

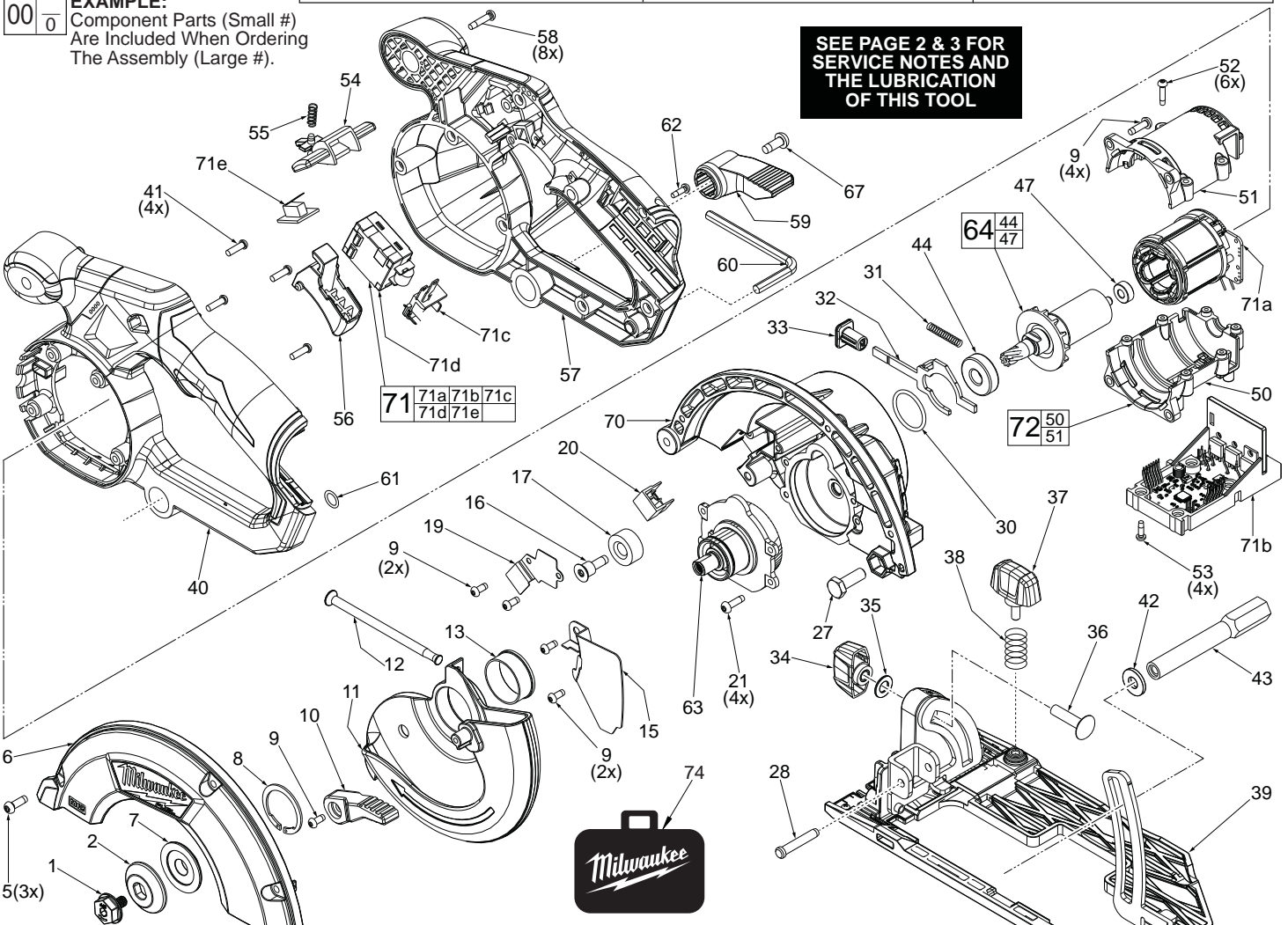


SERVICE PARTS LIST

**BULLETIN NO.
54-40-2530**

| | | | |
|--|----------------|---|-------------|
| SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS | | REVISED BULLETIN | DATE |
| M12™ FUEL™ 5-3/8" (140mm) Circular Saw | | | Nov. 2014 |
| CATALOG NO. | 2530-20 | STARTING SERIAL NO. | G32A |
| | | WIRING INSTRUCTION See Page Three | |

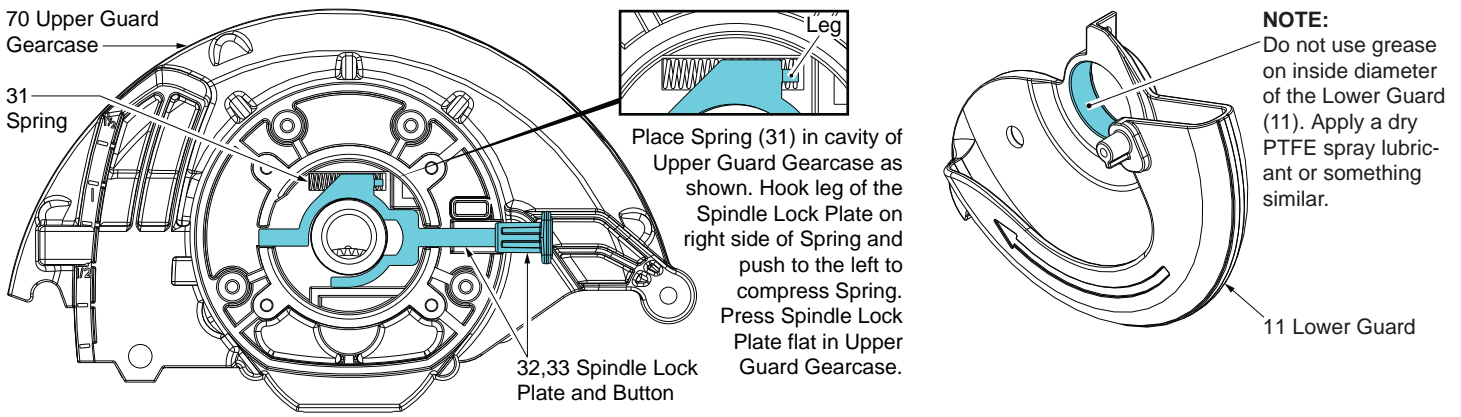
EXAMPLE:
Component Parts (Small #)
Are Included When Ordering
The Assembly (Large #).



| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|---|----------|
| 1 | 06-75-1275 | Blade Screw | 1 |
| 2 | 43-34-0885 | Outer Flange | 1 |
| 5 | 05-74-0985 | M4.0 x 12mm Pan Hd. Taptite T-20 Screw | 3 |
| 6 | 28-20-0950 | Upper Guard Cover Assembly | 1 |
| 7 | 43-34-0980 | Inner Flange | 1 |
| 8 | 34-60-0631 | Retaining Ring | 1 |
| 9 | 06-82-2653 | M3.5 x 8mm Pan Hd. Plastite T-15 Screw | 9 |
| 10 | 44-10-1075 | Lower Guard Lever | 1 |
| 11 | 28-41-2030 | Lower Guard | 1 |
| 12 | 40-50-1710 | Spring | 1 |
| 13 | 45-14-0370 | Lower Guard Sleeve | 1 |
| 15 | 44-66-2350 | Retaining Plate | 1 |
| 16 | 45-04-0485 | Bumper Screw | 1 |
| 17 | 42-38-0222 | Rubber Bumper | 1 |
| 19 | 31-15-2375 | LED Cover | 1 |
| 20 | 22-06-0550 | LED Assembly | 1 |
| 21 | 05-81-1170 | M3 x 12mm ST T-15 Screw | 4 |
| 27 | 06-75-2010 | 1/4-20 x 3/4" Left Hand Hex Hd. Screw | 1 |
| 28 | 44-60-2250 | Pivot Pin | 1 |
| 30 | 34-40-5262 | O-Ring | 1 |
| 31 | 40-50-1615 | Spring | 1 |
| 32 | 44-20-1300 | Spindle Lock Plate | 1 |
| 33 | 42-42-1270 | Spindle Lock Button | 1 |
| 34 | 43-98-0705 | Bevel Adjustment Knob | 1 |
| 35 | 45-88-1560 | Washer | 1 |
| 36 | 06-10-0150 | M6 x 25mm Carriage Bolt | 1 |
| 37 | 43-98-0605 | Rip Fence Knob | 1 |
| 38 | 40-50-0650 | Spring | 1 |
| 39 | 14-74-0560 | Shoe Assembly | 1 |
| 40 | 31-44-2965 | Housing Support Assembly Consists of: Left Housing Halve, Fuel Gauge and Fuel Gauge Label | 1 |
| 41 | 05-88-5380 | M3.5 x 12mm Pan Hd. Taptite T-15 Screw | 4 |
| 42 | 45-88-1515 | Washer | 1 |
| 43 | 45-08-0155 | Depth Shaft | 1 |

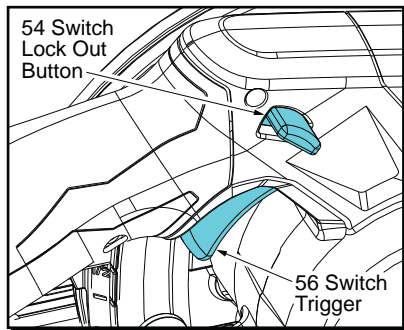
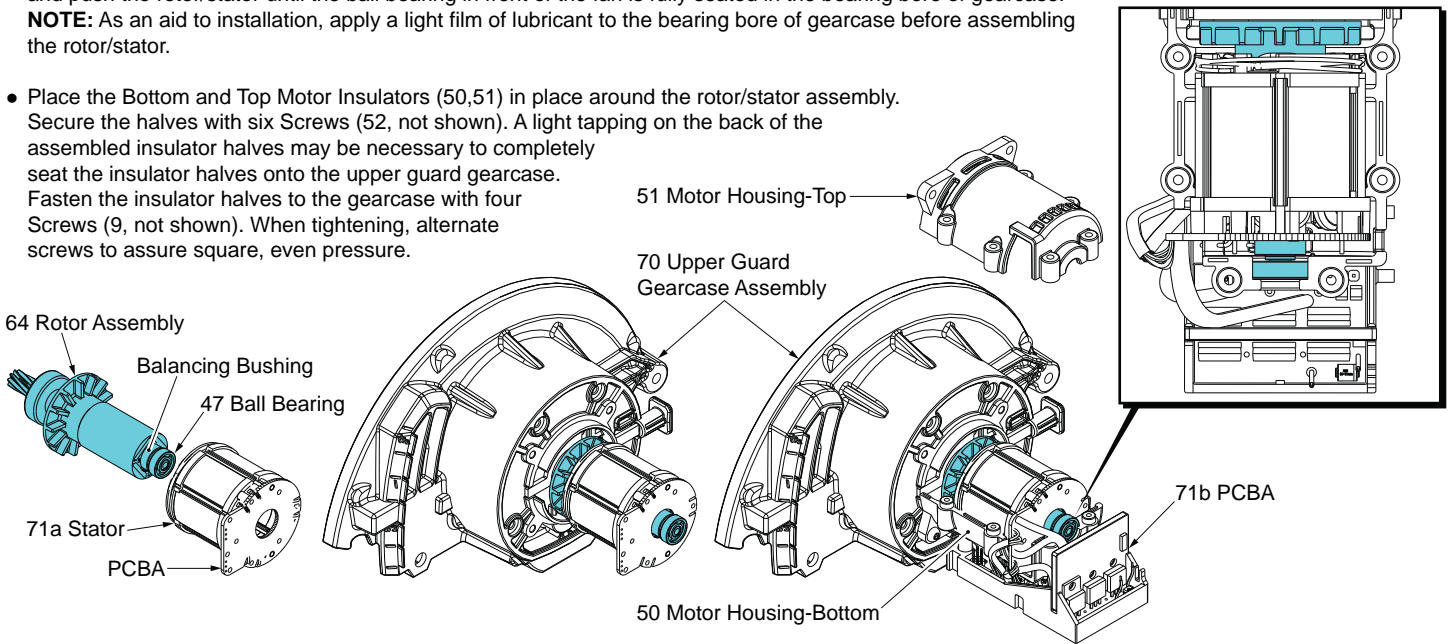
| FIG. | PART NO. | DESCRIPTION OF PART | NO. REQ. |
|------|------------|---|----------|
| 44 | 02-04-2575 | Ball Bearing | 1 |
| 47 | 02-04-1875 | Ball Bearing | 1 |
| 50 | ----- | Motor Housing - Bottom | 1 |
| 51 | ----- | Motor Housing - Top | 1 |
| 52 | 06-82-7336 | M3.0 x 20mm Pan Hd. Plastite T-10 Screw | 6 |
| 53 | 06-82-1087 | M3.0 x 12mm Pan Hd. Plastite T-10 Screw | 4 |
| 54 | 42-42-1230 | Switch Lock Out Button | 1 |
| 55 | 40-50-1760 | Spring | 1 |
| 56 | 31-92-1050 | Switch Trigger | 1 |
| 57 | 31-44-2960 | Housing Cover - Right Housing Halve | 1 |
| 58 | 06-82-2025 | M3.5 x 16mm Pan Hd. Plastite T-10 Screw | 8 |
| 59 | 44-10-0007 | Depth Lever | 1 |
| 60 | 49-96-0600 | 3/16" Hex Key | 1 |
| 61 | 34-40-4480 | O-Ring | 1 |
| 62 | 05-81-0195 | M3.0 x 12mm Pan Hd. Plastite T-10 Screw | 1 |
| 63 | 38-50-1950 | Spindle Hub Assembly | 1 |
| 64 | 23-40-0700 | Rotor Assembly with Pinion and Bearings | 1 |
| 67 | 06-82-5314 | 10-24 x 1/2" Pan Hd. Taptite T-25 Screw | 1 |
| 70 | 28-14-2530 | Upper Guard Gearcase Assy. w/Needle Bearing | 1 |
| 71 | 23-66-2535 | Stator / Electronics Assembly | 1 |
| 71a | ----- | Stator | 1 |
| 71b | ----- | PCBA | 1 |
| 71c | ----- | Battery Connector Block | 1 |
| 71d | ----- | Switch | 1 |
| 71e | ----- | Micro Switch | 1 |
| 72 | 23-16-1025 | Motor Housing Assembly | 1 |
| 73 | 12-20-2530 | Service Nameplate | 1 |
| 74 | 42-55-2520 | Contractors Bag | 1 |
| 75 | 49-22-2530 | Rip Fence (Not Shown) | 1 |
| 76 | 10-15-2570 | Warning Label (Not Shown) | 1 |

MILWAUKEE ELECTRIC TOOL CORPORATION
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Drwg. 1



IMPORTANT:

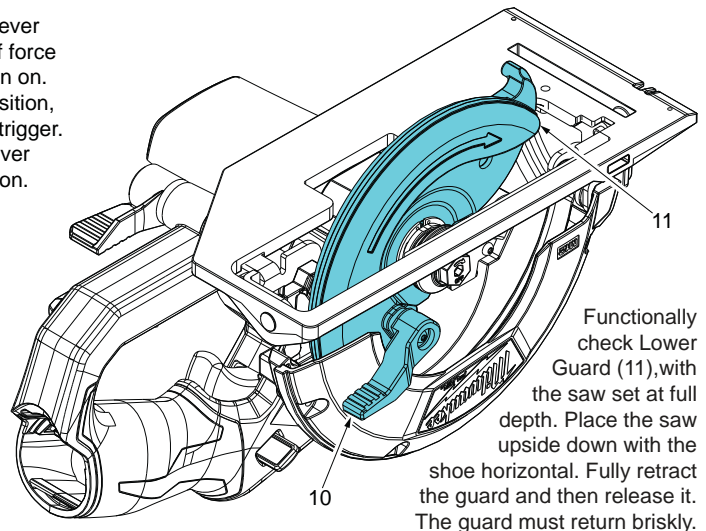
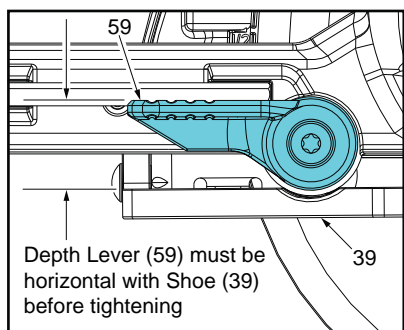
- **Strong magnetic force.** Care must be taken when installing the Rotor (64) into the Stator Assembly (71a). Do not allow rotor bearing or balancing bushing to hit PCBA on back end of stator, this could cause damage to PCBA.
- Insert the rotor/stator assembly into pinion bore of the Upper Guard Gearcase Assembly (70). Carefully wiggle and push the rotor/stator until the ball bearing in front of the fan is fully seated in the bearing bore of gearcase. **NOTE:** As an aid to installation, apply a light film of lubricant to the bearing bore of gearcase before assembling the rotor/stator.
- Place the Bottom and Top Motor Insulators (50,51) in place around the rotor/stator assembly. Secure the halves with six Screws (52, not shown). A light tapping on the back of the assembled insulator halves may be necessary to completely seat the insulator halves onto the upper guard gearcase. Fasten the insulator halves to the gearcase with four Screws (9, not shown). When tightening, alternate screws to assure square, even pressure.



Functionally check Switch Lock-Out (54) by attempting to turn on tool by applying a reasonable amount of force, up to 8 lbs., to switch trigger (56). The tool must not turn on.

Release trigger. Actuate lock-out lever and apply a reasonable amount of force to switch trigger. The tool must turn on. While trigger is still in the "ON" position, release the lock-out. Release the trigger. The tool must stop and lock-out lever must again prevent Switch actuation.

Repeat the switch check two more times.



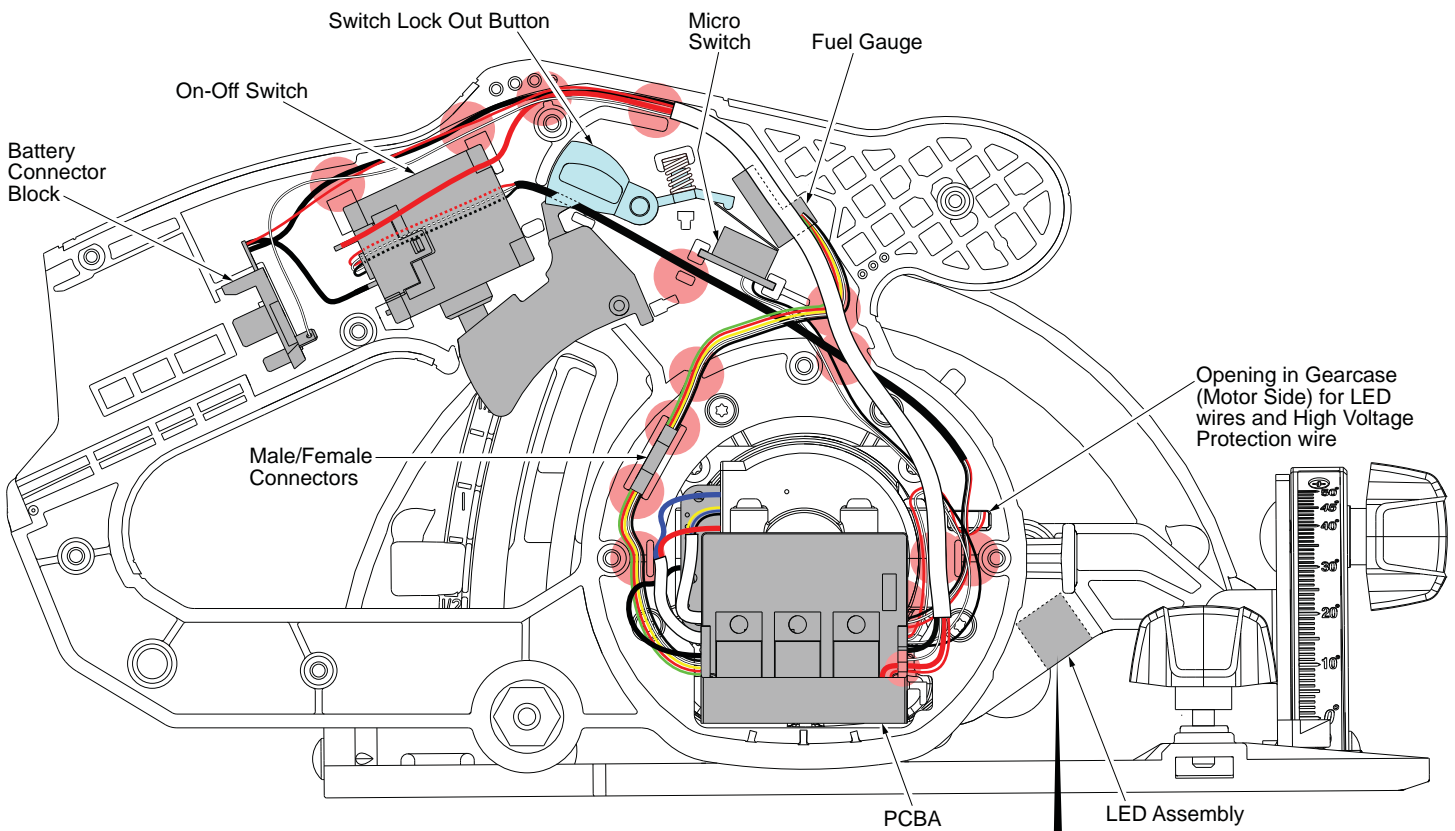


Figure 1: Route female terminal through opening in gearcase. Place red and white wires in trap on motor side and pull taut from blade side.

Figure 2: Connect the female terminal from PCBA to the male terminal of the LED Assembly (20).

Figure 3: Place LED into slotted cavity of gearcase. Place connected terminals and excess wire in cavity above the LED.

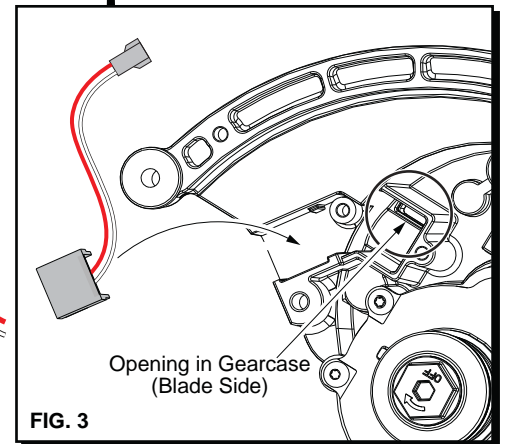
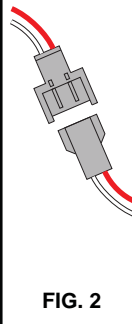
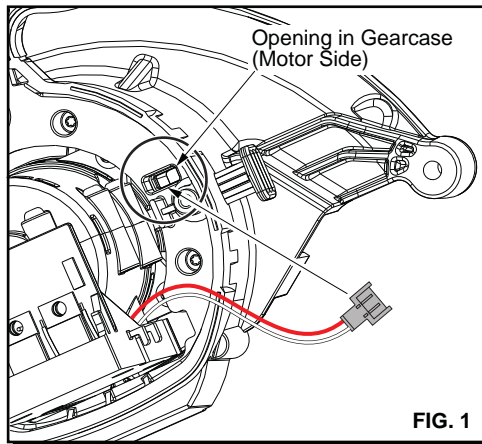
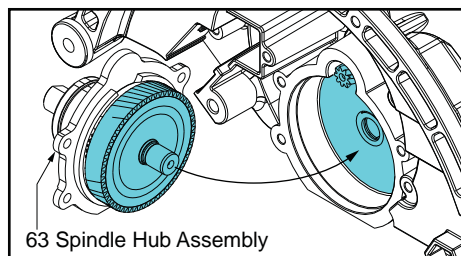
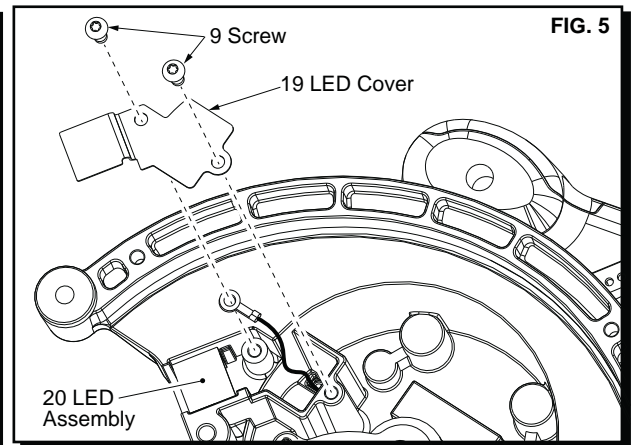
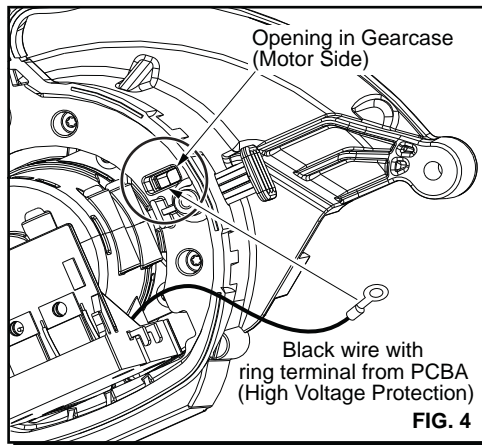


Figure 4: Route the black High Voltage Protection wire with ring terminal through opening in gearcase. Place black wire in trap on motor side and pull taut from blade side.

Figure 5: Place ring terminal over gearcase screw boss as shown. Cover the HV wire and LED Assembly with the LED Cover (19) and secure with Screws (9). Be sure that the one screw goes through the opening of the ring terminal.



LUBRICATION

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

Apply 3.0 grams (.10 oz) of 'Y' Grease to the gear bore in Upper Guard Gearcase (70). Place a liberal amount of grease on the teeth of the pinion of the Rotor Assembly (64). Place a liberal amount of grease on all of the teeth of the output gear in the Spindle Hub Assembly (63). Coat the face of output gear and the end of output shaft with grease. Total amount of grease used is approximately 6.0 grams (.20 oz).

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