



**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-I50R-706	Lock Nut	1	50	63-I40S-306	Lock Nut	1
2	63-00-41134	O-Ring	1	51	63-00-2348	Ball Bearing	1
3	63-00-2358	Ball Bearing	1	52	63-00-3324	Spring Pin	1
4	63-I50R-711	Washer	1	53	63-I40S-302	Cylinder	1
5	63-I50R-705	Shaft Gear	1	54	63-00-3326	Spring Pin	1
6	63-I50R-707	Shaft	1	55	63-I40S-303	Rotor	1
7	63-00-2357	Ball Bearing	1	56	63-I40S-304	Rotor Blade	9
8	63-I90-410	Greasing Screw	1	57C	63-I50R-305	Rear Plate	1
9	63-00-4153	O-Ring	1	58	63-00-2356	Ball Bearing	1
10	63-I50R-701	Angle Housing	1	59	63-I40S-310	Air inlet Plate	1
11	63-00-0605	Set Screw	1	60	63-305F-034	Spring	1
12	63-I50R-704	Main Shaft Gear	1	61	63-IS40S-502	F/R Valve	1
13	63-I50R-712	Washer	1	62	63-00-41146	O-Ring	1
14	63-00-2352	Ball Bearing	2	63	63-00-4121	O-Ring	1
15	63-I50R-709	Lock Nut	1	64	63-IS40S-312	Valve Washer	1
16	63-I50R-702	Lock Nut	1	65	63-00-3824	Steel Ball	1
17	63-I50R-708	Anvil Collar	1	66	63-IS40S-313	Spring	1
18	63-00-3430	Pin	1	67	63-IS40S-311	Valve	1
19	63-I50R-201	Pulse Unit Housing	1	68	63-00-41125	O-Ring	1
20	63-I40S-202	Bushing	1	69	63-I40S-309	Seat	1
21	63-I40S-424	Washer	1	70	63-I40S-101	Motor Housing	1
22	63-I40S-401	Pulse Cylinder Seat	1	71	63-00-0507	Screw	1
23	63-00-41127	O-Ring	3	72	63-I40S-503	Regulator Knob	1
24	63-I70-410	Greasing Screw	1	73	63-I40S-102	Hanger	1
25	63-00-41113	O-Ring	3	74	63-I40S-509	Bushing	1
26	63-00-3318	Spring Pin	2	75	63-IS40S-510	Pin	1
27EA	63-I40S-403-B	Front Cover	1	76	63-I40S-504	Trigger	1
28	63-I40S-408	Front Plate	1	77	63-I40S-108	Bushing	2
29	63-00-2602	X-Ring	1	78	63-00-3306	Spring Pin	1
30	63-I50R-405	Anvil	1	79	63-I40S-103	Rubber	1
31B	63-I40S-452	Roller	2	80	63-I40S-508	Bushing	1
32B	63-I40S-406-B	Drive Blade	2	81	63-305C-021	Valve Stem	1
33	63-I40S-407	Spring	2	82	63-I40S-507	Spring	1
34B	63-IS40-450	Block Valve	1	83	63-I40S-601	Muffler	1
35	63-I40S-411	Screw	1	84	63-I40S-603	Exhaust Deflector	1
36EA	63-IS40S-412-C	Valve	1		63-I40S-604A	Air Inlet 1/4"PF-19	
37C	63-00-41173	O-Ring	2	85	63-I40S-604B	Air Inlet 1/4"PT-19	1
38	63-00-3813	Steel Ball	2		63-I40S-604C	Air Inlet 1/4"NPT-18	
39EA	63-IS50R-425-C	Spring	1	86	63-00-3509	Snap Ring	1
40	63-00-3435	Pin	2	87C	63-I40S-453	Spring	1
41	63-00-3436	Pin	1	88C	63-I40S-454	Block cap	1
42C	63-I40S-404-B	Pulse Cylinder	1	89	63-00-41130	O-Ring	1
43	63-00-3407	Pin	2	90EA	63-I40-409	Back Up Ring	1
44EA	63-IS40S-415-C	Rear Plate	1	※	63-IS50RRK-E05A	Repair kit :Index No- 23(2);25(2);29,33(2);37C(2);89; 90FA	
45	63-I40S-423	Washer	1				
46C	63-IS40S-421	Pressure Valve	2	※	63-IS50RSK-E05A	Service kit :Index No- 5;12;28;31B(2);32B(2);44EA	
47	63-IS40S-314	Shut Off Stem	1				
48	63-IS40S-317	Spring	1				
49	63-I40S-402	Lock Nut	1	※	63-IS50R-400ASM	Pulse Unit	
					63-01-0501FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	