



**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.

**# Pulsing Seconds ÷ Total of Pulsing Time = No Cycles**

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

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

**250,000 pulses-sec ÷ 2 sec = 125,000 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-I50R-706	Lock Nut	1	46	63-00-2348	Ball Bearing	1
2	63-00-41134	O-Ring	1	47	63-00-3324	Spring Pin	1
3	63-00-2358	Ball Bearing	1	48	63-I70S-302	Cylinder	1
4	63-I50R-711	Washer	1	49	63-I70S-303	Rotor	1
5	63-I50R-705	Shaft Gear	1	50	63-I70S-304	Rotor Blade	9
6	63-I50R-707	Shaft	1	51	63-00-3326	Spring Pin	1
7	63-00-2357	Ball Bearing	1	52	63-I50S-305	Rear End Plate	1
8	63-I90-410	Greasing Screw	1	53	63-00-2356	Ball Bearing	1
9	63-00-4153	O-Ring	1	54	63-I40S-310	Air inlet Plate	1
10	63-I50R-701	Angle Housing	1	55	63-00-3813	Steel Ball	1
11	63-00-0605	Set Screw	1	56	63-305F-034	Spring	1
12	63-I50R-704	Main Shaft Gear	1	57	63-I40S-502	F/R Valve	1
13	63-I50R-712	Washer	1	58	63-00-41146	O-Ring	1
14	63-00-2352	Ball Bearing	2	59	63-00-41125	O-Ring	1
15	63-I50R-709	Lock Nut	1	60	63-I40S-309	Seat	1
16	63-I50R-702	Lock Nut	1	61	63-I70S-101	Motor Housing	1
17	63-I50R-708	Anvil Collar	1	62	63-00-0507	Screw	1
18	63-00-3430	Pin	1	63	63-I40S-503	Regulator Knob	1
19	63-I70R-201	Pulse Unit Housing	1	64	63-I40S-102	Hanger	1
20	63-I40S-202	Bushing	1	65	63-I40S-509	Bushing	1
21	63-I40S-424	Washer	1	66	63-I40S-510	Pin	1
22	63-I70-401	Pulse Cylinder Seat	1	67	63-I40S-504	Trigger	1
23D	63-00-41160	O-Ring	2	68	63-I40S-108	Bushing	2
24	63-00-41113	O-Ring	2	69	63-00-3306	Spring Pin	1
25	63-I70-410	Greasing Screw	1	70	63-I40S-103	Housing Rubber	1
26	63-00-3318	Spring Pin	2	71	63-I40S-508	Bushing	1
27	63-I70-403	Front Cover	1	72	63-305C-021	Valve Stem	1
28	63-I70-409	Back Up Ring	1	73	63-I40S-507	Spring	1
29	63-00-2602	X-Ring	1	74	63-I40S-601	Muffler	1
30	63-00-3435	Pin	2	75	63-I40S-603	Exhaust Deflector	1
31	63-I70-408	Front Plate	1		63-I40S-604A	Air Inlet 1/4"PF-19	
32	63-I70R-405	Anvil	1	76	63-I40S-604B	Air Inlet 1/4"PT-19	1
33B	63-I70-406-B	Drive Blade	2		63-I40S-604C	Air Inlet 1/4"NPT-18	
34B	63-I70-452	Roller	2	77	63-00-3509	Snap Ring	1
35	63-I70-407	Spring	2	78C	63-00-41173	O-Ring	1
36	63-I40S-411	Valve Screw	1	79C	63-IS40S-421	Pressure Valve	1
37D	63-IS70-412-B	Valve	1	80C	63-I70S-453	Spring	1
38	63-00-41130	O-Ring	1	81C	63-I40S-454	Block Cap	1
39C	63-I70-404-B	Pulse Cylinder	1	82D	63-00-41127	O-Ring	1
40	63-00-3436	Pin	1	※	63-I70RRK-E05A	Repair kit :Index No- 23D(2); 24(2); 28; 29; 35(2); 38; 78C	
41	63-00-3407	Pin	2				
42	63-I70-415	Rear Plate	1	※	63-I70RSK-E05A	Service kit :Index No- 5; 12; 31; 33B(2);34B(2);42; 50(9);71; 72; 73	
43	63-I40S-423	Washer	1				
44	63-I70-402	Lock Nut	1				
45	63-I70S-306	Lock Nut	1	※	63-IS70R-400ASM	Pulse Unit	
					63-01-0501FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	