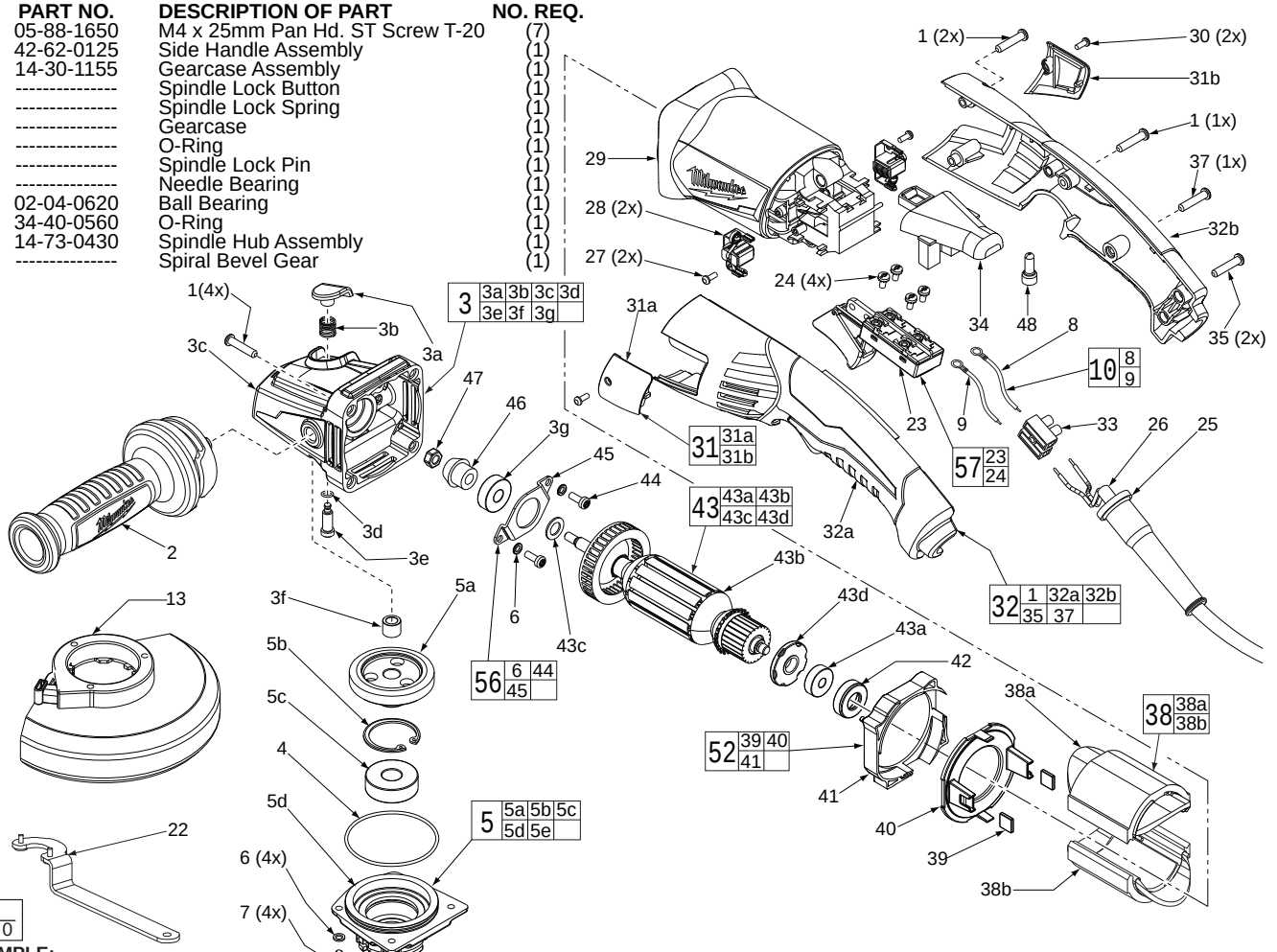
SERVICE PARTS LIST

BULLETIN NO. 54-38-2190

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS	REVISED BULLETIN	DATE
6" HP RAT-TAIL ANGLE GRINDER		Sept. 2012
CAT. NO. 6124-31 STARTING SERIAL NUMBER **D01A**	WIRING INSTRUCTION	**See Reverse Side**



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

***LUBRICATION NOTE:**
When servicing the Gears (5a & 46) or the Gearcase (3c), 90-95% of the old grease must be removed prior to new grease being added.

FIG.	LUBRICATION*
5a,46	Type "Y" Grease, No. 49-08-5270, Must Be Applied To All Gear Teeth.

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
1	05-88-1650	M4 x 25mm Pan Hd. ST Screw T-20	(7)
2	42-62-0125	Side Handle Assembly	(1)
3	14-30-1155	Gearcase Assembly	(1)
3a	----------	Spindle Lock Button	(1)
3b	----------	Spindle Lock Spring	(1)
3c	----------	Gearcase	(1)
3d	----------	O-Ring	(1)
3e	----------	Spindle Lock Pin	(1)
3f	----------	Needle Bearing	(1)
3g	02-04-0620	Ball Bearing	(1)
4	34-40-0560	O-Ring	(1)
5	14-73-0430	Spindle Hub Assembly	(1)
5a	----------	Spiral Bevel Gear	(1)
5b	----------	Retaining Ring	(1)
5c	----------	Ball Bearing	(1)
5d	----------	Spindle Hub	(1)
5e	----------	5/8" Spindle	(1)
6	05-90-0225	Spring Washer	(6)
7	05-88-1210	M4 x 14mm T-20	(4)
8	----------	Leadwire - Black	(1)
9	----------	Leadwire - White	(1)
10	23-94-0345	Leadwire Assy. Kit	(1)
13	14-32-0220	6" T 27 Guard Assy.	(1)
15	----------	O-Ring	(1)
16	----------	Wavey Spring	(1)
17	----------	Flange with Ramps	(1)
18	----------	Retaining Ring	(1)
19	43-34-0935	Inner Disc Flange	(1)
21	44-40-0035	Outer Flange Nut	(1)
22	49-96-7205	Spanner Wrench	(1)
23	23-66-2685	Trigger Switch	(1)
24	05-78-0305	M3.5 x 7mm Pan Hd. Phil. Switch Scr.	(4)
25	44-76-0095	Cord Protector	(1)
26	22-64-3425	Power Cord	(1)
27	05-88-0030	M3 x 8.5mm Pan Hd. ST Screw T-10	(2)
28	22-18-2250	Carbon Brush Assembly (Set of 2)	(1)
29	31-50-2140	Motor Housing	(1)

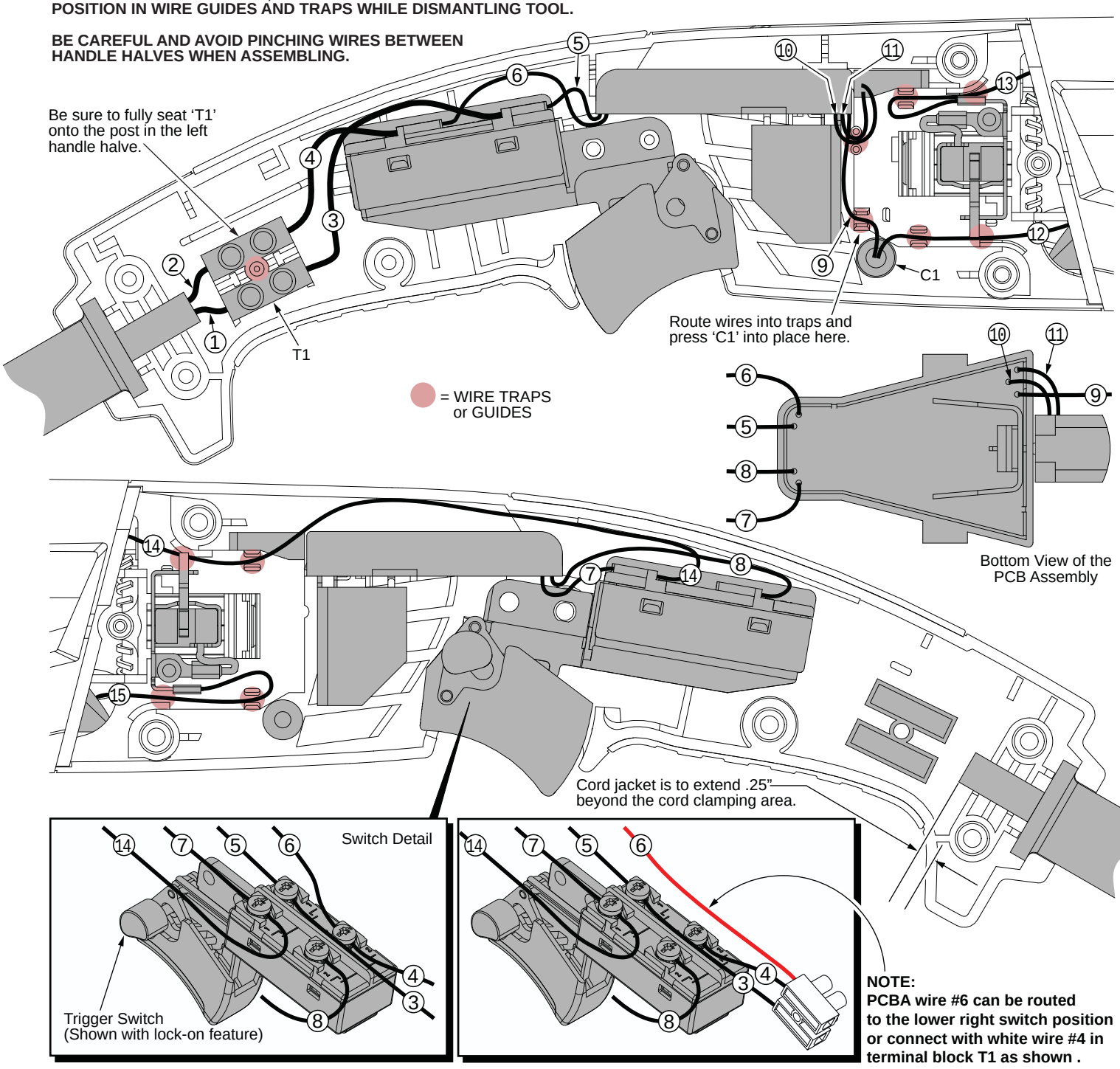
FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
30	06-82-2395	M2.6 x 10mm Pan Hd. ST Screw T-9	(2)
31	31-15-1010	Brush Cover Assembly (Set of 2)	(1)
31a	----------	Brush Cover - Left	(1)
31b	----------	Brush Cover - Right	(1)
32	31-44-0715	Rear Handle Set	(1)
32a	----------	Handle Halve - Left	(1)
32b	----------	Handle Halve - Right	(1)
33	22-56-0470	Terminal Connector Block	(1)
34	22-09-1850	PCB Assembly	(1)
35	05-88-1255	M4 x 22mm Pan Hd. ST T-20	(2)
37	06-82-1020	M4 x 14mm Pan Hd. ST T-20	(1)
38	18-07-0310	Field Assembly	(1)
38a	----------	Field Halve	(1)
38b	----------	Field Halve	(1)
39	42-28-0085	Rubber Block	(2)
40	----------	Baffle Foot	(1)
41	----------	Baffle	(1)
42	42-96-0016	Rubber Bearing Cap	(1)
43	16-10-0845	Armature Assembly	(1)
43a	02-04-2110	Ball Bearing	(1)
43b	----------	Armature	(1)
43c	45-88-0406	Washer	(1)
43d	----------	Magnetic Disc	(1)
44	05-88-1280	M4 x 10mm Pan Hd. Mach. Screw T-20	(2)
45	44-86-0155	Bearing Retainer	(1)
46	32-60-0305	Pinion	(1)
47	05-55-0620	M5 Hex Nut	(1)
48	22-56-0150	Close End Connector	(1)
50	14-46-6105	Flange with Ramps Assembly	(1)
52	42-14-0515	Baffle Assembly	(1)
56	44-86-0145	Bearing Retaining Plate Assembly	(1)
57	14-78-0525	Trigger Switch Assembly	(1)
	12-20-1560	Service Nameplate (Not Shown)	(1)
	10-20-2225	Bi-Lingual Warning Label (Not Shown)	(1)

MILWAUKEE ELECTRIC TOOL CORPORATION
13135 W. Lisbon Road, Brookfield, WI 53005

Drwg. 5

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.



NOTE:
PCBA wire #6 can be routed to the lower right switch position or connect with white wire #4 in terminal block T1 as shown .

WIRING SPECIFICATIONS

Wire No.	Wire Color	Origin or Part No.	Gauge	Length	Terminals, Connectors and End Wire Preparation
1	Black	22-64-3425	--	--	Component of Cord Set. Connect to T1 as shown.
2	White	22-64-3425	--	--	Component of Cord Set. Connect to T1 as shown.
3	Black	23-94-0345	--	--	Comp. of Leadwire Assembly Kit. Connect to Switch and T1 as shown.
4	White	23-94-0345	--	--	Comp. of Leadwire Assembly Kit. Connect to Switch and T1 as shown.
5	Black	22-09-1850	--	--	Comp. of PCB Assembly. Connect to Switch as shown.
6	White	22-09-1850	--	--	Comp. of PCB Assembly. Connect to Switch as shown.
7	Black	22-09-1850	--	--	Comp. of PCB Assembly. Connect to Switch as shown.
8	White	22-09-1850	--	--	Comp. of PCB Assembly. Connect to Switch as shown.
9	Red	22-09-1850	--	--	Comp. of PCB Assembly. Connect to Wire #12 with C1.
10	Black	22-09-1850	--	--	Component of PCB Assembly.
11	White	22-09-1850	--	--	Component of PCB Assembly.
12	Black	18-07-0310	--	--	Comp. of Field. Connect to Wire #9 with C1 as shown.
13	Black	18-07-0310	--	--	Comp. of Field. Connect to Right Brush Assy. as shown.
14	Black	18-07-0310	--	--	Component of Field. Connect to Switch as shown.
15	Black	18-07-0310	--	--	Comp. of Field. Connect to Left Brush Assy. as shown.

BULK LEAD WIRE - BULLETIN 58-01-0003

NOTE:
All leads must be held to ± 1/16".
All lead lengths are before strip-

TERMINAL DESCRIPTION		
Code	Part No.	Qnty.
T1	22-56-0470	1
CONNECTOR DESCRIPTION		
C1	22-56-0150	1