



SERVICE PARTS LIST

BULLETIN NO.
54-38-1760

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
5" / 6" RAT-TAIL ANGLE GRINDER			Oct. 2009
CATALOG NO. 6123-31	STARTING SERIAL NUMBER	B68A	
		WIRING INSTRUCTION See Reverse Side	

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

*** LUBRICATION NOTE:**
When servicing the Gears (25 & 46)
or the Gearcase (15), 90-95% of the
old grease must be removed prior
to new grease being added.

Functionally check Spindle
Lock mechanism. Spindle
Lock Pin (20) must return
briskly when released from
engagement in Gear (25).

NOTE:
Torque Armature Nut (1)
to 47 in/lbs, 55 kg/cm.

Orient Needle
Bearing (14) such
that side with vendor
I.D. is facing Gear (25).

Rubber Slug (45) is to be placed in a
cavity by the bearing bore in the
back of Motor Housing (44).

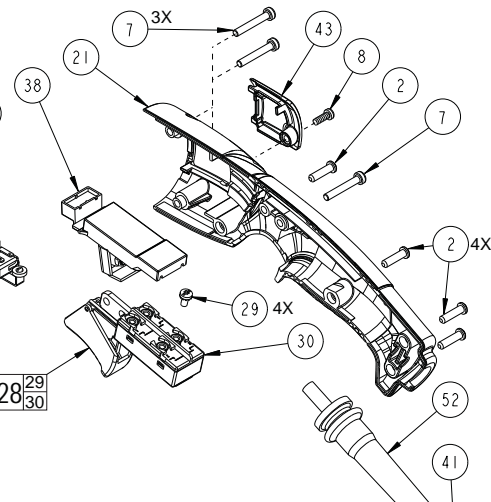
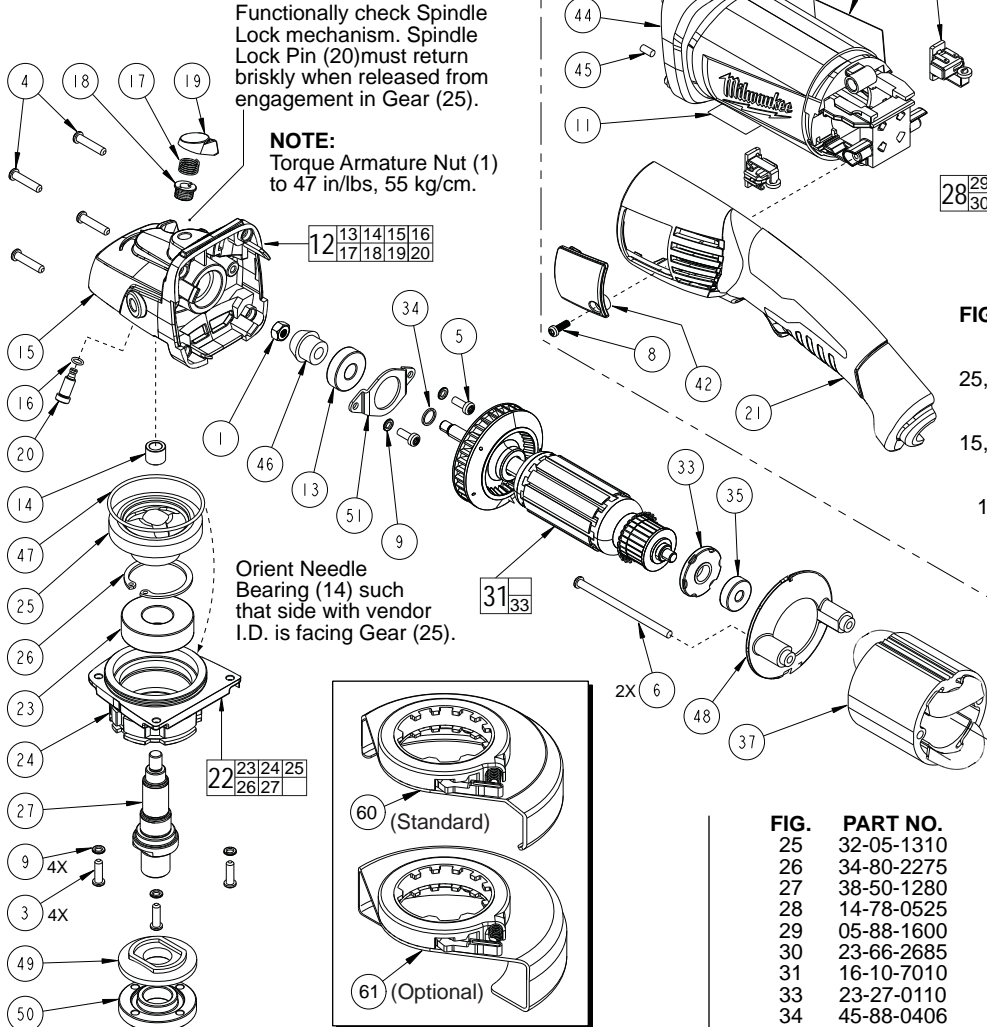


FIG. LUBRICATION
(*See lubrication note above):

- 25,46 Type "Y" Grease, No. 49-08-5270,
Must Be Applied To All Gear Teeth.
- 15,47 Lightly coat with grease O-Ring and
bearing bore in Gearcase.
- 15 .3 - .4 Ounces (9-12 Grams)
Type "Y" Grease, No. 49-08-5270.

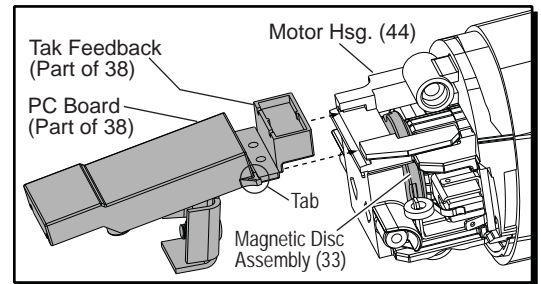
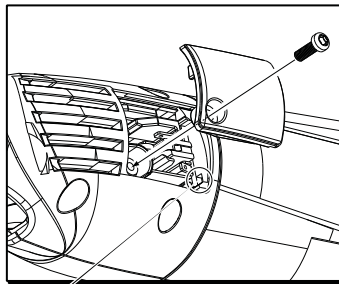
Orient Magnetic Disc Assembly (33)
with 'half moon' cut outs facing Ball
Bearing (35) as shown. Exercise caution
when installing. Make sure that the shoulder
of Magnetic Disc Assembly rests against
commutator bars with no visible gap.

Orient Fan Baffle (48) with small notch to
the top and large notch to the bottom.

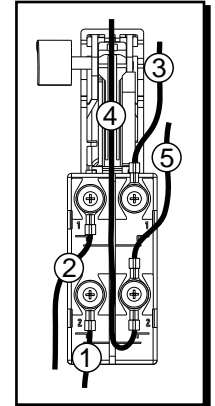
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-55-0620	M5 Hex Nut	(1)
2	05-88-1200	M4 x 16 Pan Hd. T-20 Screw	(4)
3	05-88-1210	M4 x 14 Pan Hd. T-20 Screw	(4)
4	05-88-1250	M4 x 20 Pan Hd. T-20 Screw	(4)
5	05-88-1280	M4 x 10 Pan Hd. T-20 Screw	(2)
6	05-88-1290	M4 x 76 Pan Hd. T-20 Screw	(2)
7	05-88-1650	M4 x 25 Pan Hd. T-20 Screw	(3)
8	05-88-1610	M3.5 x 10 Pan Hd. T-10 Screw	(2)
9	05-90-0225	M4 Lock Washer	(6)
10	12-20-6116	Service Nameplate	(1)
11	10-15-1230	Warning Label	(1)
12	14-29-0310	Gearcase Assembly	(1)
13	02-04-0620	Ball Bearing	(1)
14	02-50-0025	Needle Bearing	(1)
15	-----	Gearcase	(1)
16	34-40-0450	O-Ring	(1)
17	40-50-1330	Compression Spring	(1)
18	42-42-0580	Spindle Lock Tube	(1)
19	42-42-0590	Spindle Lock Button	(1)
20	42-60-1660	Spindle Lock Pin	(1)
21	14-34-0810	Rear Handle Assembly	(1)
22	14-73-0410	Spindle/Hub Assembly	(1)
23	02-04-1150	Ball Bearing	(1)
24	28-53-0410	Lower Gearcase Hub	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
25	32-05-1310	Bevel Gear	(1)
26	34-80-2275	Retaining Ring	(1)
27	38-50-1280	Spindle	(1)
28	14-78-0525	Switch Assembly	(1)
29	05-88-1600	M4 x 10 Pan Hd. Slit. T-15 Screw	(4)
30	23-66-2685	Switch	(1)
31	16-10-7010	Service Armature Assembly	(1)
33	23-27-0110	Magnetic Disc Assembly	(1)
34	45-88-0406	Washer	(1)
35	02-04-2110	Ball Bearing	(1)
37	18-07-2325	Service Field	(1)
38	22-09-1800	Module Assembly	(1)
39	22-22-1560	Carbon Brush Assembly	(2)
41	22-64-2020	Cord	(1)
42	31-15-2205	Brush Cover - Left	(1)
43	31-15-2200	Brush Cover - Right	(1)
44	31-50-2600	Motor Housing	(1)
45	31-53-0240	Rubber Slug	(1)
46	32-60-1310	Bevel Pinion	(1)
47	34-40-0180	O-Ring	(1)
48	42-14-0490	Fan Baffle	(1)
49	43-34-0036	Inner Disk Flange	(1)
50	44-40-0035	Outer Flange Nut	(1)
51	44-66-0450	Bearing Retainer	(1)
52	44-76-0210	Strain Relief	(1)
60	43-54-1075	5" T27 Guard Assembly (Standard)	(1)
	43-54-1080	6" T27 Guard Assembly (Standard)	(1)
61	43-54-1095	5" T1 Guard Assembly (Optional)	(1)
	43-54-1085	6" T1 Guard Assembly (Optional)	(1)
	42-62-0100	Side Handle (Not Shown)	(1)
	49-96-7205	Spanner Wrench (Not Shown)	(1)

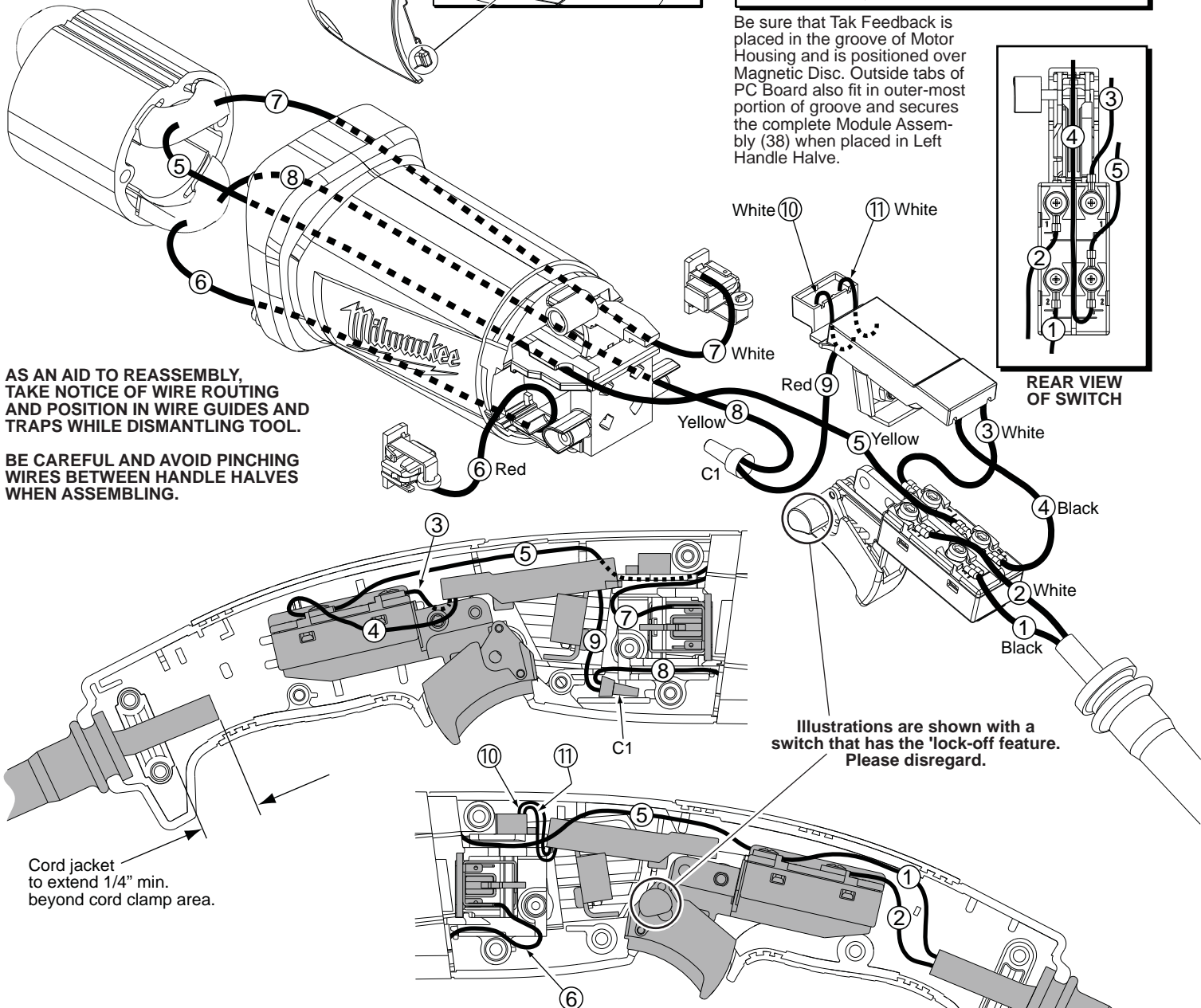
Right Brush Cover (43) has to be taken off in order to remove Right Rear Handle of tool for servicing. Brush Covers fit tightly in the Motor Housing. Do not try and pry the Brush Covers open around the exterior of part. Brush Covers have tabs that lock into notches of the Motor Housing (44) and work like hinges. Once Screw (8) is removed, insert a small pin or equivalent into the screw hole to aid in lifting Brush Cover. To reinstall Brush Covers, insert tabs into Motor Housing notches and snap down into place. Secure with Screw.



Be sure that Tak Feedback is placed in the groove of Motor Housing and is positioned over Magnetic Disc. Outside tabs of PC Board also fit in outer-most portion of groove and secures the complete Module Assembly (38) when placed in Left Handle Halve.



REAR VIEW OF SWITCH



AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.

Illustrations are shown with a switch that has a 'lock-off feature'. Please disregard.

Cord jacket to extend 1/4" min. beyond cord clamp area.

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Part No.	Gauge	Length	Terminals, Connectors and End Wire Preparation
1	Black	22-64-2020	--	--	Component of Cord Set.
2	White	22-64-2020	--	--	Component of Cord Set.
3	White	22-09-1800	--	--	Component of PC Board.
4	Black	22-09-1800	--	--	Component of PC Board.
5	Yellow	18-07-2325	--	--	Component of Service Field.
6	Red	18-07-2325	--	--	Component of Service Field.
7	White	18-07-2325	--	--	Component of Service Field.
8	Yellow	18-07-2325	--	--	Component of Service Field.
9	Red	22-09-1800	--	--	Component of PC Board.
10	White	22-09-1800	--	--	Component of PC Board.
11	White	22-09-1800	--	--	Component of PC Board.

BULK LEAD WIRE - BULLETIN 58-01-0003

NOTE:

All leads must be held to $\pm 1/16"$. All lead lengths are before stripping.

TERMINAL DESCRIPTION

Code	Part No.	Qty.
CONNECTOR DESCRIPTION		
C1	22-56-0150	1