SERVICE PARTS LIST

BULLETIN NO. 54-40-7570

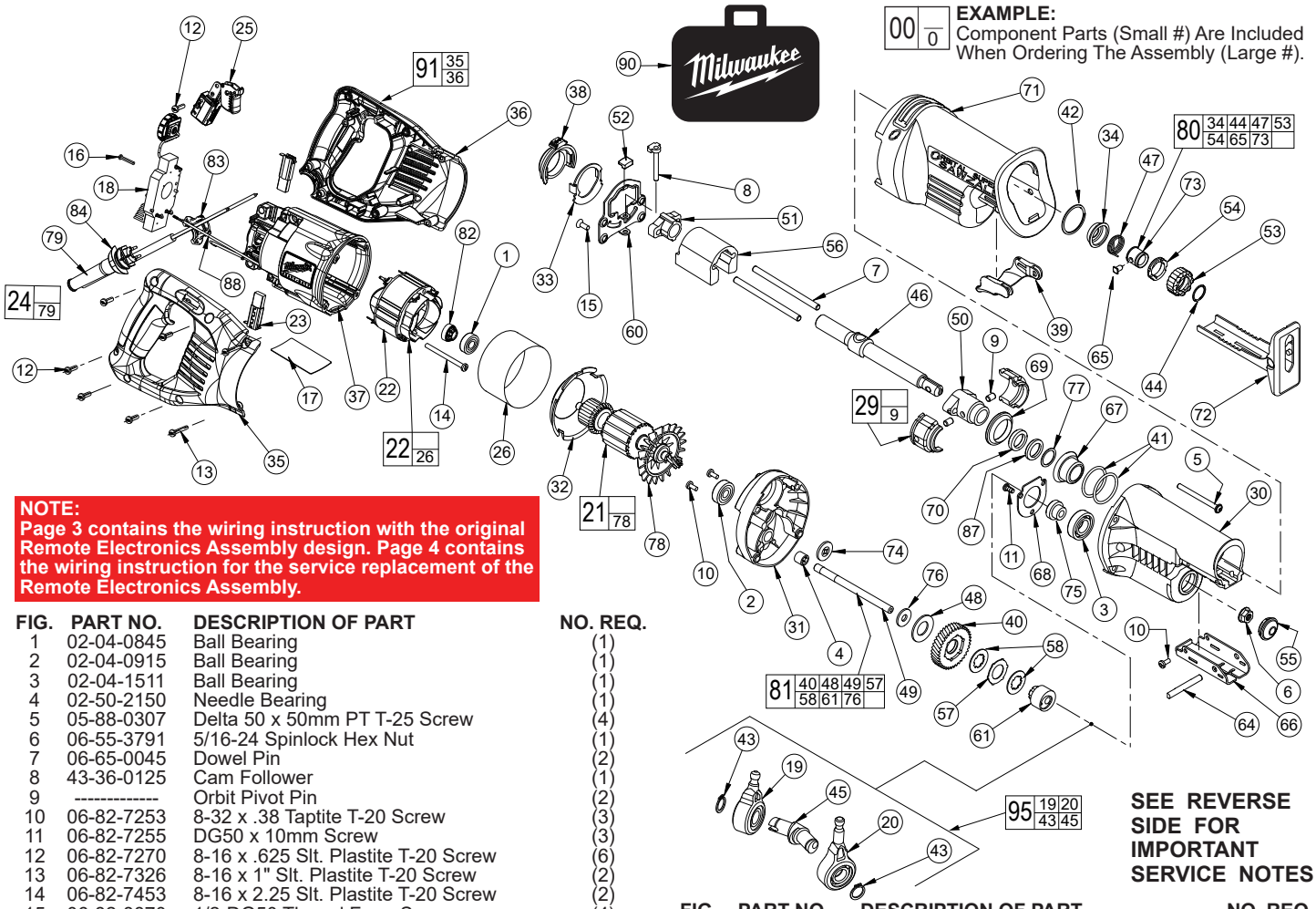
SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

1-1/4" STROKE SAWZALL®

CATALOG NO.	6538-21	SERIAL NO.	B36A

REVISED BULLETIN	DATE
	Aug. 2025

WIRING INSTRUCTION **See Pages 3 or 4**



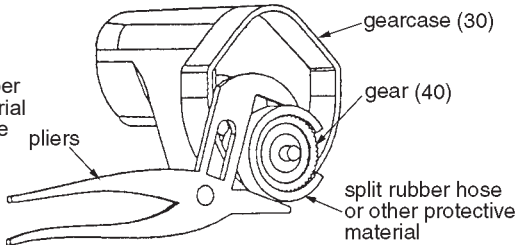
NOTE:
Page 3 contains the wiring instruction with the original Remote Electronics Assembly design. Page 4 contains the wiring instruction for the service replacement of the Remote Electronics Assembly.

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	05-88-0307	Delta 50 x 50mm PT T-25 Screw	(4)
6	06-55-3791	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 2.25 Slt. Plastite T-20 Screw	(2)
15	06-82-8870	1/2-DG50 Thread Form Screw	(4)
16	06-82-7330	4-20 x .875 Plastite T-10 Screw	(1)
17	12-20-6550	Service Nameplate	(1)
18	14-20-2530	Remote Electronics Assembly	(1)
19	----------	Secondary Wobble Plate Assembly	(1)
20	----------	Primary Wobble Plate Assembly	(1)
21	16-30-0705	Service Armature	(1)
22	18-31-0221	Service Field	(1)
23	22-20-0535	Carbon Brush Assembly	(2)
24	22-64-0595	Cord Assembly	(1)
25	23-66-2490	Switch	(1)
26	23-16-0046	Cardboard Tube	(1)
29	14-30-0080	Orbit Pocket Assembly	(1)
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	----------	Handle Half - Right	(1)
36	----------	Handle Half - Left	(1)
37	31-50-6538	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	----------	External Retaining Ring	(2)
44	34-60-3700	Retaining Ring	(1)
45	----------	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)

SEE REVERSE SIDE FOR IMPORTANT SERVICE NOTES

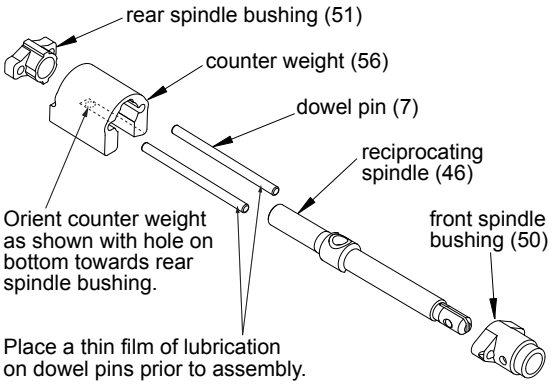
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
54	----------	Rear Cam	(1)
55	42-52-0380	Bearing Cap	(1)
56	42-87-0180	Counter Weight	(1)
57	43-06-0676	Bronze Plate	(1)
58	43-06-0685	Metal Plate	(2)
60	43-56-0620	Orbit Plate	(1)
61	43-78-0577	Orbit Drive Hub	(1)
64	44-60-1635	Shoe Pin	(1)
65	----------	Lock 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	23-38-0200	Magnet	(1)
83	31-17-0260	Cord Clamp	(1)
84	31-17-0265	Cord Clamp	(1)
87	45-06-0501	Felt Seal	(1)
88	23-94-7425	Leadwire Assembly	(1)
89	23-45-6538	Fiberglass Sleeve	(2)
90	42-55-2050	Blow Molded Carry Case	(1)
91	31-50-0972	Handle Service Kit	(1)
95	14-67-0131	Wobble Plate Service 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.

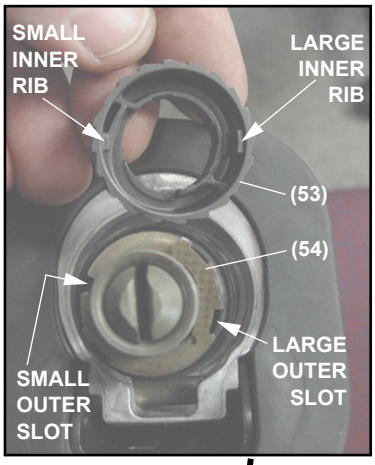


REMOVING THE STEEL QUIK-LOK® BLADE CLAMP

- 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.



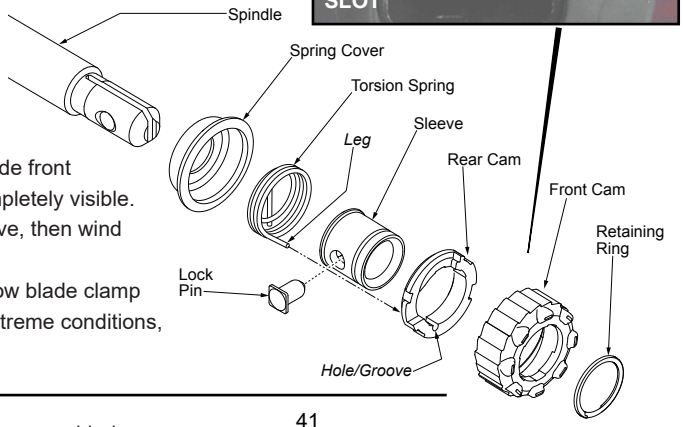
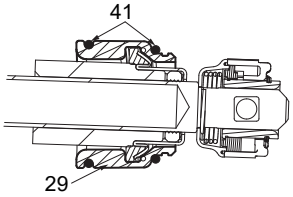


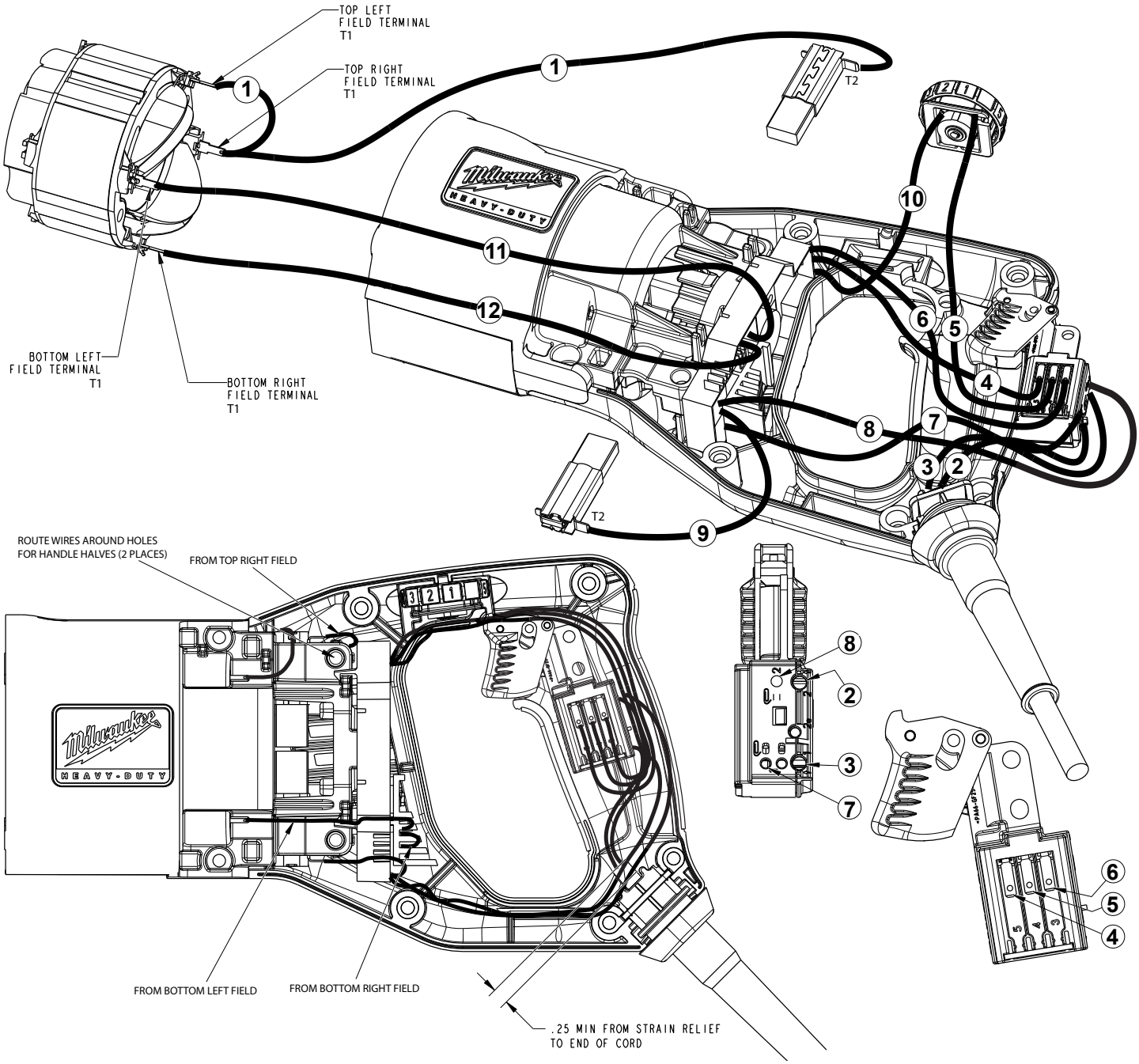
FIG.	LUBRICATION:
29,41	Lightly coat o-rings with lubrication for ease of installation onto assembled orbit pockets.
30	Place 3.2 oz. (80 grams ± 8 grams) of type "V" grease (Cat. No. 49-08-4380), in mechanism cavity of gear case.
31	Place .8 oz. (20 grams ± 2 grams) of type "V" grease (Cat. No. 49-08-4380), in lower needle bearing-gear train cavity of diaphragm.
40,58	Apply a thin coat of type "V" grease (Cat. No. 49-08-4380) between gear and metal plate.
65	Pin to be coated with graphite prior to assembly.
87	Soak in lightweight bushing oil prior to assembly.



LUBRICATION
Use Type "V" grease, No. 49-08-4380 (1 lb. tub)
NOTE: When servicing, remove 90-95% of the existing grease prior to installing Type "V". Original grease may be similar in color but not compatible with "V". Clean gear assemblies with a clean, dry cloth.

WIRING INSTRUCTIONS

TITLE **6538-21 SAWZALL® with 14-20-1040 Remote Electronics Assembly**



Wire No.	Wire Color	Origin or Part No.	Length	Terminals, Connectors and End Wire Preparation
1	White	23-94-7425	--	
2	Black	Cord Assembly	3.5	Strip .35 and tin.
3	White	Cord Assembly	3.0	Strip .35 and tin.
4	Red	Remote Electronics Assembly	--	
5	Black	Remote Electronics Assembly	--	
6	White	Remote Electronics Assembly	--	
7	White	Remote Electronics Assembly	--	
8	Black	Remote Electronics Assembly	--	
9	Black	Remote Electronics Assembly	--	
10	Black	Remote Electronics Assembly	--	
11	Yellow	Remote Electronics Assembly	--	
12	Yellow	Remote Electronics Assembly	--	

NOTES:
TERMINALS MAY BE SECURED WITH BARRELS FACING IN OR OUT. (4 PLACES).

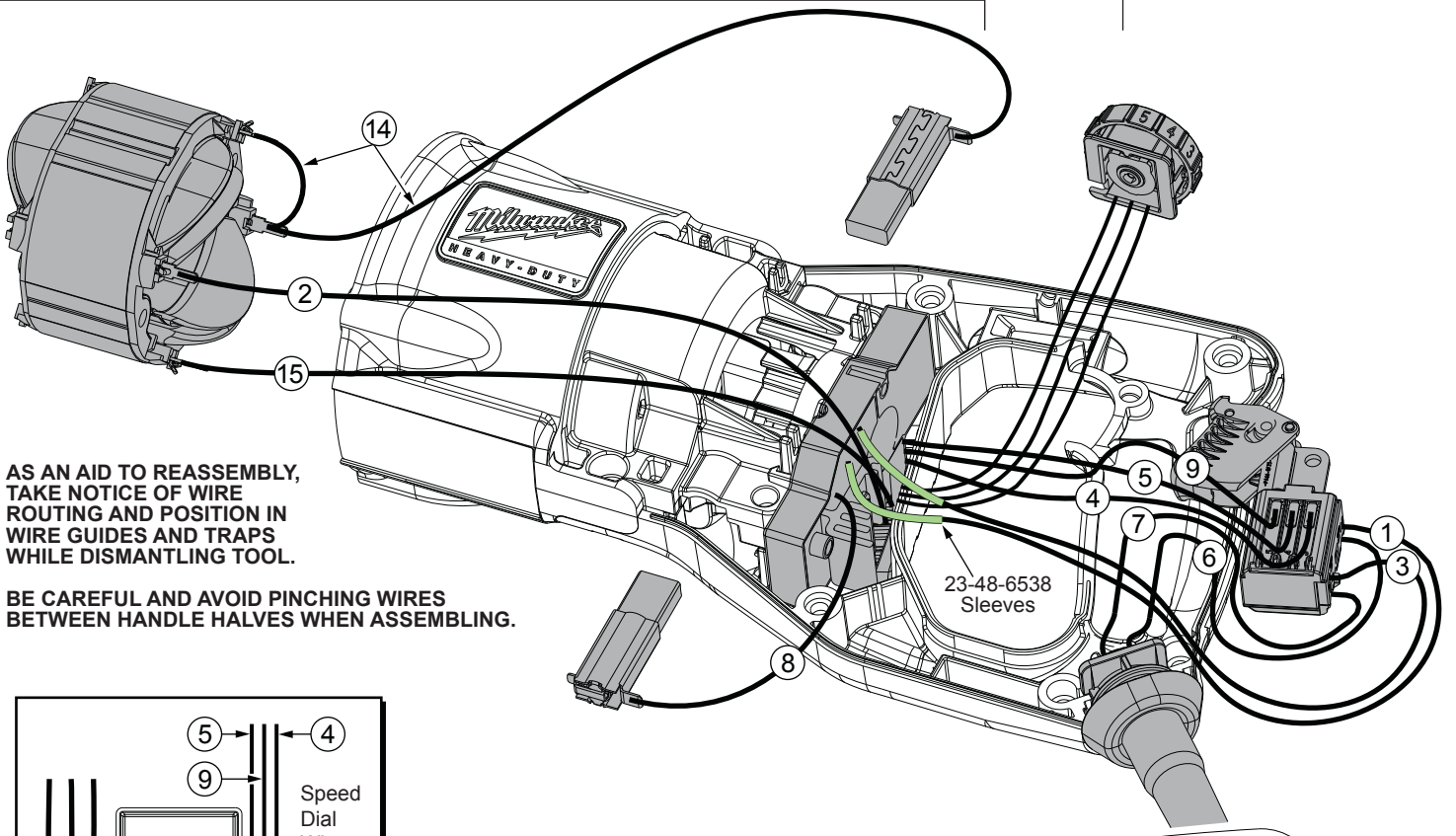
NOTE:
All leads must be held to ± 1/8".
All lead lengths are before stripping.

TERMINAL DESCRIPTION		
Code	Part No.	Qnty.
T1	23-74-1060	4
T2	23-74-0605	2

WIRING INSTRUCTIONS

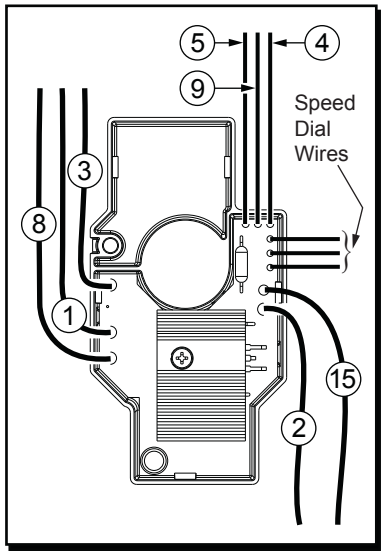
TITLE **6538-21 SAWZALL® with 14-20-1115 Remote Electronics Assembly** | BULLETIN

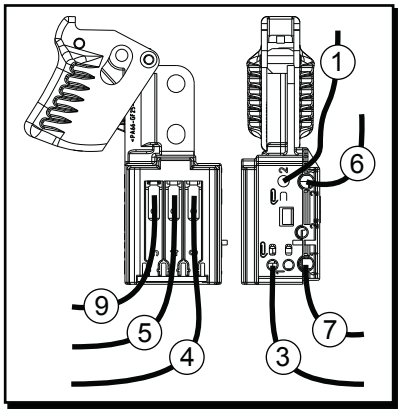
MILWAUKEE ELECTRIC TOOL CORP. 13135 WEST LISBON RD. BROOKFIELD, WIS. | DATE

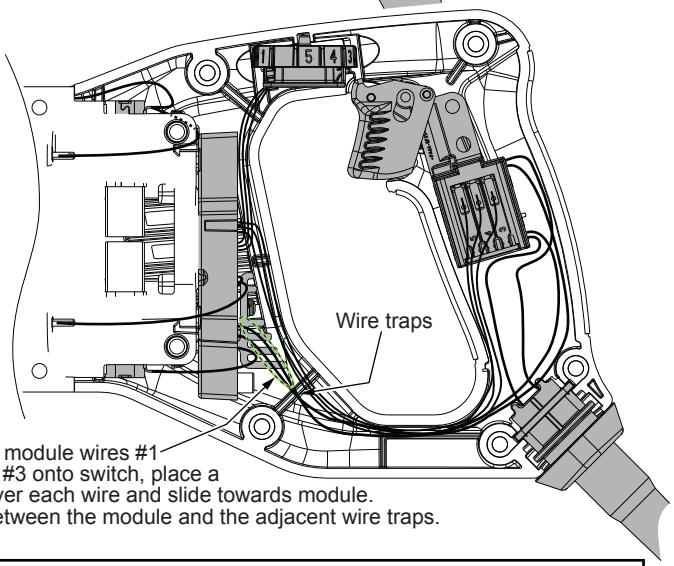


AS AN AID TO REASSEMBLY, TAKE NOTICE OF WIRE ROUTING AND POSITION IN WIRE GUIDES AND TRAPS WHILE DISMANTLING TOOL.

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







Prior to installing black module wires #1 and white module wire #3 onto switch, place a sleeve (23-48-6538) over each wire and slide towards module. Locate both sleeves between the module and the adjacent wire traps.

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation
1	Black	14-20-1105	-----	Component of the speed control module. Connect to position '2' on the back of the on-off switch.
2	Yellow	14-20-1105	-----	Component of the speed control module. Connect to the bottom left field terminal.
3	White	14-20-1105	-----	Component of the speed control module. Connect to position '1' on the back of the on-off switch.
4	Black	14-20-1105	-----	Component of the speed control module. Connect to position '3' on the left side of the on-off switch.
5	White	14-20-1105	-----	Component of the speed control module. Connect to position '4' on the left side of the on-off switch.
6	Black	22-64-4522	-----	Component of the power cord set. Connect the other end to position '2↑' on switch.
7	White	22-64-4522	-----	Component of the power cord set. Connect the other end to position '1↑' on switch.
8	Black	14-20-1105	-----	Component of the speed control module. Connect to the bottom brush tube terminal.
9	Blue	14-20-1105	-----	Component of the speed control module. Connect to position '5' on the left side of the on-off switch.
14	White	23-94-7425	-----	Leadwire assembly. Connect to the top right and left field terminals. Connect to top brush tube terminal.
15	Yellow	14-20-1105	-----	Component of the speed control module. Connect to the bottom right field terminal.