



**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, whichever 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 recommended 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	$125,000 / (300 \times 7) = 59$	59 days

Index No.	Part No.	Description	Qty	Index No.	Part No.	Description	Qty
1	63-757-026	Anvil Collar	1	41	63-00-2356	Ball Bearing	1
2	63-I40SD-419	Hold Spacer	1	42	63-00-41135	O-Ring	1
3	63-I40SD-418	Spring	1	43	63-I40-307	Rear Cover	1
4	63-I40SD-417	Quick change Hold	1	44	63-00-41144	O-Ring	2
5	63-I100-410	Greasing Screw	1	45	63-I40-101	Motor Housing	1
6	63-00-4153	O-Ring	1	46	63-I40S-108	Bushing	4
7	63-I40S-201	Pulse Unit Housing	1	47	63-I40S-102	Hanger	1
8	63-I40S-202	Bushing	1	48	63-00-41146	O-Ring	1
9	63-I40S-424	Washer	1	49	63-I40-104	Nut	1
10	63-I40S-401	Pulse Cylinder Seat	1	50	63-I40-504	Trigger	1
11	63-00-41127	O-Ring	2	51	63-00-3354	Spring Pin	1
12	63-I70-410	Greasing Screw	1	52	63-00-0505	Screw	2
13	63-00-41113	O-Ring	2	53	63-I100-503	Regulator Knob	1
14	63-00-3318	Spring Pin	2	54	63-00-4101	O-Ring	1
15EA	63-I40S-403-B	Front Cover	1	55EA	63-IS40-505B	Valve Stem	1
16	63-00-2602	X-Ring	1	56EA	63-I100-508B	Bushing	1
17	63-I40S-408	Front Plate	1	57EA	63-00-41199	O-Ring	1
18	63-00-3813	Steel Ball	3	58EA	63-I40-507B	Spring	1
19	63-I40SD-405	Anvil	1	59	63-I100-506	Spring	1
20B	63-I40S-452	Roller	2	60	63-I40-502	F/R Valve	1
21B	63-I40S-406-B	Drive Blade	2	61	63-I40-501	Valve Sleeve	1
22	63-I40S-407	Spring	2	62	63-00-41111	O-Ring	2
23	63-I40S-411	Valve Screw	1	63	63-I100-511	Pin	1
24C	63-IS40S-412-B	Valve	1	64	63-00-41145	O-Ring	1
25	63-00-41130	O-Ring	1	65	63-I40-601	Muffler	1
26	63-00-3435	Pin	2	66	63-I40-603	Exhaust Deflector	1
27C	63-I40S-404-B	Pulse Cylinder	1		63-I40-604A	Air Inlet 1/4"-19PF	
28	63-00-3407	Pin	2	67	63-I40-604B	Air Inlet 1/4"-19PT	1
29	63-00-3436	Pin	1		63-I40-604C	Air Inlet 1/4"-18NPT	
30	63-I40S-415	Rear Plate	1	68C	63-00-41173	O-Ring	1
31	63-I40S-423	Washer	1	69C	63-IS40S-421	Pressure Valve	1
32	63-I40S-402	Lock Nut	1	70C	63-I40S-453	Spring	1
33	63-I40S-306	Lock Nut	1	71C	63-I40S-454	Block Cap	1
34	63-00-2348	Ball Bearing	1	72EA	63-I40-409	Back-Up Ring	1
35	63-I50-302	Cylinder	1	※	63-I50DRK-E05A	Repair kit :Index No-	
36	63-00-3324	Spring Pin	1			11(2); 13(2) ; 16; 22(2); 25; 68C;72EA	
37	63-00-3356	Spring Pin	1	※	63-I50DSK-E05A	Service kit :Index No-	
38	63-I40S-303	Rotor	1			17; 20B(2); 21B(2); 30;	
39	63-I40S-304	Rotor Blade	9			39(9); 56EA; 57EA; 58EA	
40	63-I40-305	Rear Plate	1	※	63-I40SD-400ASM	Pulse Unit	
					63-01-0505FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	