



**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	42	63-I50S-305	Rear Plate	1
2	63-00-4153	O-Ring	1	43	63-00-2356	Ball Bearing	1
3	63-I40S-201	Pulse Unit Housing	1	44	63-I40S-310	Air Inlet Plate	1
4	63-I40S-202	Bushing	1	45	63-305F-034	Spring	1
5	63-I40S-424	Washer	1	46	63-IS40S-502	F/R Valve	1
6	63-I40S-401	Pulse Cylinder Seat	1	47	63-00-41146	O-Ring	1
7	63-00-41127	O-Ring	3	48	63-00-4121	O-Ring	1
8	63-00-41113	O-Ring	3	49	63-IS40S-312	Valve Washer	1
9	63-I70-410	Greasing Screw	1	50	63-00-3824	Steel Ball	1
10	63-00-3318	Spring Pin	2	51	63-IS40S-313	Spring	1
11EA	63-I40S-403-B	Front Cover	1	52	63-IS40S-311	Valve	1
12	63-00-2602	X-Ring	1	53	63-00-41125	O-Ring	1
13	63-I40S-408	Front Plate	1	54	63-I40S-309	Seat	1
14D	63-IS40S-405	Anvil	1	55	63-00-0507	Screw	1
15B	63-I40S-452	Roller	2	56	63-I40S-503	Regulator Knob	1
16B	63-I40S-406-B	Drive Blade	2	57	63-I40S-101	Motor Housing	1
17	63-I40S-407	Spring	2	58	63-I40S-102	Hanger	1
18B	63-IS40-450	Block Valve	1	59	63-I40S-108	Bushing	2
19	63-I40S-411	Valve Screw	1	60	63-00-3306	Spring Pin	1
20EA	63-IS40S-412-C	Valve	1	61	63-I40S-509	Bushing	1
21	63-00-41130	O-Ring	1	62	63-IS40S-510	Pin	1
22	63-00-3813	Steel Ball	2	63	63-I40S-504	Trigger	1
23EA	63-IS50S-425-C	Spring	1	64	63-I40S-103	Housing Rubber	1
24	63-00-3436	Pin	1	65	63-I40S-508	Bushing	1
25C	63-I40S-404-B	Pulse Cylinder	1	66	63-305C-021	Valve Stem	1
26	63-00-3435	Pin	2	67	63-I40S-507	Spring	1
27	63-00-3407	Pin	2	68	63-I40S-601	Muffler	1
28EA	63-IS40S-415-C	Rear Plate	1	69	63-I40S-603	Exhaust Deflector	1
29	63-I40S-423	Washer	1		63-I40S-604A	Air Inlet 1/4"PF	
30C	63-00-41173	O-Ring	2	70	63-I40S-604B	Air Inlet 1/4"PT	1
31C	63-IS40S-421	Pressure Valve	2		63-I40S-604C	Air Inlet 1/4"NPT	
32	63-IS40S-314	Pin	1	71	63-00-3509	Snap Ring	1
33	63-IS40S-317	Spring	1	72C	63-I40S-453	Spring	1
34	63-I40S-402	Lock Nut	1	73C	63-I40S-454	Block Cap	1
35	63-I40S-306	Lock Nut	1	74EA	63-I40-409	Back Up Ring	1
36	63-00-2348	Ball Bearing	1	※	63-IS50SRK-E05A	Repair kit :Index No-	
37	63-I40S-302	Cylinder	1			7(2);8(2);12;17(2); 21; 30C(2);74EA	
38	63-00-3324	Spring Pin	1	※	63-IS50SSK-E05A	Service kit :Index No-	
39	63-00-3326	Spring Pin	1			13; 15B(2);16B(2); 28EA;	
40	63-I40S-303	Rotor	1			41(9);51; 65; 66; 67	
41	63-I40S-304	Rotor Blade	9	※	63-I50S-400ASM	Pulse Unit	
					63-01-0501FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	