



SERVICE PARTS LIST

BULLETIN NO.
54-40-1628

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN 54-40-1627	DATE Dec. 2012
METAL CUTTING SAW		WIRING INSTRUCTION SEE PAGE 4	
CATALOG NO. 6370-20	STARTING SERIAL NUMBER A35D		

EXAMPLE:

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

★ = Part number change from previous service parts list.

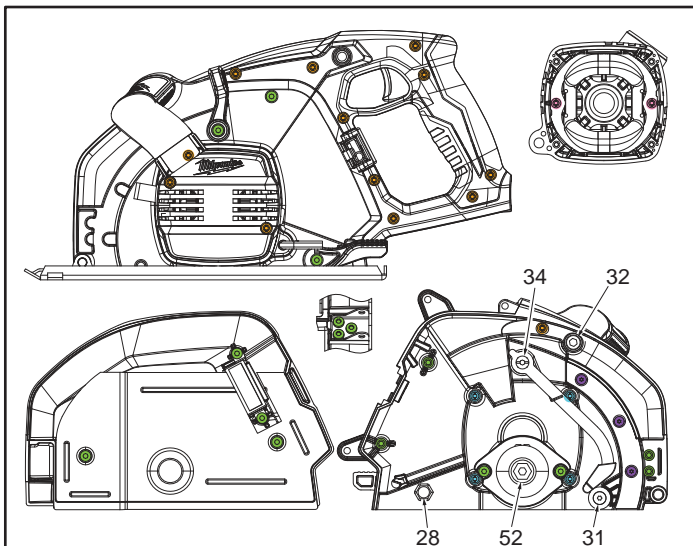
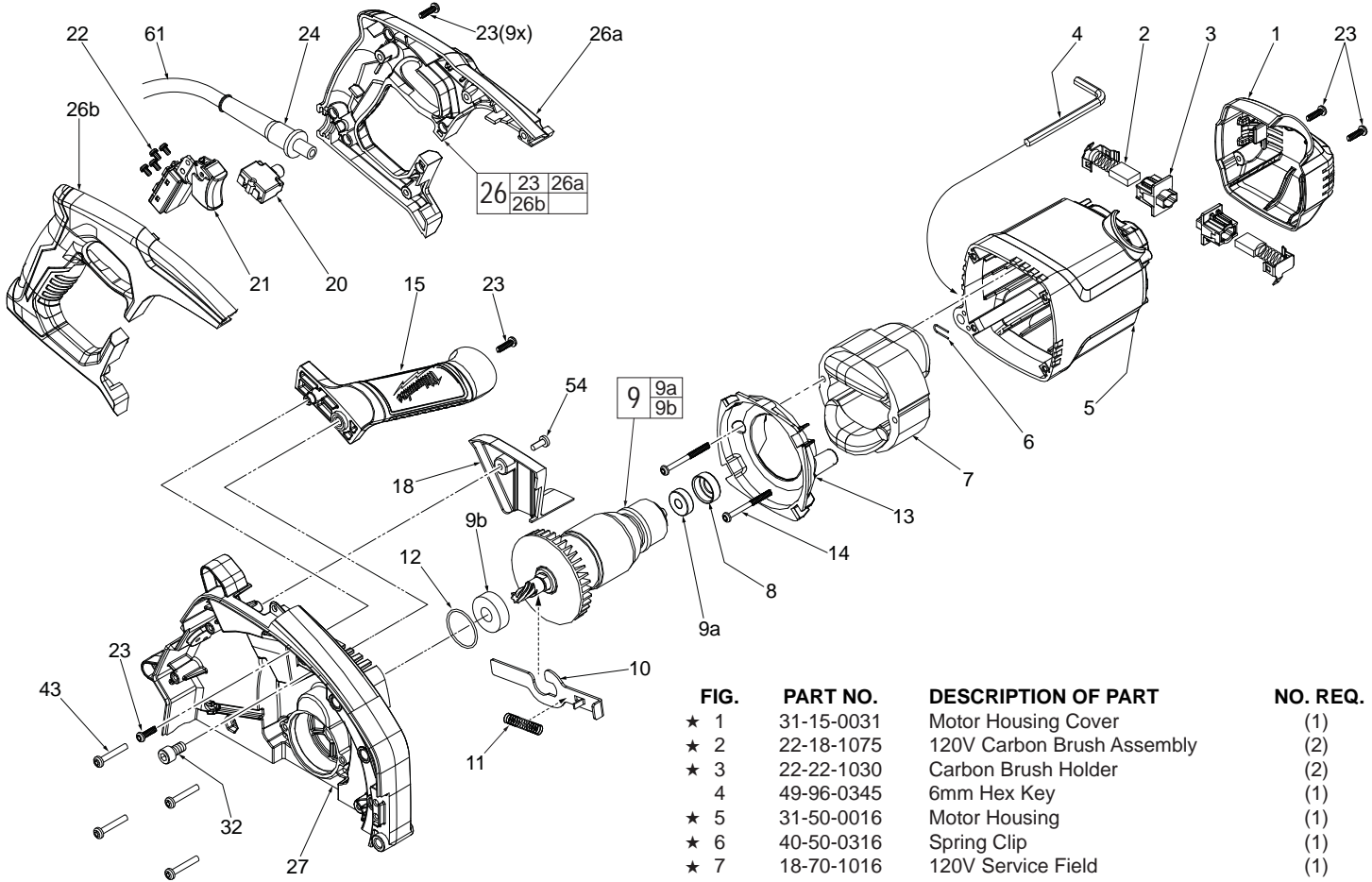


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
★ 1	31-15-0031	Motor Housing Cover	(1)
★ 2	22-18-1075	120V Carbon Brush Assembly	(2)
★ 3	22-22-1030	Carbon Brush Holder	(2)
4	49-96-0345	6mm Hex Key	(1)
★ 5	31-50-0016	Motor Housing	(1)
★ 6	40-50-0316	Spring Clip	(1)
★ 7	18-70-1016	120V Service Field	(1)
★ 8	42-96-0026	Rubber Bearing Cup	(1)
★ 9	16-70-1016	120V Service Armature Assembly	(1)
★ 9a	02-04-0847	Ball Bearing	(1)
★ 9b	02-04-1850	Ball Bearing	(1)
★ 10	44-20-0016	Spindle Lock	(1)
★ 11	40-50-0346	Spindle Lock Spring	(1)
★ 12	34-40-1375	O-Ring	(1)
★ 13	31-05-0076	Fan Baffle	(1)
★ 14	06-82-7395	8-16 x 1.75" Pan Hd. Slit. Plast. T-20	(2)
★ 15	31-44-0226	Front Handle Assembly	(1)
★ 18	31-15-0036	Wire Cover	(1)
★ 20	22-36-0161	120V 15A Overload Protector	(1)
★ 21	23-66-2685	Switch	(1)
22	05-78-0305	M3.5 x 0.6 x 0.7mm Pan Hd. Slit. T-15	(4)
23	06-82-7270	8-16 x 5/8" Pan Hd. Plast. T-20	(13)
24	44-76-0210	Cord Protector	(1)
★ 26	14-34-6370	Rear Handle Assembly	(1)
★ 26a	-----	Left Rear Handle Halve	(1)
★ 26b	-----	Right Rear Handle Halve	(1)
★ 27	28-14-0016	Gearcase	(1)
★ 32	06-75-3971	M8 x 1.25 Bolt	(1)
★ 43	05-88-9926	M5 x 16 x 2.14" Pan Hd. Taptite T-25	(4)
54	06-82-5314	10-24 x 1/2" Pan Hd. Tapt. T-25 (1 of 16)	(16)
★ 61	22-64-0437	Power Cord	(1)
★ 62	23-94-1220	Leadwire Assembly - Black (Not Shown)	(1)

FIG.	PART NO.	DESCRIPTION	QTY.
● 54	06-82-5314	10-24 x 1/2" Pan Hd. Taptite T-25	(16)
● 23	06-82-7270	8-16 x 5/8" Pan Hd. Plastite T-20	(13)
● 43	05-88-9926	M5 x 16 x 2.14" Pan Hd. Tapt. T-25	(4)
● 37	06-82-3792	8-32 x 3/8" Flat Hd. Taptite T-15	(3)
● 14	06-82-7395	8-16 x 1.75" Pan Hd. Plastite T-20	(2)

FASTENER TORQUE CHART

FIG.	DESCRIPTION	KGF/CM	IN/LBS
14	8-16 x 1.75" Pan Hd. Plastite T-20	17-23	14-20
22	M3.5 x .7mm Switch Screw	3-6	3-5
23	8-16 x 5/8" Pan Hd. Plastite T-20	15-20	13-17
31	10-32 x 13/16" Bumper Screw T-25	30-40	26-34
32	M8 X 1.25 Bolt	25-35	21-30
34	10-24 Pan Hd. Taptite T-25	30-40	26-34
37	8-32 x 3/8" Flat Hd. Taptite T-15	4-8	3-7
39	Depth Shaft	30-36	26-31
43	M5 x 16 x 2.14" Pan Hd. Tapt. T-25	40-50	34-43
54	10-24 x 1/2" Pan Hd. Tapt. T-25 (For #18)	17-23	14-20
54	10-24 x 1/2" Pan Hd. Tapt. T-25 (For #19)	20-30	17-26
54	10-24 x 1/2" Pan HdTapt. T-25 (For all other)	34-40	29-34

★ = Part number change from previous service parts list.

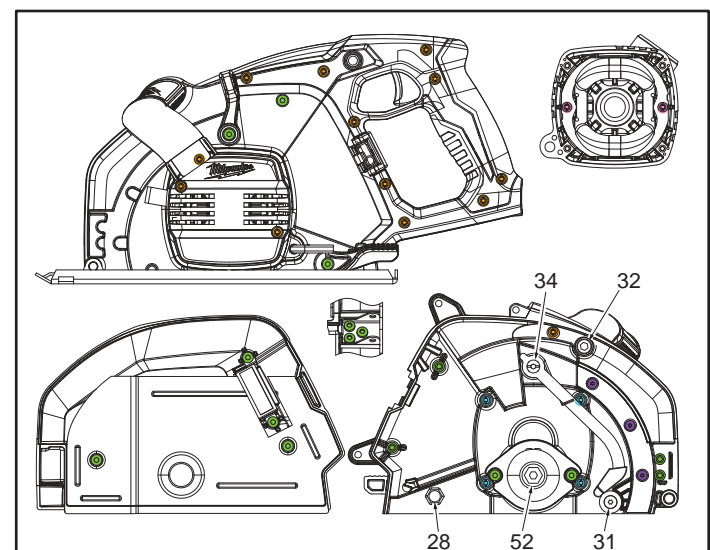
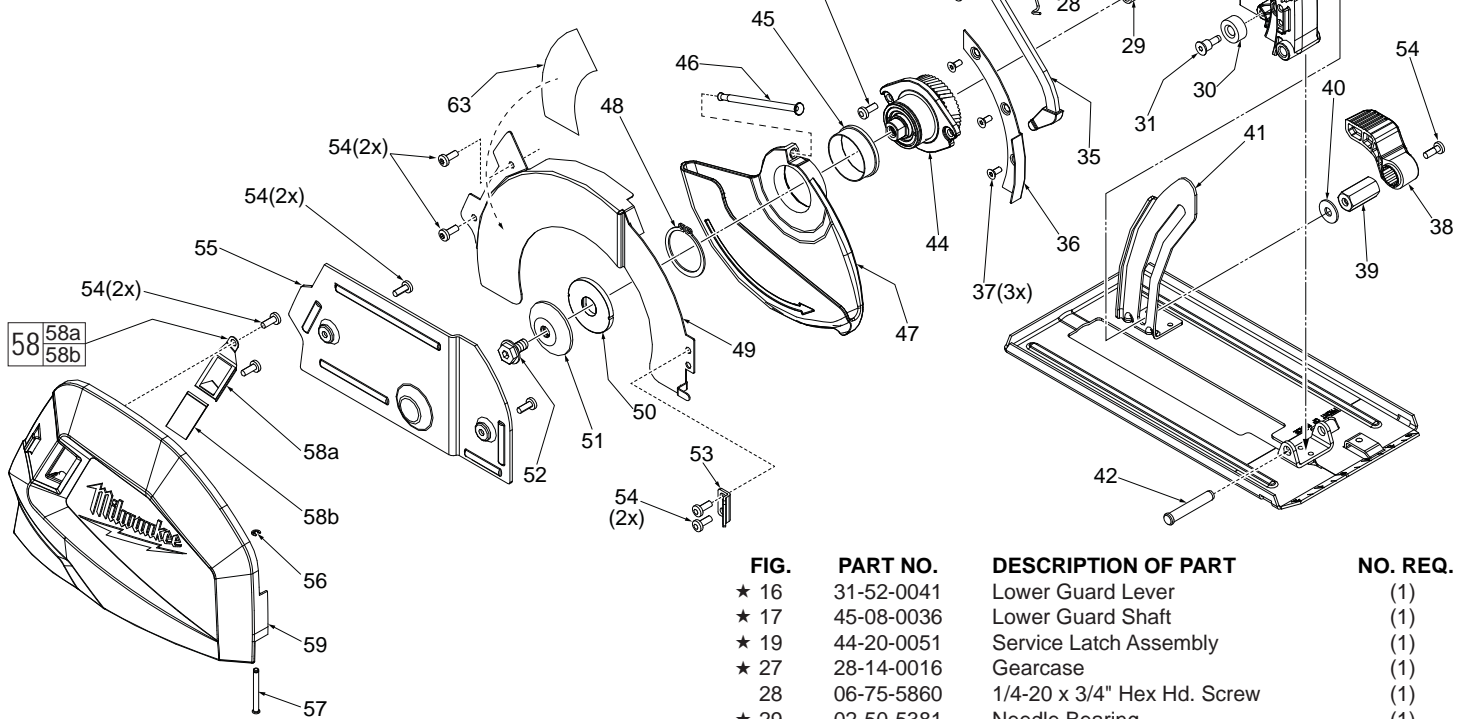
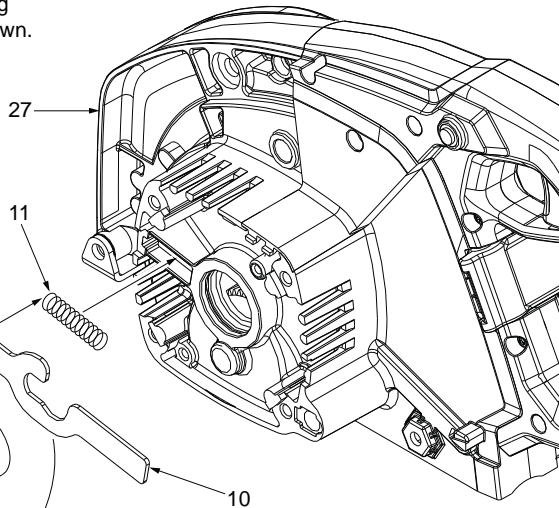
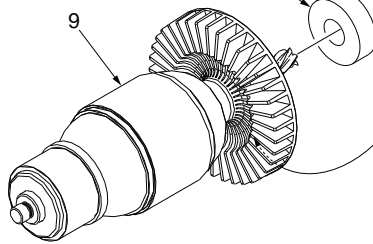


FIG.	PART NO.	DESCRIPTION	QTY.
●	54	06-82- 5314 10-24 x 1/2" Pan Hd. Taptite T-25	(16)
●	23	06-82-7270 8-16 x 5/8" Pan Hd. Plastite T-20	(13)
●	43	05-88-9926 M5 x 16 x 2.14" Pan Hd. Tapt. T-25	(4)
●	37	06-82-3792 8-32 x 3/8" Flat Hd. Taptite T-15	(3)
●	14	06-82-7395 8-16 x 1.75" Pan Hd. Plastite T-20	(2)

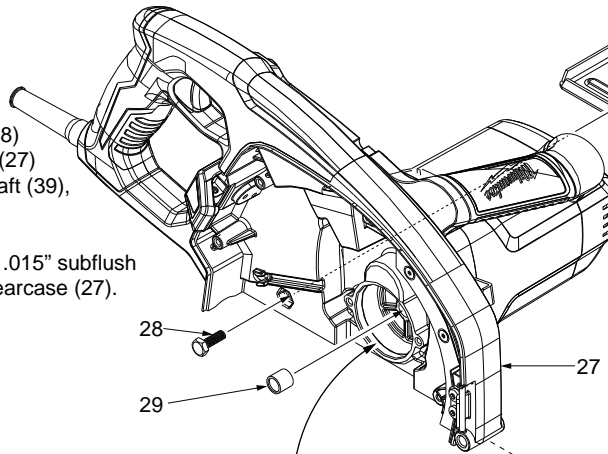
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
★	16	31-52-0041 Lower Guard Lever	(1)
★	17	45-08-0036 Lower Guard Shaft	(1)
★	19	44-20-0051 Service Latch Assembly	(1)
★	27	28-14-0016 Gearcase	(1)
	28	06-75-5860 1/4-20 x 3/4" Hex Hd. Screw	(1)
★	29	02-50-5381 Needle Bearing	(1)
	30	42-38-0222 Rubber Bumper	(1)
	31	45-04-0485 10-32 x 13/16" T-25 Bumper Screw	(1)
★	33	40-50-0356 Torsion Spring	(1)
★	34	06-82-5561 10-24 Pan Hd. Taptite T-25	(1)
★	35	44-14-0016 Lower Guard Link Assembly	(1)
★	36	43-56-0016 Chip Guide Plate	(1)
	37	06-82-3792 8-32 x 3/8" Flat Hd. Taptite T-15	(3)
★	38	31-52-0017 Depth Lever	(1)
★	39	45-08-0016 Depth Shaft	(1)
★	40	45-88-8461 Washer	(1)
★	41	45-16-0131 Shoe Assembly	(1)
	42	44-60-1180 Pivot Pin	(1)
★	44	43-78-0026 Service Hub Assembly	(1)
★	45	45-14-0021 Lower Guard Sleeve	(1)
★	46	40-50-0045 Lower Guard Spring	(1)
★	47	28-41-0016 Lower Guard	(1)
★	48	34-60-0860 Retaining Ring	(1)
★	49	43-54-0031 Inner Guard	(1)
★	50	43-34-0091 Inner Flange	(1)
★	51	43-34-0093 Outer Flange	(1)
	52	06-75-0035 5/16" 18 x 9/16" Blade Screw	(1)
★	53	42-70-0051 Cover Latching Clip	(1)
★	54	06-82-5314 10-24 x 1/2" Pan Hd. Tapt. T-25 (15 of 16)	(16)
★	55	28-20-0016 Collector Cover Plate	(1)
★	56	34-60-0401 E-Ring	(1)
★	57	44-60-0106 Front Latch Pin	(1)
★	58	43-50-0020 Window Assembly	(1)
★	58a	Window Retainer	(1)
★	58b	Window Glass	(1)
★	59	28-20-0021 Collector Cover	(1)
★	63	10-20-0000 Warning Label	(1)

Place spindle lock spring (11) into the spring retaining area on the gearcase (27), as shown. Press ball bearing (9b) to the shoulder on the armature shaft (9). Orient the spindle lock (10) onto the armature shaft, inbetween the pressed on bearing and the front of the fan, as shown. Carefully insert the armature pinion/bearing into the gearcase. Align the spindle lock with the channel in the gearcase, making sure that the tab on the spindle lock engages the front of the spring.

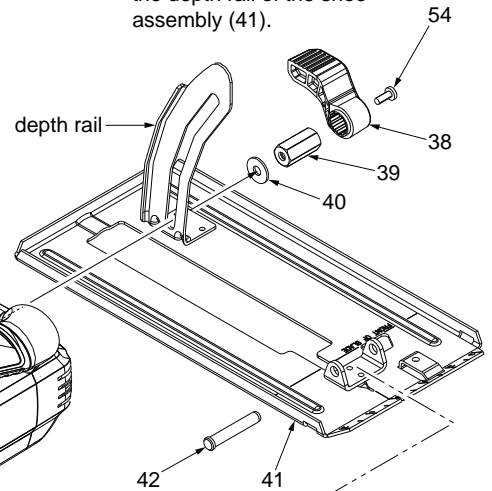


Verify that the hex head bolt (28) is fully seated in the gearcase (27) while assembling the depth shaft (39), as shown.

Press the bearing (29) flush to .015" subflush to the gear cavity wall in the gearcase (27).



Orient the washer (40) such that the rounded edge is towards the depth rail of the shoe assembly (41).



When servicing, remove 90-95% of the existing grease prior to installing Type 'Y' grease. Original grease maybe similar in color but not compatible with 'Y'.

LUBRICATION

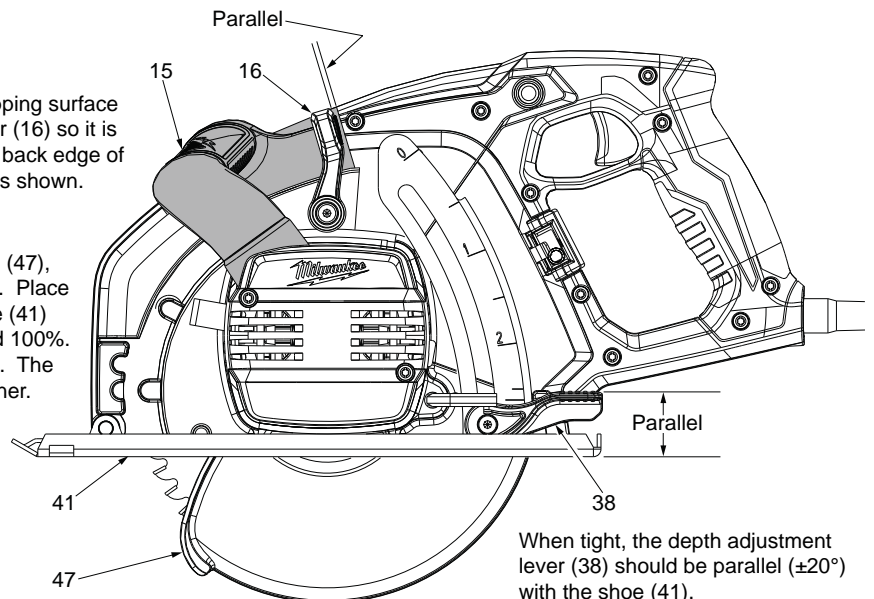
Type 'Y' Grease, No. 49-08-5270

Note: Approx. 20 grams (.7 oz.) will be used

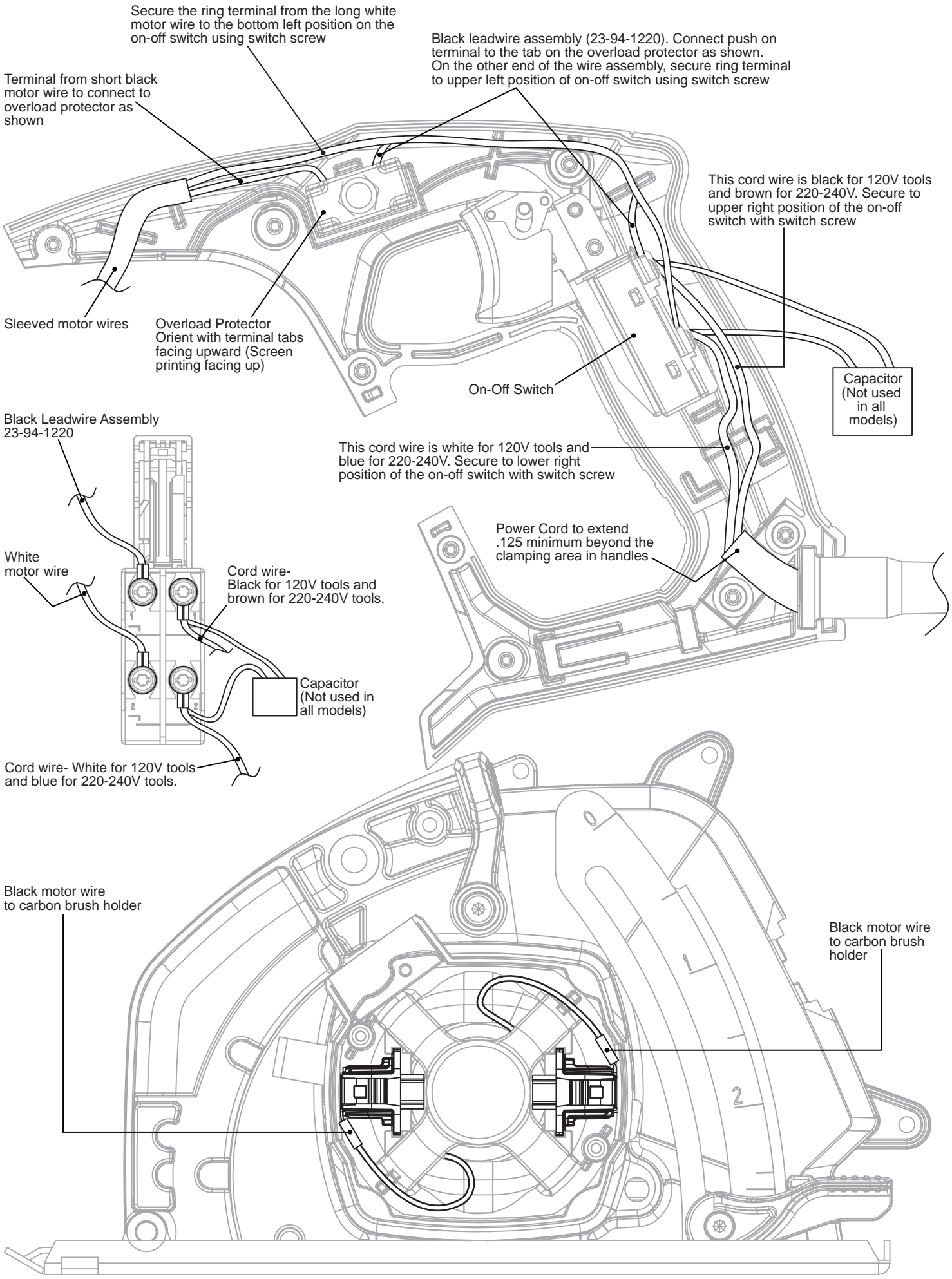
- Place a light coat of grease on the lower guard shaft (17) before assembling into the gearcase hole. (Approx. 1g/.035oz.).
- Coat o-ring (12) with grease prior to installing in groove of bearing cavity of gearcase (27). Coat bearing cavity (with o-ring installed) with grease prior to installing ball bearing (9b). (Approx. 2g/.07oz.).
- Place a heavy coating of grease over and around all teeth of the pinion gearing of the armature (9). (Approx. 2g/.07oz.).
- Place 9-11 grams (.32-.39oz.) of grease into the gear cavity of gearcase (27) prior to installing the service hub assembly (44).
- Place a heavy coating of grease over and around all of the teeth of the gear of the service hub assembly. (Approx. 3g/.1oz.).
- Coat the outside surface of needle bearing (29) and the needle bearing cavity of gearcase (27) with grease. (Approx. 1g/.035oz.)

Orient the textured gripping surface of the lower guard lever (16) so it is parallel ($\pm 20^\circ$) with the back edge of the front handle (15), as shown.

Functionally check the lower guard (47), with the saw set at full depth of cut. Place the saw upside down with the shoe (41) horizontal. Retract the lower guard 100%. Release the lower guard lever (16). The guard should return in a brisk manner.



When tight, the depth adjustment lever (38) should be parallel ($\pm 20^\circ$) with the shoe (41).



Secure the ring terminal from the long white motor wire to the bottom left position on the on-off switch using switch screw

Black leadwire assembly (23-94-1220). Connect push on terminal to the tab on the overload protector as shown. On the other end of the wire assembly, secure ring terminal to upper left position of on-off switch using switch screw

Terminal from short black motor wire to connect to overload protector as shown

This cord wire is black for 120V tools and brown for 220-240V. Secure to upper right position of the on-off switch with switch screw

Sleeved motor wires

Overload Protector Orient with terminal tabs facing upward (Screen printing facing up)

On-Off Switch

Capacitor (Not used in all models)

Black Leadwire Assembly 23-94-1220

This cord wire is white for 120V tools and blue for 220-240V. Secure to lower right position of the on-off switch with switch screw

White motor wire

Cord wire- Black for 120V tools and brown for 220-240V tools.

Capacitor (Not used in all models)

Power Cord to extend .125 minimum beyond the clamping area in handles

Cord wire- White for 120V tools and blue for 220-240V tools.

Black motor wire to carbon brush holder

Black motor wire to carbon brush holder