



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 involved on the operation to calculate the accurate pulsing time. Here is an example:

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

$$250,000 \text{ pulses-sec} \div 2 \text{ sec} = 125,000 \text{ cycles}$$

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	$125,000 / (300 * 7) = 59$	59 days

Index No.	Part No.	Description	Qty	Index No.	Part No.	Description	Qty
1	63-I50R-706	Lock Nut	1	51	63-I70S-306	Lock Nut	1
2	63-00-41134	O-Ring	1	52	63-00-2348	Ball Bearing	1
3	63-00-2358	Ball Bearing	1	53	63-00-3324	Spring Pin	1
4	63-I50R-711	Washer	1	54	63-I70S-302	Cylinder	1
5	63-I50R-705	Shaft Gear	1	55	63-00-3326	Spring Pin	1
6	63-I50R-707	Shaft	1	56	63-I70S-303	Rotor	1
7	63-00-2357	Ball Bearing	1	57	63-I70S-304	Rotor Blade	9
8	63-I90-410	Greasing Screw	1	58	63-I50S-305	Rear Plate	1
9	63-00-4153	O-Ring	1	59	63-00-2356	Ball Bearing	1
10	63-I50R-701	Angle Housing	1	60	63-I40S-310	Air inlet Plate	1
11	63-00-0605	Set Screw	1	61	63-305F-034	Spring	1
12	63-I50R-704	Main Shaft Gear	1	62	63-IS40S-502	F/R Valve	1
13	63-I50R-712	Washer	1	63	063-0-41146	O-Ring	1
14	63-00-2352	Ball Bearing	2	64	63-00-4121	O-Ring	1
15	63-I50R-709	Lock Nut	1	65	63-IS40S-312	Valve Washer	1
16	63-I50R-702	Lock Nut	1	66	63-00-3824	Steel Ball	1
17	63-I50R-708	Anvil Collar	1	67	63-IS40S-313	Spring	1
18	63-00-3430	Pin	1	68	63-IS40S-311	Valve	1
19	63-I70R-201	Pulse Unit Housing	1	69	63-00-41125	O-Ring	1
20	63-I40S-202	Bushing	1	70	63-I40S-309	Seat	1
21	63-I40S-424	Washer	1	71	63-I70S-101	Motor Housing	1
22	63-I70-401	Pulse Cylinder Seat	1	72	63-00-0507	Screw	1
23D	63-00-41160	O-Ring	2	73	63-I40S-503	Regulator Knob	1
24	63-I70-410	Greasing Screw	1	74	63-I40S-102	Hanger	1
25	63-00-41113	O-Ring	3	75	63-I40S-509	Bushing	1
26	63-00-3318	Spring Pin	2	76	63-IS40S-510	Pin	1
27	63-I70-403	Front Cover	1	77	63-I40S-504	Trigger	1
28	63-I70-408	Front Plate	1	78	63-I40S-108	Bushing	2
29	63-I70-409	Back Up Ring	1	79	63-00-3306	Spring Pin	1
30	63-00-2602	X-Ring	1	80	63-I40S-103	Housing Rubber	1
31	63-I70R-405	Anvil	1	81	63-I40S-508	Bushing	1
32B	63-I70-452	Roller	2	82	63-305C-021	Valve Stem	1
33B	63-I70-406-B	Drive Blade	2	83	63-I40S-507	Spring	1
34	63-I70-407	Spring	2	84	63-I40S-601	Muffler	1
35B	63-IS40-450	Block Valve	1	85	63-I40S-603	Exhaust Deflector	1
36	63-I40S-411	Screw	1		63-I40S-604A	Air Inlet 1/4"PF-19	
37EA	63-IS70-412-C	Valve	1	86	63-I40S-604B	Air Inlet 1/4"PT-19	1
38C	63-00-41173	O-Ring	2		63-I40S-604C	Air Inlet 1/4"NPT-18	
39	63-00-3813	Steel Ball	2	87	63-00-3509	Snap Ring	1
40EA	63-IS70R-425-C	Spring	1	88C	63-I70S-453	Spring	1
41	63-00-3435	Pin	2	89C	63-I40S-454	Block Cap	1
42	63-00-3436	Pin	1	90	63-00-41130	O-Ring	1
43C	63-I70-404-B	Pulse Cylinder	1	91D	63-00-41127	O-Ring	1
44	63-00-3407	Pin	2	※	63-IS70RRK-E05A	Repair kit :Index No-	
45EA	63-IS70-415-C	Rear Plate	1			23D(2);25(2);29;30;34(2);38C(2); 90	
46	63-I40S-423	Washer	1	※	63-IS70RSK-E05A	Service kit :Index No-	
47C	63-IS40S-421	Pressure Valve	2			5;12;28;32B(2);33B(2);	
48D	63-IS130-314	Shut Off Stem	1			45EA;57(9);67;81;82;83	
49EA	63-IS150-317	Spring	1	※	63-IS70R-400ASM	Pulse Unit	
50	63-I70-402	Lock Nut	1		63-01-0501FL	Accessories Kits Included	
					63-Pulse Tool Fluid, 125ml	Pulse Tool Fluid, 125ml	