



**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-I100-410	Greasing Screw	1	43	63-00-41146	O-Ring	1
2	63-00-4153	O-Ring	1	44	63-I40-104	Nut	1
3	63-I80H-201	Pulse Unit Housing	1	45	63-I40-504	Trigger	1
4	63-I40S-202	Bushing	1	46	63-00-3354	Spring Pin	1
5	63-I100-424	Washer	1	47	63-00-0512	Screw	2
6	63-I80-401	Pulse Cylinder Seat	1	48	63-I100-503	Regulator Knob	1
7	63-00-41212	O-Ring	2	49	63-00-4101	O-Ring	1
8	63-I70-410	Greasing Screw	1	50	63-IS40-505B	Valve Stem	1
9	63-00-41113	O-Ring	2	51	63-I100-508B	Bushing	1
10	63-00-3325	Spring Pin	2	52	63-00-41199	O-Ring	1
11	63-I80-408	Front Cover	1	53	63-I40-507B	Spring	1
12	63-00-2602	X-Ring	1	54	63-00-3813	Steel Ball	1
14	63-I80-405	Anvil	1	55	63-I100-506	Spring	1
15	63-I80-407	Spring	2	56	63-IS40-502	F/R Valve	1
16	63-I80-406	Drive Blade	2	57	63-I40-501	Valve sleeve	1
17	63-I90-452	Roller	2	58	63-00-41111	O-Ring	2
18	63-I80-411	Valve Screw	1	59	63-00-41145	O-Ring	1
19	63-IS80-412	Valve	1	60	63-I40-601	Muffler	1
20	63-00-41162	O-Ring	1	61	63-I40-603	Exhaust Deflector	1
21	63-00-3407	Pin	2		63-I40-604A	Air Inlet 1/4"PF	
22	63-I80-404	Pulse Cylinder	1	62	63-I40-604B	Air Inlet 1/4"PT	1
23	63-00-3436	Pin	1		63-I40-604C	Air Inlet 1/4"NPT	
25	63-I80-415	Rear Plate	1	63	63-I100-511	Pin	1
26	63-I40S-423	Washer	1	64	63-00-41173	O-Ring	1
27	63-I80-402	Lock Nut	1	65	63-IS40S-421	Pressure Valve	1
28	63-I80-306	Lock Nut	1	66	63-I90-453	Spring	1
29	63-00-2348	Ball Bearing	1	67	63-I40S-454	Block Cap	1
30	63-I80-302	Cylinder	1	68	63-I100-409	Back Up Ring	1
31	63-00-3324	Spring Pin	1	69	63-I60-103	Housing Rubber	1
32	63-00-3356	Spring Pin	1	70	63-I80-422	Back Up Ring	1
33	63-I80S-303	Rotor	1	71	63-I80H-408	Front Plate	1
34	63-I80S-304	Rotor Blade	9	72	63-00-3435	Pin	2
35	63-I80-305	Rear Plate	1	•	63-I80-109FL	Tool Cover	1
36	63-00-2332	Ball Bearing	1	•	63-I80RK-MZ	Repair kit :Index No- 7(2);9(2);12;15(2);20;64;68;70	
37	63-00-41214	O-Ring	1				
38	63-I80-307	Rear Cover	1	•	63-I80SK-MZ	Service kit :Index No- 16(2);17(2)25; 34(9); 51	
39	63-00-41213	O-Ring	2				
40	63-I80-101	Motor Housing	1				
41	63-I40S-108	Bushing	4	•	63-I40-451	Impulse Oil	
42	63-I40S-102	Hanger	1				
•	63-I80H-400ASM	Pulse unit : Index No- 6,7,8,9,10,11,12,14,15,16,17,18,19,20,21,22,23, 25,27,64,65,66,67,68,70,71,72					