



# SERVICE PARTS LIST

**BULLETIN NO.**  
**54-22-1046**

SPECIFY CATALOG NO. AND SERIAL NO. WHEN ORDERING PARTS		REVISED BULLETIN	DATE
<b>2" DIE GRINDER</b>		54-22-1045	Apr. 2010
<b>CATALOG NO.</b>	<b>5196</b>	WIRING INSTRUCTION <b>58-01-0314</b>	
	<b>STARTING SERIAL NO.</b>	<b>675E</b>	

**Collets**

The collet must be attached to the collet nut before it is put into the collet shaft. Be sure that the size of the collet matches the size of the bit shank being used. If the wrong size bit shank is used, the collet may break. For attaching or detaching the collet nut to the collet, follow the illustrated instructions.

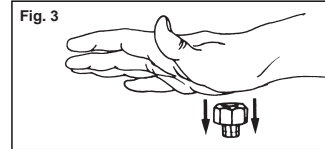
**Attaching Collet to Collet Nut**



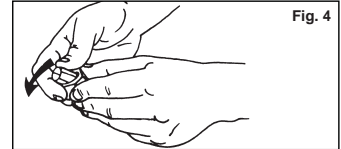
To assemble, place the narrow end of the collet on an even surface. Take the nut and place it over the collet (Fig. 1).



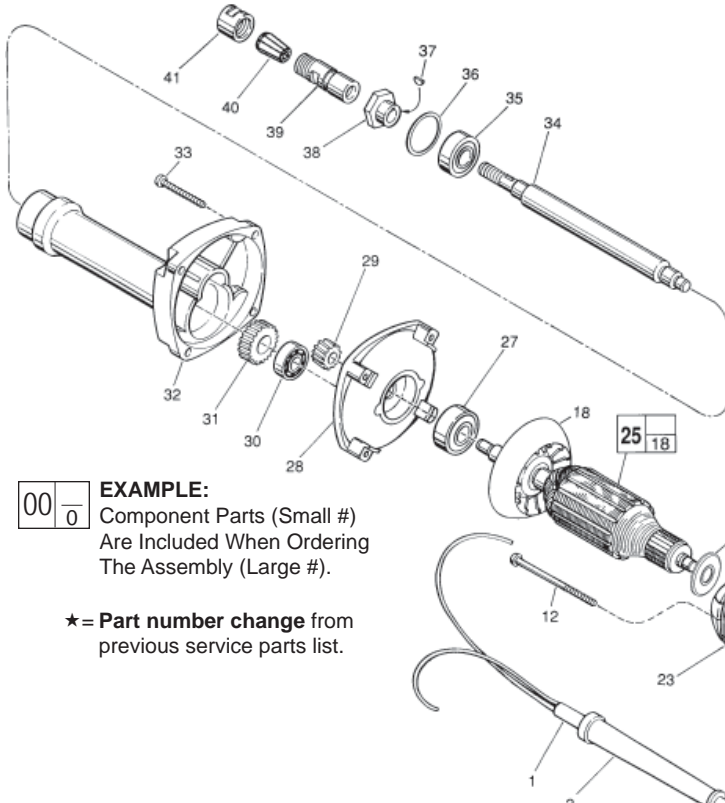
Position nut squarely over collet with the smaller opening of the nut facing up (Fig. 2).



Snap nut and collet together by firmly applying downward pressure into assembly with palm of hand (Fig. 3).



To remove collet from nut, hold nut firmly with one hand and press the collet to one side with the other hand (Fig. 4).



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

★ = Part number change from previous service parts list.

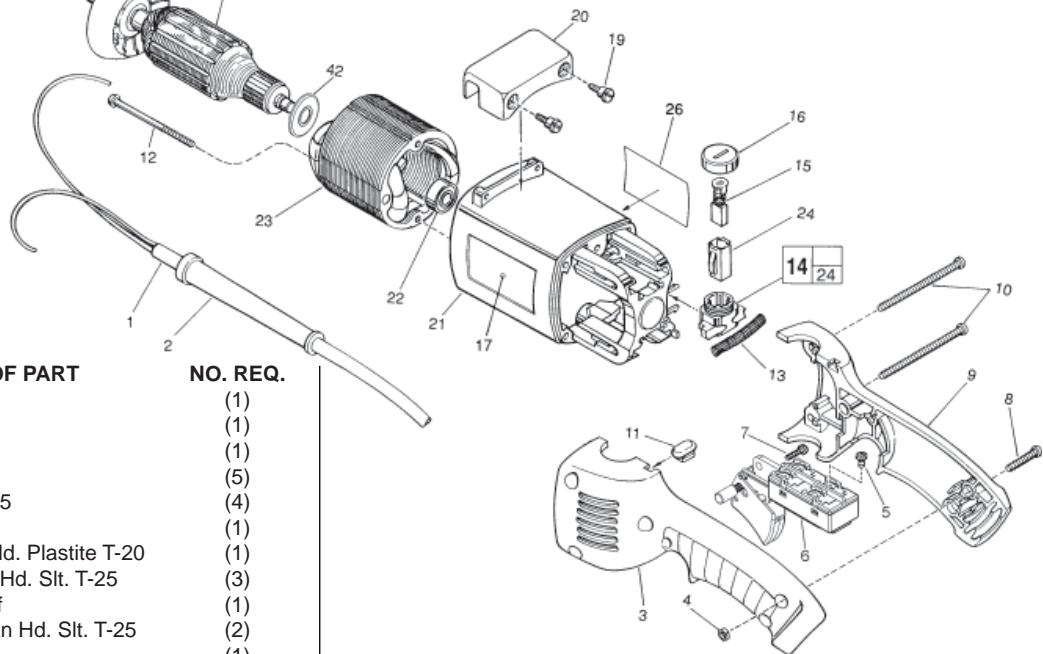


FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
	1	22-64-0785 Cord Set	(1)
	2	44-76-0050 Cord Protector	(1)
★	3	31-44-1717 Left Handle Half	(1)
	4	06-55-1050 10-24 Hex Nut	(5)
★	5	05-78-0305 Switch Screw T-15	(4)
★	6	23-66-1801 Switch	(1)
	7	06-82-7409 8-16 x 2-1/2" Pan Hd. Plastite T-20	(1)
	8	06-82-2568 10-24 x 7/8" Pan Hd. Slit. T-25	(3)
★	9	31-44-1718 Right Handle Half	(1)
	10	06-82-2598 10-24 x 2-3/4" Pan Hd. Slit. T-25	(2)
	11	42-38-0190 Bumper	(1)
	12	06-82-7375 8-16 x 2-1/2" Taptite T-20	(2)
	13	40-50-7770 Brush Holder Spring	(2)
	14	22-22-1325 Brush Holder Assembly	(2)
	15	22-18-0680 Carbon Brush Assembly	(2)
	16	23-44-0210 Brush Retaining Screw	(2)
	17	12-20-5200 Service Nameplate Kit	(1)
	18	22-84-0710 Fan	(1)
	19	45-04-0720 Shoulder Screw	(2)
	20	31-70-0125 Tool Rest	(1)
	21	31-50-0548 Motor Housing	(1)
	22	02-04-0845 Ball Bearing	(1)
	23	18-50-0090 Field	(1)
	24	22-20-0660 Brush Tube	(2)
	25	16-50-1130 Armature	(1)
★	26	10-98-1806 Warning Label	(1)
	27	02-04-1860 Ball Bearing	(1)
	28	28-28-1565 Diaphragm	(1)
	29	32-02-3020 Armature Gear	(1)
	30	02-04-0910 Ball Bearing	(1)
	31	32-75-3030 Spindle Gear	(1)
	32	28-50-6190 Spindle Housing	(1)
	33	06-82-7407 10-14 x 1-9/16" Pan Hd. T-20	(4)

FIG.	PART NO.	DESCRIPTION OF PART	NO. REQ.
	34	38-50-5320 Spindle Shaft	(1)
	35	02-04-1860 Ball Bearing	(1)
	36	34-80-2600 Internal Retaining Ring	(1)
	37	06-42-0400 Woodruff Key	(1)
	38	43-34-0390 Collet Flange	(1)
	39	48-68-0040 1/4" Collet Body	(1)
	40	48-66-0975 1/4" Collet	(1)
	41	48-68-0031 1/4" Collet Nut	(1)
	42	23-16-1700 Commutator Insulator	(1)
		49-96-4040 1/2" Open End Wrench	(1)
		49-96-4090 11/16" Open End Wrench	(1)
		49-96-4075 1" Open End Wrench	(1)

**FIG. 32 LUBRICATION**  
**Important!** Completely clean out old grease from the spindle housing and replace with 3/4 Oz. Type "Y" Grease, No. 49-08-5270.