



SERVICE PARTS LIST

BULLETIN NO.
54-40-0640

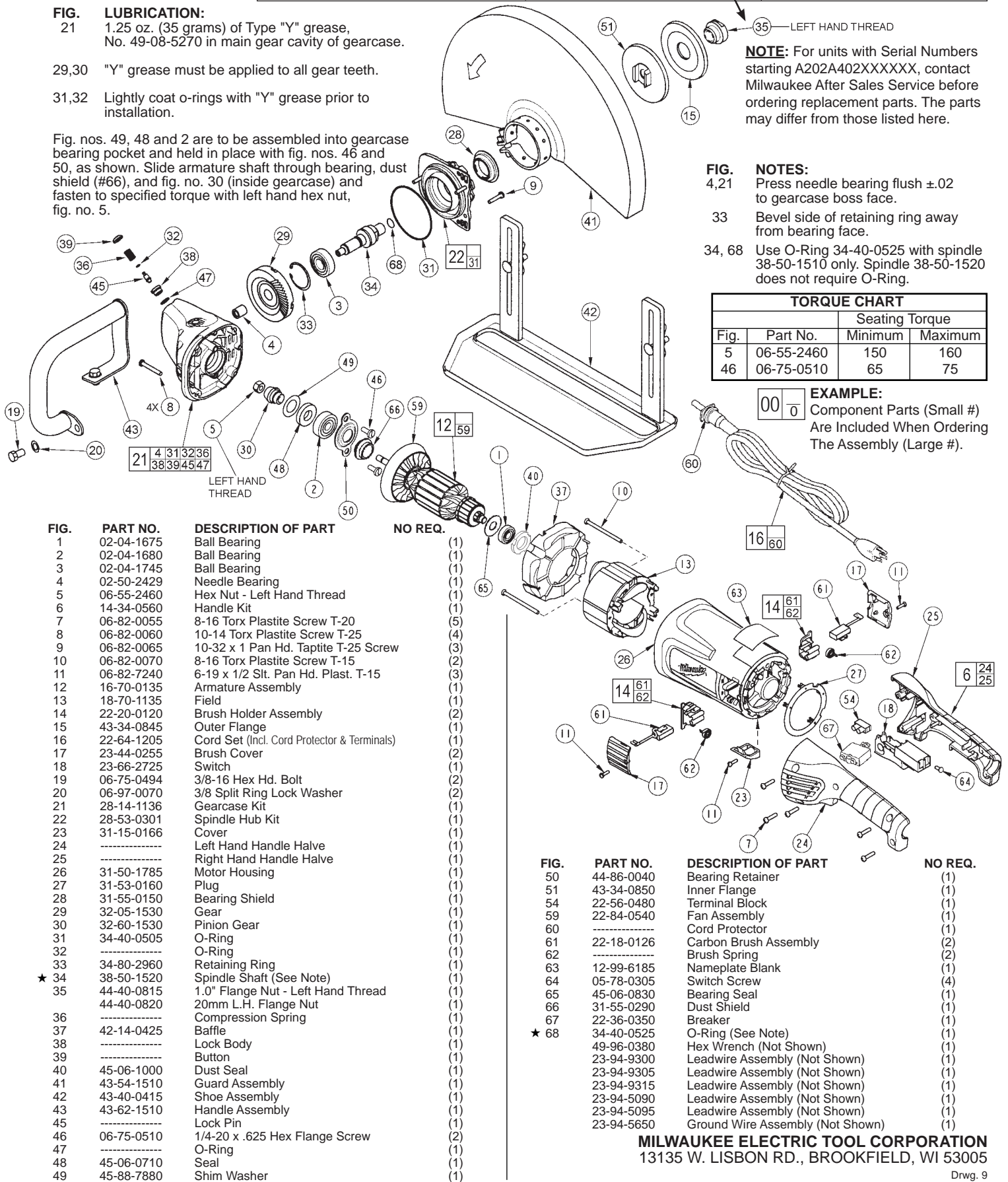
| | | | | |
|---|----------------|----------------------|-------------------------------------|--|
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | | REVISED BULLETIN | DATE |
| 14" ABRASIVE CUT-OFF MACHINE | | | | Feb. 2009 |
| CATALOG NO. | 6185-20 | SERIAL NUMBER | A20A <small>see NOTE</small> | WIRING INSTRUCTION 58-01-1372 |

FIG. 21 LUBRICATION:
1.25 oz. (35 grams) of Type "Y" grease, No. 49-08-5270 in main gear cavity of gearcase.

29,30 "Y" grease must be applied to all gear teeth.

31,32 Lightly coat o-rings with "Y" grease prior to installation.

Fig. nos. 49, 48 and 2 are to be assembled into gearcase bearing pocket and held in place with fig. nos. 46 and 50, as shown. Slide armature shaft through bearing, dust shield (#66), and fig. no. 30 (inside gearcase) and fasten to specified torque with left hand hex nut, fig. no. 5.



NOTE: For units with Serial Numbers starting A202A402XXXXXX, contact Milwaukee After Sales Service before ordering replacement parts. The parts may differ from those listed here.

- FIG. NOTES:**
- 4,21 Press needle bearing flush ± 0.02 to gearcase boss face.
 - 33 Bevel side of retaining ring away from bearing face.
 - 34, 68 Use O-Ring 34-40-0525 with spindle 38-50-1510 only. Spindle 38-50-1520 does not require O-Ring.

| | | Seating Torque | |
|------|------------|----------------|---------|
| Fig. | Part No. | Minimum | Maximum |
| 5 | 06-55-2460 | 150 | 160 |
| 46 | 06-75-0510 | 65 | 75 |

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

| FIG. | PART NO. | DESCRIPTION OF PART | NO REQ. |
|------|------------|---|---------|
| 1 | 02-04-1675 | Ball Bearing | (1) |
| 2 | 02-04-1680 | Ball Bearing | (1) |
| 3 | 02-04-1745 | Ball Bearing | (1) |
| 4 | 02-50-2429 | Needle Bearing | (1) |
| 5 | 06-55-2460 | Hex Nut - Left Hand Thread | (1) |
| 6 | 14-34-0560 | Handle Kit | (1) |
| 7 | 06-82-0055 | 8-16 Torx Plastite Screw T-20 | (5) |
| 8 | 06-82-0060 | 10-14 Torx Plastite Screw T-25 | (4) |
| 9 | 06-82-0065 | 10-32 x 1 Pan Hd. Taptite T-25 Screw | (3) |
| 10 | 06-82-0070 | 8-16 Torx Plastite Screw T-15 | (2) |
| 11 | 06-82-7240 | 6-19 x 1/2 Slit. Pan Hd. Plast. T-15 | (3) |
| 12 | 16-70-0135 | Armature Assembly | (1) |
| 13 | 18-70-1135 | Field | (1) |
| 14 | 22-20-0120 | Brush Holder Assembly | (2) |
| 15 | 43-34-0845 | Outer Flange | (1) |
| 16 | 22-64-1205 | Cord Set (Incl. Cord Protector & Terminals) | (1) |
| 17 | 23-44-0255 | Brush Cover | (2) |
| 18 | 23-66-2725 | Switch | (1) |
| 19 | 06-75-0494 | 3/8-16 Hex Hd. Bolt | (2) |
| 20 | 06-97-0070 | 3/8 Split Ring Lock Washer | (2) |
| 21 | 28-14-1136 | Gearcase Kit | (1) |
| 22 | 28-53-0301 | Spindle Hub Kit | (1) |
| 23 | 31-15-0166 | Cover | (1) |
| 24 | ----- | Left Hand Handle Halve | (1) |
| 25 | ----- | Right Hand Handle Halve | (1) |
| 26 | 31-50-1785 | Motor Housing | (1) |
| 27 | 31-53-0160 | Plug | (1) |
| 28 | 31-55-0150 | Bearing Shield | (1) |
| 29 | 32-05-1530 | Gear | (1) |
| 30 | 32-60-1530 | Pinion Gear | (1) |
| 31 | 34-40-0505 | O-Ring | (1) |
| 32 | ----- | O-Ring | (1) |
| 33 | 34-80-2960 | Retaining Ring | (1) |
| ★ 34 | 38-50-1520 | Spindle Shaft (See Note) | (1) |
| 35 | 44-40-0815 | 1.0" Flange Nut - Left Hand Thread | (1) |
| | 44-40-0820 | 20mm L.H. Flange Nut | (1) |
| 36 | ----- | Compression Spring | (1) |
| 37 | 42-14-0425 | Baffle | (1) |
| 38 | ----- | Lock Body | (1) |
| 39 | ----- | Button | (1) |
| 40 | 45-06-1000 | Dust Seal | (1) |
| 41 | 43-54-1510 | Guard Assembly | (1) |
| 42 | 43-40-0415 | Shoe Assembly | (1) |
| 43 | 43-62-1510 | Handle Assembly | (1) |
| 45 | ----- | Lock Pin | (1) |
| 46 | 06-75-0510 | 1/4-20 x .625 Hex Flange Screw | (2) |
| 47 | ----- | O-Ring | (1) |
| 48 | 45-06-0710 | Seal | (1) |
| 49 | 45-88-7880 | Shim Washer | (1) |

| FIG. | PART NO. | DESCRIPTION OF PART | NO REQ. |
|------|------------|----------------------------------|---------|
| 50 | 44-86-0040 | Bearing Retainer | (1) |
| 51 | 43-34-0850 | Inner Flange | (1) |
| 54 | 22-56-0480 | Terminal Block | (1) |
| 59 | 22-84-0540 | Fan Assembly | (1) |
| 60 | ----- | Cord Protector | (1) |
| 61 | 22-18-0126 | Carbon Brush Assembly | (2) |
| 62 | ----- | Brush Spring | (2) |
| 63 | 12-99-6185 | Nameplate Blank | (1) |
| 64 | 05-78-0305 | Switch Screw | (4) |
| 65 | 45-06-0830 | Bearing Seal | (1) |
| 66 | 31-55-0290 | Dust Shield | (1) |
| 67 | 22-36-0350 | Breaker | (1) |
| ★ 68 | 34-40-0525 | O-Ring (See Note) | (1) |
| | 49-96-0380 | Hex Wrench (Not Shown) | (1) |
| | 23-94-9300 | Leadwire Assembly (Not Shown) | (1) |
| | 23-94-9305 | Leadwire Assembly (Not Shown) | (1) |
| | 23-94-9315 | Leadwire Assembly (Not Shown) | (1) |
| | 23-94-5090 | Leadwire Assembly (Not Shown) | (1) |
| | 23-94-5095 | Leadwire Assembly (Not Shown) | (1) |
| | 23-94-5650 | Ground Wire Assembly (Not Shown) | (1) |

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