



### **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.

$$\text{\# Pulsing Seconds} + \text{Total of Pulsing Time} = \text{No Cycles}$$

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

Index No.	Part No.	Description	Q'ty	Index No.	Part No.	Description	Q'ty
1	63-747-002	Spring Holder	1	47	63-00-2348	Ball Bearing	1
2	63-I50R-706	Lock Nut	1	48	63-00-3324	Spring Pin	1
3	63-00-41134	O-Ring	1	49	63-I40S-302	Cylinder	1
4	63-00-2358	Ball Bearing	1	50	63-I40S-303	Rotor	1
5	63-I50R-711	Washer	1	51	63-I40S-304	Rotor Blade	9
6	63-00-3813	Steel Ball	2	52	63-00-3326	Spring Pin	1
7	63-I50RD-705	Shaft Gear	1	53C	63-I50R-305	Rear End Plate	1
8	63-I50R-707	Shaft	1	54	63-00-2356	Ball Bearing	1
9	63-00-2357	Ball Bearing	1	55	63-I40S-310	Airinlet Plate	1
10	63-I90-410	Screw	1	56	63-305F-034	Spring	1
11	63-00-4153	O-Ring	1	57	63-I40S-502	F/R Valve	1
12	63-I50R-701	Angle Housing	1	58	63-00-41146	O-Ring	1
13	63-00-0605	Set Screw	1	59	63-00-41125	O-Ring	1
14	63-I50R-704	Main Shaft Gear	1	60	63-I40S-309	Seat	1
15	63-I50R-712	Washer	1	61	63-I40S-101	Motor Housing	1
16	63-00-2352	Ball Bearing	2	62	63-00-0507	Screw	1
17	63-I50R-709	Lock Nut	1	63	63-I40S-503	Regulator Knob	1
18	63-I50R-702	Lock Nut	1	64	63-I40S-102	Hanger	1
19	63-I50R-708	Anvil Collar	1	65	63-I40S-509	Bushing	1
20	63-00-3430	Pin	1	66	63-I40S-510	Pin	1
21	63-I50R-201	Pulse Unit Housing	1	67	63-I40S-504	Trigger	1
22	63-I40S-202	Bushing	1	68	63-I40S-108	Bushing	2
23	63-I40S-424	Washer	1	69	63-00-3306	Spring Pin	1
24	63-I40S-401	Pulse Cylinder Seat	1	70	63-I40S-103	Housing Rubber	1
25	63-00-41127	O-Ring	3	71	63-I40S-508	Bushing	1
26	63-00-41113	O-Ring	2	72	63-305C-021	Valve Stem	1
27	63-I70-410	Greasing Screw	1	73	63-I40S-507	Spring	1
28	63-00-3318	Spring Pin	2	74	63-I40S-601	Muffler	1
29EA	63-I40S-403-B	Front Cover	1	75	63-I40S-603	Exhaust Deflector	1
30	63-00-2602	X-Ring	1		63-I40S-604A	Air Inlet 1/4"PF-19	
31EB	63-I80-411	Valve Screw	1	76	63-I40S-604B	Air Inlet 1/4"PT-19	1
32D	63-IS40S-412-B	Valve	1		63-I40S-604C	Air Inlet 1/4"NPT-18	
33	63-00-41130	O-Ring	1	77	63-00-3509	Snap Ring	1
34	63-00-3435	Pin	2	78C	63-00-41173	O-Ring	1
35	63-I40S-408	Front Plate	1	79C	63-IS40S-421	Pressure Valve	1
36	63-I50R-405	Anvil	1	80C	63-I40S-453	Spring	1
37B	63-I40S-452	Roller	2	81C	63-I40S-454	Block Cap	1
38B	63-I40S-406-B	Drive Blade	2	82EA	63-I40-409	Back Up Ring	1
39	63-I40S-407	Spring	2	83EB	63-I80-422	Back Up Ring	1
40C	63-I40S-404-B	Pulse Cylinder	1	•	63-I50RDSK-MZ	Service kit :Index No-7; 14; 35; 37B(2); 38B(2); 43; 51(9); 71; 72; 73	
41	63-00-3436	Pin	1				
42	63-00-3407	Pin	2				
43	63-I40S-415	Rear Plate	1	•	63-I50RDRK-MZ	Repair kit :Index No-25(2); 26(2); 30; 33; 39(2); 78C; 82EA	
44	63-I40S-423	Washer	1				
45	63-I40S-402	Lock Nut	1	•	63-I40-451	Impulse Oil	
46	63-I40S-306	Lock Nut	1				
•	63-I50R-400ASM	Pulse unit : Index No-24,25,26,27,28,29EA,30,31EB,32D,33,34,35,36,37B,38B,39,40C,41,42,43,45,78C,79C,80C,81C,82EA,83EB					