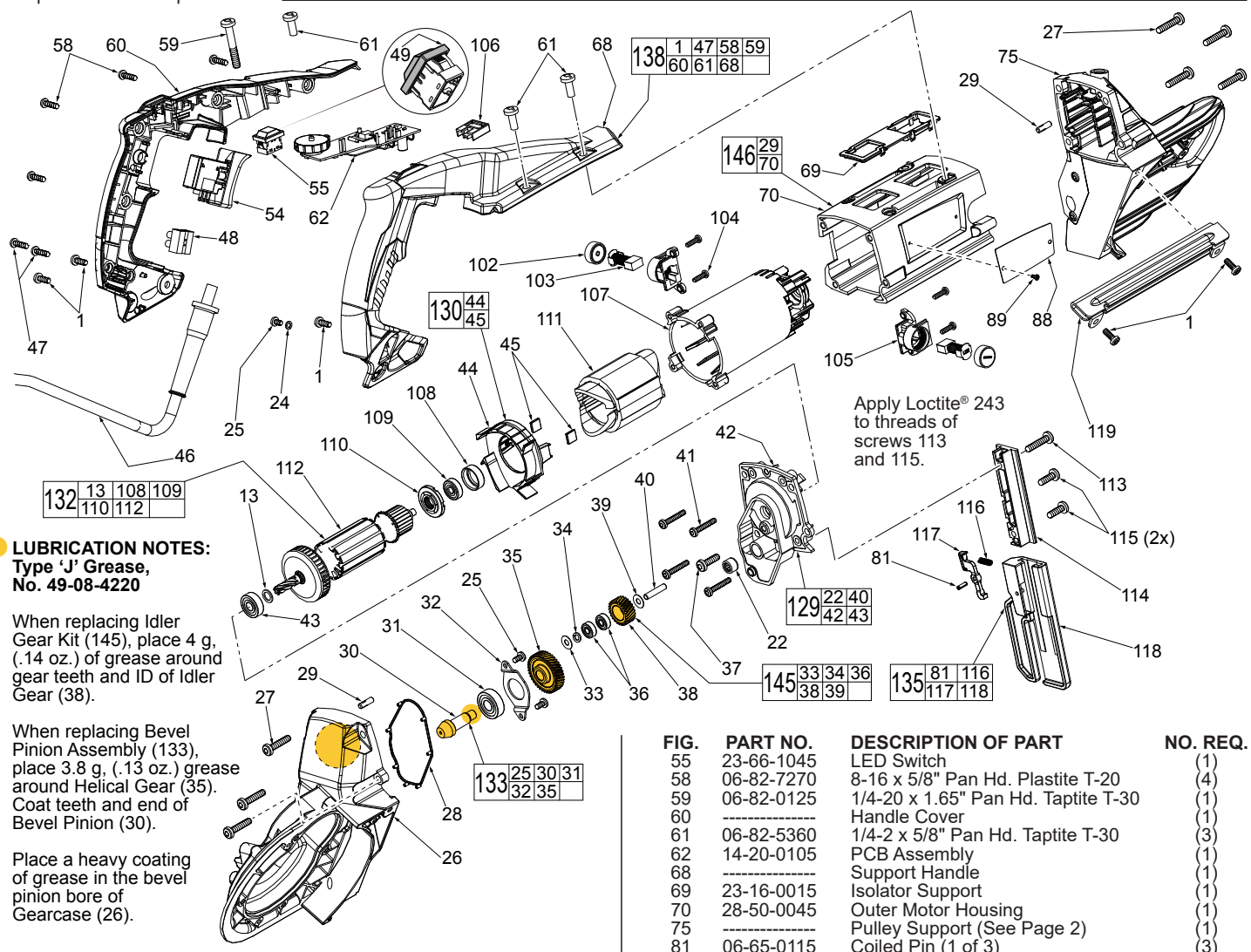
SERVICE PARTS LIST

BULLETIN NO. 54-40-6243

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS	REVISED BULLETIN	DATE
DEEP CUT BANDSAW	54-40-6242	Feb. 2022
CATALOG NO. 6232-20 STARTING SERIAL NO. **D51D**	WIRING INSTRUCTION **See Page 4 thru 7**	

★ = **Part number change** from previous service parts list.



LUBRICATION NOTES:
Type 'J' Grease, No. 49-08-4220

When replacing Idler Gear Kit (145), place 4 g, (.14 oz.) of grease around gear teeth and ID of Idler Gear (38).

When replacing Bevel Pinion Assembly (133), place 3.8 g, (.13 oz.) grease around Helical Gear (35). Coat teeth and end of Bevel Pinion (30).

Place a heavy coating of grease in the bevel pinion bore of Gearcase (26).

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
★ 1	06-82-5314	10-24 x 1/2" Pan Hd. Tapt. T-25 (5 of 17)	(17)
22	----------	Bushing (1 of 3)	(3)
24	05-90-0225	Washer	(1)
25	06-82-8828	8-32 x .313" Pan Hd. Taptite T-20	(3)
26	----------	Gearcase (See Page 3)	(1)
27	06-82-5376	12-24 x 1" Pan Hd. Taptite T-27	(7)
28	34-40-0185	Seal Gasket	(1)
29	----------	Pin	(2)
30	----------	Bevel Pinion	(1)
31	----------	Ball Bearing	(1)
32	----------	Bearing Plate	(1)
33	45-88-0895	Washer	(1)
34	45-88-6230	Spring Washer	(1)
35	----------	Helical Gear	(1)
36	----------	Ball Bearing	(2)
37	06-82-5358	12-24 x 3/4" Pan Hd. Taptite T-27	(1)
38	----------	Idler Gear	(1)
39	45-88-6232	Washer	(1)
40	----------	Pin	(1)
41	06-82-7326	8-16 x 1" Pan Hd. Plastite T-20	(4)
42	----------	Diaphragm	(1)
43	02-04-0175	Ball Bearing (1 of 2)	(2)
44	----------	Baffle	(1)
45	42-28-0085	Rubber Block	(2)
46	22-64-0440	Power Cord	(1)
47	06-82-7409	8-16 x 1/2" Pan Hd. Plastite T-20	(2)
48	22-56-0470	Terminal Block	(1)
49	42-38-0085	Rubber Switch Cover	(1)
50	23-94-0405	Leadwire Assembly-Black (Not Shown)	(1)
51	23-94-0435	Leadwire Assembly-White (Not Shown)	(1)
52	23-94-0440	Leadwire Assembly-Red (Not Shown)	(1)
54	23-66-0645	On-Off Switch	(1)
55	23-66-1045	LED Switch	(1)
58	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(4)
59	06-82-0125	1/4-20 x 1.65" Pan Hd. Taptite T-30	(1)
60	----------	Handle Cover	(1)
61	06-82-5360	1/4-2 x 5/8" Pan Hd. Taptite T-30	(3)
62	14-20-0105	PCB Assembly	(1)
68	----------	Support Handle	(1)
69	23-16-0015	Isolator Support	(1)
70	28-50-0045	Outer Motor Housing	(1)
75	----------	Pulley Support (See Page 2)	(1)
81	06-65-0115	Coiled Pin (1 of 3)	(3)
88	12-20-6232	Service Nameplate	(1)
89	----------	Nameplate Screw	(2)
102	23-44-0220	Brush Cap	(2)
103	22-18-0025	Carbon Brush	(2)
104	05-88-1360	M4 x 13.5mm ST Screw	(4)
105	22-20-0080	Brush Holder Assembly	(2)
106	14-20-0195	Sensor Assembly	(1)
107	31-50-0305	Inner Motor Housing	(1)
108	42-96-0016	Bearing Cap	(1)
109	02-04-0645	Ball Bearing	(1)
110	23-38-0030	Magnetic Ring	(1)
111	18-07-0025	Service Field Kit	(1)
112	----------	Armature	(1)
113	06-82-0065	10-32 x 1" Pan Hd. Taptite T-25	(1)
114	30-13-0015	T-Block	(1)
115	06-82-5330	10-32 x 5/8" Pan Hd. Taptite T-25	(2)
116	40-50-0845	Lever Release Spring	(1)
117	42-42-0060	Release Button	(1)
118	----------	Shoe Bumper	(1)
119	43-54-0085	Blade Guard	(1)
129	14-13-0010	Diaphragm Kit	(1)
130	42-14-0015	Fan Baffle Kit	(1)
132	16-10-0025	Service Armature Kit	(1)
133	32-60-0095	Bevel Pinion Assembly	(1)
135	42-18-0035	Shoe Bumper Kit	(1)
138	31-44-0745	Handle Assembly Kit	(1)
145	32-60-6230	Idler Gear Kit	(1)

SEE PAGE 3 FOR FASTENER TORQUE CHART

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

★ = Component change from previous service parts list.

FIG. NOTE:
73 Use Loctite® 243 or the equivalent to the threads of Screw (73) prior to installing T-Handle (74) onto Pulley Support (75).

SEE PAGE 3 FOR FASTENER TORQUE CHART

FIG. NOTE:
75,90 Use Loctite® 326 or the equivalent to secure the Blade Backing Pad (90) to the Pulley Support (75).

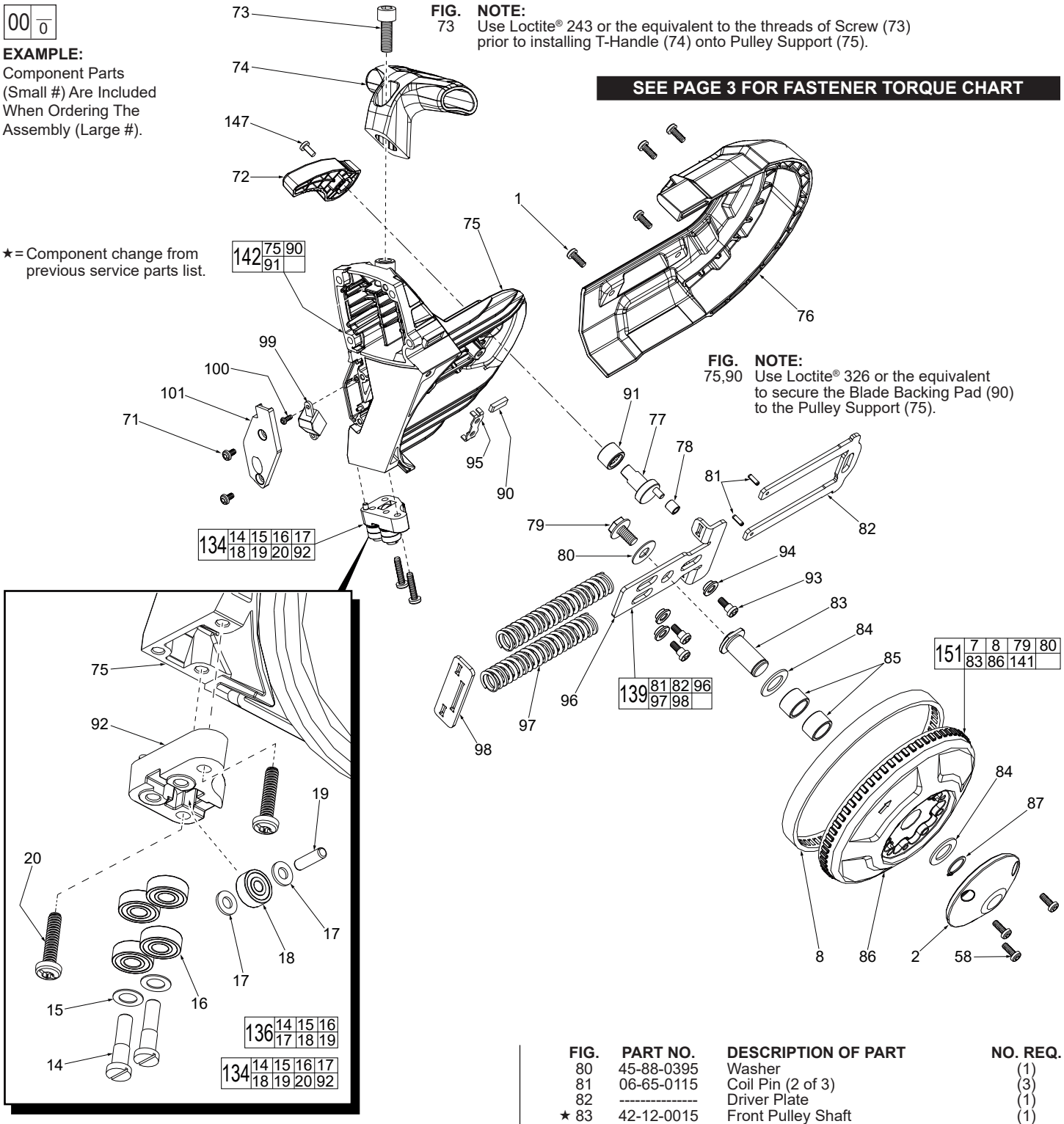


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
★ 1	06-82-5314	10-24 x 1/2" Pan Hd. Tapt. T-25 (4 of 17)	(17)
2	31-15-0325	Pulley Cover (1 of 2)	(2)
8	45-69-0010	Pulley Tire (1 of 2)	(2)
14	----------	12-24 UNC x .96" Slotted (2 of 4)	(4)
15	----------	Washer (2 of 4)	(4)
16	----------	Ball Bearing (4 of 8)	(8)
17	----------	Washer (2 of 4)	(4)
18	----------	Ball Bearing (1 of 2)	(2)
19	----------	Pin (1 of 2)	(2)
20	06-82-5574	10-24 x 7/8" Pan Hd. Tapt. T-25 (2 of 4)	(4)
★ 58	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20 Screw	(3)
71	06-82-7252	8-32 x .38" Pan Hd. Taptite T-20	(2)
72	31-52-0066	Tension Release Lever	(1)
73	06-75-4675	3/8"-16 UNC x 1" Socket Hd. Cap Screw	(1)
74	31-44-0740	Front T-Handle	(1)
75	----------	Pulley Support	(1)
76	31-15-0335	Front Pulley Shroud	(1)
77	45-08-0070	Cam Shaft	(1)
78	42-40-0105	Cam Bushing	(1)
79	06-75-0035	5/16-18 x 9/16" Screw	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
80	45-88-0395	Washer	(1)
81	06-65-0115	Coil Pin (2 of 3)	(3)
82	----------	Driver Plate	(1)
★ 83	42-12-0015	Front Pulley Shaft	(1)
84	45-88-7165	Washer	(2)
★ 85	42-40-0585	Sleeve Bearing	(2)
★ 86	28-95-2715	Front Pulley	(1)
87	34-60-1400	Snap Ring	(1)
90	44-52-0120	Blade Backing Pad	(1)
91	02-50-0035	Needle Bearing	(1)
92	----------	Front Roller Block	(1)
93	06-81-0075	Shoulder Screw	(3)
94	42-40-0115	Tension Bushing	(3)
95	44-66-6232	Wear Plate	(1)
96	----------	Support Plate	(1)
97	----------	Blade Tension Spring	(2)
98	----------	Contact Plate	(1)
99	14-20-0115	LED Assembly	(1)
100	05-81-0010	M3 x 8mm Screw	(1)
101	31-15-0345	LED Cover	(1)
134	42-24-0015	Front Guide Roller Kit	(1)
136	14-46-0465	Guide Roller Kit	(1)
139	42-18-0015	Tensioning Mechanism Assembly	(1)
142	14-30-0060	Pulley Support Kit	(1)
147	06-82-0145	8-32 x .48" Pan Hd. M Screw T-20	(1)
★151	14-30-2729	Pulley Service Kit	(1)

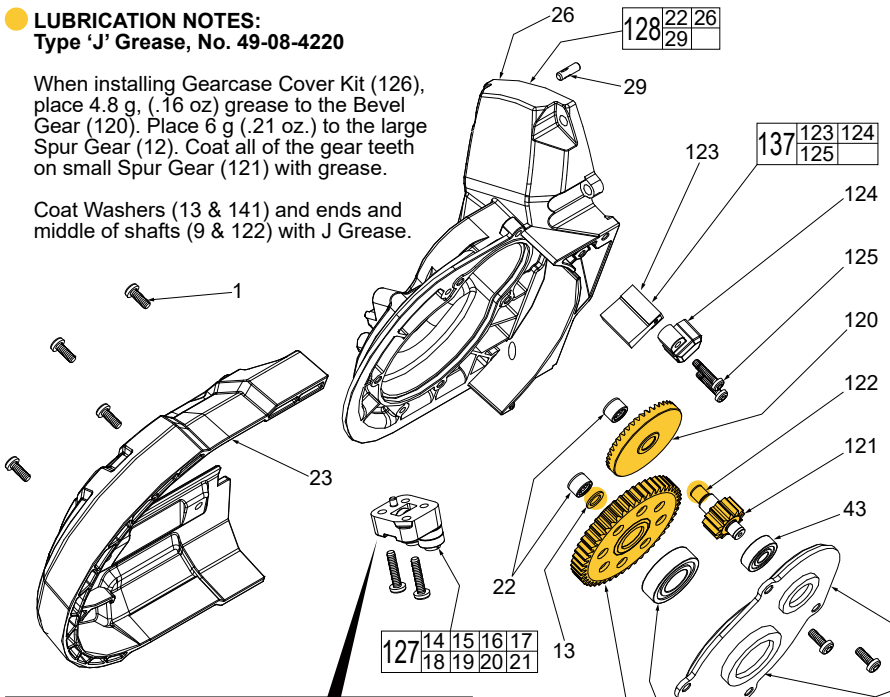
★ = Component change from previous service parts list.

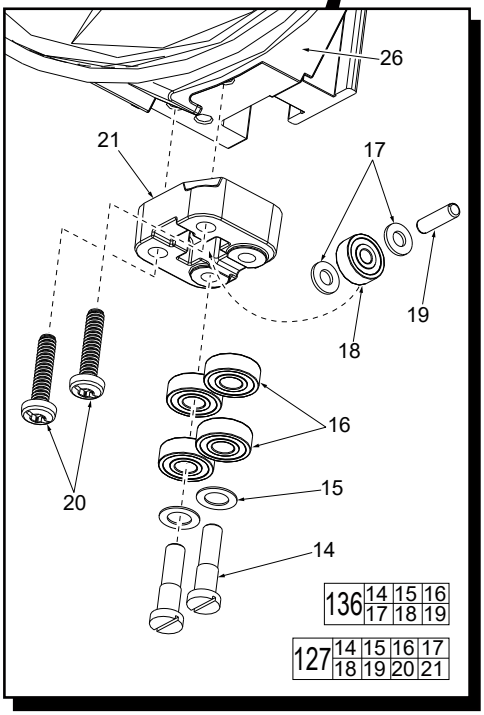
LUBRICATION NOTES:
Type 'J' Grease, No. 49-08-4220

When installing Gearcase Cover Kit (126), place 4.8 g, (.16 oz) grease to the Bevel Gear (120). Place 6 g (.21 oz.) to the large Spur Gear (12). Coat all of the gear teeth on small Spur Gear (121) with grease.

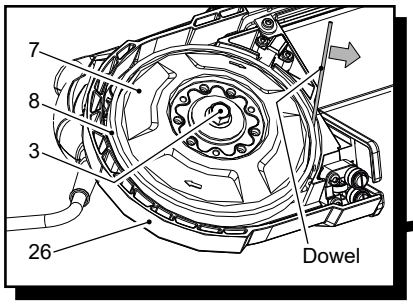
Coat Washers (13 & 141) and ends and middle of shafts (9 & 122) with J Grease.

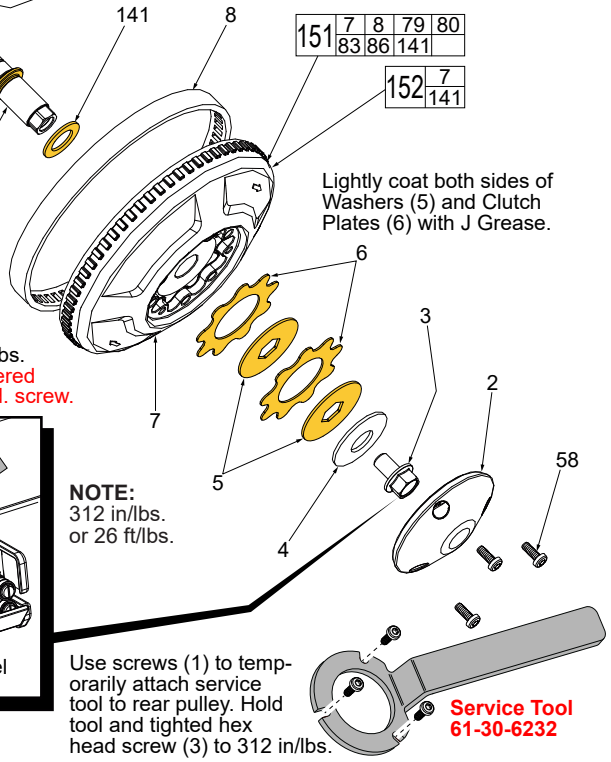
SCREW TORQUE CHART			
Fig.	Part No.	Location	Torque (In/Lbs.)
3	06-75-0010	Rear Pulley	312
20	06-82-5574	Front Roller Block	
		Rear Roller Block	39
25	06-82-8828	Bearing Plate	
		Ground Terminal	17
27	06-82-5376	Gearcase	
		Pulley Support	38
37	06-82-5358	Diaphragm	38
41	06-82-7326	Diaphragm	16
47	06-82-7409	Handle Cover	17
58	06-82-7270	Handle Cover	17
59	06-82-0125	Handle Cover	39
61	06-82-5360	Handle Cover	
		Support Handle	39
71	06-82-7252	LED Cover	22
73	06-75-4675	Front T-Handle	83
79	06-75-0035	Support Plate	104
93	06-81-0075	Support Plate	36
100	05-81-0010	LED Assembly	6
104	05-88-1360	Brush Holder Assembly	5
113	06-82-0065	T-Block	19
115	06-82-5330	T-Block	19
125	06-82-5346	Tire Cleaning Brush Cover	22
147	06-82-0145	Tension Release Lever	22





To properly tighten hex head screw (3), use a wooden dowel or a nylon rod in the opening between the rear pulley (7) and gearcase (26). Be careful not to damage pulley tire (8). Apply enough pressure to prevent rear pulley from turning. Torque hex head screw (3) to 312 in/lbs. **Service Tool 61-30-6232** can be ordered to secure rear pulley to tighten hex hd. screw.





Lightly coat both sides of Washers (5) and Clutch Plates (6) with J Grease.

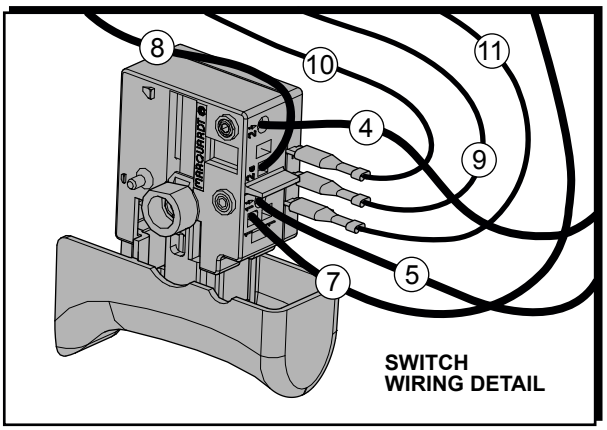
NOTE:
312 in/lbs.
or 26 ft/lbs.

Use screws (1) to temporarily attach service tool to rear pulley. Hold tool and tighted hex head screw (3) to 312 in/lbs.

Service Tool 61-30-6232

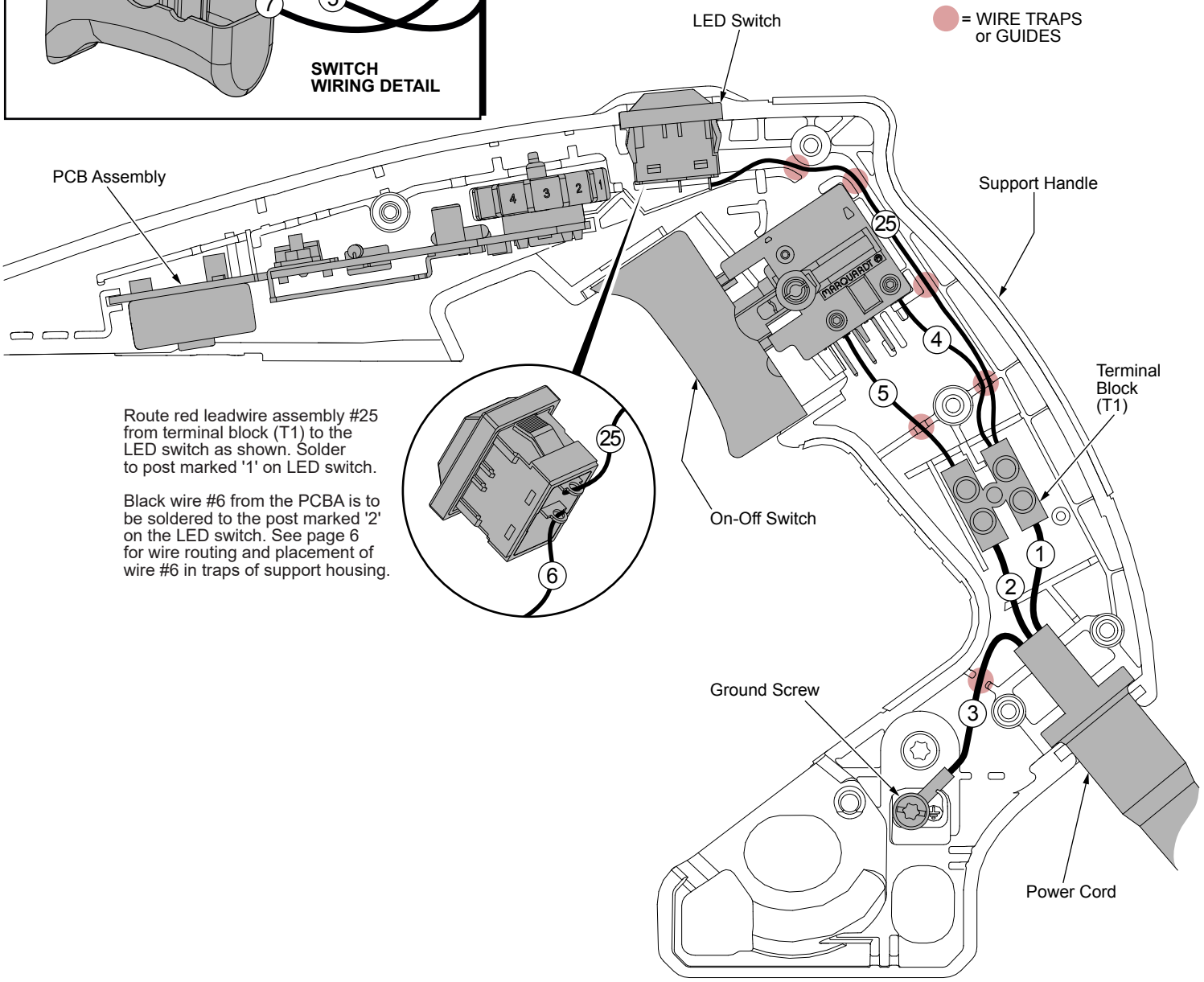
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
★ 1	06-82-5314	10-24 x 1/2" Pan Hd. Tapt. T25 (8 of 17)	(17)
2	31-15-0325	Pulley Cover (1 of 2)	(2)
3	06-75-0010	M Screw, 3/8"-16 UNC 5/8" Hex Hd.	(1)
4	40-50-0805	Disc Spring	(1)
5	43-06-0010	Clutch Washer	(2)
6	43-06-0015	Clutch Plate	(2)
★ 7	28-95-2710	Rear Pulley	(1)
8	45-69-0010	Pulley Tire (1 of 2)	(2)
9	----------	Spindle	(1)
10	----------	Gearcase Cover	(1)
11	----------	Ball Bearing	(1)
12	----------	Spur Gear	(1)
13	45-88-0406	Washer (1 of 2)	(2)
14	----------	12-24 UNC x .96" Slotted (2 of 4)	(4)
15	----------	Washer (2 of 4)	(4)
16	----------	Ball Bearing (4 of 8)	(8)
17	----------	Washer (2 of 4)	(4)
18	----------	Ball Bearing (1 of 2)	(2)
19	----------	Pin (1 of 2)	(2)
20	06-82-5574	10-24 x 7/8" Pan Hd. Tapt. T-25 (2 of 4)	(4)
21	----------	Rear Roller Block	(1)
22	----------	Bushing (2 of 3)	(3)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
23	31-15-0330	Rear Pulley Shroud	(1)
26	----------	Gearcase	(1)
29	----------	Pin (1 of 2)	(2)
43	02-04-0175	Ball Bearing (1 of 2)	(2)
★ 58	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20 Screw	(3)
120	----------	Bevel Gear	(1)
121	----------	Spur Gear	(1)
122	----------	Shaft	(1)
123	----------	Tire Cleaning Brush	(1)
124	----------	Tire Cleaning Brush Cover	(1)
125	06-82-5346	8-32 x 3/4" Pan Hd. Taptite T-20	(2)
126	14-30-0010	Gearcase Cover Kit	(1)
127	42-28-0025	Rear Guide Roller Kit	(1)
128	14-30-0015	Gearcase Top Assembly	(1)
136	14-46-0465	Guide Roller Kit	(1)
137	44-60-0295	Tire Clearing Brush Kit	(1)
141	45-88-1580	Washer	(1)
	42-55-6232	Blow Molded Carrying Case (Not Shown)	(1)
★ 151	14-30-2729	Pulley Service Kit	(1)
★ 152	28-95-0074	Rear Pulley Service Kit	(1)



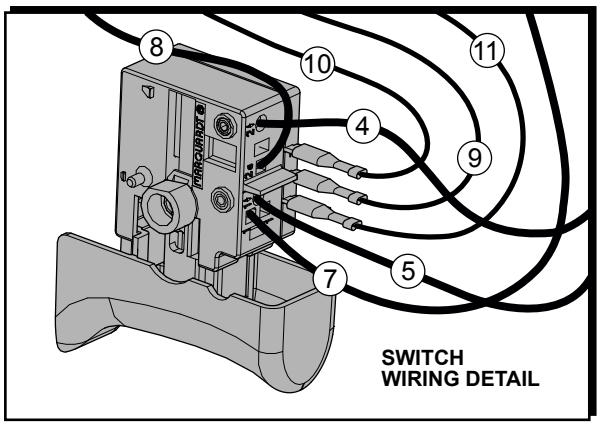
AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

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



WIRING SPECIFICATIONS

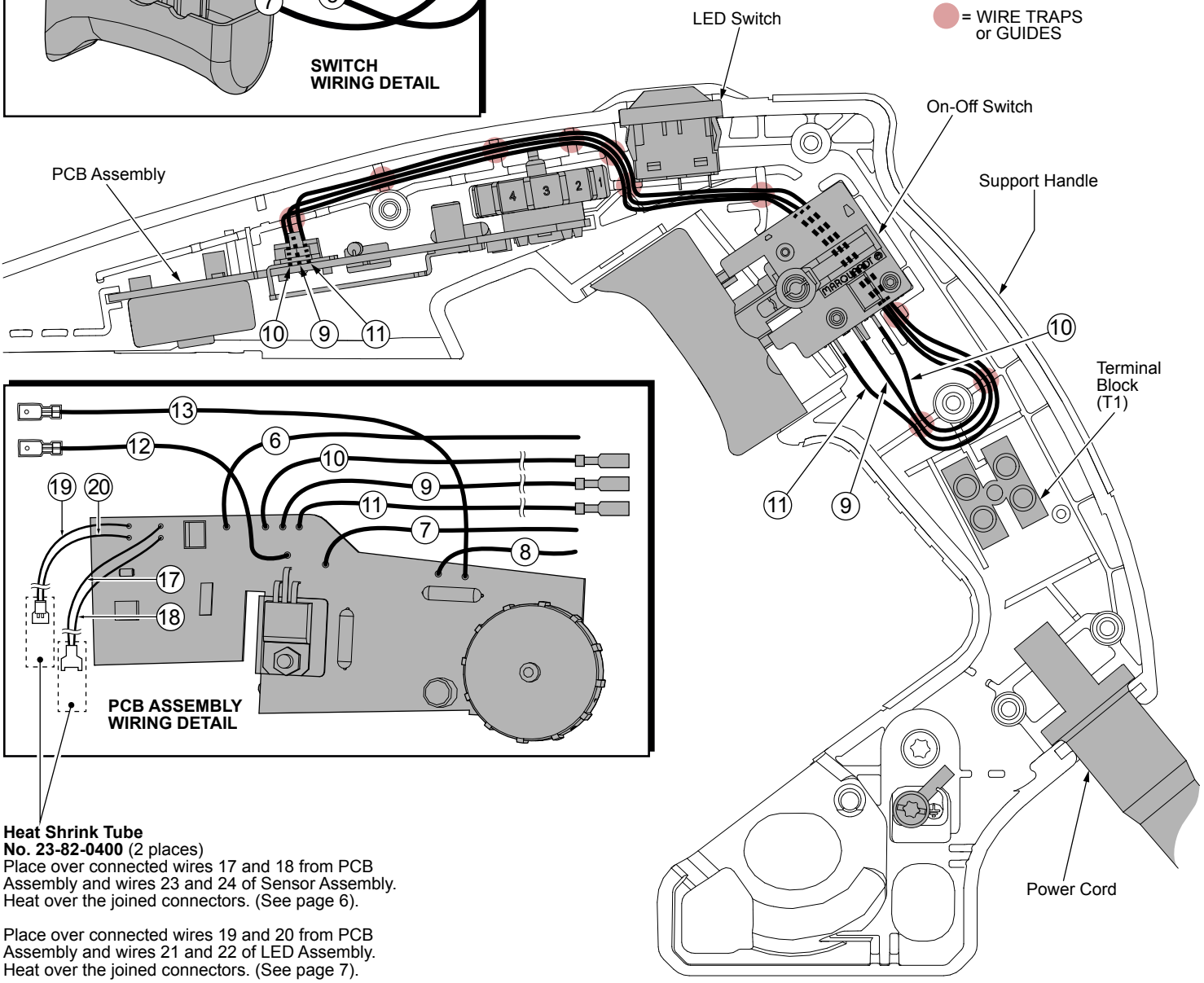
Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	Cord	-----	Component of the cord set. Connect to lower right of terminal block (T1).
2	White	Cord	-----	Component of the cord set. Connect to lower left of terminal block (T1).
3	Green	Cord	-----	Component of the cord set. Connect to grounding area on surface of gearcase.
4	Black	23-94-0405	-----	Leadwire assembly. On one end twist strands together with red wire #25 and connect with the upper right of terminal block (T1). Connect the other end to the '2↓' position of the switch.
5	White	23-94-0435	-----	Leadwire assembly. Connect one end to the upper left of terminal block (T1). Connect the other end to the '1↓' position of the switch.
25	Red	23-94-0440	-----	Leadwire assembly. On one end twist strands together with black wire #4 and connect with the upper right of terminal block (T1). Solder other end to position '1' on LED switch.



SWITCH WIRING DETAIL

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.



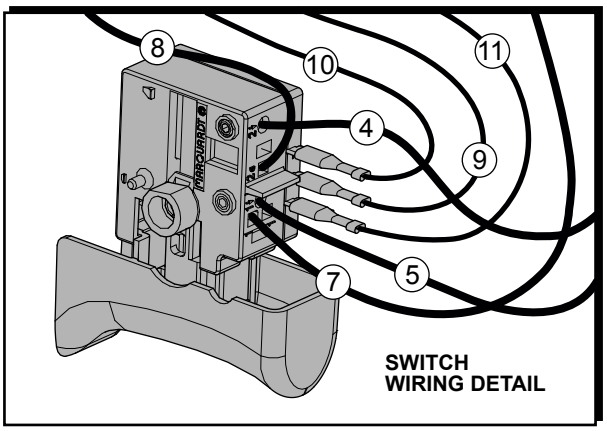
PCB ASSEMBLY WIRING DETAIL

Heat Shrink Tube
No. 23-82-0400 (2 places)
Place over connected wires 17 and 18 from PCB Assembly and wires 23 and 24 of Sensor Assembly. Heat over the joined connectors. (See page 6).

Place over connected wires 19 and 20 from PCB Assembly and wires 21 and 22 of LED Assembly. Heat over the joined connectors. (See page 7).

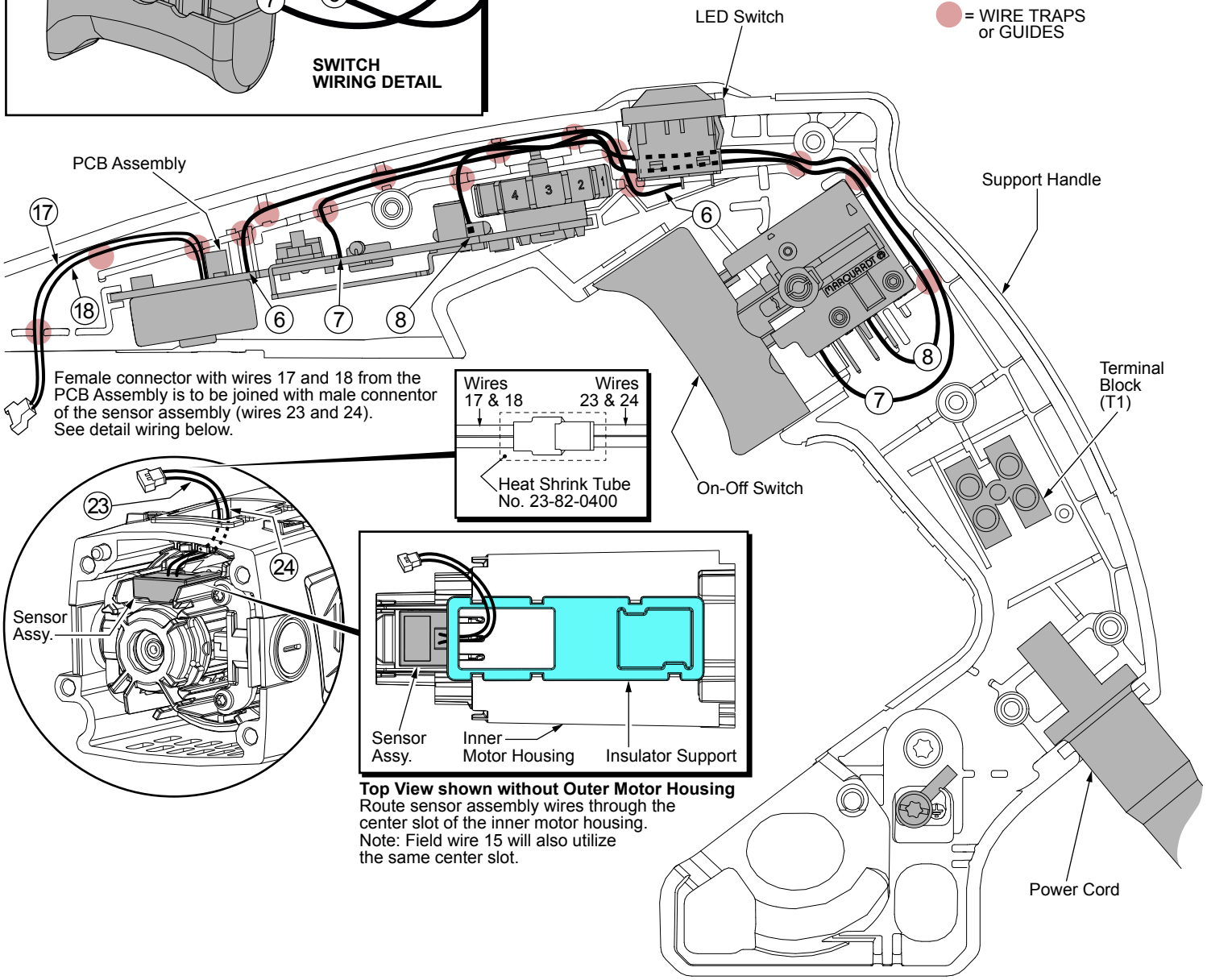
WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
9	Red	14-20-0105	-----	Component of the PCB Assembly. Connect to the '2a' position on the on-off switch.
10	White	14-20-0105	-----	Component of the PCB Assembly. Connect to the '1↑' position on the on-off switch.
11	Black	14-20-0105	-----	Component of the PCB Assembly. Connect to the '↑2' position on the on-off switch.



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

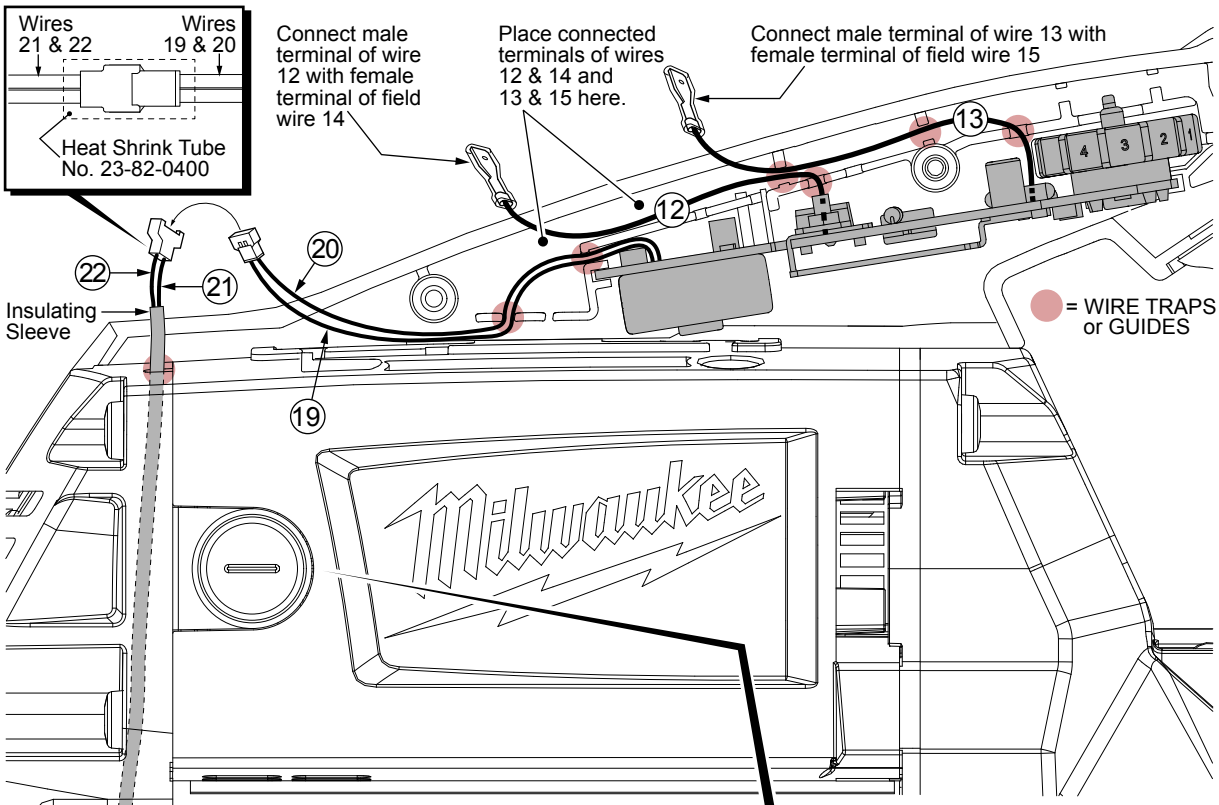
BE CAREFUL AND AVOID PINCHING WIRES BETWEEN HANDLE HALVES WHEN ASSEMBLING.

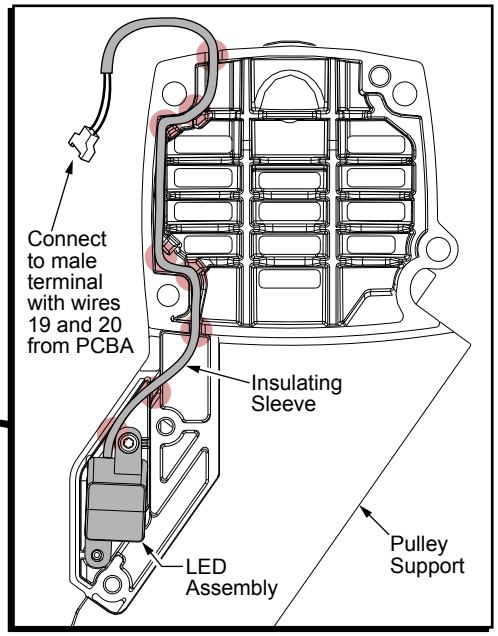


Top View shown without Outer Motor Housing
Route sensor assembly wires through the center slot of the inner motor housing. Note: Field wire 15 will also utilize the same center slot.

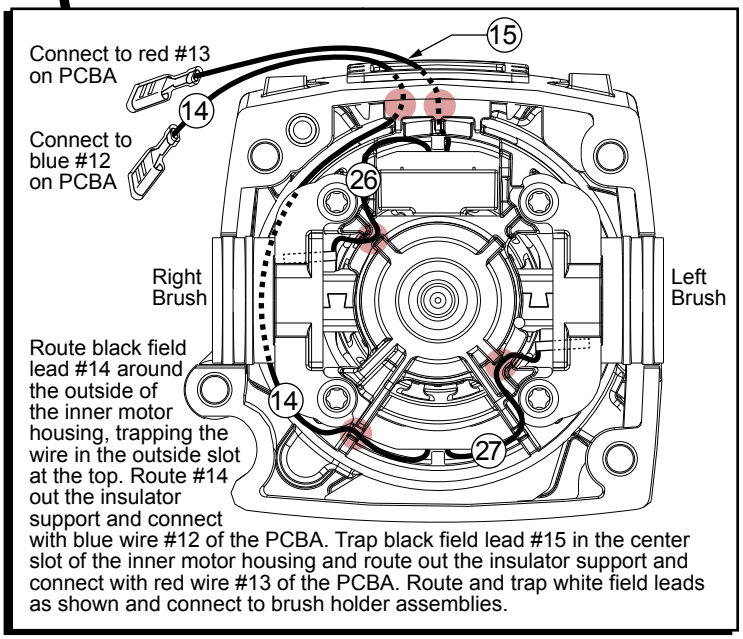
WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
6	Black	14-20-0105	-----	Component of the PCB Assembly. Solder to position '2' on LED switch.
7	White	14-20-0105	-----	Component of the PCB Assembly. Connect to position '1' at the on-off switch.
8	Black	14-20-0105	-----	Component of the PCB Assembly. Connect to position '1' at the on-off switch.
17	Black	14-20-0105	-----	Components of the PCB Assy. Wires 17 and 18 are joined together with a female connector.
18	White	14-20-0105	-----	The female connector is to connect with the male terminal of sensor assembly 14-20-0195.
23	Red	14-20-0195	-----	Components of the Sensor Assy. Wires 23 and 24 are joined together with a male connector.
24	White	14-20-0195	-----	The male connector is to connect with female terminal of wires 17 and 18.





BACK VIEW (INSIDE) OF PULLEY SUPPORT



FRONT VIEW (BRUSH END) OF OUTSIDE MOTOR HOUSING

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
12	Blue	14-20-0105	-----	Component of PCB Assembly. Connect male terminal with female terminal of wire 14.
13	Red	14-20-0105	-----	Component of PCB Assembly. Connect male terminal with female terminal of wire 15.
14	Black	18-07-0025	-----	Component of the field. Connect female terminal to the male terminal of blue wire #12.
15	Black	18-07-0025	-----	Component of the field. Connect female terminal to the male terminal of red wire #13.
19	Black	14-20-0105	-----	Components of PCB Assembly. Wires 19 and 20 are joined together with a male terminal.
20	White	14-20-0105	-----	Connect the male terminal to the female terminal of wires 21 and 22 of the LED assembly.
21	Black	14-20-0115	-----	Components of the LED assy. Wires 21 and 22 are joined together with a female terminal.
22	White	14-20-0115	-----	Connect the female terminal to the male terminal of wires 19 and 20 of the PCB Assembly.
26	White	18-07-0025	-----	Component of the field. From top of field, connect to the right brush holder tab.
27	White	18-07-0025	-----	Component of the field. From bottom of field, connect to the left brush holder tab.