



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 either one occurs first. The tool's performance should be evaulated. 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.

Pulsing Seconds + Total of Pulsing Time = 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 pulses-sec \div 2 sec = 125,000 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	



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No. Part No. Description City No. Part No. Description	dox				ارمام ا	I				
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38 63-I40S-402 Lock Nut 1 × 63-IS40SDSK-MZ Service kit :Index No- 39 63-I40S-306 Lock Nut 1 1 1 7; 20B(2); 21B(2); 32EA; 40 63-00-2348 Ball Bearing 1 45(9); 55; 69; 70; 71					_			1		
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40 63-00-2348 Ball Bearing 1 45(9); 55; 69; 70; 71					*	63-IS40SDSK-MZ				
41 63-00-3324 Spring Pin 1 * 63-IS40SDRK-MZ Repair kit :Index No-					*	63-IS40SDRK-MZ				
							11(2);12(2);16;22(2);26;34C(2);78EA			
43 63-00-3326 Spring Pin 1 × 63-140-451 Impulse Oil					*	63-140-451	Impulse Oil			
44 63-I40S-303 Rotor 1				1						
* 63-IS40SD-400ASM Pulse unit : Index No-	Ţ									
10,11,12,13,14,15EA,16,17,18,19,20B,21B,										
22,23B,24EB,25EA,26,27EA,28,29C,30,31,32EA,34C,35C,38,										
76C,77C,78EA,79EB			76C,77C,78EA,79EB							