



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

Index No.	Part No.	Description	Q'ty	Index No.	Part No.	Description	Q'ty
1	63-I70SD-465	Anvil Caller	1	50	63-00-2356	Ball Bearing	1
2	63-I70SD-419	Hold Spacer	1	51	63-00-41181	O-Ring	2
3	63-I70SD-418	Spring	1	52	63-00-41138	O-Ring	1
4	63-I70SD-417	Quick Change Hold	1	53	63-IS70-307	Rear Cover	1
5	63-I100-410	Greasing Screw	1	54	63-IS100-524	Valve Seat	1
6	63-00-4153	O-Ring	1	55	63-00-41127	O-Ring	2
7	63-I70-201	Pulse Unit Housing	1	56	63-IS100-312	Washer	1
8	63-I40S-202	Bushing	1	57	63-00-3824	Steel Ball	3
9	63-I40S-424	Washer	1	58	63-IS100-313	Spring	1
10	63-I70-401	Pulse Cylinder Seat	1	59	63-IS100-311	Valve	1
11	63-I70-410	Greasing Screw	1	60	63-IS100-518	Seat	1
12	63-00-41113	O-Ring	4	61	63-IS90-101	Motor Housing	1
13	63-00-3318	Spring Pin	1	62	63-I40S-108	Bushing	4
14	63-00-41160	O-Ring	2	63	63-IS100-609	Screw	1
15	63-I70-403	Front Cover	1	64	63-I40S-102	Hanger	1
16	63-I70-409	Back Up Ring	1	65	63-00-41166	O-Ring	1
17	63-00-2602	X-Ring	1	66	63-I100-104	Nut	1
18EC	63-I80-411	Valve Screw	1	67	63-I130-504	Trigger	1
19	63-00-3435	Pin	2	68	63-00-3354	Spring Pin	1
20	63-I70-408	Front Plate	1	69	63-00-0505	Screw	2
21	63-I70SD-405	Anvil	1	70	63-I100-503	Regulator Knob	1
23	63-I70-406-B	Drive Blade	2	71	63-00-4101	O-Ring	1
24	63-I70-452	Roller	2	72EA	63-IS100-505B	Valve stem	1
25	63-I70-407	Spring	2	74EA	63-I100-508B	Bushing	1
26	63-IS40-450	Block Valve	1	75EA	63-00-41199	O-Ring	1
27	63-IS70-412-C	Valve	1	76EA	63-I100-507B	Spring	1
28	63-00-41130	O-Ring	1	77	63-I100-506	Spring	1
29	63-IS70D-425	Spring	1	78	63-IS100-502	F/R Valve	1
30	63-I70-404-B	Pulse Cylinder	1	79	63-I100-501	Valve Sleeve	1
31	63-00-3436	Pin	1	80	63-00-41111	O-Ring	2
32	63-00-41173	O-Ring	2	81	63-00-4158	O-Ring	1
33	63-IS40S-421	Pressure Valve	2	82	63-I70-601	Muffler	1
34	63-I70S-453	Spring	1	83	63-I100-603	Exhaust Deflector	1
35	63-00-3407	Pin	2		63-I100-604A	Air Inlet 1/4"PF 19	
36	63-I40S-454	Block Cap	1	84	63-I100-604B	Air Inlet 1/4"PT 19	1
37	63-IS70-415-C	Rear Plate	1		63-I100-604C	Air Inlet 1/4"NPT 18	
38	63-IS90-314	Shut Off Stem	1	85	63-I100-511	Pin	1
39	63-IS150-317	Spring	1	86	63-00-3813	Steel Ball	2
40	63-I40S-423	Washer	1	87EB	63-I90-103	Housing Rubber	1
41	63-I70-402	Lock Nut	1	88EC	63-I80-422	Back Up Ring	1
42	63-I90-306	Lock Nut	1	•	63-I90-109FL	Tool Cover	1
43	63-00-2348	Ball Bearing	1	•	63-IS70DRK-MZ	Repair kit :Index No- 12(2);14(2);16;17;25(2);28;32(2)	
44	63-00-3324	Spring Pin	1	•	63-IS70DSK-MZ	Service kit :Index No- 20;23(2);24(2); 37; 48(9); 58; 74EA; 75EA; 76EA	
45	63-I70-302	Cylinder	1	•	63-I40-451	Impulse Oil	
46	63-00-3339	Spring Pin	1				
47	63-I70-303	Rotor	1				
48	63-I70-304	Rotor Blade	9				
49	63-I70-305	Rear Plate	1				
•	63-IS70D-400ASM	Pulse unit : Index No- 10,11,12,13,14,15,16,17,18EC,19,20,21,23,24,25,26,27,28,29,30,31,32,33,34,35,36,37,41,57,86,88EC					