



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-I100-410	Greasing Screw	1	38	63-00-3813	Steel Ball	1
2	63-00-4153	O-Ring	1	39	63-305F-034	Spring	1
3	63-I40S-201	Pulse Unit Housing	1	40	63-I40S-502	F/R Valve	1
4	63-I40S-202	Bushing	1	41	63-00-41146	O-Ring	1
5	63-I40S-424	Washer	1	42	63-00-41125	O-Ring	1
6	63-I40S-401	Pulse Cylinder Seat	1	43	63-I40S-309	Seat	1
7	63-00-41127	O-Ring	3	44	63-I40S-101	Motor Housing	1
8	63-I70-410	Greasing Screw	1	45	63-00-0507	Screw	1
9	63-00-41113	O-Ring	2	46	63-I40S-503	Regulator Knob	1
10	63-00-3318	Spring Pin	2	47	63-I40S-102	Hanger	1
11EA	63-I40S-403-B	Front Cover	1	48	63-I40S-509	Bushing	1
12	63-00-2602	X-Ring	1	49	63-I40S-510	Pin	1
13	63-I40S-411	Valve Screw	1	50	63-I40S-504	Trigger	1
14C	63-IS40S-412-B	Valve	1	51	63-00-3306	Spring Pin	1
15	63-00-41130	O-Ring	1	52	63-I40S-108	Bushing	2
16	63-00-3435	Pin	2	53	63-I40S-103	Housing Rubber	1
17	63-I40S-408	Front Plate	1	54	63-I40S-508	Bushing	1
18	63-I40S-405	Anvil	1	55	63-305C-021	Valve Stem	1
19B	63-I40S-452	Roller	2	56	63-I40S-507	Spring	1
20B	63-I40S-406-B	Drive Blade	2	57	63-I40S-601	Muffler	1
21	63-I40S-407	Spring	2	58	63-I40S-603	Exhaust Deflector	1
22C	63-I40S-404-B	Pulse Cylinder	1		63-I40S-604A	Air Inlet 1/4"PF-19	
23	63-00-3436	Pin	1	59	63-I40S-604B	Air Inlet 1/4"PT-19	1
24	63-00-3407	Pin	2		63-I40S-604C	Air Inlet 1/4"NPT-18	
25	63-I40S-415	Rear Plate	1	60	63-00-3509	Snap Ring	1
26	63-I40S-423	Washer	1	61C	63-00-41173	O-Ring	1
27	63-I40S-402	Lock Nut	1	62C	63-IS40S-421	Pressure Valve	1
28	63-I40S-306	Lock Nut	1	63C	63-I40S-453	Spring	1
29	63-00-2348	Ball Bearing	1	64C	63-I40S-454	Block Cap	1
30	63-00-3324	Spring Pin	1	65EA	63-I40-409	Back Up Ring	1
31	63-I40S-302	Cylinder	1	※	63-I50SRK-E05A	Repair kit :Index No-	
32	63-I40S-303	Rotor	1			7(2); 9(2); 12; 15; 21(2); 61C; 65EA	
33	63-I40S-304	Rotor Blade	9	※	63-I50SSK-E05A	Service kit :Index No-	
34	63-00-3326	Spring Pin	1			17; 19B(2); 20B(2) 25; 33(9);	
35	63-I50S-305	Rear Plate	1			54; 55; 56	
36	63-00-2356	Ball Bearing	1	※	63-I40S-400ASM	Pulse Unit	
37	63-I40S-310	Air Inlet Plate	1		63-01-0501FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	