | (1) |
| 36 | 31-44-2501 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| ★ 50 | 42-24-0066 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0575 | Orbit Drive Hub | (1) |
| 62 | 44-52-1000 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

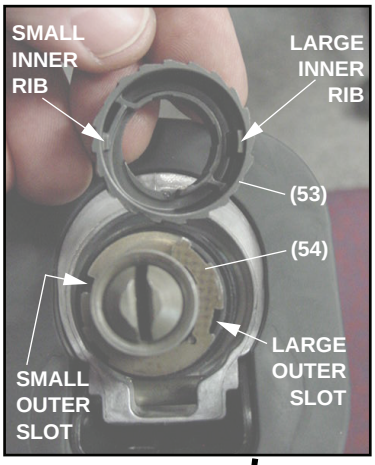


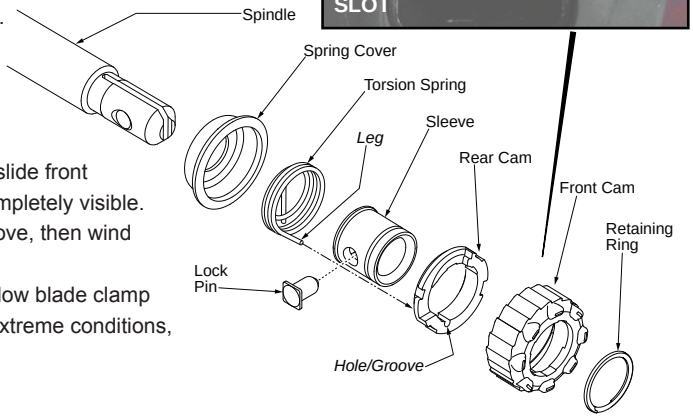

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

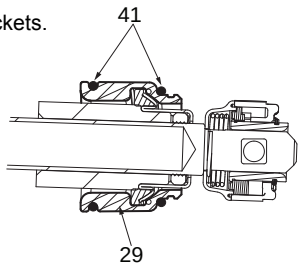
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.



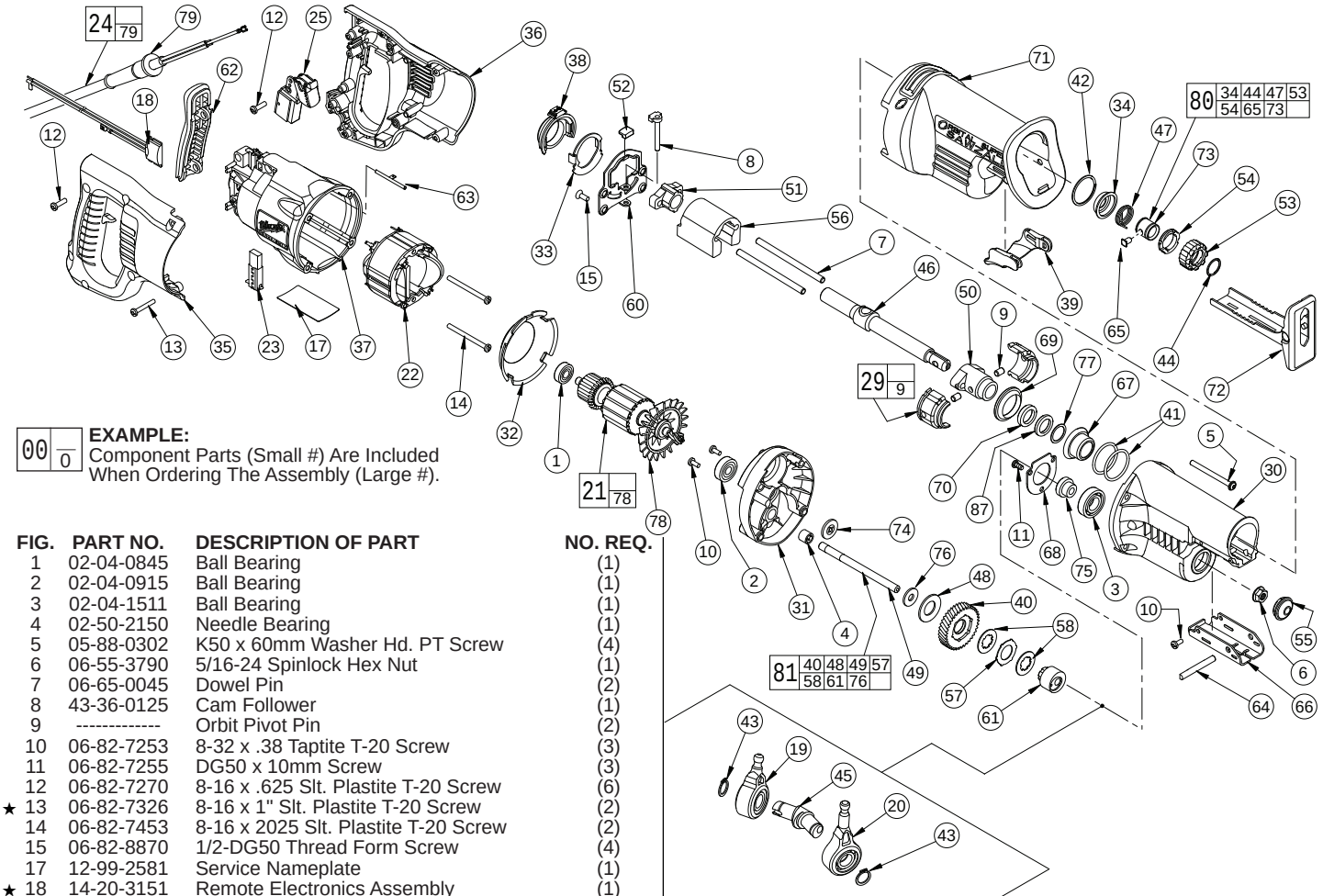

| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



# SERVICE PARTS LIST

**BULLETIN NO.**
**54-40-7583**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|
| **1-1/4" STROKE SAWZALL®** | | | 54-40-7582 | Feb. 2017 |
| **CATALOG NO.** | **6536-21** | STARTING SERIAL NO. **A66D** | WIRING INSTRUCTION **58-01-0056** | |

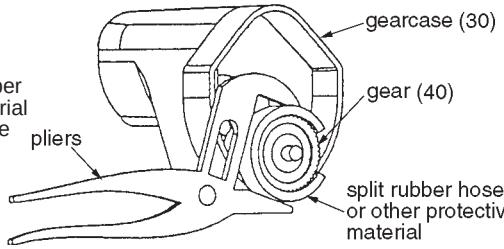



00 0 **EXAMPLE:**
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

| 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 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| ★ 13 | 06-82-7326 | 8-16 x 1" Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| ★ 18 | 14-20-3151 | Remote Electronics Assembly | (1) |
| 19 | 14-67-0126 | Secondary Wobble Plate Assembly | (1) |
| 20 | 14-67-0136 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| ★ 24 | 22-64-1122 | Cord Assembly | (1) |
| ★ 25 | 23-66-0205 | Switch | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2500 | Handle Half - Right | (1) |
| 36 | 31-44-2501 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0066 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

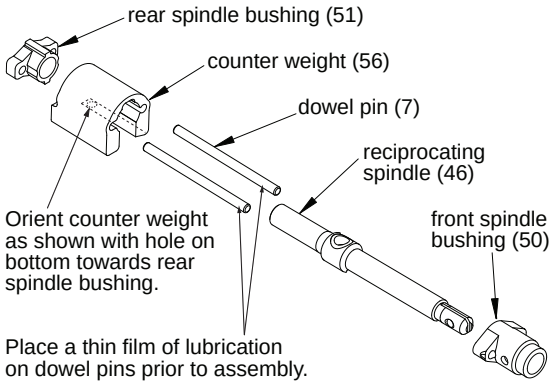
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0575 | Orbit Drive Hub | (1) |
| ★ 62 | 44-52-0105 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




**Service Fixture**
**61-10-0270**
(Pressing Pin Tool)

| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

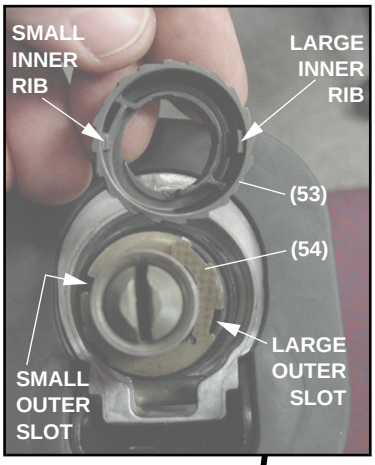


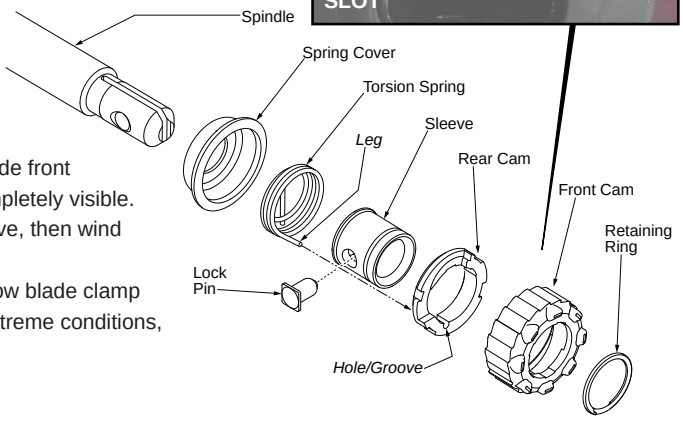

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

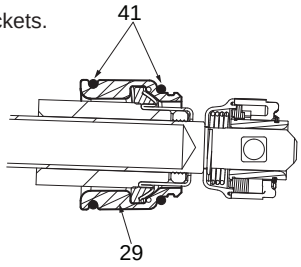
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.



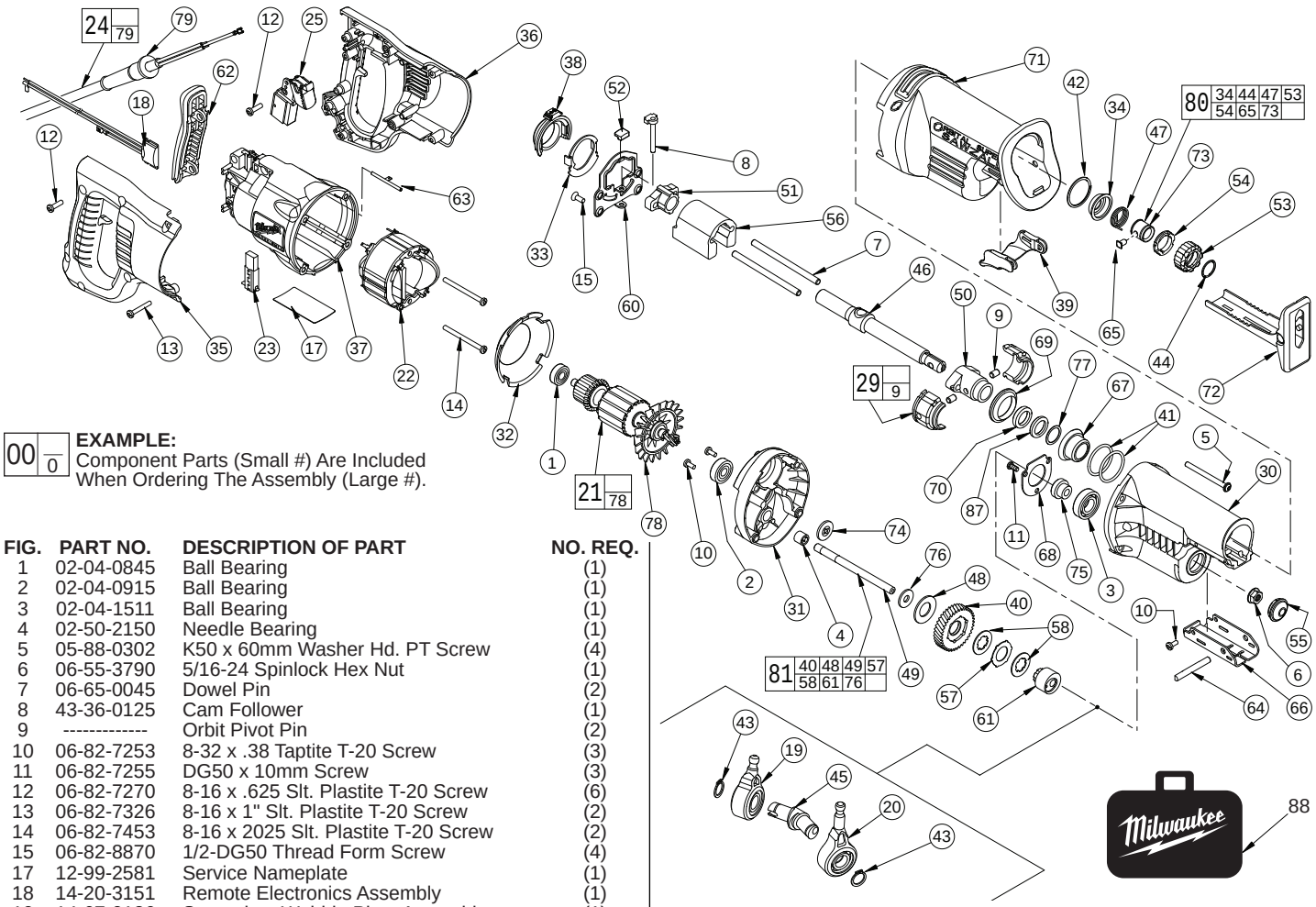

| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



# SERVICE PARTS LIST

**BULLETIN NO. 54-40-7584**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|
| **1-1/4" STROKE SAWZALL®** | | | 54-40-7583 | Feb. 2017 |
| **CATALOG NO.** | **6536-21** | STARTING SERIAL NO. **A66E** | WIRING INSTRUCTION **58-01-0056** | |

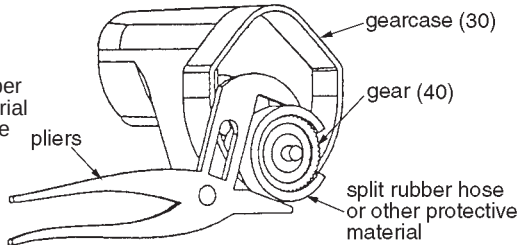



00 0 **EXAMPLE:**
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

| 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 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7326 | 8-16 x 1" Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| 18 | 14-20-3151 | Remote Electronics Assembly | (1) |
| 19 | 14-67-0126 | Secondary Wobble Plate Assembly | (1) |
| 20 | 14-67-0136 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| ★ 24 | 22-64-1124 | Cord Assembly | (1) |
| 25 | 23-66-0205 | Switch | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| ★ 35 | 31-44-2505 | Handle Half - Right | (1) |
| ★ 36 | 31-44-2506 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0066 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

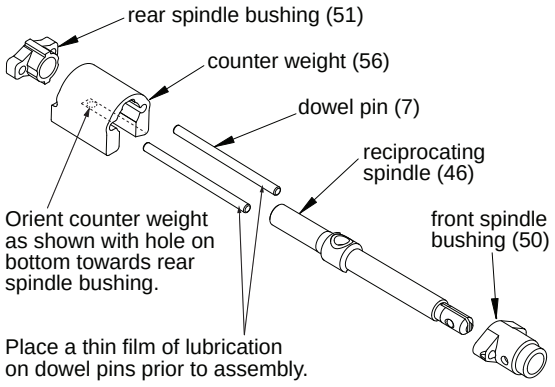
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| ★ 61 | 43-78-0577 | Orbit Drive Hub | (1) |
| 62 | 44-52-0105 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| ★ 88 | 42-55-2051 | Carrying Case | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




**Service Fixture**
**61-10-0270**
(Pressing Pin Tool)

| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

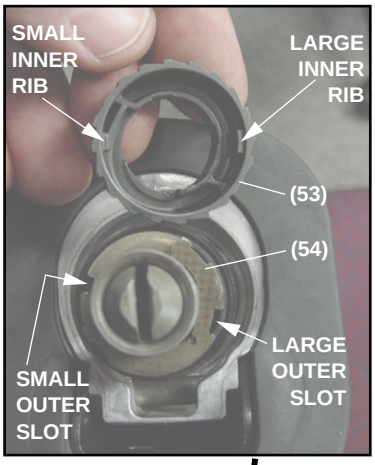


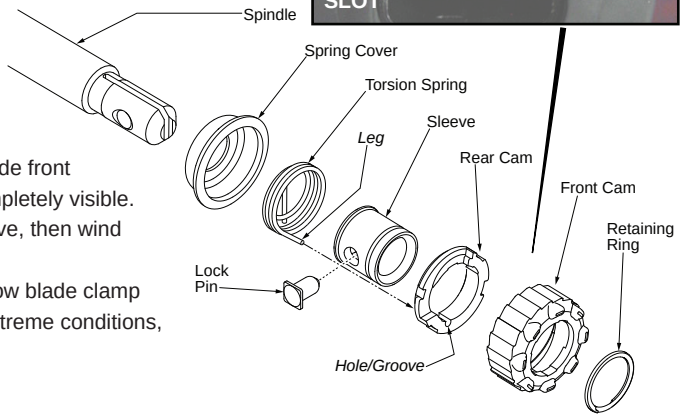

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

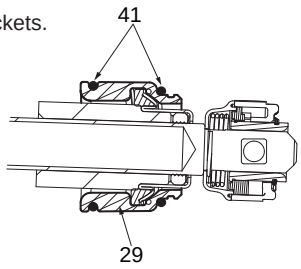
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.



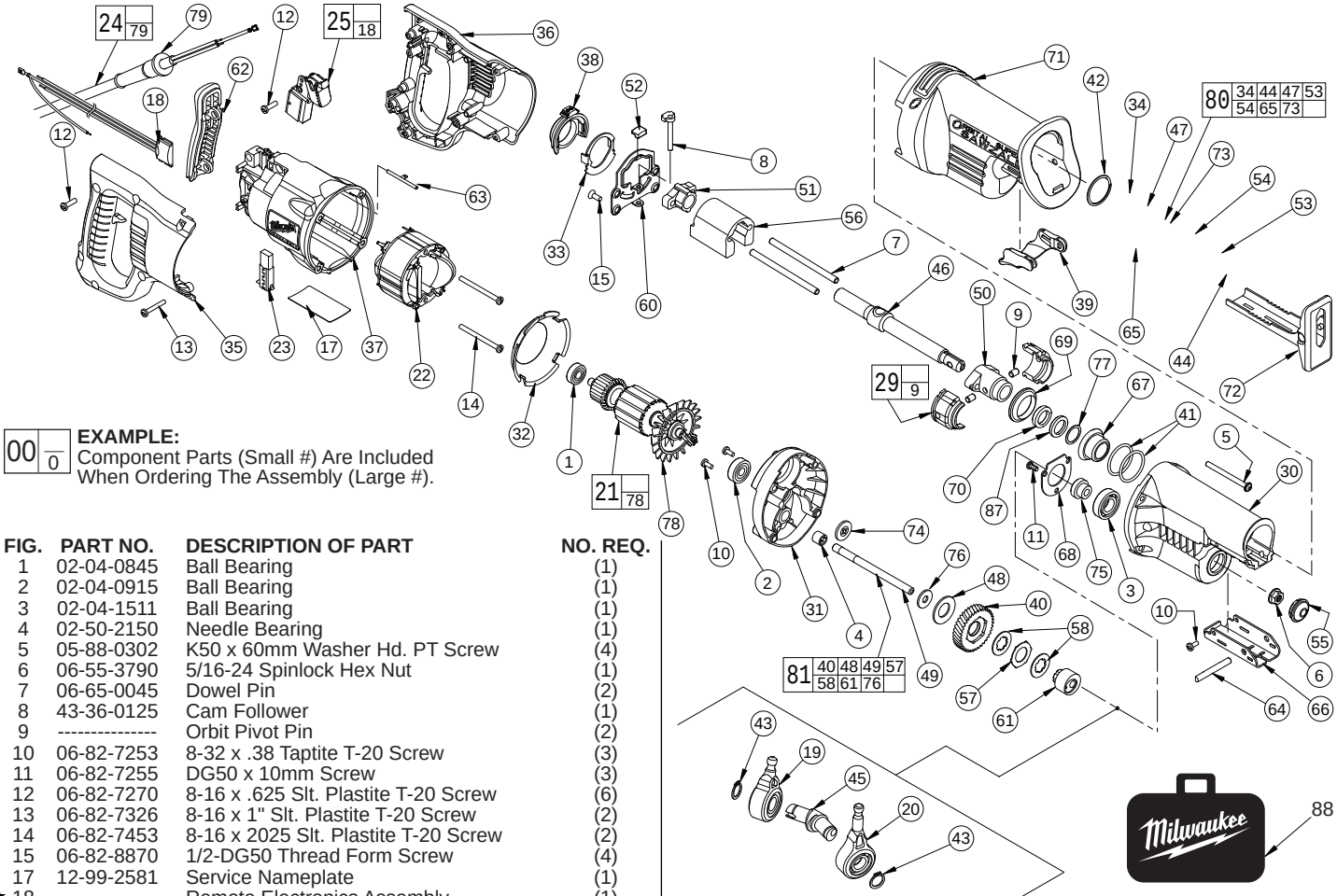

| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



# SERVICE PARTS LIST

BULLETIN NO. 54-40-7585

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
|---|---|---|---|---|
| 1-1/4" STROKE SAWZALL® | | | 54-40-7584 | Feb. 2017 |
| CATALOG NO. 6536-21 | STARTING SERIAL NO. A66F | | WIRING INSTRUCTION | See Page 3 |



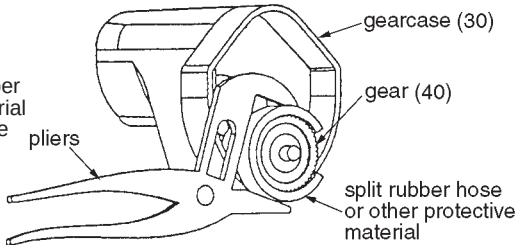




| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 1 | 02-04-0845 | Ball Bearing | (1) |
| 2 | 02-04-0915 | Ball Bearing | (1) |
| 3 | 02-04-1511 | Ball Bearing | (1) |
| 4 | 02-50-2150 | Needle Bearing | (1) |
| 5 | 05-88-0302 | K50 x 60mm Washer Hd. PT Screw | (4) |
| 6 | 06-55-3790 | 5/16-24 Spinlock Hex Nut | (1) |
| 7 | 06-65-0045 | Dowel Pin | (2) |
| 8 | 43-36-0125 | Cam Follower | (1) |
| 9 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7326 | 8-16 x 1" Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| ★ 18 | ---------- | Remote Electronics Assembly | (1) |
| 19 | 14-67-0126 | Secondary Wobble Plate Assembly | (1) |
| 20 | 14-67-0136 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| 24 | 22-64-1124 | Cord Assembly | (1) |
| ★ 25 | 23-66-4245 | Switch Assembly | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2505 | Handle Half - Right | (1) |
| 36 | 31-44-2506 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0066 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

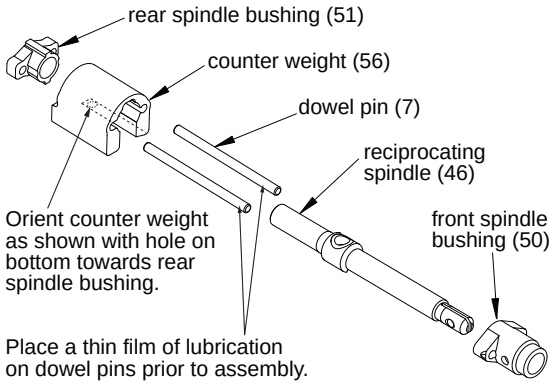
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0577 | Orbit Drive Hub | (1) |
| 62 | 44-52-0105 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| 88 | 42-55-2051 | Carrying Case | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




**Service Fixture**
**61-10-0270**
(Pressing Pin Tool)

| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

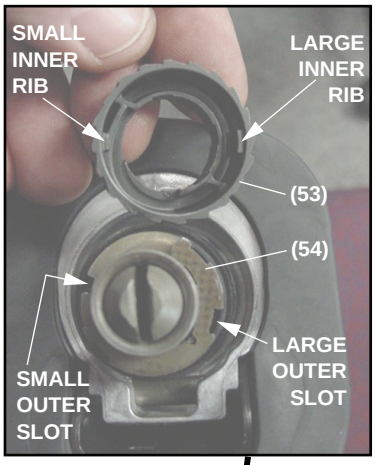


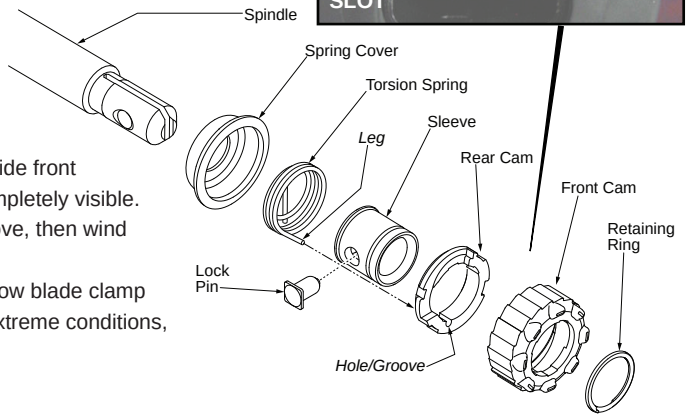

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

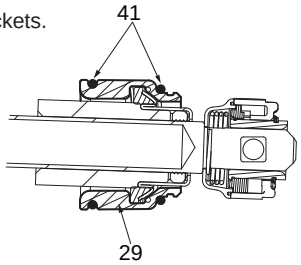
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.

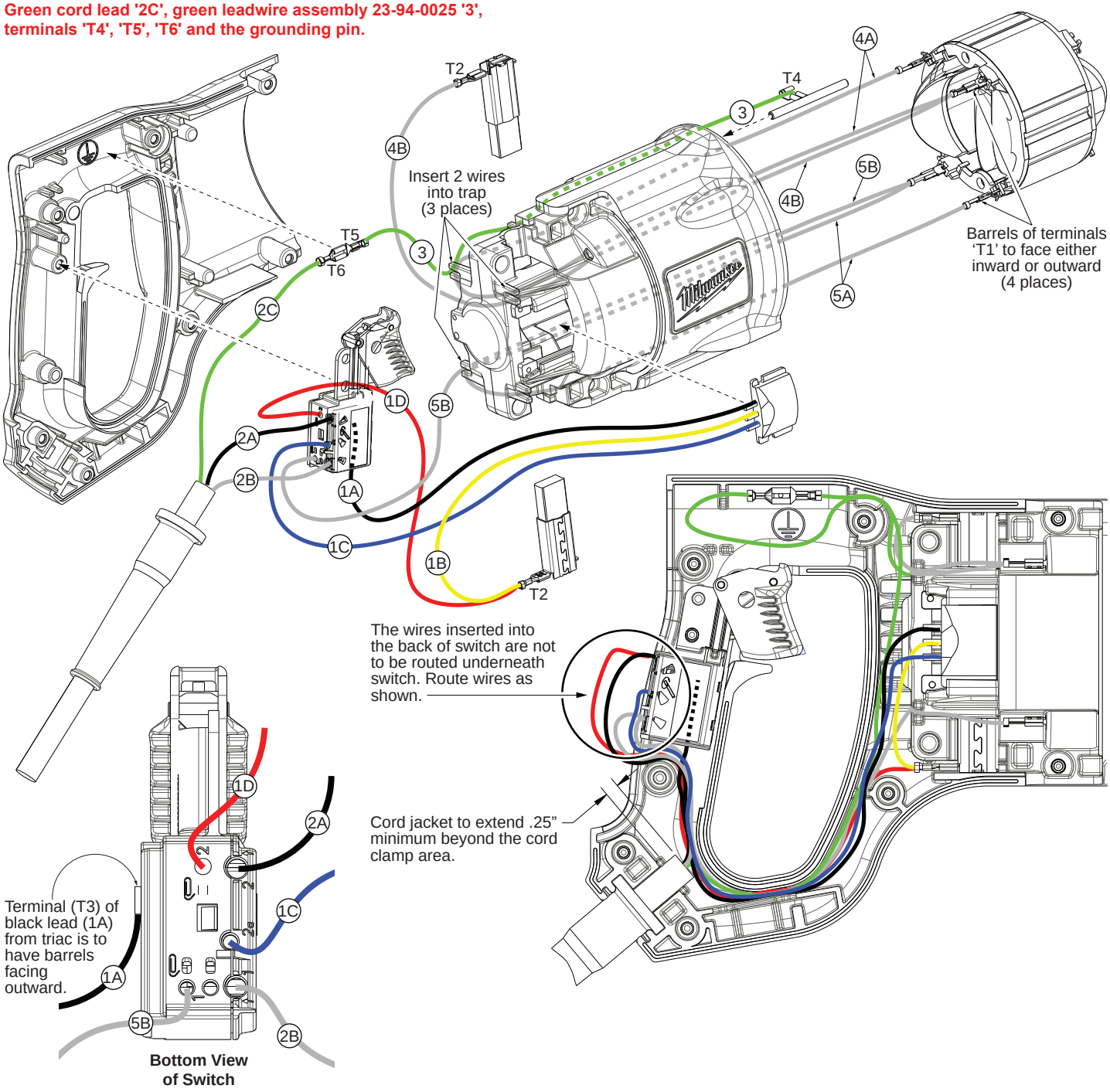



| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



**NOTE: For (DI) Double Insulated tools disregard the following: Green cord lead '2C', green leadwire assembly 23-94-0025 '3', terminals 'T4', 'T5', 'T6' and the grounding pin.**




| WIRING SPECIFICATIONS | | | | | | |
|---|---|---|---|---|---|---|
| Wire No. | Wire Color | Origin or Part No. | Ga. | Length | Terminals, Connectors and End Wire Preparation | |
| 1A | Black | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1B | Yellow | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1C | Blue | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1D | Red | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 2A | Black | Cord Assembly | 16 | 4.00 | Strip .340 and tin. | |
| 2B | White | Cord Assembly | 16 | 3.25 | Strip .340 and tin. | |
| 2C | Green | Cord Assembly | 16 | 11.25 | Strip .19 for T6. | |
| 3 | Green | 23-94-0025 | 18 | 7.00 | Strip each end .190 for T4 and T5. | |
| 4A | White | 23-94-6750 | 18 | 2.90 | Strip one end .19 for T2. | Strip both .15 and join for T1. |
| 4B | White | 23-94-6750 | 18 | 5.00 | Strip one end .15 for T1. | |
| 5A | White | 23-94-6755 | 18 | 9.25 | Strip one .320 and tin. | Strip both .15 and join for T1. |
| 5B | White | 23-94-6755 | 18 | 5.00 | Strip one end .15 for T1. | |
| BULK LEAD WIRE - BULLETIN 58-01-0003 | | | | | | |

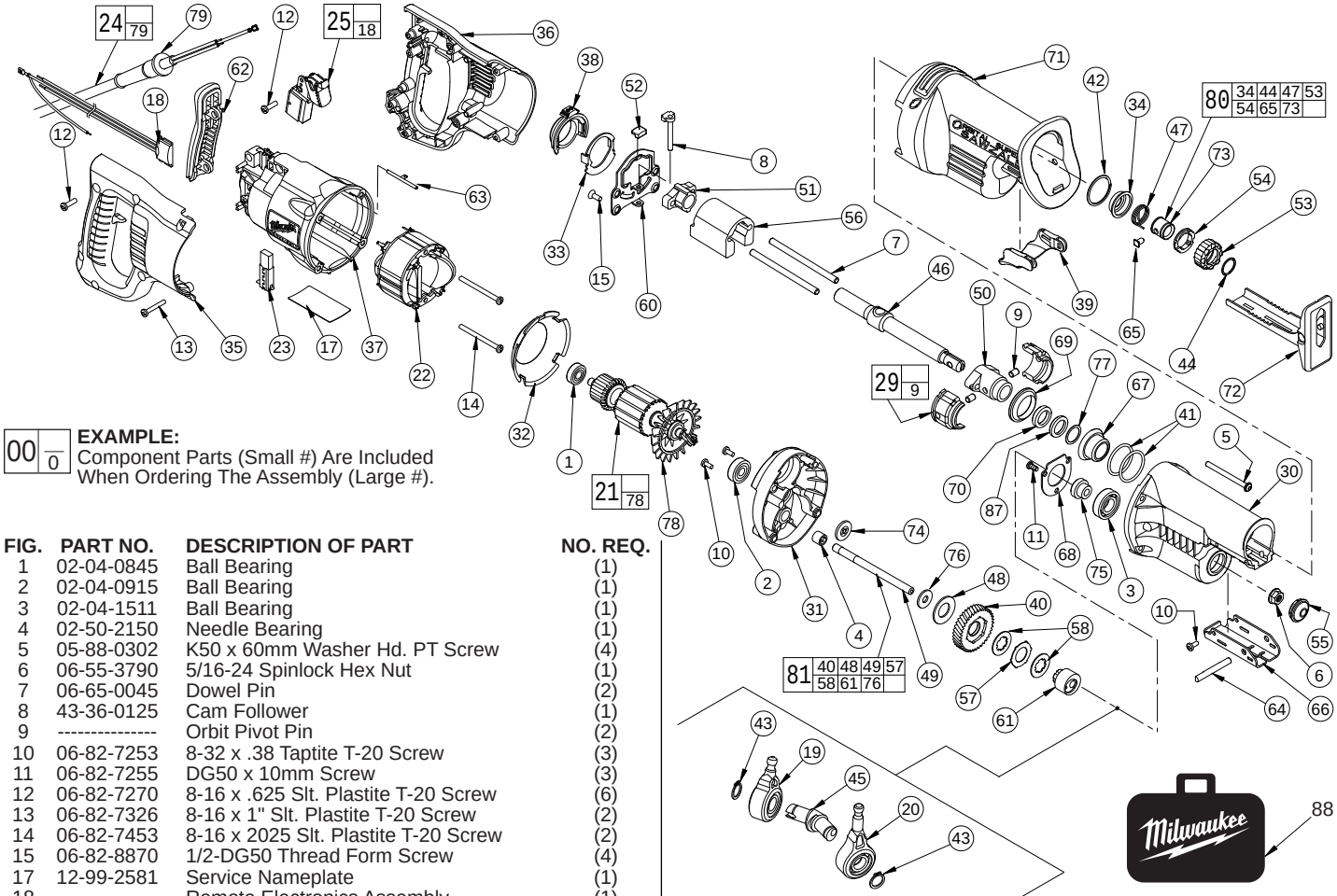
**NOTE:**
All leads must be held to ± 1/8".
All lead lengths are before stripping.

| TERMINAL DESCRIPTION | | |
|---|---|---|
| Code | Part No. | Qnty. |
| T1 | 23-74-1060 | 4 |
| T2 | 23-74-0017 | 2 |
| T3 | 23-74-0010 | 1 |
| T4 | 23-74-0605 | 1 |
| T5 | 23-74-0105 | 1 |
| T6 | 23-74-1095 | 1 |

# SERVICE PARTS LIST

BULLETIN NO.
**54-40-7586**

| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | REVISED BULLETIN | DATE |
|---|---|---|---|
| **1-1/4" STROKE SAWZALL®** | | 54-40-7585 | Jan. 2017 |
| **CATALOG NO. 6536-21** | STARTING SERIAL NO. **A66G** | WIRING INSTRUCTION | **See Page 3** |

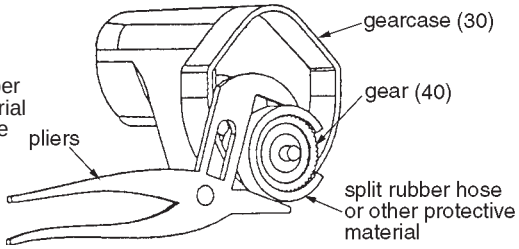



**EXAMPLE:**
Component Parts (Small #) Are Included When Ordering The Assembly (Large #).

| 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 | ---------- | 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 Slt. Plastite T-20 Screw | (6) |
| 13 | 06-82-7326 | 8-16 x 1" Slt. Plastite T-20 Screw | (2) |
| 14 | 06-82-7453 | 8-16 x 2025 Slt. Plastite T-20 Screw | (2) |
| 15 | 06-82-8870 | 1/2-DG50 Thread Form Screw | (4) |
| 17 | 12-99-2581 | Service Nameplate | (1) |
| 18 | ---------- | Remote Electronics Assembly | (1) |
| 19 | 14-67-0126 | Secondary Wobble Plate Assembly | (1) |
| 20 | 14-67-0136 | Primary Wobble Plate Assembly | (1) |
| 21 | 16-30-0700 | Service Armature | (1) |
| 22 | 18-30-1700 | Service Field | (1) |
| 23 | 22-20-0590 | Carbon Brush Assembly | (2) |
| 24 | 22-64-1124 | Cord Assembly | (1) |
| 25 | 23-66-4245 | Switch Assembly | (1) |
| 29 | 14-30-0080 | Orbit Pocket Assembly | (2) |
| 30 | 28-14-2600 | Gearcase | (1) |
| 31 | 28-28-2600 | Diaphragm | (1) |
| 32 | 31-05-0155 | Baffle | (1) |
| 33 | 31-11-0130 | Orbital Cam Plate | (1) |
| 34 | ---------- | Spring Cover | (1) |
| 35 | 31-44-2505 | Handle Half - Right | (1) |
| 36 | 31-44-2506 | Handle Half - Left | (1) |
| 37 | 31-50-0085 | Motor Housing | (1) |
| 38 | 31-52-0045 | Orbit Shift Lever | (1) |
| 39 | 31-52-0090 | Shoe Release Lever | (1) |
| 40 | 32-40-2050 | Intermediate Gear | (1) |
| 41 | 34-40-0040 | O-Ring | (2) |
| 42 | 34-60-0125 | Retaining Ring | (1) |
| 43 | 34-60-1315 | External Retaining Ring | (2) |
| 44 | 34-60-3700 | Retaining Ring | (1) |
| 45 | 36-92-0701 | Wobble Shaft | (1) |
| 46 | 38-50-6400 | Reciprocating Spindle | (1) |
| 47 | ---------- | Torsion Spring | (1) |
| 48 | 40-50-8850 | Disc Spring | (1) |
| 49 | 42-12-0190 | Wobble Shaft Axle | (1) |
| 50 | 42-24-0066 | Front Spindle Bushing | (1) |
| 51 | 42-24-0525 | Rear Spindle Bushing | (1) |
| 52 | 42-38-0055 | Orbit Bumper | (1) |
| 53 | ---------- | Front Cam | (1) |
| 54 | ---------- | Rear Cam | (1) |
| 55 | 42-52-0380 | Bearing Cap | (1) |
| 56 | 42-87-0180 | Counter Weight | (1) |
| 57 | 43-06-0676 | Bronze Plate | (1) |

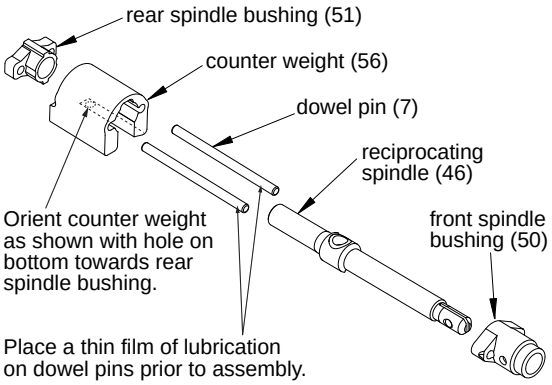
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|---|---|---|---|
| 58 | 43-06-0685 | Metal Plate | (2) |
| 60 | 43-56-0620 | Orbit Plate | (1) |
| 61 | 43-78-0577 | Orbit Drive Hub | (1) |
| 62 | 44-52-0105 | Cushion Grip | (1) |
| 63 | 44-60-0530 | Grounding Pin | (1) |
| 64 | 44-60-1635 | Shoe Pin | (1) |
| 65 | ---------- | Lock Pin | (1) |
| 66 | 44-66-0880 | Shoe Retainer | (1) |
| 67 | 44-86-0035 | Front Orbit Cap | (1) |
| 68 | 44-86-0655 | Bearing Retainer | (1) |
| 69 | 45-06-0110 | Orbit Seal | (1) |
| 70 | 45-06-0475 | Polypak Seal | (1) |
| 71 | 45-12-0700 | Gearcase Insulator | (1) |
| 72 | 45-16-0645 | Shoe Assembly | (1) |
| 73 | ---------- | Sleeve | (1) |
| 74 | 45-28-0555 | Slinger | (1) |
| 75 | 45-36-1445 | Spacer | (1) |
| 76 | 45-88-1555 | Washer | (1) |
| 77 | 45-88-8577 | Washer | (1) |
| 78 | 22-84-0531 | Fan | (1) |
| 79 | 44-76-0210 | Cord Protector | (1) |
| ★ 80 | 14-46-1062 | Large Quik-Lok Blade Clamp | (1) |
| 81 | 14-08-0075 | Gear Protecting Clutch Assembly | (1) |
| 87 | 45-06-0501 | Felt Seal | (1) |
| 88 | 42-55-2051 | Carrying Case | (1) |
| | 23-94-0025 | Ground Wire Assembly | (1) |
| | 23-94-6750 | Leadwire Assembly | (1) |
| | 23-94-6755 | Leadwire Assembly | (1) |

| FIG. | NOTES: |
|---|---|
| 1 | Bearing to be installed with seal towards commutator. |
| 4,31 | Press needle bearing flush ±.005 with inner surface of diaphragm. |
| 6,49 | 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. |
| 6,40 | 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. |




**Service Fixture**
**61-10-0270**
(Pressing Pin Tool)

| | |
|---|---|
| 7,46,50,51,56 | 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 (46) and counter weight (56) must be installed inside assembly (7,50) and (7,51) 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. |
| 17,37 | Install nameplate in motor housing recess prior to assembling diaphragm onto motor housing. |
| 29,42 | **Service fixture #61-10-0205** must be used when installing retaining ring (42) onto orbit pocket assembly (29). |
| 40,57 | Tabs of bronze plate engage intermediate gear. |
| 40,48 | Concave side of disc spring towards intermediate gear. |
| 58,61 | Tabs of metal plates engage orbit drive hub. |
| 70 | O-ring of polypak seal faces mechanism - toward rear of tool. |
| 74 | Shoulder extension of grease slinger should face bearing. |

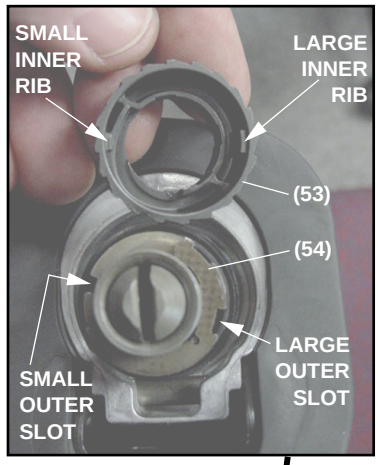


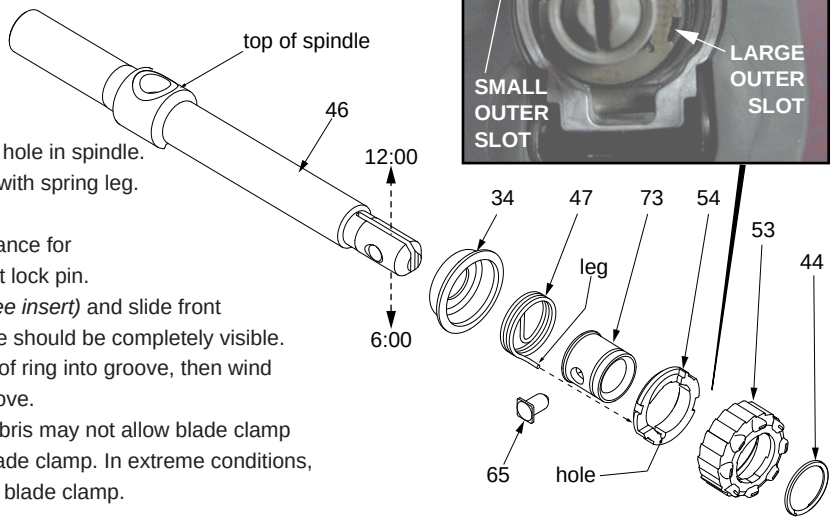

**REMOVING THE STEEL QUIK-LOK® BLADE CLAMP**

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

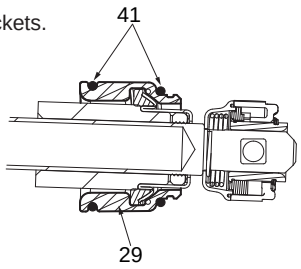
**REASSEMBLY OF THE STEEL QUIK-LOK® BLADE CLAMP**

- 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.

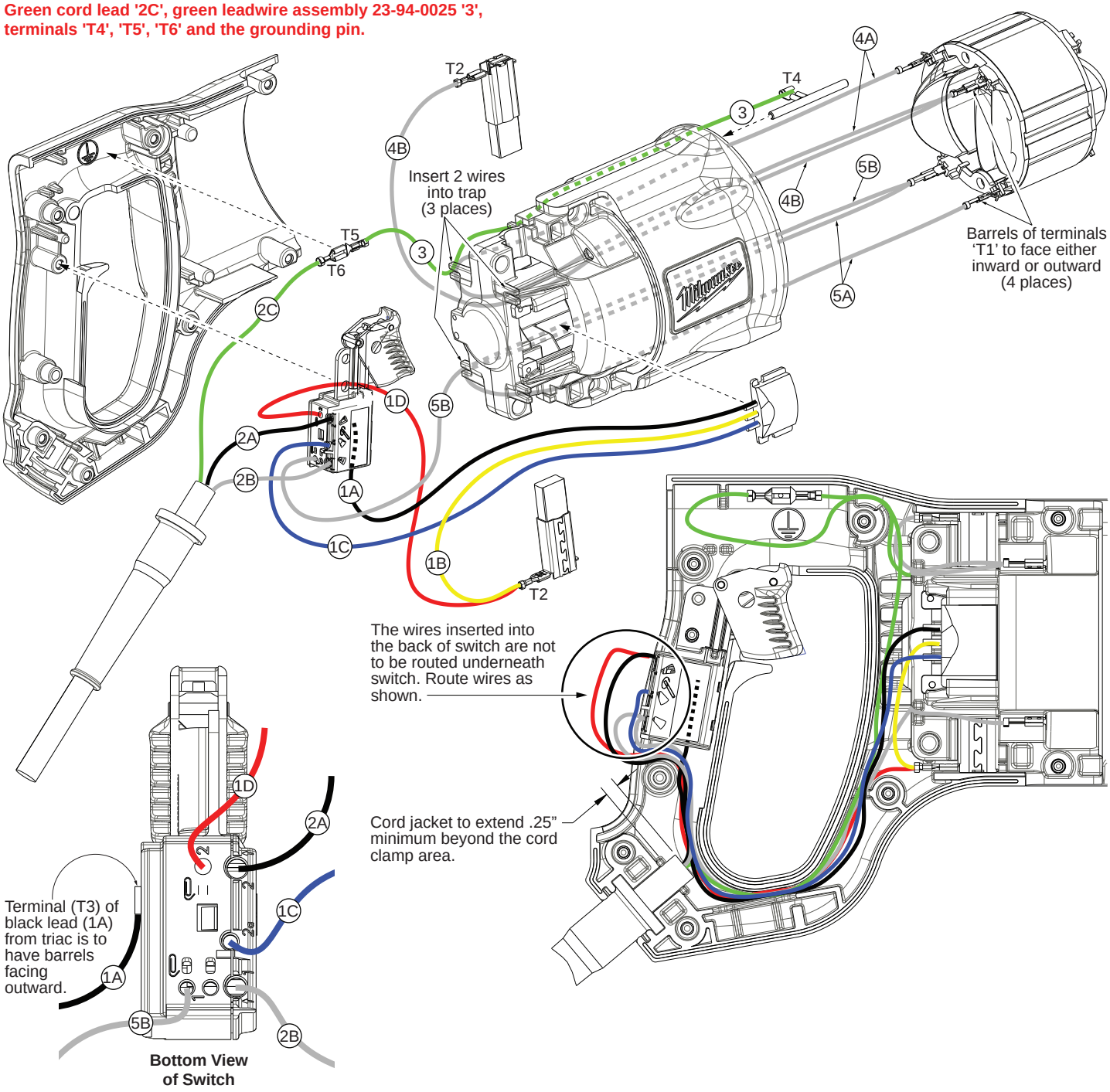



| FIG. | LUBRICATION: |
|---|---|
| 29,41 | Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets. |
| 30 | Place 3.2 oz. (80 grams ± 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case. |
| 31 | Place .8 oz. (20 grams ± 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm. |
| 40,58 | Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate. |
| 65 | Pin to be coated with graphite prior to assembly. |
| 87 | Soak in lightweight bushing oil prior to assembly. |



**NOTE: For (DI) Double Insulated tools disregard the following: Green cord lead '2C', green leadwire assembly 23-94-0025 '3', terminals 'T4', 'T5', 'T6' and the grounding pin.**




## WIRING SPECIFICATIONS

| Wire No. | Wire Color | Origin or Part No. | Ga. | Length | Terminals, Connectors and End Wire Preparation | |
|---|---|---|---|---|---|---|
| 1A | Black | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1B | Yellow | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1C | Blue | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 1D | Red | TRIAC | --- | --- | Component of Switch Assembly 23-66-4245. | |
| 2A | Black | Cord Assembly | 16 | 4.00 | Strip .340 and tin. | |
| 2B | White | Cord Assembly | 16 | 3.25 | Strip .340 and tin. | |
| 2C | Green | Cord Assembly | 16 | 11.25 | Strip .19 for T6. | |
| 3 | Green | 23-94-0025 | 18 | 7.00 | Strip each end .190 for T4 and T5. | |
| 4A | White | 23-94-6750 | 18 | 2.90 | Strip one end .19 for T2. | Strip both .15 and join for T1. |
| 4B | White | 23-94-6750 | 18 | 5.00 | Strip one end .15 for T1. | |
| 5A | White | 23-94-6755 | 18 | 9.25 | Strip one .320 and tin. | Strip both .15 and join for T1. |
| 5B | White | 23-94-6755 | 18 | 5.00 | Strip one end .15 for T1. | |

**BULK LEAD WIRE - BULLETIN 58-01-0003**

**NOTE:**
All leads must be held to ± 1/8".
All lead lengths are before stripping.

| TERMINAL DESCRIPTION | | |
|---|---|---|
| Code | Part No. | Qnty. |
| T1 | 23-74-1060 | 4 |
| T2 | 23-74-0017 | 2 |
| T3 | 23-74-0010 | 1 |
| T4 | 23-74-0605 | 1 |
| T5 | 23-74-0105 | 1 |
| T6 | 23-74-1095 | 1 |