



#### 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, which ever 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 recommend 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	Q'ty	Index No.	Part No.	Description	Q'ty
1	63-00-0612	Set Screw	1	38	63-I130-504	Trigger	1
2	63-I100-201	Pulse Unit Housing	1	39	63-00-3354	Spring Pin	1
3	63-I100-202	Bushing	1	40	63-00-0505	Screw	2
4	63-I100-424	Washer	1	41	63-I100-503	Regulator Knob	1
5	63-I100-401	Pulse Cylinder Seat	1	42EA	63-IS100-505B	Valve Stem	1
6	63-00-41106	O-Ring	2	44EA	63-I100-508B	Bushing	1
7	63-00-3426	Pin	2	45EA	63-00-41199	O-Ring	1
8	63-I100-408	Front Plate	1	46EA	63-I100-507B	Spring	1
9	63-I100-410	Greasing Screw	1	47	63-00-3813	Steel Ball	1
10	63-00-4153	O-Ring	2	48	63-I100-506	Spring	1
11	63-I100-411	Valve Screw	1	49	63-I100-502	F/R Valve	1
12	63-IS100-412	Valve	1	50	63-I100-501	Valve Sleeve	1
13	63-00-4101	O-Ring	2	51	63-00-41111	O-Ring	2
14	63-00-3432	Pin	4	52	63-I100-101	Motor Housing	1
15	63-I100-409	Back-up Ring	1	53	63-I40S-108	Bushing	4
16	63-00-2601	X-Ring	1	54	63-I40S-102	Hanger	1
17EB	63-I100-405-B	Anvil	1	55	63-00-41127	O-Ring	1
18B	63-I100-452	Roller	2	56	63-I100-104	Nut	1
19B	63-I100-406-B	Drive Blade	2	57	63-I100-511	Pin	1
20	63-I100-407	Spring	2	58	63-00-4158	O-Ring	1
21	63-00-3441	Pin	1	59EB	63-I70-601	Muffler	1
22C	63-I100-404-B	Pulse Cylinder	1	60	63-I100-603	Exhaust Deflector	1
23	63-I100-415	Rear Plate	1		63-I100-604A	Air Inlet 1/4"-19PF	
24	63-I100-423	Washer	1	61	63-I100-604B	Air Inlet 1/4"-19PT	1
25	63-I100-402	Lock Nut	1		63-I100-604C	Air Inlet 1/4"-18NPT	
26	63-I100-306	Lock Nut	1	62C	63-00-41173	O-Ring	1
27	63-00-2345	Ball Bearing	1	63C	63-IS40S-421	Pressure Valve	1
28	63-I100-302	Cylinder	1	64C	63-I100-453	Spring	1
29	63-00-3324	Spring Pin	1	65C	63-I40S-454	Block Cap	1
30	63-I100-304	Rotor Blade	9	66EB	63-I100-103	Housing Rubber	1
31	63-I100-303	Rotor	1	•	63-I100-109FL	Tool Cover	1
32	63-00-3339	Spring Pin	1	•	63-I100SK-MZ	Service kit :Index No-	
33	63-I100-305	Rear Plate	1			8;18B(2);19B(2);23; 30(9);	
34	63-00-2358	Ball Bearing	1			44EA;45EA;46EA	
35	63-00-41138	O-Ring	1	•	63-I100RK-MZ	Repair kit :Index No-	
36	63-I100-307	Rear Cover	1			6(2);10(2);13;15;16;20(2);62C	
37	63-00-41116	O-Ring	2	•	63-I40-451	Impulse Oil	
•	63-I100-400ASM	Pulse unit : Index No- 5,6,7,8,9,10,11,12,13,14,15,16,17EB,18B,19B,20,21,22C,23,25,62C,63C,64C,65C					