



**Recommendations for Maintenance:**

Please, note it is important to make sure the tool has clean, dry and lubricated air at the recommended pressure supplied to it. (Please consult the service manual for further instructions)

The pulse tool requires preventive maintenance like oil changes and have the parts inspected periodically. It is recommended to make the first preventive maintenance at 250,000 pulses-seconds or 6 months, which either one occurs first. The tool's performance should be evaluated. The oil needs to be changed. Inspect all the soft parts of the pulse unit (the soft parts are referenced as the "Repair Kit" - see parts list page 2). The Repair Kit includes all the necessary parts and it is recommend to be performed every six months (unless parts are in good condition). If the tool fails before the 250,000 pulses-seconds then the pulse unit needs to be rebuilt, with the "Repair Kit" and "Service Kit" (see parts list page 2). Caution: prevailing torque, which makes that the tool start pulsing early, reduces the life of the Oil & O-rings of the pulse unit. A pulse-second is not every second the tool is running, only when it's "pulsing" and applying torque. On typical applications the tool should run down freely until fastener is snug and then the tool starts pulsing until it reaches the preset torque. When operating the tool on the fastener, start counting once the tool begins pulsing. You can use a watch with a second hand and time it until the tool shuts-off. Use the information to calculate how many pulse-seconds the tool performs per application each day. Then perform some basic math to calculate the tool's maintenance schedule. Use this formula.

$$\# \text{ Pulsing Seconds} \div \text{Total of Pulsing Time} = \text{No Cycles}$$

NOTE: Please include the rework, reverse, or retightening time is involve on the operation to calculate the accurate pulsing time. Here is an example:

Pulsing Time = 2 seconds  
Pulses- seconds recommended = 250,000

$$250,000 \text{ pulses-sec} \div 2 \text{ sec} = 125,000 \text{ cycles}$$

Using the information above, you can estimate the maintenance period for the tool by using this formula:

No of Fasteners	Pulsing Time per Fastener	No of Parts Assembled per Day	Calculation	Maintenance Period
7	2 seconds	300	125,000 / (300*7) = 59	59 days

Index No.	Part No.	Description	Qty	Index No.	Part No.	Description	Qty
1	63-I100-410	Greasing Screw	1	39	63-00-41144	O-Ring	2
2	63-00-4153	O-Ring	1	40	63-I40-101	Motor Housing	1
3	63-I40S-201	Pulse Unit Housing	1	41	63-I40S-108	Bushing	4
4	63-I40S-202	Bushing	1	42	63-I40S-102	Hanger	1
5	63-I40S-424	Washer	1	43	63-00-41146	O-Ring	1
6	63-I40S-401	Pulse Cylinder Seat	1	44	63-I40-104	Nut	1
7	63-00-41127	O-Ring	2	45	63-I40-504	Trigger	1
8	63-I70-410	Greasing Screw	1	46	63-00-3354	Spring Pin	1
9	63-00-41113	O-Ring	2	47	63-00-0505	Screw	2
10	63-00-3318	Spring Pin	2	48	63-I100-503	Regulator Knob	1
11EA	63-I40S-403-B	Front Cover	1	49	63-00-4101	O-Ring	1
12	63-00-2602	X-Ring	1	50EA	63-IS40-505B	Valve Stem	1
13	63-I40S-408	Front Plate	1	51EA	63-I100-508B	Bushing	1
14	63-I40S-405	Anvil	1	52EA	63-00-41199	O-Ring	1
15	63-I40S-407	Spring	2	53EA	63-I40-507B	Spring	1
16B	63-I40S-406-B	Drive Blade	2	54	63-00-3813	Steel Ball	1
17B	63-I40S-452	Roller	2	55	63-I100-506	Spring	1
18	63-I40S-411	Valve Screw	1	56	63-I40-502	F/R Valve	1
19C	63-IS40S-412-B	Valve	1	57	63-I40-501	Valve sleeve	1
20	63-00-41130	O-Ring	1	58	63-00-41111	O-Ring	2
21	63-00-3435	Pin	2	59	63-00-41145	O-Ring	1
22C	63-I40S-404-B	Pulse Cylinder	1	60	63-I40-601	Muffler	1
23	63-00-3436	Pin	1	61	63-I40-603	Exhaust Deflector	1
24	63-00-3407	Pin	2	62	63-I40-604B	Air Inlet 1/4"PT	1
25	63-I40S-415	Rear Plate	1	63	63-I100-511	Pin	1
26	63-I40S-423	Washer	1	64C	63-00-41173	O-Ring	1
27	63-I40S-402	Lock Nut	1	65C	63-IS40S-421	Pressure Valve	1
28	63-I40S-306	Lock Nut	1	66C	63-I40S-453	Spring	1
29	63-00-2348	Ball Bearing	1	67C	63-I40S-454	Block Cap	1
30	63-I40-302	Cylinder	1	68EA	63-I40-409	Back-Up Ring	1
31	63-00-3324	Spring Pin	1	※	63-I40RK-E05A	Repair kit :Index No-	
32	63-00-3356	Spring Pin	1			7(2); 9(2); 12; 15(2); 64C; 68EA; 20	
33	63-I40S-303	Rotor	1	※	63-I40SK-E05A	Service kit :Index No-	
34	63-I40S-304	Rotor Blade	9			13; 16B(2); 17B(2); 25;	
35	63-I40-305	Rear Plate	1			34(9); 51EA; 52EA; 53EA	
36	63-00-2356	Ball Bearing	1	※	63-I40S-400ASM	Pulse Unit	
37	63-00-41135	O-Ring	1	※	63-01-0501FL	Kit Accessories Included	
38	63-I40-307	Rear Cover	1	※	63-Pulse Tool Fluid, 125ml	Oil Fluid 125ml	