SERVICE PARTS LIST

STARTING

SERIAL NO

67

68

72

74

75

76

77

78

79

81

82

83

84

87

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★80

44-86-0035

44-86-0655

45-06-0110

45-06-0475

45-12-0700

45-16-0645

45-28-0555

45-36-1445

45-88-1555

45-88-8577

22-84-0531

44-76-0210

14-46-1062

14-08-0075

23-38-0200

31-17-0260

31-17-0265

45-06-0501

23-94-7425

23-48-6538

42-55-2051

(51)

-(56)

B36C

00

0

(50)

(9)

Milwankee

53

42-52-0380

Front Cam

Rear Cam

Bearing Cap

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS

54-40-7571

EXAMPLE:

REVISED BULLETIN DATE Jan. 2017

80 34 44 47 53 54 65 73

WIRING INSTRUCTION See Page 3

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

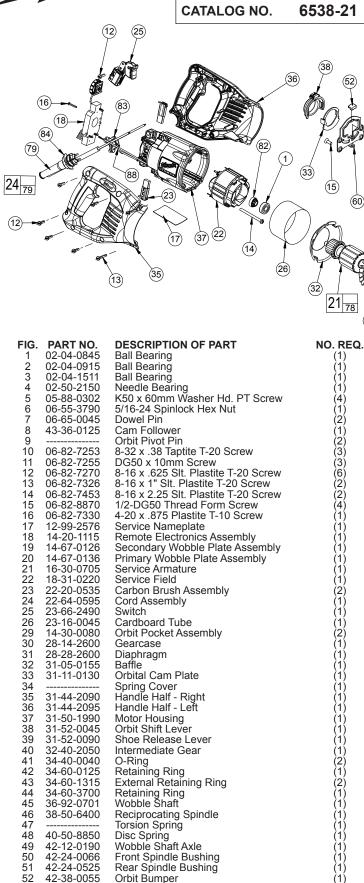
(34)

(65)

(47)

(73)





78	10 2 31	29 9 70 87 76 48 49 57 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6 6	(1) (8) (75) (3) (10) (58) (10) (68) (75) (3) (10) (68) (75) (3) (10) (68) (75) (75) (75) (75) (75) (75) (75) (75	(72) (5) (6) (6) (6) (6)
		(45) (20) (43)	SEE REV SIDE FOI IMPORTA SERVICE	R NT
	FIG. PART NO 56 42-87-018 57 43-06-068 60 43-56-062 61 43-78-057 64 44-60-163 65	Counter Weight Bronze Plate Metal Plate Orbit Plate Orbit Drive Hub Shoe Pin Lock Pin Shoe Retainer	t T	NO. REQ. (1) (2) (1) (1) (1) (1) (1) (1)

Front Orbit Cap

Orbit Seal

Sleeve

Slinger

Spacer

Washer

Washer

Magnet Cord Clamp

Cord Clamp

Leadwire Assembly

Fiberglass Sleeve Carrying Case (Not Shown)

Felt Seal

Fan

Polypak Seal

Shoe Assembly

Cord Protector

Large Quik-Lok Blade Clamp

Gear Protecting Clutch Assembly

Bearing Retainer

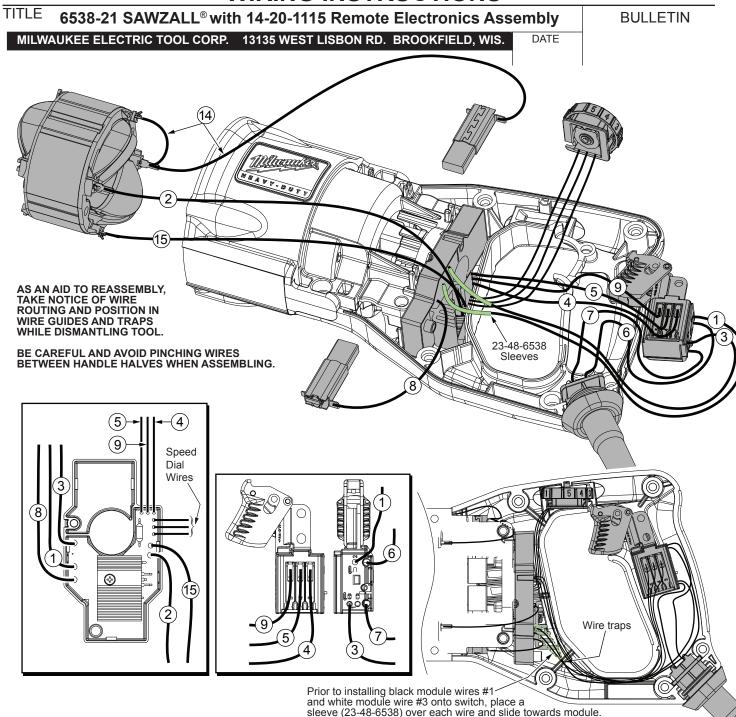
Gearcase Insulator

MILWAUKEE TOOL • www.milwaukeetool.com 13135 W. LISBON RD., BROOKFIELD, WI 53005

FIG. 1	NOTES: Bearing to be installed with seal towards commutator.					
4,31						
6,49	Apply Blue Loctite® 242 to treads of wobble shaft axle prior to installing s	pinlock hex nut. Torque spinlock hex i	nut to 160-190 in. lbs.			
6,40	Hold the intermediate gear still with a	gearcase (30)				
	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.	gear (40)				
	Thex that with a whereon, as shown.	split rubber hose	Service Fixture			
		or other protective material	61-10-0270 (Pressing Pin Tool)			
7,46,50,51,56	Press dowel pins flush to front side of front spindle bushing. Press dowel	rear spindle bushing	(51)			
	pins flush to back side of rear spindle bushing. NOTE: Reciprocating spindle (46) and counter weight (56) must be installed inside assembly	counter weig	ht (56)			
	(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.	dol	wel pin (7)			
17,37	Install nameplate in motor housing recess prior		reciprocating spindle (46)			
,	to assembling diaphragm onto motor housing.	Orient counter weight				
29,42	Service fixture #61-10-0205 must be used when installing retaining ring (42) onto orbit pocket assembly (29).	as shown with hole on bottom towards rear spindle bushing.	front spindle bushing (50)			
40,57	Tabs of bronze plate engage intermediate gear.					
40,48	Concave side of disc spring towards intermediate gear.	Place a thin film of lubrication on dowel pins prior to assembly.	a.O			
58,61	Tabs of metal plates engage orbit drive hub.					
70	O-ring of polypak seal faces mechanism - toward rear of tool.	SMALL	LARGE			
74	Shoulder extension of grease slinger should face bearing.	RIB	INNER RIB			
REMOVING TH	HE STEEL QUIK-LOK® BLADE CLAMP ————————————————————————————————————		1111			
	external retaining ring (44) and pull front cam (53) off.		(53)			
'	Pull lock pin (65) out and remove remainder of parts and discard.					
	OF THE STEEL QUIK-LOK® BLADE CLAMP	146/1	(54)			
	Coat new lock pin with powdered graphite. Held tool in a vertical position.					
	 Hold tool in a vertical position. Place spring cover (34) onto spindle. 					
	Slide torsion spring (47) onto spindle shaft OUTER SMALL OUTER					
• .	ositioned at the 6:00 position.	46 OUTER SLOT	3LOT			
	ve (73) onto spindle aligning hole on sleeve with hole in spindle.	12:00				
	cam (54) over sleeve, aligning hole in rear cam with spring leg. pring leg inserts into hole in rear cam.	34 47	73 54			
	ar cam (54) counter clockwise until there is clearance for	Jan Jan	53			
lock pin (6	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						
	reely. The use of spray lubricant can help free blade clamp. In extreme cond	itions, 65 hole -				
follow the	se 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 p	pockets. 41
30	Place 3.2 oz. (80 grams \pm 8 grams) of type "T" grease (Cat. No. 49-08-4290), in mechanism cavity of gear case.	
31	Place .8 oz. (20 grams \pm 2 grams) of type "T" grease (Cat. No. 49-08-4290), in lower needle bearing-gear train cavity of diaphragm.	
40,58	Apply a thin coat of type "T" grease (Cat. No. 49-08-4290) between gear and metal plate.	
65	Pin to be coated with graphite prior to assembly.	29
87	Soak in lightweight bushing oil prior to assembly	

WIRING INSTRUCTIONS



	WIRING SPECIFICATIONS						
Wire No.	Wire Color	Origin or Gauge	Length	Terminals, Connectors and 1 or 2 End Wire Preparation			
Black	14-20-1	1105	Compo	nent of the speed control module. Connect to position '2' on the back of the on-off switch.			
Yellow	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom left field terminal.			
White	14-20-	1105	Compo	nent of the speed control module. Connect to position '1' on the back of the on-off switch.			
Black	14-20-1	1105	Compo	nent of the speed control module. Connect to position '3' on the left side of the on-off switch.			
White	14-20-1	1105	Compo	nent of the speed control module. Connect to position '4' on the left side of the on-off switch.			
Black	22-64-4	1522	Compo	nent of the power cord set. Connect the other end to position '2↑' on switch.			
White	22-64-4	1522	Compo	nent of the power cord set. Connect the other end to position '1↑' on switch.			
Black	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom brush tube terminal.			
Blue	14-20-	1105	Compo	nent of the speed control module. Connect to position '5' on the left side of the on-off switch.			
White	23-94-7	7425	Leadw	re assembly. Connect to the top right and left field terminals. Connect to top brush tube terminal.			
Yellow	14-20-	1105	Compo	nent of the speed control module. Connect to the bottom right field terminal.			

Locate both sleeves between the module and the adjacent wire traps.