



SERVICE PARTS LIST

BULLETIN NO.
54-38-1425

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
7/9" SANDER			Aug. 2007
CATALOG NO.	6081-20	SERIAL NUMBER	989A
		WIRING INSTRUCTION 58-01-1370	

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

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
★ 45	44-60-1650	Lock Pin	(1)
46	44-66-2100	Bearing Retaining Plate	(1)
★ 47	34-40-4555	O-Ring	(1)
48	45-06-0710	Seal	(1)
49	45-88-7880	Shim Washer	(1)
50	45-88-8466	5/8-11 Spindle Washer	(1)
54	22-56-0480	Terminal Block	(1)
59	22-84-0540	Fan Assembly	(1)
60	44-76-0325	Cord Protector	(1)
61	22-18-0126	Carbon Brush Assembly	(2)
62	-----	Brush Spring	(2)
63	12-99-5001	Nameplate Blank	(1)

**SEE BACK PAGE FOR
IMPORTANT SERVICE NOTES**

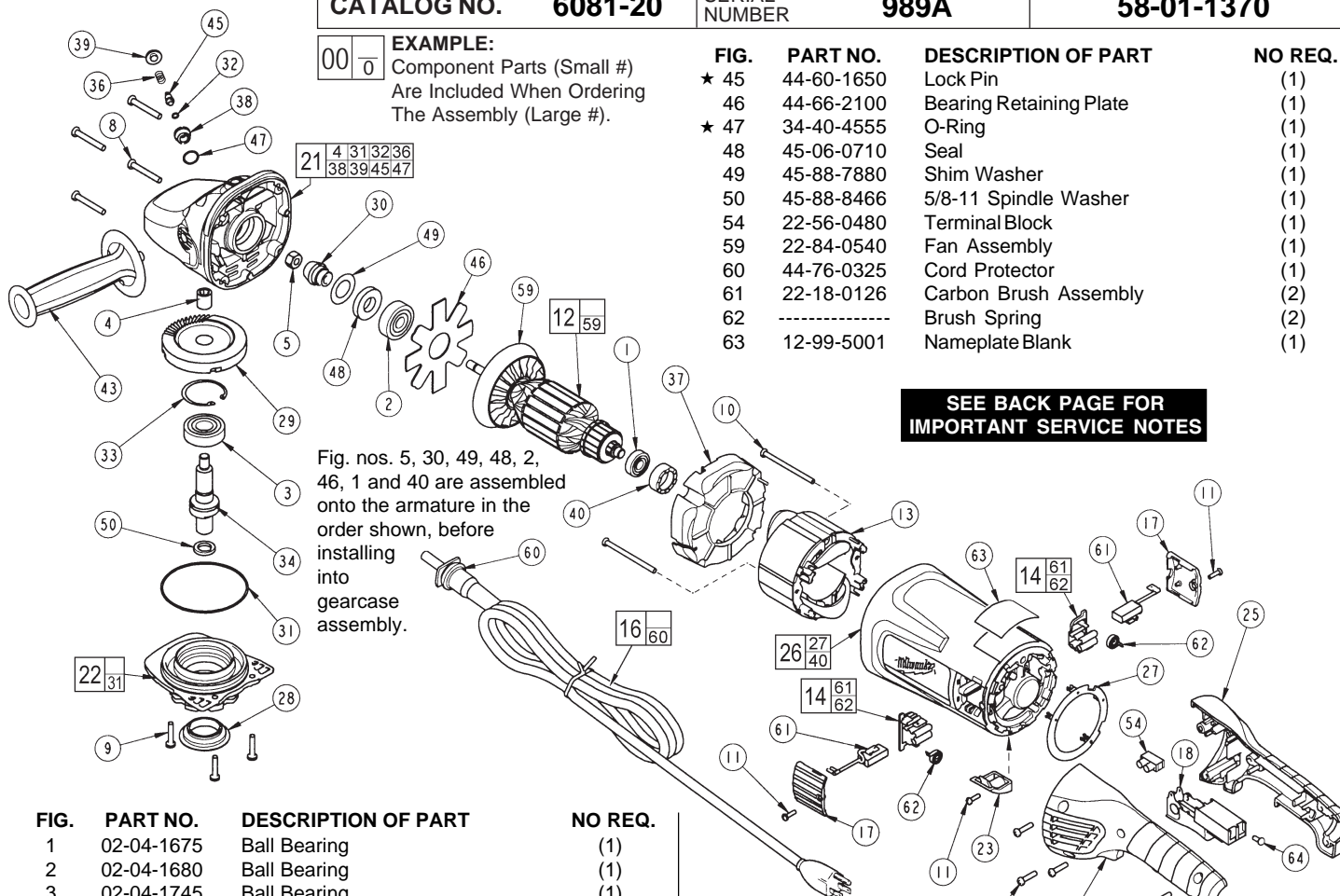


Fig. nos. 5, 30, 49, 48, 2, 46, 1 and 40 are assembled onto the armature in the order shown, before installing into gearcase assembly.

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
1	02-04-1675	Ball Bearing	(1)
2	02-04-1680	Ball Bearing	(1)
3	02-04-1745	Ball Bearing	(1)
4	02-50-2429	Needle Bearing	(1)
5	06-55-2455	Hex Nut	(1)
7	06-82-0055	8-16 Torx Plastite Screw T-20	(5)
8	06-82-0060	10-14 Torx Plastite Screw T-25	(4)
9	06-82-0065	10-32 x 1 Pan Hd. Taptite T-25 Screw	(3)
10	06-82-0070	8-16 Torx Plastite Screw T-15	(2)
11	06-82-7240	6-19 x 1/2 Slit. Pan Hd. Plast. T-15	(3)
12	16-70-0132	Armature Assembly	(1)
13	18-70-1130	Field	(1)
14	22-20-0120	Brush Holder Assembly	(2)
16	22-64-3615	Cord Set (Incl. Cord Protector and Terminals)	(1)
17	23-44-0255	Brush Cover	(2)
18	23-66-2725	Switch	(1)
21	28-14-1131	Gearcase Assembly	(1)
22	28-53-0151	Spindle Hub Assembly	(1)
23	31-15-0166	Cover	(1)
24	31-44-0842	Left Hand Handle Halve	(1)
25	31-44-0835	Right Hand Handle Halve	(1)
26	31-50-1751	Motor Housing Assembly	(1)
27	31-53-0160	Plug	(1)
28	31-55-0150	Bearing Shield	(1)
29	32-05-1505	Gear	(1)
30	32-60-1505	Pinion Gear	(1)
31	34-40-0505	O-Ring	(1)
★ 32	34-40-4300	O-Ring	(1)
33	34-80-2960	Retaining Ring	(1)
34	38-50-2500	Spindle Shaft	(1)
★ 36	40-50-1550	Compression Spring	(1)
37	42-14-0425	Baffle	(1)
★ 38	42-30-0150	Lock Body	(1)
★ 39	42-42-0290	Button	(1)
40	42-96-0145	Bearing Cup	(1)
43	43-62-1265	Side Handle	(1)

FIG.	PART NO.	DESCRIPTION OF PART	NO REQ.
64	05-78-0305	Switch Screw	(4)
	23-94-2650	Leadwire Assembly	(1)
	23-94-2655	Leadwire Assembly	(1)
	23-94-5650	Ground Wire Assembly	(1)

FIG. LUBRICATION:
21 1.25 oz. (35 grams) of Type "Y" grease, No. 49-08-5270 in main gear cavity of gearcase.

29,30 "Y" grease must be applied to all gear teeth.
31,32 Lightly coat o-rings with "Y" grease prior to installation.

FIG. NOTES:
4,21 Press needle bearing flush ±.02 to gearcase boss face.

5 Torque to 140 in.-lbs.

7,10 Torque to 20 in.-lbs.

8 Torque to 30 in.-lbs.

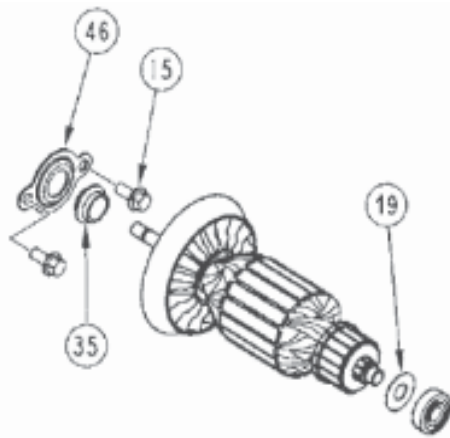
9 Torque to 35 in.-lbs.

64 Torque to 4 in.-lbs.

33 Bevel side of retaining ring away from bearing face.

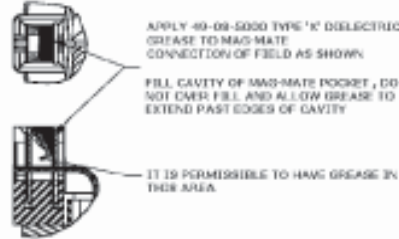
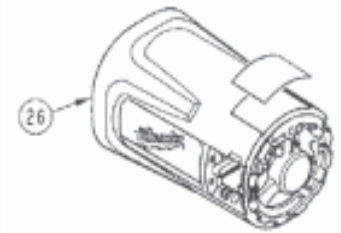
1,40 Seat bearing cup completely onto ball bearing.

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Drwg. 7



31-50-1752 Motor Housing Kit incorporates changes to the shielding of the armature pinion and commutator ball bearings along with the retaining of the pinion ball bearing into the gearcase assembly of 7" / 9" 15Amp Sander / Grinders – 6080-20, 6081-20, 6082-20, 6086-20, 6088-20 and 6089-20.

Additionally, a change has been made to the motor housing and wiring of the tool. The ATF field coil is now 'hard-wired' with four [4] new leadwire assemblies, see **Wiring Instruction 58-01-1371**. Add 'X' Grease, 49-08-5000 to mag-mate field terminals as need.



Caution! Do Not overfill the cavity, excess grease can cause a build up of dust / dirt and result in a possible 'shorting-out' or burning at the connection.

Motor Housing Kit consist of:	Discarded Parts:	Model Affected
2ea 06-75-0510 ¼-20 Hex Screw* <i>item 15</i>		All
1ea 45-06-0830 Bearing Seal <i>item 19</i>		All
1ea 31-50-1785 Motor Housing <i>item 26</i>	31-50-1751 Motor Housing	All
1ea 31-53-0160 Plug**	31-53-0160 Plug*	All
1ea 31-55-0290 Dust Shield <i>item 35</i>		All
1ea 44-86-0040 Bearing Retainer ^A <i>item 46</i>	44-66-2100 Bearing Ret Plate	All
1ea 23-94-9300 LeadWire Assembly	23-94-2650 LeadWire Assy	All
1ea 23-94-9305 LeadWire Assembly	23-94-2655 LeadWire Assy	All
1ea 23-94-9310 LeadWire Assembly		All
1ea 23-94-9315 LeadWire Assembly		All
	42-96-0145 Bearing Cup	All

* Torque 06-75-0510 to 65-75 in.-lbs.

** running change, part modified without part number change – two wire traps added – part must have a total of 4 wire traps

ITEMS NOT INCLUDED IN KIT: MUST BE ORDERED AS NEEDED

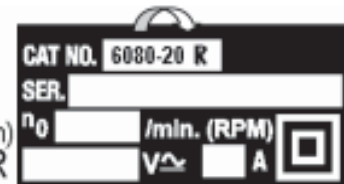
1ea 22-56-1050 Blade Hsg Assembly***	22-56-0900 Blade Hsg Assy	6086-20, 6089-20
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*** 6086-20 & 6089-20 will also require changing out of the Quik-Lok™ Cord Blade Housing Assembly.

1ea 28-14-1131 GearCase Assembly****	28-14-1131 GearCase Assy	All, prior to 2003
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**** required for early version Gear Case Assembly, manufactured prior to 2003, without screw bosses to accept the 06-75-0510 ¼-20 Hex Head Screws

Stamp or etch an 'R' in the tool's nameplate next to the catalog number after installation of the 'current production' service replacement parts listed above.



^A Service Note - 'check for slip fit' - mounting of 02-04-1680 Ball Bearing to the armature shaft may require removal of a 0.0001" – 0.0002" from the O.D. of the armature pinion end ball bearing journal - it is recommended to use emery cloth and armature lathe to lightly sand, for a few seconds, removing the material necessary for the pinion shaft to be a 'slip fit through the pinion ball bearing' as it is being held in place in the GearCase by the 44-86-0040 Bearing Retainer.